WELDMATIC®

Weldmatic W19 Wirefeeder

Operators Manual

Weldmatic Two Roll Drive Wirefeeder
Model No. W19-3, Iss A
05/07

MADE IN AUSTRALIA

GOLD SHIELD WARRANTY

W19-40 Rev G

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Contents

Read First

The information contained in this manual is set out to enable you to properly maintain your new equipment and ensure that you obtain maximum operating efficiency.

Please ensure that this information is kept in a safe place for ready reference when required at any future time.

When ordering spare parts, please quote the model and serial number of the power source and part number of the item required. All relevant numbers are shown in lists contained in this manual. Failure to supply this information may result in unnecessary delays in supplying the correct parts.

Safety

Before this equipment is put into operation, please read the Safe Practices section of this manual. This will help to avoid possible injury due to misuse or improper welding applications.

Handle on Wirefeeder

Please note that the handle fitted to the W19 Wirefeeder is intended for carrying the equipment by hand only.

DO NOT use this handle for suspending or mounting the wirefeeder in any other manner.

Safe Practices When Using Welding Equipment

These notes are provided in the interests of improving operator safety. They should be considered only as a basic guide to Safe Working Habits. A full list of Standards pertaining to industry is available from the Standards Association of Australia, also various State Electricity Authorities, Departments of Labour and Industry or Mines Department and other Local Health or Safety Inspection Authorities may have additional requirements. Australian Standard AS1674.2 provides a comprehensive guide to safe practices in welding.

Eye Protection

NEVER LOOK AT AN ARC WITHOUT PROTECTION. Wear a helmet with safety goggles or glasses with side shields underneath, with appropriate filter lenses protected by clear cover lens. This is a MUST for welding, cutting, and chipping to protect the eyes from radiant energy and flying metal. Replace the cover lens when broken, pitted, or spattered.

Recommended Shade Filter Lens

Amps	TIG	MMAW	MIG	Pulsed MIG
0-100	10	9	10	12-13
100-150	11	10	10	12-13
150-200	12	10-11	11-12	12-13
200-300	13	11	12-13	12-13
300-400	14	12	13	14
400-500	—	13	14	14
500 +	—	—	14	14

Burn Protection

The welding arc is intense and visibly bright. Its radiation can damage eyes, penetrate light-weight clothing, reflect from light-coloured surfaces, and burn the skin and eyes. Burns resulting from gas-shielded arcs resemble acute sunburn, but can be more severe and painful.

Wear protective clothing - leather or heat resistant gloves, hat, and safety-toe boots. Button shirt collar and pocket flaps, and wear cuffless trousers to avoid entry of sparks and slag.

Avoid oily or greasy clothing. A spark may ignite them. Hot metal such as electrode stubs and work pieces should never be handled without gloves.

Ear plugs should be worn when welding in overhead positions or in a confined space. A hard hat should be worn when others are working overhead.

Flammable hair preparations should not be used by persons intending to weld or cut.

Toxic Fumes

Adequate ventilation with air is essential. Severe discomfort, illness or death can result from fumes, vapours, heat, or oxygen depletion that welding or cutting may produce. **NEVER** ventilate with oxygen.

Lead, cadmium, zinc, mercury, and beryllium bearing and similar materials when welded or cut may produce harmful concentrations of toxic fumes. Adequate local exhaust ventilation must be used, or each person in the area as well as the operator must wear an air-supplied respirator. For beryllium, both must be used.

Metals coated with or containing materials that emit fumes should not be heated unless coating is removed from the work surface, the area is well ventilated, or the operator wears an air-supplied respirator.

Work in a confined space only while it is being ventilated and, if necessary, while wearing air-supplied respirator.

Vapours from chlorinated solvents can be decomposed by the heat of the arc (or flame) to form phosgene, a highly toxic gas, and lung and eye irritating products. The ultra-violet (radiant) energy of the arc can also decompose trichlorethylene and perchlorethylene vapours to form phosgene. Do not weld or cut where solvent vapours can be drawn into the welding or cutting atmosphere or where the radiant energy can penetrate to atmospheres containing even minute amounts of trichlorethylene or percholorethylene.

Fire and Explosion Prevention

Be aware that flying sparks or falling slag can pass through cracks, along pipes, through windows or doors, and through wall or floor openings, out of sight of the operator. Sparks and slag can travel up to 10 metres from the arc.

Keep equipment clean and operable, free of oil, grease, and (in electrical parts) of metallic particles that can cause short circuits.

If combustibles are present in the work area, do NOT weld or cut. Move the work if practicable, to an area free of combustibles. Avoid paint spray rooms, dip tanks, storage areas, ventilators. If the work can not be moved, move combustibles at least 10 metres away out of reach of sparks and heat; or protect against ignition with suitable and snug-fitting fire-resistant covers or shields.

Walls touching combustibles on opposite sides should not be welded on or cut. Walls, ceilings, and floor near work should be protected by heat-resistant covers or shields.

A person acting as Fire Watcher must be standing by with suitable fire extinguishing equipment during and for some time after welding or cutting if;

- Combustibles (including building construction) are within 10 metres.
- Combustibles are further than 10 metres but can be ignited by sparks.
- Openings (concealed or visible) in floors or walls within 10 metres may expose combustibles to sparks.
- Combustibles adjacent to walls, ceilings, roofs, or metal partitions can be ignited by radiant or conducted heat.

After work is done, check that area is free of sparks, glowing embers, and flames.

A tank or drum which has contained combustibles can produce flammable vapours when heated. Such a container must never be welded on or cut, unless it has first been cleaned as described in AS.1674-2. This includes a thorough steam or caustic cleaning (or a solvent or water washing, depending on the combustible's solubility), followed by purging and inerting with nitrogen or carbon dioxide, and using protective equipment as recommended in AS.1674-2. Water-filling just below working level may substitute for inerting.

Hollow castings or containers must be vented before welding or cutting. They can explode. Never weld or cut where the air may contain flammable dust, gas, or liquid vapours.

Shock Prevention

Exposed conductors or other bare metal in the welding circuit, or ungrounded electrically alive equipment can fatally shock a person whose body becomes a conductor. Ensure that the equipment is correctly connected and earthed. If unsure have the equipment installed by a qualified electrician. On mobile or portable equipment, regularly inspect condition of trailing power leads and connecting plugs. Repair or replace damaged leads.

Fully insulated electrode holders should be used. Do not use holders with protruding screws. Fully insulated lock-type connectors should be used to join welding cable lengths.

Terminals and other exposed parts of electrical units should have insulated knobs or covers secured before operation.

If the supply cable is damaged it must be replaced by the manufacturer, their service agent or a similarly qualified person.

1 Introduction

Gas Metal Arc Welding (G.M.A.W.) is an arc welding process where a consumable wire is fed by motor driven feed rolls to a welding gun, and where welding current is supplied from the welding power source. The welding arc is struck between the work piece and the end of the wire, which melts into the weld pool. The arc and the weld pool are both shielded by gas flow from the gun, or in the case of "self shielded" wires, by gases generated by the wire core.

The process is very versatile in that by selection of the correct wire composition, diameter and shielding gas, it can be used for applications ranging from sheet-metal to heavy plate, and metals ranging from carbon steel to aluminium alloys.

The Weldmatic W19 has been designed to be used with consumable wires in the range from 0.6mm to 2.0mm diameter. The smaller wire sizes are used when welding at lower currents, such as sheet-metal applications. Increasing the wire diameter permits higher welding currents to be selected.

A common application of G.M.A.W. is for welding Mild Steel. In this application, a Mild Steel solid consumable wire such as AUSTMIG ES6 is used with a shielding gas of Carbon Dioxide, or Argon mixed with Carbon Dioxide. Alternatively, Flux-cored consumable wires are available in both gas shielded, and 'gasless' self shielding types.

Stainless steel and Aluminium can be welded with G.M.A.W. using the correct consumable wire and shielding gas.

The W19 wirefeeder has been designed to feed a range of hard, soft, and flux-cored wires for the G.M.A.W. process. A compact motor with integral gear box is coupled to a two roll drive assembly forming the basic component of the wirefeeder. The motor is controlled by an electronic speed control which provides speed regulation and compensation for supply voltage variations.

2 Receiving

Check the equipment received against the shipping invoice to make sure the shipment is complete and undamaged. If any damage has occurred in transit, please immediately notify your supplier.

The W19-3 package contains;

- W19 Enclosed Wirefeeder
- (This) Operating Manual W19-40.

If the W19-3 Wirefeeder is included in a package with a Weldmatic MIG welder, it will also containing the following;

- 10m interconnecting leads
- 3.6m Bernard gun and cable assembly
- 10m work lead
- Gas hose
- Argon/mixed gas regulator/flowgauge

3 Specifications

Supply Voltage

32 volts AC, (from welding power source)

Rated Supply Current

5 Amps

Circuit Breaker Rating

5 Amps

Pre/post Gas Range

0 – 2.0 seconds

Burnback Range

0 – 0.07 seconds

Start Speed

Normal or Creep (selectable)

Overall Dimensions

L - 420mm, W - 325mm, H - 360mm

Spool Sizes

5Kg, 15Kg

Wirespeed Range

10 – 144 RPM (1.3 – 19 Metres per min.)

(Fitted with 42mm diameter feed rolls)

Wire Size Range

0.6mm – 1.6mm diameter (solid wire)

0.9mm – 2.0mm diameter (cored wire)

4 Controls

1 On/Off Switch

(Located on the back panel) In the OFF position, this switch interrupts the 30 volts ac supply to the wirefeeder. Set the switch ON to energise the feeder.

2 Wire Speed Control

Sets the speed of the wire feed motor within the range of 10 - 144 RPM, providing 1.3 - 19 metres per minute of welding wire. Rotate control clockwise to increase feed rate.

3 Power On Indicator

Illuminated when the wirefeeder is energised.

4 Pre-gas Control

Sets the time period of gas flow before welding commences, and can be set for 0 - 2 seconds.

5 Post-gas Control

This sets the time period of gas flow after welding ceases, and can be set for 0 - 2 seconds.

6 Inch Button

Press to feed wire without energising the welding power source. The wire will feed at the current Wirespeed setting.

7 Latch Mode Button and Indicator

Press to select and deselect 'Latch' mode. When 'Latch' mode is selected, the operator need close the gun switch momentarily only to commence welding, and again momentarily to end welding. This can help to reduce operator fatigue during long welding runs.

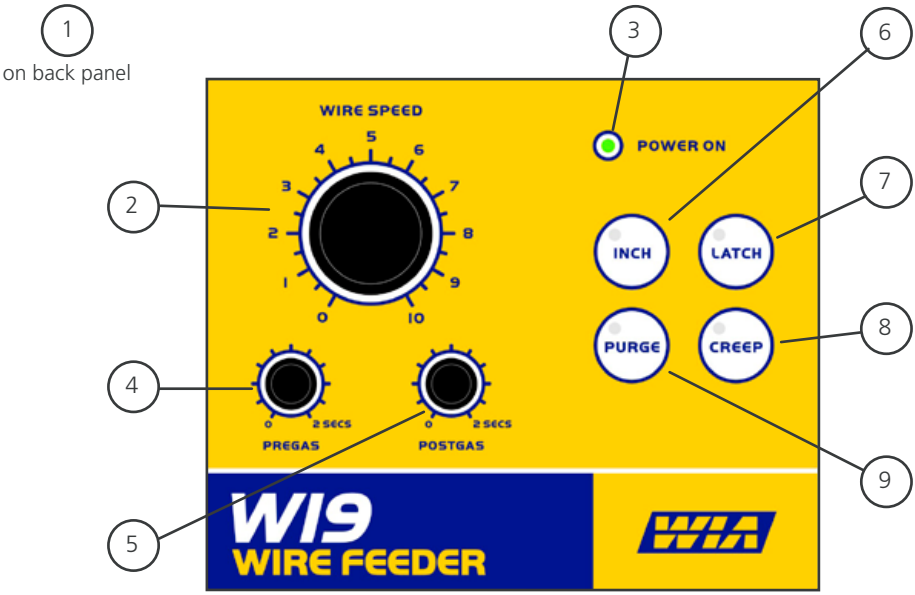

Fig 1 Wire Feeder Controls

8 Creep Mode Button and Indicator

Press to select and deselect 'Creep' mode' for improved arc starting. When 'Creep' mode is selected, the welding wire feeds at reduced speed at the beginning of each weld, progressing to full running speed once the arc is established.

9 Purge Button

Press to open the gas solenoid valve without energising the welding power source.

5 Installation

The Weldmatic W19 wirefeeder is connected to the welding power source via the composite cable interconnecting lead consisting of welding power cable, control cable and gas hose.

Check all connections are firmly made to ensure good electrical contact, and to prevent gas leaks.

Fitting the Gun and Cable Assembly

The standard Weldmatic W19-3 model wirefeeder is intended to accept a BERNARD gun cable equipped with a 'MILLER' power-pin which incorporates connection points for welding current and shielding gas. There is a separate connector for the gun switch.

To attach the gun/cable assembly power-pin to the wirefeeder mechanism, engage the mating parts, then gently ease the power-pin into position taking care not to damage the fitted 'O' rings. Position the gun cable inlet wire guide close, but not in contact with feed rolls.

Tighten the clamp screw firmly to ensure a good electrical connection to the power pin. Welding current passes through this connection.

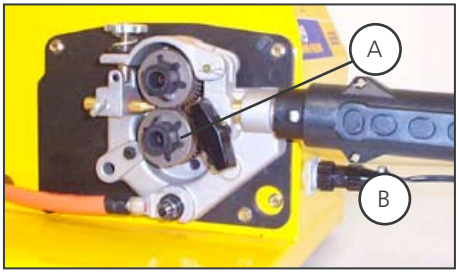

Fig 2 Gun/Cable Assembly

A - Rotate clockwise to clamp gun power pin
B - Gun switch connection

Fitting the Consumable Wire

The quality of the consumable wire greatly affects how reliably a gas metal arc welder will operate. For best results when welding mild steel, we recommend quality WIA AUSTMIG ES6. Dirty, rusty or kinked wire will not feed smoothly through the gun cable and will cause erratic welding. Deposits from the wire will clog the gun cable liner requiring it to be replaced prematurely.

Place the spool of welding wire onto the spool holder. The location pin should mate with a hole provided on the wire spool body. Fit the spool retaining 'R' clip supplied. Check the adjustment of the spool brake, which should be set to prevent over run of the wire spool at the end of a weld, without unduly loading the wirefeed motor. The braking can be adjusted by the Nyloc nut using a 15/16" AF or 24mm socket wrench.

Feeding the Consumable Wire

Release the compression screw and rotate the top roller arm to the open position. The end of the welding wire can now be passed through the inlet guide, over the bottom feed roll, and into the output wire guide tube.

Check that the feed roll groove is correct for the wire in use. The appropriate sizes are stamped on the feed rolls, and refer to the adjacent groove.

The standard W19-3 model is supplied with MR190300 twin 'V' groove 0.9/1.2mm roll top and bottom. 'V' groove rollers are suitable for solid hard wires such as carbon and stainless steel.

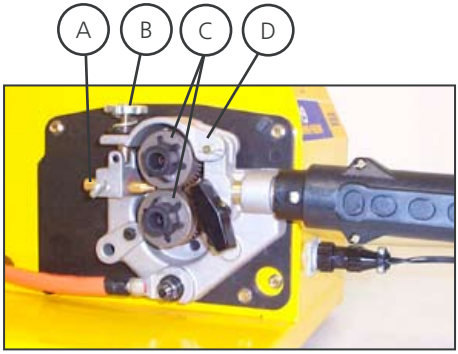

Fig 3 Wire Feed Assembly

A - Inlet guide
B - Compression screw
C - Feed rolls
D - Top roller arm

Check also that the correct size contact tip is fitted at the gun end. Feed roll and tip details are shown in Section 9 of this manual.

Check the alignment of each feed roll relative to the welding wire. If necessary the alignment of the rolls can be adjusted by rotating the roll's central screw using a 3/16" hex key.

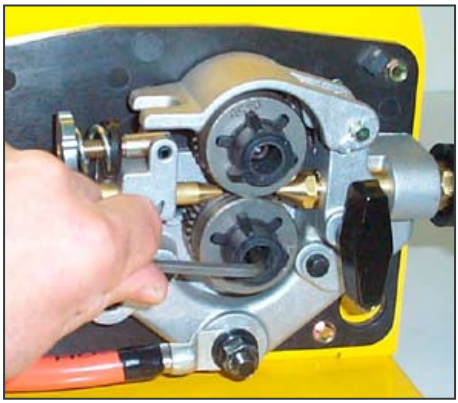

Fig 4 Adjusting Feed Rollers

Return the pressure arm to the closed position and adjust the compression screw to provide sufficient clamping of the feed roll to achieve constant wirefeed. Do not over tighten.

With the machine energised, operate the INCH switch to feed wire through the gun cable.

6 General Maintenance

Before removing the wirefeeder cover, ENSURE that the welding power source is disconnected from the mains power supply or that wirefeeder is disconnected from the welding power source. When the equipment is energised LETHAL VOLTAGES are present on the electrical components enclosed in the power source.

Dust

Care should be taken to prevent excessive build-up of dust and dirt within the welding power source. It is recommended that at regular intervals, according to the prevailing conditions, the equipment covers be removed and any accumulated dust be removed by the use of dry, low pressure compressed air, or a vacuum cleaner.

Wirefeed

In order to obtain the most satisfactory welding results from the G.M.A.W. process, the wirefeed must be smooth and constant. Most causes of erratic wirefeed can be cured by basic maintenance. Check that the:

1 Feed rolls are the correct size and type for the wire in use. Check also that the drive groove is aligned with the wire (refer page 9), and that the groove is not worn;

2 Gun cable liner is clear of dust and swarf build-up. When replacement becomes necessary, fit only the correct liner (see page 17). The build-up of dust can be minimised by regular purging of the liner with dry compressed air. This may be conveniently done each time the wire spool is replaced;

3 Welding tip is free of obstructions such as spatter build-up. Ream out the tip bore with a suitable size oxy-tip cleaner. Replace the welding tip as it becomes worn;

4 Feed roll pressure is not excessive. The pressure should be just sufficient to feed the wire evenly. Excessive pressure will deform the electrode wire and make feeding more difficult;

5 Consumable wire spool holder rotates smoothly and that the braking action is not excessive. The spool should only have sufficient braking to prevent over run when the motor stops. This also may be conveniently checked each time the wire is replenished;

7 Welding wire is straight and free of buckles or 'waviness'. To check, remove 2 or 3 metres of wire from the spool. Clamp one end in a vice or similar, then holding the other end pull the wire out straight. Look down the length of the wire, any buckles will be obvious. Buckled wire is extremely difficult to feed reliably and should be replaced;

8 Welding wire is free of surface rust. Replace if rust is evident.

7 External Trouble Shooting

If the following checks do not identify the fault condition, the equipment should be returned to a WIA Service agent. Phone 1300 300 884 for details of your nearest service agent.

There is no wirefeed when gun switch is closed :

Power On indicator is off

1 Check the power source is connected to a functional mains power outlet. Test outlet using a known working appliance

2 Check the equipment is switched on, ie the ON/OFF switch is in the ON position on both the power source and the wirefeeder.

3 Check the Circuit breaker at the power source (press to reset).

4 Check the interconnecting lead is securely plugged in at the welder and the wirefeeder and that the lead is not damaged.

Power On indicator is on

1 Check that the wirefeed control is set appropriately

2 The gun switch circuit is incomplete.
- Check the gun switch for continuity with an ohm meter when the switch is pressed. Replace if faulty
- Check the gun switch connections make good contact.

There is wirefeed but no output voltage when gun switch is closed:

1 Power source may have overheated.

2 There may be broken wires in the control cables between the power source and the wirefeeder.

Erratic wirefeed

Erratic wirefeed is the MOST LIKELY cause of failure in all Gas Metal Arc Welding. It should therefore be the first point checked when problems occur.

1 Refer to the points in 'Wirefeed' in Section 6

2 Check if the consumable wire is slipping in the feed rolls. Replace the feed roll if it is the incorrect size or is worn

3 Check that gun cable liner is not too short and is fitted correctly. Refer to page 18 for fitting instructions.

Circuit breaker trips repeatedly

1 Open the drive rolls, close the gun switch and check that the motor runs freely without tripping the circuit breaker.

Circuit breaker trips

Return the equipment to a WIA service agent.

Circuit breaker does not trip

1 Refer to the points in 'Wirefeed' in Section 6.

2 Ensure feed roll gear teeth are free of any material which might prevent smooth rotation.

8.1 Circuit Diagrams - W19-3 Wirefeeder

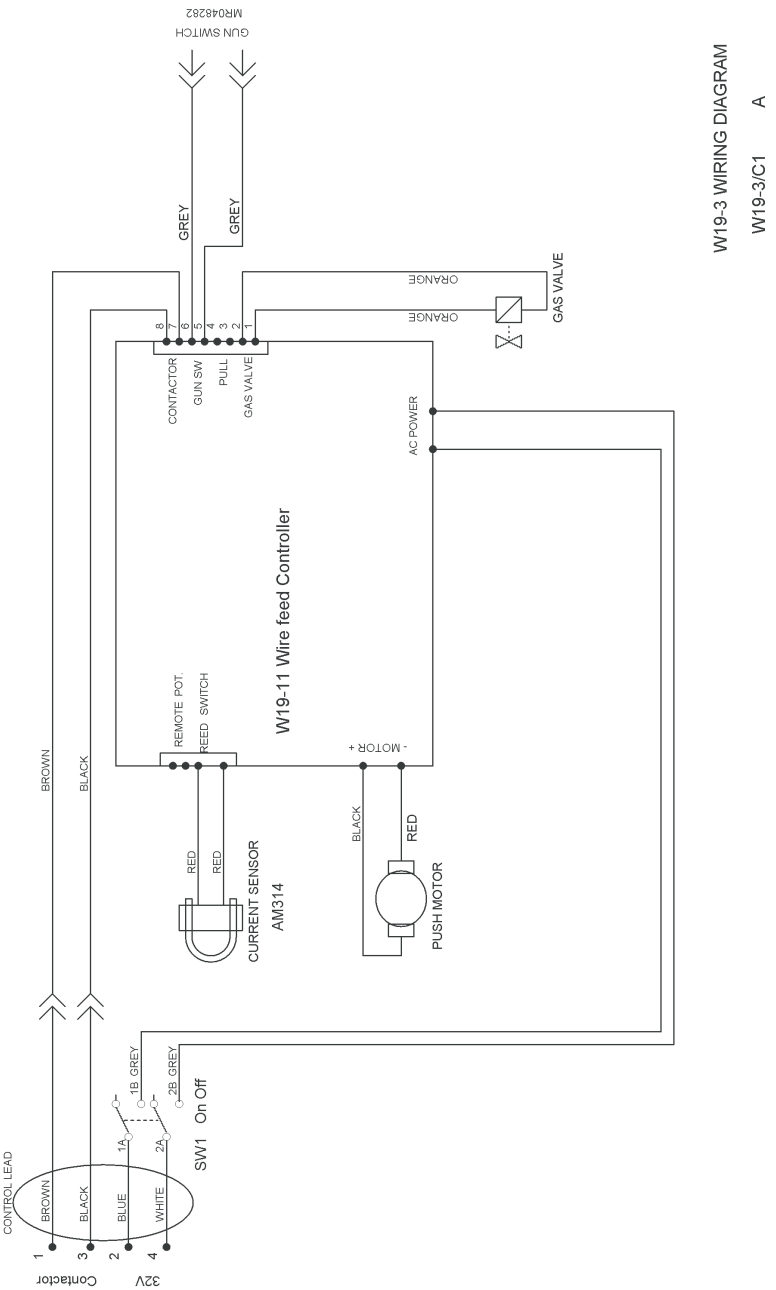

Fig 5 W19-3 Wirefeeder Circuit Diagram

8.2 Wire Feed Controller PCB

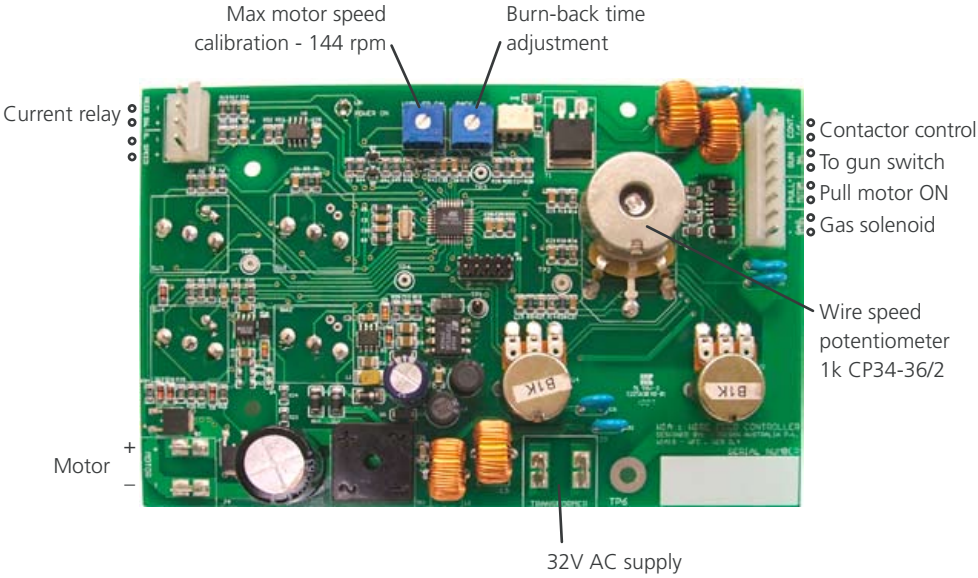

Fig 6 PCB

The W19-11 wire feed control circuit board is a micro-processor based circuit which employs pulse width modulation to control the speed of the wire feed motor.

Inputs to the circuit are:

- AC Supply 32 volts +/- 10%, protected by a 5 amp circuit breaker
- Gun switch contact, normally open;
- Reed switch welding current sensor;
- On-board potentiometer settings for Wirespeed, Pre and Post gas time;
- On-board press buttons for Inch, Purge, Latch mode and Creep start mode.

Outputs from the circuit are:

- Nom. 0 – 24 volts DC motor drive;
- Nom. 30 volts DC gas solenoid valve supply;
- Triac closure to energise 32 volt AC contactor in welding power source;

On-board adjustments are:

- Maximum motor speed calibration, which should be set for 144 rpm;
- Burnback time, set as required.

9.1 Assembly and Parts List - W19-3 Wirefeeder

Fig 7 W19-3 parts

Item #	Part #	Description	Qty
1	HF200-1/15	Nylon Mounting Foot	4
2	MR193388	Motor and 2 Roll Drive Assembly	1
3	AM177	Spool Holder Assembly, complete	1
4	MZ208015	Handle, black	1
5	W19-0PS	Panel Set, complete, yellow, no stickers	1
6	M0029	Potentiometer Knob, Large	1
7	E0016	Potentiometer Knob, Small	2
8	WIN343	Front Label	1
9	MR048282	Gun Switch Socket	1
10	E0023	Switch, On – Off	1
11	W11-11/1	Hose Connector	2
12	CP101-0/18	Gas Valve, 24V dc	1
13	W19-11N	Printed Circuit Board, complete	1
Including	CP34-36/2	Potentiometer, 1k, Wire Wound	1
14	AM314	Current Sensor, complete	1
Optional (not illustrated)			
15	MR164902	Euro Gun Adaptor	
16	BE4995N	Bernard E-Z Feed Adaptor	

9.2 Assembly and Parts List - Wirefeed Assembly

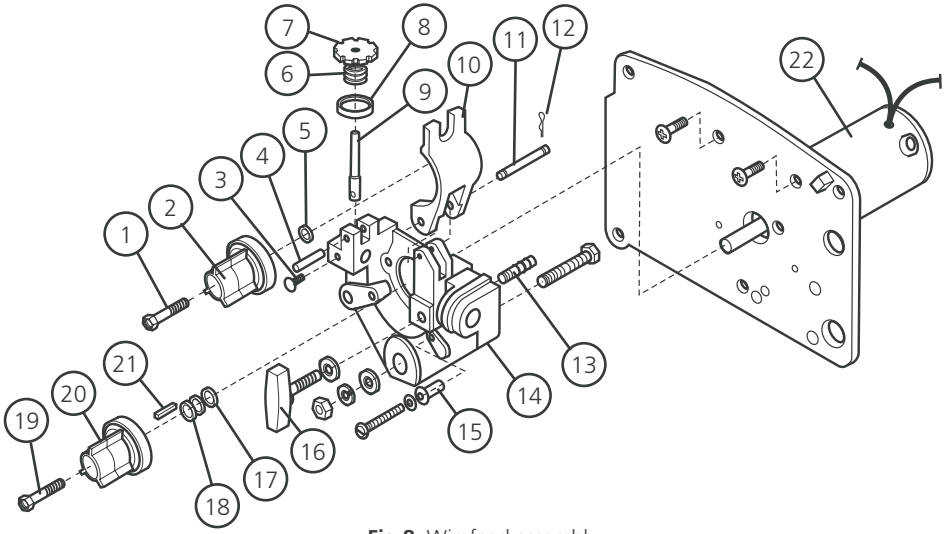

Fig 8 Wirefeed assembly

Item #	Part #	Description	Qty
1	MR602 009	Screw, .250-20 x 1.250 soc hd hex gr 8	1
2	MR172 075	Feed Roll Carrier, w/component 24 pitch	1
3	MR054 263	Thumb Screw, stl .250-20 x .500	1
4	MR010 224	Spring Pin, CS .187 x 1.000	1
5	MR166 072	Spacer, Gear	1
6	MR089 562	Pinned Fastener	1
7	MR085 244	Cupped Washer, stl .328 ID x .812 OD x .125	1
8	MR089 477	Spring, cprsn .770 OD x .105 wire x 1.225	1
9	MR085 243	Tension Adjustment Knob	1
10	MR166 071	Lever, Mtg Pressure Gear	1
11	MR079 634	Hinge Pin	1
12	MR151 828	Cotter Hair Pin, .054 x .750	2
13	MR144 172	Hose Fitting, brs Barbed m 3/16 tbg x .250-20	1
14	MR172 391	Gun/Feeder Adapter Housing	1
15	MR048 449	Washer, shldr nyl .363 OD x .194 ID x .703	1
16	MR124 778	Knob, T 2.000 bar w/.312-18 x 1.000lg	1
17	MR605 308	Ring, rtng ext .500 shaft	1
18	MR079 625	Wave Washer, .500 ID x .750 OD x .015thk	1
19	MR121 271	Screw, .250-20 x .500 soc hd	1
20	MR172 076	Feed Roll Carrier, w/components 24 pitch	1
21	MR092 865	Key, stl	1
22	MR193188	Gear Motor, 24VDC 146RPM	1
Includes	MR136745	Brush & Spring Assembly	2

Note: Some parts may be available by import only.

9.3 Assembly and Parts List - Feed Rolls

Feed Rolls

Wire size	"V" groove for solid wires	"U" groove for soft or cored wires	"V" knurled for hard-shelled cored wires	"U" cogged for extremely soft wire or soft-shelled cored wires (i.e. hard facing types)
0.6mm	MR087131	-	-	-
0.8mm	MR079594	-	-	-
0.9mm	MR079595	MR044749	MR079606	-
0.9 / 1.2mm	MR190300	-	-	-
1.0mm	MR161189	-	-	-
1.2mm	MR079596	MR079599	MR079607	MR083318
1.6mm	MR079598	MR079601	MR079609	MR079614
2.0mm	-	MR079602	MR079610	MR079615

Note: Each feed roll kit includes top and bottom feed rolls, and wire guide.

9.4 Assembly and Parts List - Gun and Cable Assembly

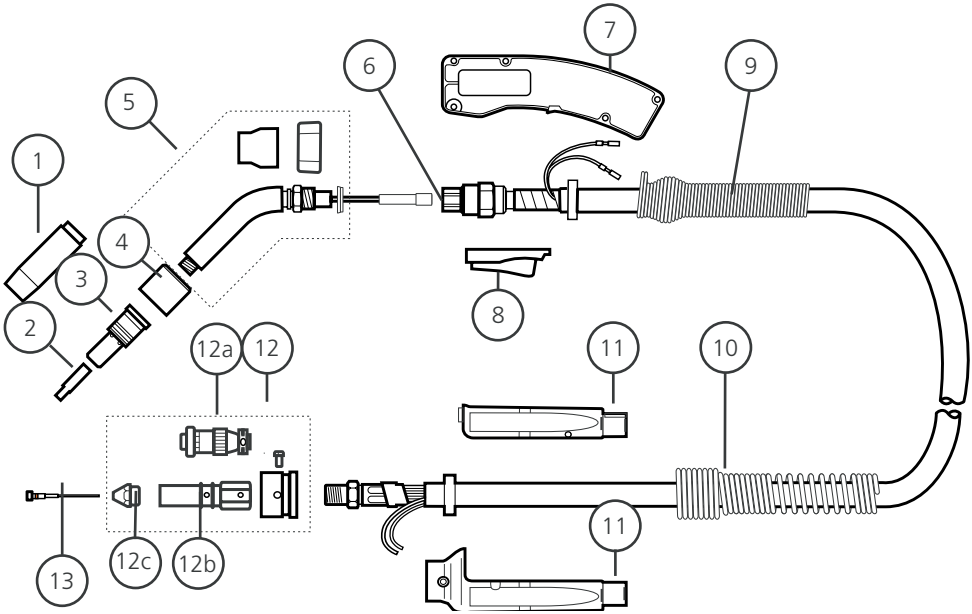

Fig 9 BEQ4012AR7EM (400 amp) Gun and Cable Assembly

Item #	Part #	Description
1	BE4591 BE4491 BE4592 BE4492	Nozzle, copper, straight (supplied) Nozzle, brass, straight Nozzle, copper, tapered Nozzle, brass, tapered
2	see 'Tips'	Contact Tip
3	BE4435	Gas Diffuser (Head)
4	BE4423	Cap
5	BEQT3-45	Body Tube Assembly
6	BE4313B	End Fitting
7	BE1880198	Handle Kit (includes both halves, screws & posts)
8	BE5662	Trigger
9	BE2520042	Handle Spring
10	BE2520041	Strain Relief (metal spring)
11	BE2520069	Rigid Strain Relief
12	BE1199M	Miller Direct Plug Kit
Includes 12a	MR079878	Plug, 4 Pin Housing & Pins
12b	MR079974	"O" ring
12c	BE4477 BE4474	Power Pin Tip, 0.6-1.2mm, or Power Pin Tip, 1.3-3.0mm (not incl. in BE1199M)
13	BE43115 BE43115X BE44215	Steel Liner 0.9-1.2mm Nylon Liner 0.9-1.2mm Steel Liner 1.6mm

To replace liner: Disconnect gun/cable assembly at the Euro adaptor. Remove nozzle (1) and head (3). Withdraw old liner from the wirefeeder end. Insert new liner and refit gun/cable assembly to the wirefeeder.

At the gun end, compress the liner within the gun cable, then cut it **one contact tip length past the end of the body tube** (5). Refit head, tip and nozzle.

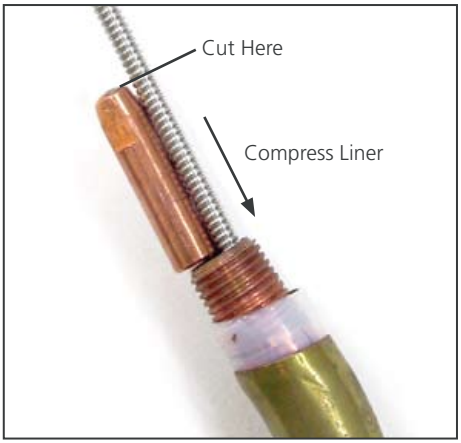

Fig 10 Replacing the gun cable liner

Tips

Wire diameter	Part number
0.6mm	BE7497
0.8mm	BE7488
0.9mm	BE7489
1.0mm	BE7496
1.2mm	BE7490
1.3mm	BE7498
1.6mm	BE7491
2.0mm	BE7492
2.4mm	BE7493
2.8mm	BE7494
3.2mm	BE7495

9.5 Assembly and Parts List - Composite Cable Interconnecting Lead Kit

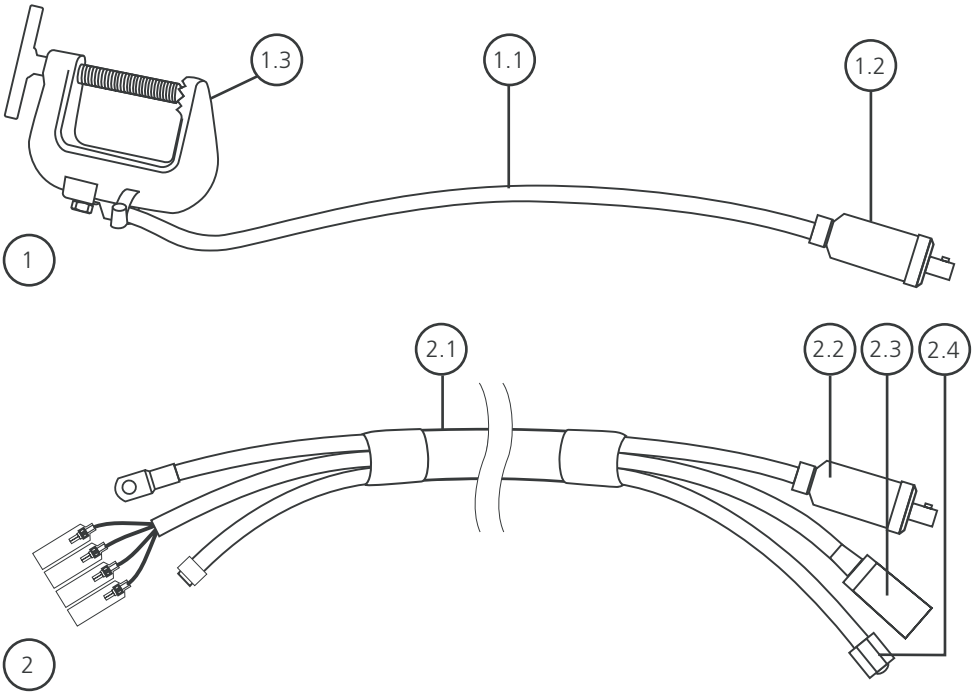

Fig 11 AM322-0/10 Interconnecting Lead Kit

Item #	Part #	Description	Qty
1	AM322-2/10	Work Lead	1
Includes 1.1	CABW50	Welding Cable 50mm^2	10m
1.2	WGEC4	Plug, Dinse	1
1.3	WGAA2	Work Clamp	1
2	AM320-1/10	10m Composite Cable Interconnecting Lead	1
Includes 2.1	CABW50COMP	Composite Cable with 50mm^2 Weld Flex	10m
2.2	WGEC4	Plug, Dinse	1
2.3	AM112-3/1	Control Plug, 4 Pin, male	1
2.4	WGAC23	5/8" UNF Gas Nut & Tail	1

10 Warranty Information

WIA Gold Shield 3 Year Warranty

Effective 1st March 2005

At WIA, we are serious about product quality.

Every new Weldmatic and Weldarc machine comes fully backed by the WIA 'Gold Shield 3 Year Warranty', covering parts and workmanship, so you can be guaranteed you're buying reliability and performance.

This limited warranty supersedes all previous WIA (Welding Industries of Australia) warranties and is exclusive with no other guarantees or warranties expressed or implied.

Limited Warranty

Subject to the terms and conditions below, WIA warrants to its original retail purchaser that new WIA equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by WIA.

THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, WIA will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. WIA must be notified in writing within thirty (30) days of such defect or failure, at which time WIA will provide instructions on the warranty claim procedures to be followed.

WIA shall honour warranty claims on warranted equipment in the event of such a failure within the warranty time periods. All warranty time periods start on the date that the equipment was delivered to the original retail purchaser, or 18 months after the equipment date of manufacture, whichever is the earlier.

Parts and workmanship on Weldarc and Weldmatic equipment are covered for a period of 3 years (except for gas regulator, gun cable and consumables listed below.)

Items replaced under original warranty are warranted for the remainder of the original equipment warranty, or for a period of ninety (90) days, whichever is the greater.

Gas regulator and gun/cable assembly are warranted for 90 days.

WIA's Limited Warranty shall not apply to:

1 Consumable components; such as contact tips, cutting nozzles, contactors, brushes, relays or parts that fail due to normal wear.

2 Equipment that has been modified by any party other than WIA, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

WIA PRODUCTS ARE INTENDED FOR PURCHASE AND USE BY COMMERCIAL / INDUSTRIAL USERS AND PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

In the event of a warranty claim covered by this warranty, the exclusive remedies shall be, at WIA's option: (1) repair; or (2) replacement; or, where authorised in writing by WIA in appropriate cases, (3) the reasonable cost of repair or replacement by an authorised WIA service agent; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at customer's risk and expense.

WIA's option of repair or replacement will be F. O. B. Factory at Melrose Park, Adelaide, or F. O. B. at a WIA authorised service facility as determined by WIA. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

TO THE EXTENT PERMITTED BY LAW, THE REMEDIES PROVIDED HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES. IN NO EVENT SHALL WIA BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT), WHETHER BASED ON CONTRACT, TORT OR ANY OTHER LEGAL THEORY.

ANY EXPRESS WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTEE OR REPRESENTATION AS TO PERFORMANCE, AND ANY REMEDY FOR BREACH OF CONTRACT TORT OR ANY OTHER

LEGAL THEORY WHICH, BUT FOR THIS PROVISION, MIGHT ARISE BY IMPLICATION, OPERATION OF LAW, CUSTOM OF TRADE OR COURSE OF DEALING, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE, WITH RESPECT TO ANY AND ALL EQUIPMENT FURNISHED BY WIA IS EXCLUDED AND DISCLAIMED BY WIA.