

6. Replacement of wear and tear parts

Worn out electrodes can be reground several times up to minimum length of 75 mm when standard nozzles are used.

6.2.2 Electrode changing PMW 350-S90/-S180

At these torch designs the electrode can be changed comfortably from the back without dismantling of the welding nozzle. Therefore the complete electrode clamping module is screwed out from the torch and replaced by a new module already prepared.

Generally the predefined electrode clamping module is screwed until the stop into the torch, however, can be varied for the determination of the best electrode position and therefore the best arc characteristics in a range of ± 1.5 mm, also during welding.

For presetting the electrode in the electrode clamping module the electrode setting gauge is screwed on the clamping module until the limit stop. Then the clamping of the electrode will be solved so that you can position the electrode to the stop screw. Finally the electrode will be fixed again.

Worn out electrodes can be reground several times up to minimum length of 110 mm when standard nozzles are used.

6.3 Centering piece changing

The centring piece and the insulating sleeve form a unit. If these parts show a black coating, which cannot be removed anyhow, they have fissures or are damaged in any other way, they have to be replaced.

After removing the nozzle (see chapt. 6.1) the centering piece and the ceramic sleeve can be taken out and checked.

The assembly will be done according to chap. 6.1, starting from point 4.

- After each inspection or the replacement of wearing parts, humidity and possible impurities of the torch chamber have to be removed with oil and fat free compressed air or, at least, 20 seconds long with the function „check gases”.**