



SPOOLKING-200
Spool Gun Manual

1. Safety precaution

- 1.1 Before installing the welding gun, please read the safety precautions carefully and know about the equipment requirements (such as welders, wire feeders, shielding gas etc.) to make sure the correct installation and employment.
- 1.2 For safety, only can qualified people operate the gun.
- 1.3 Make sure the rated current works within correct range, if overrated; the welding gun will be damaged easily!
- 1.4 Ensure the faulty and damaged cable is not used.
- 1.5 Do not make the gun touch sharp and over-heated work pieces.
- 1.6 Always wear a work clothes, proper fitted welding helmet and protection products according to the labor protection.
- 1.7 Keep operator's eyes, face and other parts away from gun head when observe the wire is out or not,

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Printed at November 28, 2009

	Flux adjuster
	Control plate

6 List of spare parts

SN.	Spare Parts	Spec	Quantity
1	Contact Tip	0.030	1
2	Spanner	4mm	1

in order to avoid injury by splashing wires.

2. Main specifications

Rated Welding Current	CO ₂	200A
	Mixed Gas	160A
Duty Cycle		35%
Wire Diameter	Mild Steel	0.4-0.8mm
	Stainless	0.6-0.8mm
	Aluminium	0.6-1.0mm
Wire Speed		0~16m/min
Spool Cover Diameter		φ102mm
Motor Voltage		DC 24V
Standard Cable Length		6m/8m/10m
Speed Adjust Potentiometer		10kΩ(1kΩ/5kΩ)
Cooling System		Air cooling
Changeable Gun Neck		Straight neck/Goose neck
Net Weight (8m)		4.4kg
Connection		Euro-central

Criterion: GB/T15579.7-2005

Welding mode: MIG/MAG

Guiding mode: manual

Rated voltage: ≤113V

Rated electrical controlling rate: 24V

3. Installation and Operation

3.1 Connect the welding gun with welder

Switch off welder power, make the Euro-central connector connect with wire feeder adaptor, and tighten threaded collar. Insert plug into receptacle, and tighten threaded collar.

3.2 Installing wire spool

Press the button on the spool cover then open it, loose the spool cover fixing screw (level), slide wire spool to it's shaft, Adjust nut to make it suitable. Push wire through guides into wire feeding roll. Press the trigger after closed the cover, wire feeding roll make the wire into the gun tube.

3.3 Adjusting the wire feeding pressure

Use the speed control knob at MigSonic-145 to control wire speed. Turn the pressure adjusting screw clockwise with hand, the pressure will increase, otherwise it will decrease.

5 Troubleshooting

SN.	TROUBLE	REASON AND REMEDY
1	No electric arc	The circuit between the gun and work pieces is cut
		Power and control lead are invalid.
2	Arc is set between nozzle and work piece	Splashes accumulate in the nozzles
		Insulator of the nozzle is burnout
3	Gun body or cable is over-heated	Welding current is too big
		The contact tip is not screwed tightly.
		Loop cable contacts badly
4	Wire feeding roll turns but do not feed wire	Adjust wire feeding pressure
5	Wire feeds unevenly	The pressure of the idler wheel is too big or small
		The wire diameters are not equal or cooper plating is inferior.
		The liner is with wrong type, specs and assembled incorrect or damaged.
		Wire feeding system is not qualified.
		Idler wheel is worn or assembled incorrect, or with wrong specs.
6	Wire feeding roll does not turn	Motor conduct wire and connector
		Control wire and connector
		Control plate DC 24V power source
7	No protection gas	Cylinder valve, gas valve

(eg. Wire feeder).

4.4 Once finishing the welding process, should clear the gun and keep it safe for the future use.

4.5 If the gun is not used more than one week, please take out the liner from the gun to avoid that the rust would prevent feeding wires.

4.6 Under the following circumstances, make sure to take protective measures outside.

a) The conditions of being electric shocked augmented.

b) The condition of being combustible materials.

c) The condition of being a steeplejack.

d) The condition of being air current.

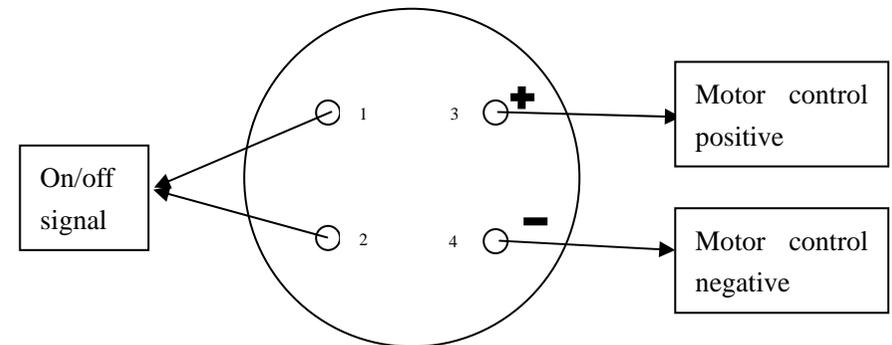
e) The condition of being noises.

f) The condition of being sealed containers.

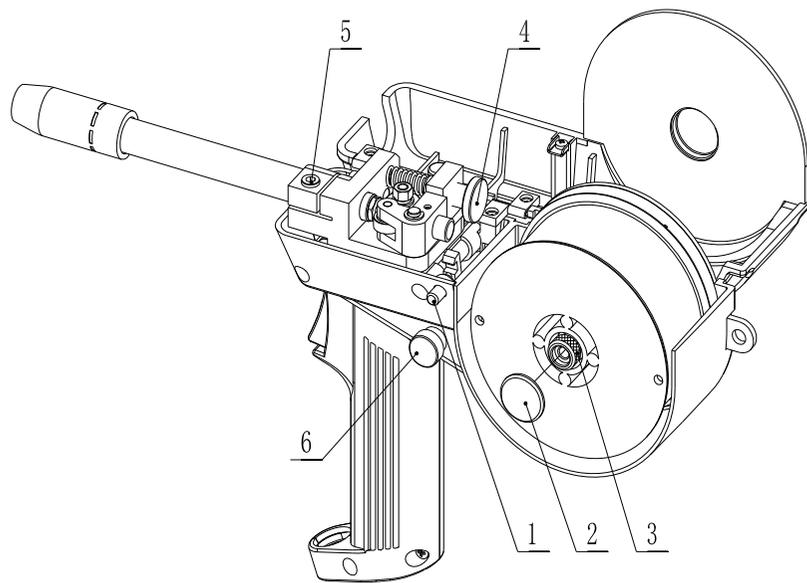
3.4 Adjusting the wire feeding speed

Turn the wire feeding speed adjusting knob clockwise, the speed will increase, otherwise it will decrease.

Drawing 1. Control receptacle definition



Drawing 2. Configuration diagram



1. Spool cover open button
2. Spool cover fix screw
3. Spool Cover tighten nut

4. wire pressure adjustment screw
5. Gun neck screw
6. wire speed control knob(some model)

4. Warning

4.1 splashes

4.1.1 Splashes easily damage the gun and affect the welding quality in the course of welding. So in order to avoid feeding problems, unstable electric arc and reducing the effect of the shielding gas, pls clear away the splashes in the nozzles and contact tip in time.

4.1.2 If the nozzle is not cleared duly, the splashes would make the gun inside short circuit to burn the gun spares.

4.1.3 Please use the grease to defense the splashes. Avoid beating the gun using solid objects to clear the spatter.

4.2 Strictly prohibit acting the gun as tools for knocking and cracking.

4.3 Do not use the cable to drag other heavy objects