

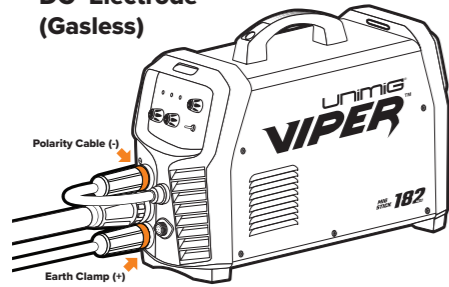
# VIPER 182 Mk II

# Welding Setup Guide

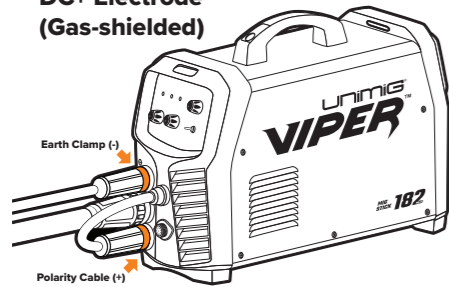


## Polarity: MIG

### DC- Electrode (Gasless)



### DC+ Electrode (Gas-shielded)



## MIG Setup Guide

Material Type	Wire Type	Wire Size	Drive Roller	Polarity	Shielding Gas	Gas Flow Rate	Material Thickness	1mm	2mm	3mm	4mm	6mm	8mm	
Steel	ER70S-6	0.8mm	V Groove	DCEP+	ArCO <sup>2</sup>	8-12L/min	Voltage (V)	15	18	20	21	23	23	
							Wire Speed (m/min)	5	7.5	8.5	9	12	13	
	ER70S-6	0.9mm	V Groove	DCEP+	ArCO <sup>2</sup>	8-12L/min	Voltage (V)	/	18	18.5	19	22	23	
							Wire Speed (m/min)	/	6	7	7.5	11	13	
	E71T-11	0.8mm	F Groove (Knurled)	DCEN-				Voltage (V)	14	17	21	22	23	/
								Wire Speed (m/min)	3.5	5.5	8.5	9	11	/
	E71T-11	0.9mm	F Groove (Knurled)	DCEN-				Voltage (V)	15	18	19	20	22	23
								Wire Speed (m/min)	4	5	5.5	6	8	9
Stainless Steel	316LSi	0.8mm	V Groove	DCEP+	ArCO <sup>2</sup>	8-12L/min	Voltage (V)	12	13	14.5	16	17	19	
							Wire Speed (m/min)	7	8	9	10	11	15	
	316LSi	0.9mm	V Groove	DCEP+	ArCO <sup>2</sup>	8-12L/min	Voltage (V)	/	13	14.5	16	18	20	
							Wire Speed (m/min)	/	7	8	9	10	14	
Aluminium	5356	1.0mm	U Groove	DCEP+	Ar	8-12L/min	Voltage (V)	/	11	12	13	17	18	
							Wire Speed (m/min)	/	9	10	11	14	16	

## Drive Rollers

SKU	Description
0.6-0.8V30/22	Drive Roll V Groove 0.6-0.8mm
0.8-1.0V30/22	Drive Roll V Groove 0.8-1.0mm
0.9-1.2V30/22	Drive Roll V Groove 0.9-1.2mm
1.0-1.2V30/22	Drive Roll V Groove 1.0-1.2mm
0.8-0.9F30/22	Drive Roll Knurled 0.8-0.9mm
0.9-1.2F30/22	Drive Roll Knurled 0.9-1.2mm
0.8-1.0U30/22	Drive Roll U Groove 1.0-1.2mm
0.9-1.0U30/22	Drive Roll U Groove 0.9-1.0mm
0.9-1.2U30/22	Drive Roll U Groove 0.9-1.2mm
1.0-1.2U30/22	Drive Roll U Groove 1.0-1.2mm

Please refer to operating manual for more detailed information.

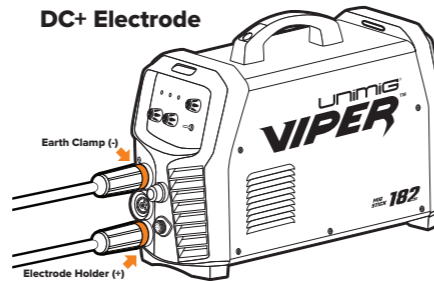
## SB15 MIG Torch Spares

SKU	Description	QTY
PCTH15	TIP HOLDER	2
PGNS15	NOZZLE SPRING	2
PCT0008-06	CONTACT TIPS - Steel 0.6mm	10
PCT0008-08	CONTACT TIPS - Steel 0.8mm	10
PCT0008-09	CONTACT TIPS - Steel 0.9mm	10
PCT0008-10	CONTACT TIPS - Steel 1.0mm	10
PCT0008-12	CONTACT TIPS - Steel 1.2mm	10
PCTAL0008-09	CONTACT TIPS - Aluminium 0.9mm	10
PCTAL0008-10	CONTACT TIPS - Aluminium 1.0mm	10
PCTAL0008-12	CONTACT TIPS - Aluminium 1.2mm	10
PGN15CON	GAS NOZZLE - Conical	2
PGN15CYL	GAS NOZZLE - Cylindrical	2
PGN15SPOT	GAS NOZZLE - Spot	2
PGN15TAP	GAS NOZZLE - Tapered	2

Please refer to operating manual for more detailed information.

## Polarity: Stick

### DC+ Electrode



Please refer to electrode packaging for correct polarity settings.

## Stick Setup Guide

Material Type	Electrode Type	Electrode Thickness	2.5mm	3.2mm	4.0mm
Steel	HYPERARC <sup>®</sup> GP 6013	Amperage Range (A)	55-90A	90-135A	135-180A
		Polarity	DCEP+		
	HYPERARC <sup>®</sup> 16TC	Amperage Range (A)	65-100A	95-150A	150-180A
		Polarity	DCEP+		
Stainless Steel	HYPERARC <sup>®</sup> 316L	Amperage Range (A)	40-70A	75-110A	100-150A
		Polarity	DCEP+		

This setup information is intended to act as a guide only. Individual may vary depending on technique, skill and material. Please refer to the operating manual for further instructions.