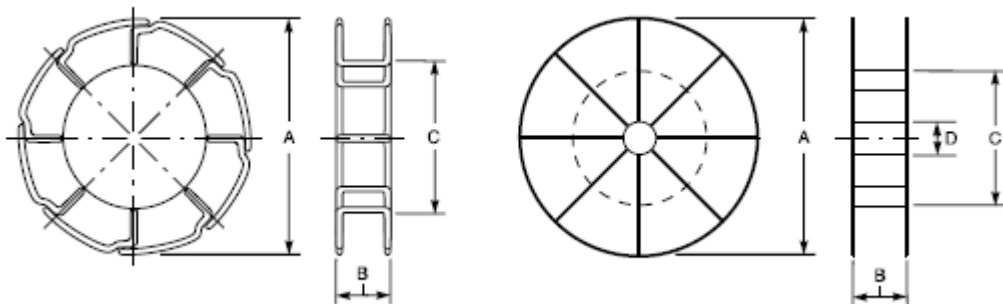


## CUSTOMER INFORMATION REPORT

**TOPIC:** Winding spool wire mixing problem.

The most popular wires on the market, MG 2 and comparable ones, are coiled on spools with capacities of 15 kg called B300 and BS300. Simple representation of these spools are in the image below. There are specific tolerances for each dimension identified by A,B,C and D. For more information, check the relevant AWS and EN ISO standards sections.(AWS A5.02 ve EN ISO 544)



It is imposible to wrap wires by knotting and entwining the lower and upper windings because the process of winding wires on spool is entirely dependent on automation. In order to convey the most common causes of these types of problems and to offer solutions, the following items are listed;

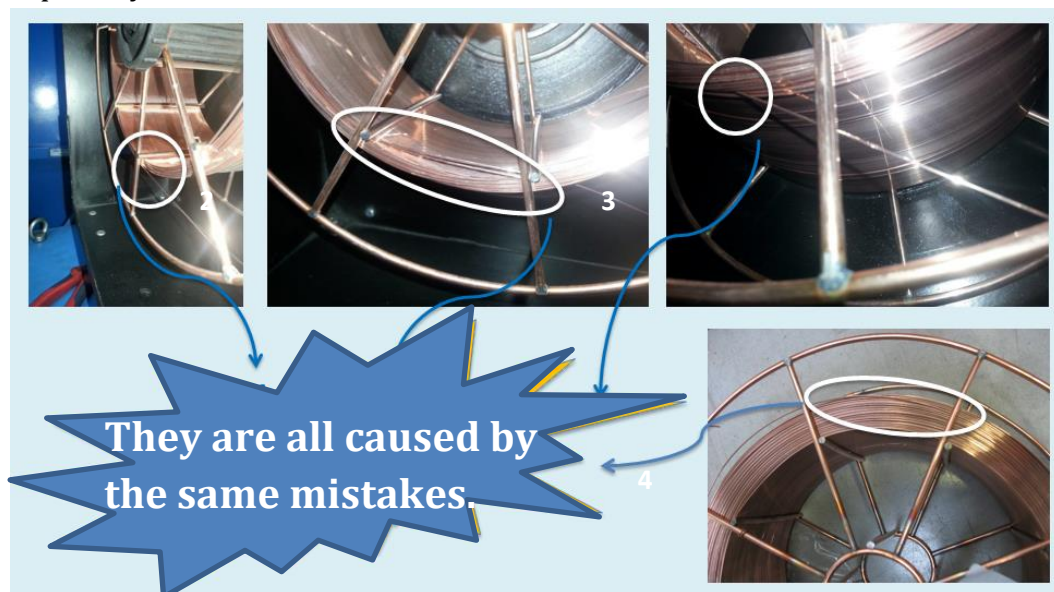
Spool torque screw:

- Limits the spin speed of spool,
- Aavailable on all MIG/MAG machines,



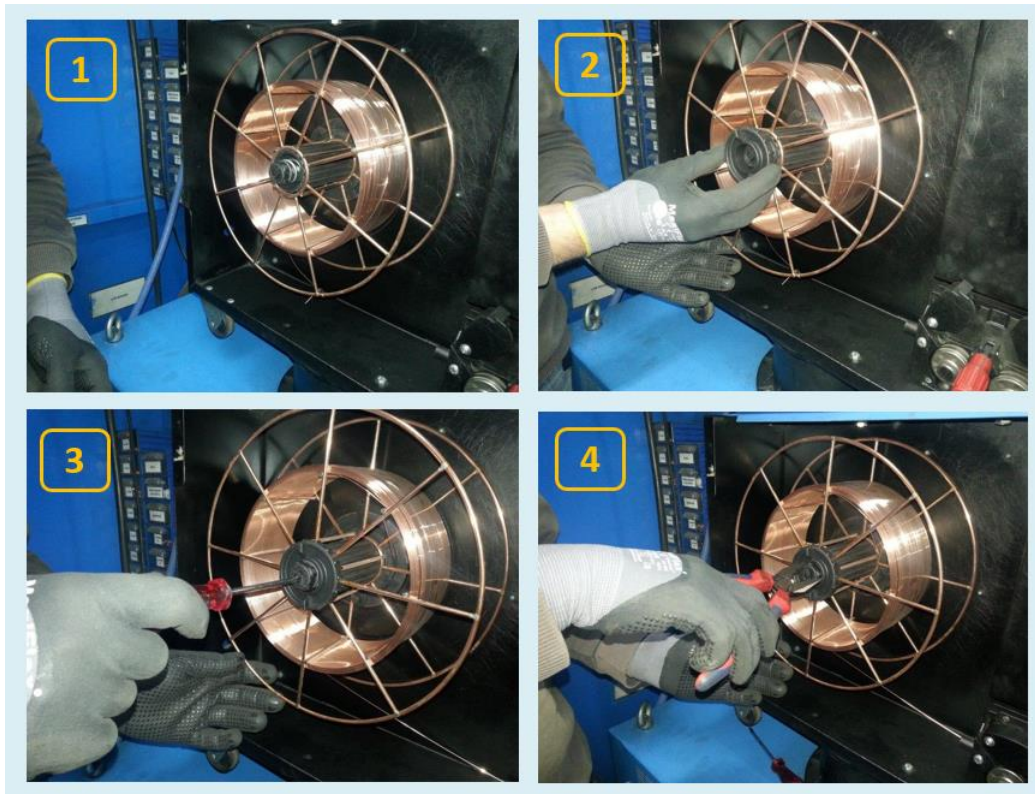


- If the torque screw too tight;
  1. Causes sticking on side walls on spool.
  2. It may cause the spool marks on the wire when the spool is about to be consumed.
  3. If the spool has impact or transportation damage this problems more noticeable, especially on wires with a thickness of 0,80mm.



- If the torque screw is too loose;
  - Even when the torch trigger is released, it causes the spool to rotate freely and the wire to come out and tangle around the spool.
- Torque screw can be adjusted with a screwdriver or pliers. It can be simply adjusted manually on some welding machines.

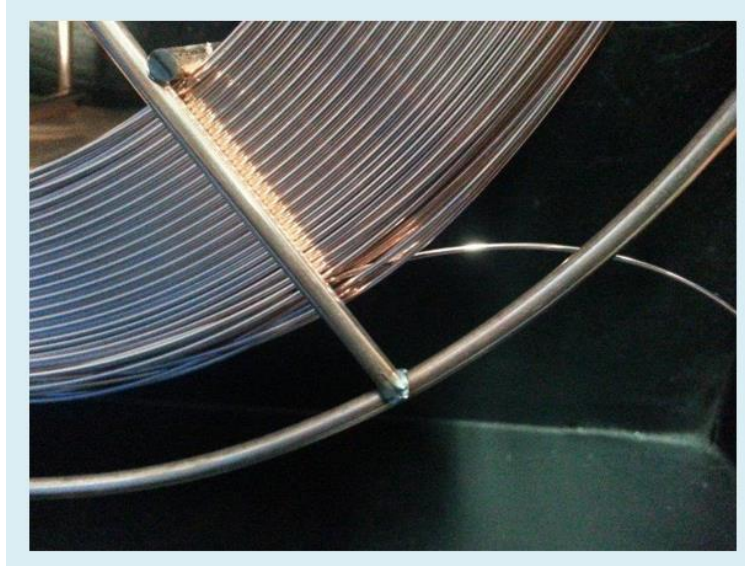




- One of the other winding problems is caused by mixing. If the wire is accidentally missed by welders while feeding to the rollers and an image like the one in the photos is encountered; the wire looks as if it is coming from the bottom after using some amount.



- The wire coming from the bottom after some use after mixing.

**Solutions:**

- Torque screw should be used at the ideal pressure setting.
- In case the wire is missed by welder while feeding to the wire rollers, wire should be discarded without trying the wrap it again.
- Due to the fact that spools are metal, the probability of mixing is much higher in spools that are damaged. Therefore handling and transportation operations should be carried out carefully, in case of mixing of damaged spools, they should be pulled out of place where they are stuck with the help of wire pliers and continued to be used.