

# Setup Procedure for XMT 350 MPa with SS 22D Wire Feeder for Gas Metal Arc Welding

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*A handout containing the highlights of the video titled Setup procedure for XMT 350 MPa with SS 22D Wire Feeder (GMAW)*

## Setting up the wire feeder

1. Get your filler metal. Make sure it is the right size. Place it on the machine.



*CAPTION 1. FOR THE DEMONSTRATION, THE INSTRUCTOR PLACES A 0.035 ER70S 6 FILLER METAL ON THE WIRE FEEDER.*

2. Hold on to the wire as you pull it to avoid unspooling. Clip off bent end.



*CAPTION 2. CUT THE BENT END OF THE WIRE.*

3. Open the wire feeder panel door and insert the wire through the feeder. If the wire feeder is angled down, feed off the top of the wire. If it is angled up, feed the wire from the bottom. Check the drive rolls and make sure you have the correct side facing out. Put the clip for the spool so it doesn't get displaced.



CAPTION 3. THE WIRE IS INSERTED THROUGH THE FEEDER.



CAPTION 4. THE INSTRUCTOR HOLDS ONE OF THE DRIVE ROLLS.



*CAPTION 5. THE WIRE SPOOL IS KEPT IN PLACE BY THE CLIP (PLACED RIGHT IN THE MIDDLE OF THE SPOOL).*

4. Feed the wire coming out from the wire feeder through the MIG gun, and then connect the gun to the wire feeder. Snug it down on the wire feeder and close the panel door.



*CAPTION 6. THE WIRE IS INSERTED THROUGH THE MIG GUN.*

5. Remove the cap from the gas cylinder. Do a quick turn of the valve to release the shielded gas, and then close it again. This releases the gas for a brief moment to clear any dirt that may block the passage way for the gas. Make sure no one is standing within the vicinity where the gas will be released to.
6. Install the flow meter to the gas cylinder in a straight, upright position.



*CAPTION 7. THE INSTRUCTOR SHOWS THE FLOW METER THAT WILL BE INSTALLED ON THE GAS CYLINDER.*

### **Attaching the wire feeder to the power source (XMT 350 MPa)**

1. Plug the 15-pin connector. Line the pins to their sockets, then make sure it is secured on the power source. This cable connects both the wire feeder and the XMT 350 MPa machine.



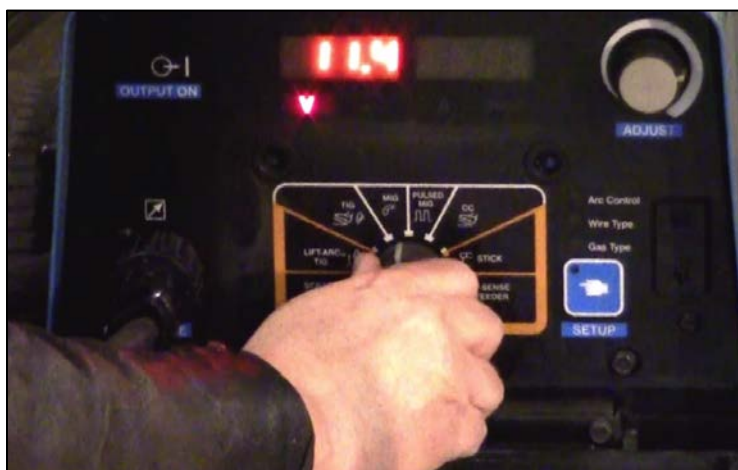
*CAPTION 8. THE INSTRUCTOR PLUGS THE 15-PIN CONNECTOR ONTO THE XMT 350 MPA MACHINE.*

2. Connect the lead from the XMT 350 MPa machine to the MIG gun. In the video, the instructor connected the lead to the plus (positive) terminal.



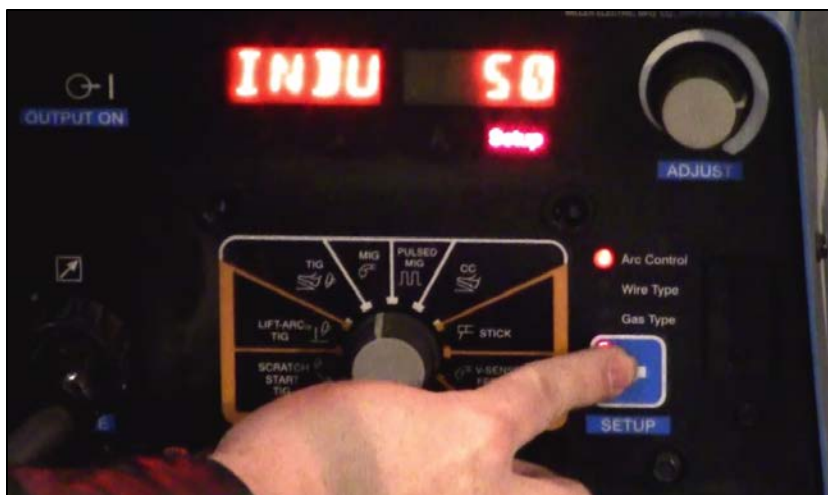
CAPTION 9. THE LEAD CONNECTION SUPPLIES POWER TO THE WIRE FEEDER MACHINE.

3. Turn on the XMT 250 MPa machine and open the panel door.
4. Turn the knob to MIG for Gas Metal Arc Welding.



CAPTION 10. THE INSTRUCTOR TURNS THE KNOB TO MIG.

5. Click on the Setup button to access options for Arc Control, Wire Type, and Gas Type. Once set, click on the Setup button again to let the machine load the selected program settings. Close the door panel.



CAPTION 11. THE INSTRUCTOR SETS THE ARC CONTROL, WIRE TYPE, AND GAS TYPE, BY CLICKING ON THE SETUP BUTTON. A LIGHT WILL TURN ON FOR THE CURRENTLY SELECTED CATEGORY, AND WILL MOVE TO THE NEXT ONE WHENEVER THE SETUP BUTTON IS PUSHED. THE KNOB ON THE UPPER RIGHT CORNER OF THE MACHINE DISPLAYS AND CHANGES THE SETTING FOR THE SELECTED CATEGORY. IN THE PHOTO, THE INSTRUCTOR HAS THE ARC CONTROL CATEGORY SELECTED, AND HAS SET IT TO INDUCTANCE.

6. Hook the workpiece connection to its terminal on the XMT 350 MPa.

### Turning the wire feeder on

1. If the machine for the wire feeder doesn't power up, double check your connection to the XMT 350 MPa machine.
2. Take the small cable wire from the MIG gun and connect it to its terminal on the wire feeder machine.



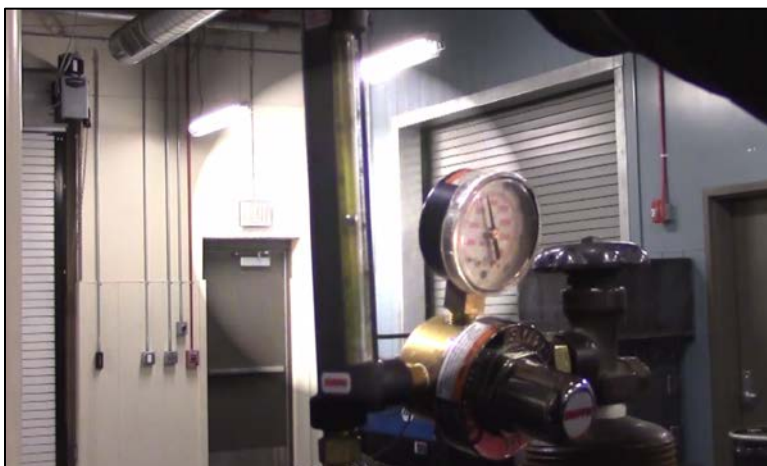
CAPTION 12. THE WIRE IS CONNECTED TO ITS TERMINAL ON THE WIRE FEEDER.

3. Click on the switch for Jog, to feed the wire.



CAPTION 13. THE JOG AND PURGE SWITCHES

4. On the gas cylinder, gently turn on the shielding gas then open it the whole way. Click on Purge and watch the gauge on the installed flow meter. The flow meter ball should be between 25 and 35 cubic feet per hour.



CAPTION 14. THE FLOW METER BALL INSIDE THE GAUGE CONNECTED TO THE GAS CYLINDER.

5. Set the voltage, and wire fed speed.



CAPTION 15. THE INSTRUCTOR SETS THE VOLTAGE AND WIRE SPEED.

## Looking for other learning materials?

The [Gas Metal Arc Welding iTunes U course](#) has videos and other learning materials for you to view. You can [download iTunes for free](#) to view the course and course materials. Closed-captioned videos are available at [T4E's YouTube page](#).

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