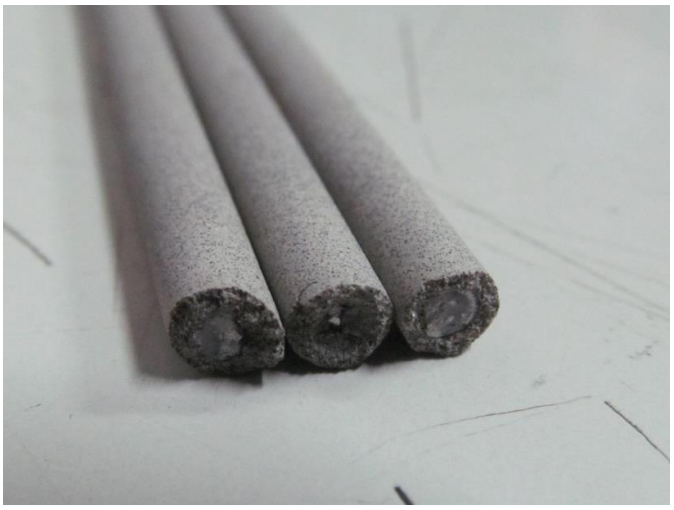
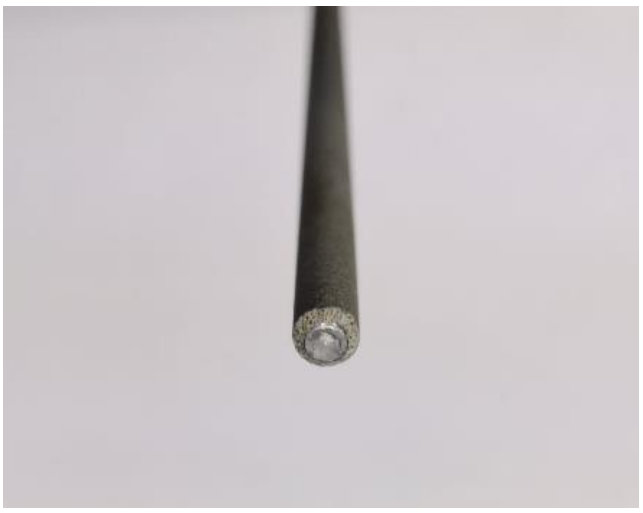
CUSTOMER INFORMATION REPORT

TOPIC: How to overcome ignition problems on electrode?

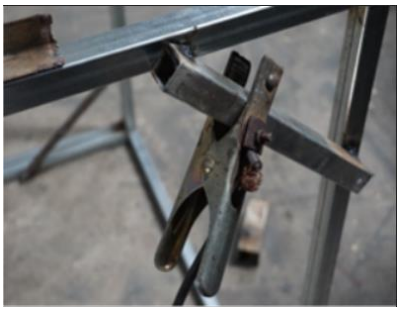
1 – Tip form of the electrode should be checked. Disordered tip forms could cause difficulties at the first ignition process.



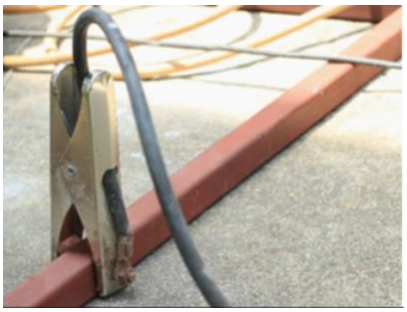


2 – Welding machines with ''Hot Start'' feature should be preferred. Due to this feature, at the start of welding, the welding machine will create high current and will provide sufficient arc forming power in the first ignition.

3 – Grounding and pliers connection should be checked. Electrode ignition is difficult with wrong connections or patterns. For instance, the connections are attached to painted parts, except the copper part of the chassis and the worn chassis are some defects that would cause noncomformity.



Chassis is not clamped to the copper part of the structure

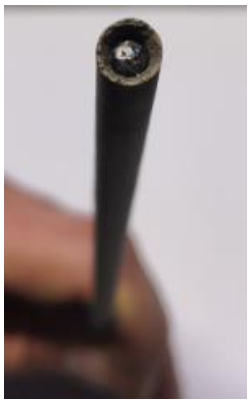


Chassis is clamped to the painted part

Proper clamped chassis

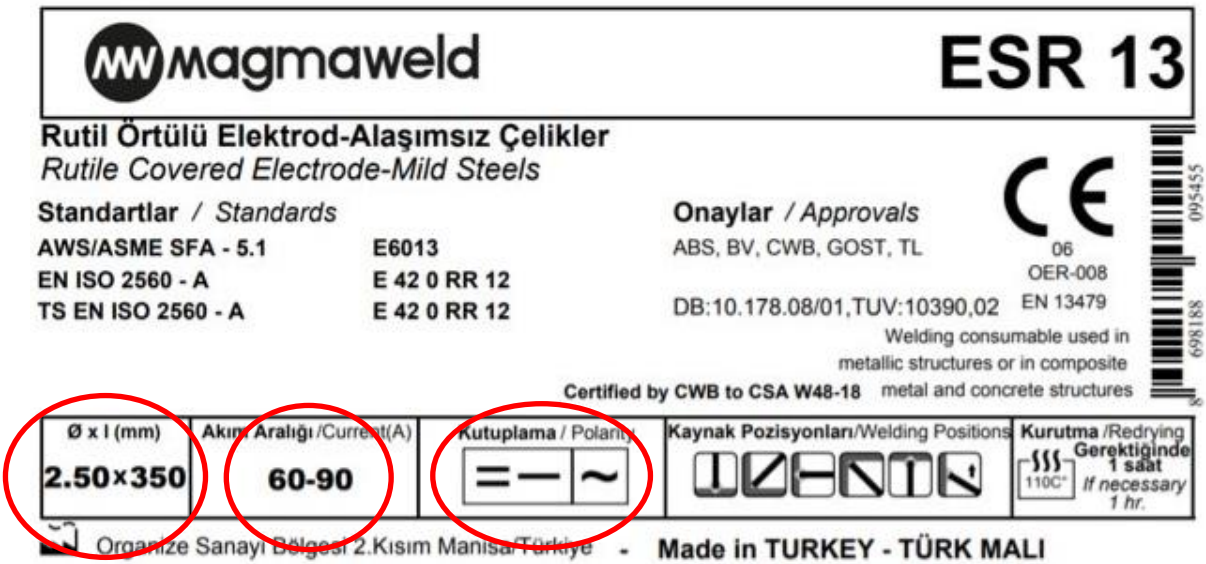
4 – Base metal should be cleaned and prepared before welding . Unsuitabilities like dirt, rust, dye, stain etc. on material surface can cause difficulties on ignition and they are some of the main reasons of welding errors.

5 – Before reigniting an used electrode, arc tip must be in proper form. It can be cleaned before igniting if requires to; otherwise there might be difficulties on ignition.



6 – First ignition of electrode must be done by rubbing it to the surface (like striking a match). Hitting to the surface with the electrode is a wrong application. In this case, there will be difficulties on ignition and shedding of the electrode cover might occur.

7 – Proper current and polarization must be selected for the specific electrode. Wrong current selection could cause spatter or crimson of the electrode. Mispolarization also causes difficulties on ignition. Suitable current values and proper polarizations are shown on the label of the electrode package.



2.50 mm diameter electrode. 60-90 Amper range, DC(-) or AC currents are suitable.