



WeldKing™ NT1-4E MIG/MAG  
WELDING GUN OPERATION 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.

1.2 For safety, only qualified people can operate the gun.

1.3 Make sure the rated gun works within rated current range. The welding gun will be damaged easily if it is used overrated!

1.4 Ensure not to use faulty and damaged cable.

1.5 Do not put the gun on sharp or heat 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 feeding, in order to avoid injury of splashing wires.

## 2. Main specifications

Model	Cooling System	Rated Current		Duty	Wire	Liner length	Air Flow
		CO2	M21	Cycle	Diameter		
		(A)	(A)	%	(mm)		
NT1	Air	180	125	60	0.6-1.2	$\geq 3$	10-18

Welding process: MIG/MAG

Guiding mode: manual

Rated voltage:  $\leq 113V$

Rated control voltage: 24V

## 3. Installation

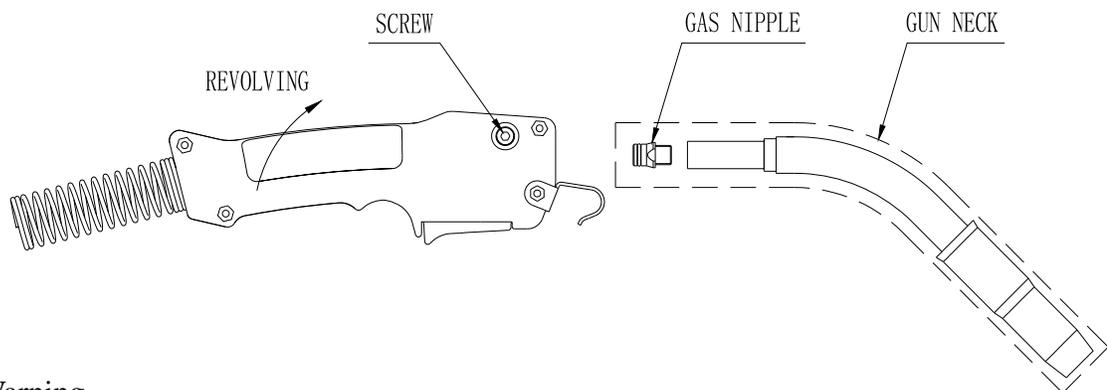
3.1 Connect gun end Euro plug with wire feeder adaptor and tighten knob.

3.2 Installation and unload of gun neck assembly

3.2.1 Loose the locking screw with spanner when unload, pull out the gun neck.

3.2.2 Revolving gun handle one cycle along following “arrow”, insert the gun neck completely and lock the locking screw.

3.2.3 Loose locking screw, Gun neck can be changed to various angle with different welding position. Please make sure the screw is locked well after angle is fixed.



4. Warning

4.1 Do not coil cable as fig, distribute the cable straight.

4.2 In order not to prevent liner from distorting permanently, which will increase the feeding pressure, keep the liner straight while installation.

4.3 Spatter

4.3.1 Spatter easily damage the gun and affect the welding quality in the course of welding. To avoid feeding problems, unstable electric arc and reducing the effect of the shielding gas, please clear spatter inside the nozzles and contact tip frequently.

4.3.3 Use the anti-spatter grease or pray will help reducing the spatter. Avoid to knock the gun by hard objects to clear the spatter.

4.4 Strictly prohibit to knocking and hammering.

4.5 Do not drag other heavy objects (e.g. Wire feeder) with the gun.

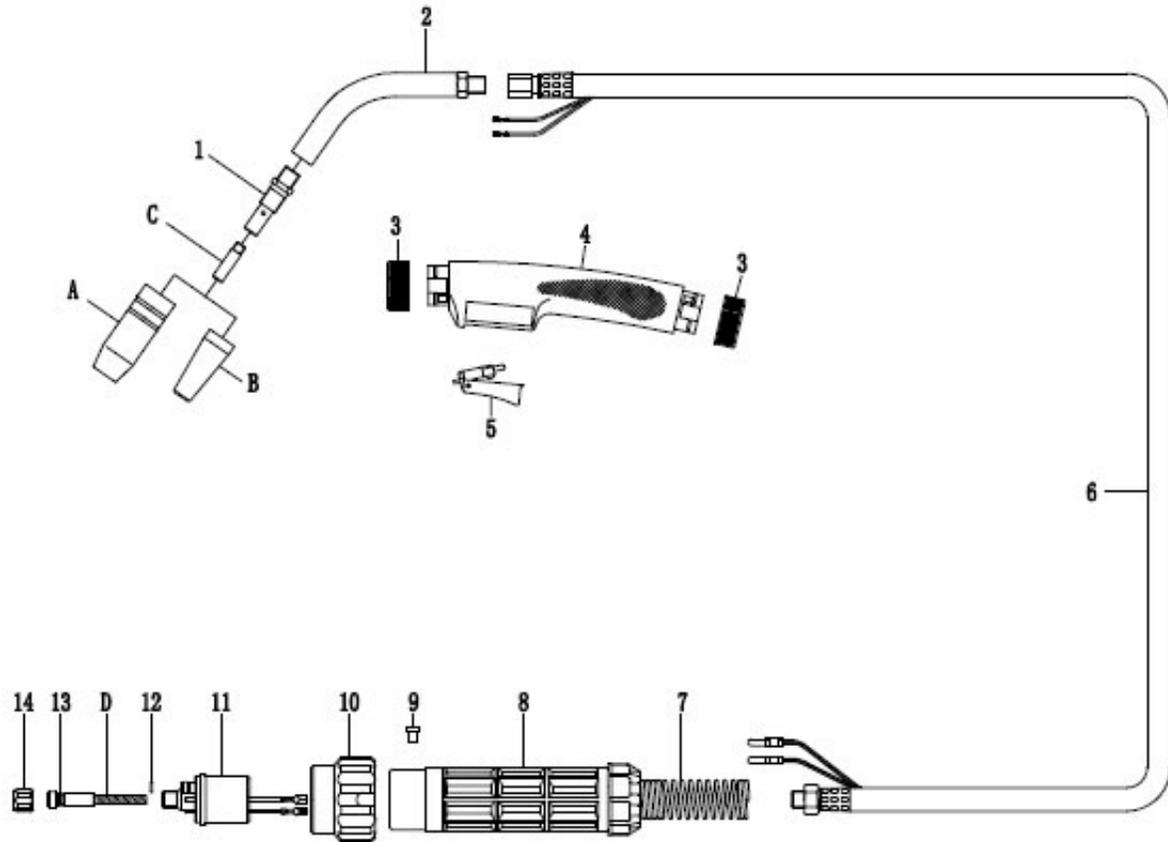
4.6 after welding, Please clean the gun and keep it safe for the future use.

4.7 If the gun is not used more than one week, please take out the liner from the gun to avoid rust.

5. Troubleshooting and measures

SN.	TROUBLE	REASON AND REMEDY
1	No electric arc	The circuit between the gun and work pieces is cut
		Power or control lead is faulty.
2	Arc is set between nozzle and work piece	Spatter accumulates in the nozzles
		Insulation of the nozzle is burned.
3	Gun body or cable is over-heated	Welding current is too high
		The contact tip is not screwed tightly.
		Poor cable connection
4	Wires melt to contact tip	wire feed speed is too slow
		Wires are blocked because of the accumulated spatter inside the liner or the cable is bend too much.
		The distance between contact tip and work pieces is too much. The distance should be 10 times of the wire diameter.
		Contact tip is used too long.
5	Wire feeds unevenly	The pressure of the pressure drive wheel is not set properly
		The wire diameters are not even or cooper coating problem.
		Wrong liner type, specs or liner damaged.
		Wire feeding system problem.
		Pressure wheel is worn or assembled incorrectly, or used wrong wheel.

WeldKing™ NT1-4E, Order No. 07000412



Nozzles

ITEM	DESCRIPTION	ORDER NO.	
1	Nozzle Self Insulated	21-37	A
2	Nozzle Self Insulated	21-50*	A
3	Nozzle Self Insulated	21-62	A
4	Nozzle Self Insulated	21-37F	A
5	Nozzle Self Insulated	21-50F	A
6	Nozzle Self Insulated	21-62F	A
7	Nozzle Self Shielding	LA8201	B

Contact Tips

ITEM	DESCRIPTION	ORDER NO.	

1	Contact Tip 0.023"/0.6mm Ecu	11-23	C
2	Contact Tip 0.030"/0.8mm Ecu	11-30*	C
3	Contact Tip 0.035"/0.9mm Ecu	11-35	C
4	Contact Tip 0.040"/1.0mm Ecu	11-40	C
5	Contact Tip 0.045"/1.2mm Ecu	11-45	C

#### Liners

ITEM	DESCRIPTION	ORDER NO.	
1	Steel Liner 0.030"-0.035"/0.8-0.9mm X15ft	42-3035-12*	C
2	Teflon Liner 0.030"-0.035"/0.8-0.9mm X15ft	42T-3035-12	C

\* Default

#### Component

ITEM	DESCRIPTION	PART No.	QTY
1	Gas Diffuser	51	1
2	Goose neck(45°)	61-45	1
	Goose neck(55°)	61-55	1
3	Handle locking Nut	EH1111	1
4	Gun Handle (Front)	EH1101	1
5	Trigger Assembly	EJ0003	1
6	Gun & Cable Assembly.3.65M	TEL1012-H	1
7	Rear spring protective sleeve	ES2201	
8	Rear cover	EH2201	1
9	Screw(M4X6)	EH2211	1
10	Rear lock nut	EP2001	1
11	Euro connector(Tweco)	ETU001	1
12	O ring 4x1	Q504010	1
13	O ring 4x8	Q504018	1
14	Nut M11X1	TEU1011	1

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