

## Troubleshooting Guide from Tregaskiss

PROBLEM	POSSIBLE CAUSE	POSSIBLE SOLUTION
1. Electrode does not feed or erratic wire feeding.	<ol style="list-style-type: none"> <li>1. Feeder relay/malfunction.</li> <li>2. Broken control lead.</li> <li>3. Poor adaptor connection.</li> <li>4. Worn or broken switch.</li> <li>5. Improper drive roll size.</li> <li>6. Drive roll tension misadjusted.</li> <li>7. Burn back to contact tip.</li> <li>8. Wrong size liner.</li> <li>9. Buildup inside of liner.</li> <li>10. Worn drive roll.</li> <li>11. Improper guide tube relationship.</li> <li>12. Improper wire guide diameter.</li> <li>13. Gaps at liner junctions.</li> <li>14. Contact tip.</li> </ol>	<ol style="list-style-type: none"> <li>1. Consult feeder manufacturer.</li> <li>2. <ol style="list-style-type: none"> <li>a. Test &amp; connect spare control lead.</li> <li>b. Install new cable.</li> </ol> </li> <li>3. Test &amp; replace leads and/or contact pins.</li> <li>4. Replace.</li> <li>5. Replace with proper size.</li> <li>6. Adjust tension at feeder.</li> <li>7. See '<a href="#">Contact Tip Burn Back</a>'.</li> <li>8. Replace with correct size.</li> <li>9. Replace liner, check condition of electrode.</li> <li>10. <ol style="list-style-type: none"> <li>a. Replace with new drive roll.</li> <li>b. Stone edge of groove on drive roll.</li> </ol> </li> <li>11. <ol style="list-style-type: none"> <li>a. Adjust/replace guide as close to drive rolls as possible.</li> <li>b. Eliminate all gaps in electrode path.</li> </ol> </li> <li>12. Replace with proper guide diameter.</li> <li>13. Replace with new liner, using the Tregaskiss Liner Gauge.</li> <li>14. Inspect and replace.</li> </ol>
2. Short contact tip life.	<ol style="list-style-type: none"> <li>1. Improper voltage and/or wire feed speed.</li> <li>2. Erratic wire feeding.</li> <li>3. Improper tip stickout.</li> <li>4. Improper electrode stickout.</li> <li>5. Faulty ground.</li> </ol>	<ol style="list-style-type: none"> <li>1. Set parameters.</li> <li>2. See '<a href="#">Erratic Wire Feeding</a>'.</li> <li>3. Adjust nozzle/tip relationship.</li> <li>4. Adjust torch to base metal relationship.</li> <li>5. Repair all cables &amp; connections.</li> </ol>
3. Torch running hot.	<ol style="list-style-type: none"> <li>1. Exceeding duty cycle.</li> <li>2. Loose or poor power connection.</li> </ol>	<ol style="list-style-type: none"> <li>1. <ol style="list-style-type: none"> <li>a. Replace with properly rated Tregaskiss torch.</li> <li>b. Decrease parameters to within torch rating.</li> </ol> </li> <li>2. <ol style="list-style-type: none"> <li>a. Clean, tighten or replace cable grounding connection.</li> <li>b. Tighten torch &amp; cable connections to specified torque.</li> </ol> </li> </ol>



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4. Porosity in weld.	<ol style="list-style-type: none"> <li>1. Insulator worn.</li> <li>2. Retaining head damaged.</li> <li>3. Extreme heat or duty cycle.</li> <li>4. Solenoid faulty.</li> <li>5. No gas.</li> <li>6. Flow improperly set.</li> <li>7. Gas ports plugged.</li> <li>8. Ruptured gas hose.</li> <li>9. Control circuit loss.</li> <li>10. Worn, cut or missing o-rings.</li> <li>11. Loose fittings.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace nozzle/insulator.</li> <li>2. Replace retaining head.</li> <li>3. Replace with heavy duty consumables.</li> <li>4. Replace solenoid.</li> <li>5. <ol style="list-style-type: none"> <li>a. Install full tanks.</li> <li>b. Check supply.</li> <li>c. Check for hose leaks.</li> </ol> </li> <li>6. Adjust.</li> <li>7. <ol style="list-style-type: none"> <li>a. Clean or replace gas diffuser/retaining head.</li> <li>b. Clean nozzle.</li> </ol> </li> <li>8. Repair or replace cable or line.</li> <li>9. See '<u>Electrode does not feed</u>'.</li> <li>10. Replace o-rings.</li> <li>11. Tighten torch &amp; cable connections to specified torque.</li> </ol>
5. Contact tip burn back.	<ol style="list-style-type: none"> <li>1. Improper voltage and/or wire feed speed.</li> <li>2. Erratic wire feeding.</li> <li>3. Improper tip stickout.</li> <li>4. Improper electrode stickout.</li> <li>5. Faulty ground.</li> </ol>	<ol style="list-style-type: none"> <li>1. Set parameters.</li> <li>2. See '<u>Erratic wire feeding</u>'.</li> <li>3. Adjust nozzle/tip relationship.</li> <li>4. Adjust torch to base metal relationship.</li> <li>5. Repair all cables &amp; connectors.</li> </ol>
6. Tip disengages from retaining head.	<ol style="list-style-type: none"> <li>1. Worn retaining head.</li> <li>2. Improper tip installation.</li> <li>3. Extreme heat or duty cycle.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace tip and/or retaining head.</li> <li>2. Install as per your Tregaskiss product Technical Guide.</li> <li>3. Replace with heavy duty consumables.</li> </ol>
7. Erratic arc.	<ol style="list-style-type: none"> <li>1. Worn contact tip.</li> <li>2. Buildup inside of liner.</li> <li>3. Wrong tip size.</li> <li>4. Not enough bend in gooseneck.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace.</li> <li>2. Replace liner, check condition of electrode.</li> <li>3. Replace with correct size tip.</li> <li>4. Replace with 45° or 60° gooseneck.</li> </ol>
8. Extreme spatter.	<ol style="list-style-type: none"> <li>1. Improper machine parameters.</li> <li>2. Improper tip installation.</li> <li>3. Improper shielding.</li> <li>4. Contaminated wire or work piece.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust parameters.</li> <li>2. Adjust nozzle/tip relationship.</li> <li>3. <ol style="list-style-type: none"> <li>a. Verify shielding gas coverage.</li> <li>b. Verify gas mixture.</li> </ol> </li> <li>4. Clean wire and work piece.</li> </ol>
9. Liner is discolored full length.	<ol style="list-style-type: none"> <li>1. Short circuit to electrode.</li> <li>2. Broken copper stranding in power cable.</li> </ol>	<ol style="list-style-type: none"> <li>1. Isolate electrode reel from feeder and drive block. Consult feeder manufacturer's manual.</li> <li>2. Replace gun.</li> </ol>

