

GMAW Maintenance Schedule

This is a starting list; you may want to add or remove items by inserting and deleting rows on this worksheet.

		REQUIRED DAILY			
General Machine					
Clean outside of machine and cables	Wipe down outside of machine with degreaser and entire length of cable.				
Inside Case	Blow out inside with air hose then wipe all surfaces with degreaser.				
Gun and Lead					
Clean Nozzle	Remove gas nozzle from gun and clean out all spatter. File outside rim clean and square.				
Tip	Remove tip and file to square. Use tip cleaner to clean out orifice.				
Tip Size	Ensure the tip size is the same as the wire size on the roll.				
Work Lead	Ensure a proper connection, no bare wires. Make sure it will clamp tight.				
Wire and Rollers					
Wire roll	Check to be sure that there is enough wire on the roll and that it is secure.				
Rollers	Disengage the tension screw and lift up the top roller. Look for misalignment and dust build-up. Relock tension screw.				
Tension screw	Check for proper tension on the screw. With machine on, press a gloved hand against the wire coming out of the gun and depress the trigger. Wire should move you hand without pressure from you, but you should be able to stop the wire by pressing back slightly.				
Gas Cylinder					
Valve	Check that valve is closed tightly. Open all the way, no pressure should show on the line side of regulator. Check valve to regulator connection with soap and water for leaks.				
Regulator	Pressure should be set at no more than 25 cfm. Depress trigger to make sure gas comes out.				
SHUT DOWN		Date last completed			
Gas Cylinder					
Turn off cylinder valve all the way. Relieve pressure adjustment knob/screw.					
Leads					
Wrap first the work lead then the gun lead in large loops around the front handle or side saddle of the machine. Make sure there are no kinks.					
Weld grate and table					
Check weld grate for stray weld spatter or marks, grind off until smooth and flat. Sweep the main table surface you were working on and then the floor.					