

HOBART®

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2017-10

Processes

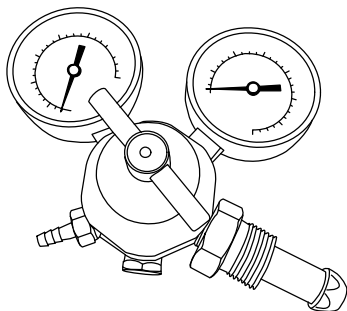


GMAW

Gas Regulation

Flow Gauge Regulator

Inert Gas



OWNER'S MANUAL

File: Accessory



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SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING

MIG REG 2017-10

-  Protect yourself and others from injury — read, follow, and save these important safety precautions and operating instructions.

1-1. Symbol Usage

-  **DANGER!** – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

-  Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

NOTICE – Indicates statements not related to personal injury.


 Indicates special instructions.




This group of symbols means Warning! Watch Out! ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult


symbols and related instructions below for necessary actions to avoid the hazards.

1-2. Arc Welding Hazards

-  The symbols shown in this section are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-5. Read and follow all Safety Standards.

-  Only qualified persons should install, operate, maintain, and repair this equipment. A qualified person is defined as one who, by possession of a recognized degree, certificate, or professional standing, or who by extensive knowledge, training and experience, has successfully demonstrated his ability to solve or resolve problems relating to the subject matter, the work, or the project and has received safety training to recognize and avoid the hazards involved.

-  During operation, keep everybody, especially children, away.

-  Do not use this equipment unless you are trained in its proper use or are under competent supervision. Follow the procedures described in this booklet every time you use the equipment. Failure to follow these instructions can cause fire, explosion, asphyxiation, property damage, or personal injury. This equipment must be used in accordance with all Federal, State, and local regulations as well as DOT (Department of Transportation) and CGA (Compressed Gas Association) regulations. Contact your gas supplier for more information on the proper use of compressed gases.



READ INSTRUCTIONS.

- Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing equipment. Read the safety information at the beginning of the manual and in each section.
- Use only genuine replacement parts from the manufacturer.
- Perform installation, maintenance, and service according to the Owner's Manuals, industry standards, and national, state, and local codes.



HOT PARTS can burn.

- Do not touch hot parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.



FUMES AND GASES can be hazardous.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Keep your head out of the fumes. Do not breathe the fumes.
- Ventilate the work area and/or use local forced ventilation at the arc to remove welding fumes and gases. The recommended way to determine adequate ventilation is to sample for the composition and quantity of fumes and gases to which personnel are exposed.
- If ventilation is poor, wear an approved air-supplied respirator.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watch-person nearby. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
- Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.



BUILDUP OF GAS can injure or kill.

- Shut off compressed gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes from arc rays and sparks when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.
- Wear body protection made from durable, flame-resistant material (leather, heavy cotton, wool). Body protection includes oil-free clothing such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.



FLYING METAL or DIRT can injure eyes.

- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.



CYLINDERS can explode if damaged.

Compressed gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding or cutting process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.
- Never weld on a pressurized cylinder – explosion will result.
- Use only correct compressed gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve. Do not stand in front of or behind the regulator when opening the valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Use the proper equipment, correct procedures, and sufficient number of persons to lift, move, and transport cylinders.
- Read and follow instructions on compressed gas cylinders, associated equipment, and Compressed Gas Association (CGA) publication P-1 listed in Safety Standards.










WELDING can cause fire or explosion.

Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.



- Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Do not weld where flying sparks can strike flammable material.
- Protect yourself and others from flying sparks and hot metal.
- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- Do not cut or weld on tire rims or wheels. Tires can explode if heated. Repaired rims and wheels can fail. See OSHA 29 CFR 1910.177 listed in Safety Standards.
- Do not weld on containers that have held combustibles, or on closed containers such as tanks, drums, or pipes unless they are properly prepared according to AWS F4.1 and AWS A6.0 (see Safety Standards).
- Watch for fire, and keep a fire extinguisher nearby.
- Do not weld where the atmosphere can contain flammable dust, gas, or liquid vapors (such as gasoline).
- Connect work cable to the work as close to the welding area as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock, sparks, and fire hazards.
- Do not use welder to thaw frozen pipes.
- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
- Wear body protection made from durable, flame-resistant material (leather, heavy cotton, wool). Body protection includes oil-free clothing such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.
- Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding.
- After completion of work, inspect area to ensure it is free of sparks, glowing embers, and flames.
- Use only correct fuses or circuit breakers. Do not oversize or bypass them.
- Follow requirements in OSHA 1910.252 (a) (2) (iv) and NFPA 51B for hot work and have a fire watcher and extinguisher nearby.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.

1-3. Additional Safety Precautions



-  Use regulator only with inert welding gases. Do not use this regulator with gases other than those for which it is intended. Contact the gas supplier and consult the SDS sheet to be sure the compressed gas is compatible with regulator components. Do not interchange regulators or other equipment unless the gases that were used are compatible.
-  Inspect all equipment before use. Do not use damaged, defective, or improperly adjusted equipment. Make sure levers and valves work properly, threads on equipment are clean (no grease or oil) and not deformed, gauges are intact and easy to read, regulator is clean and free of oil or dirt, and fittings are properly sized for the cylinder. Make sure hoses are clean (no grease or oil) and ferrules are properly installed so the fitting does not slip inside the hose. Be sure all connections are tight.
-  Check compressed gas system for leaks with an approved leak detection solution or leak detector.
-  Do not lubricate regulator, gauges, or compressed gas fittings. Stop using the regulator immediately and contact the gas supplier if oil or grease is found in these components. Take regulator and other components to a qualified repair station for cleaning. Do not use sealing tape on cylinder connections.
-  Do not use adapters on cylinder connections. Use a regulator with the correct compressed gas fitting.
-  Do not open the cylinder valve more than necessary to clear the valve port. Opening the valve too much can cause the cylinder to tip over due to the force of the escaping gas. Never stand in front of the valve port.
-  Do not use regulator as a shut-off device. Close cylinder valve when system is not in use.

1-4. California Proposition 65 Warnings

-  Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)
-  This product contains chemicals, including lead, known to the state of California to cause cancer, birth defects, or other reproductive harm. *Wash hands after use.*

1-5. Principal Safety Standards

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, is available as a free download from the American Welding Society at <http://www.aws.org> or purchased from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Safe Practices for Welding and Cutting Containers that have Held Combustibles, American Welding Society Standard AWS A6.0, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 14501 George Carter Way, Suite 103, Chantilly, VA 20151 (phone: 703-788-2700, website: www.cganet.com).

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 5060 Spectrum Way, Suite 100, Mississauga, Ontario, Canada L4W 5N5 (phone: 800-463-6727, website: www.csagroup.org).

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 25 West 43rd Street, New York, NY 10036 (phone: 212-642-4900, website: www.ansi.org).

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B, from National Fire Protection Association, Quincy, MA 02169 (phone: 1-800-344-3555, website: www.nfpa.org).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910.177 Subpart N, Part 1910 Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 (phone: 1-866-512-1800) (there are 10 OSHA Regional Offices—phone for Region 5, Chicago, is 312-353-2220, website: www.osha.gov).

Applications Manual for the Revised NIOSH Lifting Equation, The National Institute for Occupational Safety and Health (NIOSH), 1600 Clifton Rd, Atlanta, GA 30329-4027 (phone: 1-800-232-4636, website: www.cdc.gov/NIOSH).

SECTION 2 – INTRODUCTION



- ⚠** Inspect all equipment before use. Do not use damaged, defective, or improperly adjusted welding equipment. Make sure levers and valves work properly, threads on equipment are clean (no grease or oil) and not deformed, gauges are intact and easy to read, regulator is clean and free of oil or dirt, and fittings are properly sized for the cylinder. Make sure hoses are clean (no grease or oil) and ferrules are properly installed so the fitting does not slip inside the hose. Be sure all connections are tight and there are no leaks in the system.

This booklet offers basic information regarding inert gas pressure regulators. Given reasonable care, the regulators will provide trouble-free use for many years.

SECTION 3 – PRE-INSTALLATION PROCEDURES: REGULATORS



- ⚠** Do not use this equipment unless you are trained in its proper use or are under competent supervision. Follow the procedures described in this booklet every time you use the equipment. Failure to follow these instructions may cause fire, explosion, asphyxiation, property damage, or personal injury. This equipment must be used in accordance with all Federal, State, and local regulations as well as DOT (Department of Transportation) and CGA (Compressed Gas Association) regulations. Contact your gas supplier for more information on the proper use of compressed gases.
- ⚠** Regulators must be used only with the gases and pressures for which they are designed. Consult a safety data sheet (SDS) for gases used to determine compatibility of gases and regulator components (available from your gas supplier).
1. Check the designed pressure rating of the regulator (labeled or stamped on the regulator body) and the scale range of the pressure gauges. The pressure ratings must be adequate for the cylinder pressure and the operating pressure.
 2. Verify the materials used in the construction of the regulator are compatible with the intended gas service.
 3. Verify the regulator inlet connection is compatible with the cylinder outlet valve connections.
 4. Install a check valve purge assembly and pressure relief devices in the operating system as required.
 5. Do not interchange pressure regulators or other equipment that was used with different gases unless you are sure the gases are compatible.
 6. Do not use regulator equipment for oxygen service that has been in other gas service.
 7. If the regulator has an open port, that port must be assembled for its intended use.

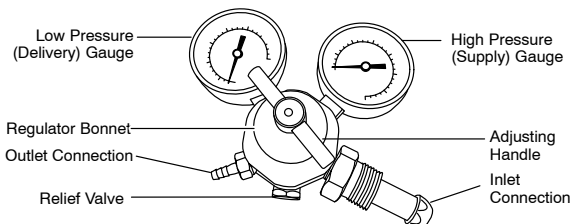
8. If gauges are used with the regulator and the regulator is UL listed, the following requirements apply:
 - A. Gauges over 1,000 psi (6895 kPa) should be UL listed per UL standard 404.
 - B. Gauges under 1,000 psi (6895 kPa) should be UL recognized per UL standard 252.
9. Do not use pressure regulators in ambient temperatures below -40°F (-40°C) or above 140°F (60°C).

SECTION 4 – INSTALLATION AND OPERATION



- ⚠ Inspect all equipment before use. Do not use damaged, defective, or improperly adjusted welding and cutting equipment. Make sure levers and valves work properly, threads on equipment are clean (no grease or oil) and not deformed, gauges are intact and easy to read, regulator is clean and free of oil or dirt, and fittings are properly sized for the cylinder. Make sure hoses are clean (no grease or oil). Be sure all connections are tight and there are no leaks in the system.**

Inert Gas Regulator



1. Attach the regulator to the cylinder valve and tighten firmly with a wrench.
2. Connect the operating system to the regulator outlet.
3. Turn the regulator adjusting handle counterclockwise until the adjusting handle turns freely (no spring load). This closes the regulator valve.
4. Close the regulator outlet valve (if used).

- ⚠ Do not stand in front of or behind the regulator when opening the cylinder valve. Never open a cylinder valve suddenly as this can damage a regulator.**

5. Slowly open the cylinder valve until the full cylinder pressure is indicated on the high pressure (supply) regulator gauge. The high pressure gauge should read the cylinder pressure. The low pressure (delivery) gauge should read zero (0).
6. With the valve at the outlet of the regulator closed and the adjusting handle tension released, leave pressure on the inlet for 5–10 minutes. The low pressure (delivery) gauge should not indicate any pressure increase. A pressure increase indicates gas leakage past the regulator valve seat.

- ⚠ Do not use the regulator if gas leakage occurs.**

7. Turn the adjusting handle clockwise to set a normal delivery pressure.

- ⚠ Do not use the regulator if you are unable to attain a desired pressure or the pressure continues to rise above the set point.**
- 8. If the unit functioned properly in the previous step, close the cylinder valve and note the readings of both the high pressure (supply) and low pressure (delivery) pressure gauges. After 5–10 minutes, a drop in the reading of either gauge indicates a leak in the system.
- ⚠ Use an approved oil-free leak detection fluid to locate possible leaks at the inlet, any threaded port, through the regulator diaphragm or through the outlet valve. PTFE tape is an acceptable pipe thread sealant. If other sealing materials are preferred, those materials must be compatible with the gas that is being used in the system.**
- 9. If a leak is indicated, relieve all pressures from the regulator and retighten the connections.
- ⚠ Do not use the regulator if a leak continues or is found at the diaphragm or outlet valve.**
- 10. If the system is determined to be leak free, turn the adjusting handle clockwise until the desired pressure setting is indicated on the low pressure (delivery) pressure gauge.
- 11. Open the outlet valve to purge the system. Adjust the regulator adjusting handle to obtain the desired pressure setting at the flow conditions.

NOTICE – A regulator is not intended to be used as a shut-off device. Close the cylinder valve when system is not in use. Install a pressure relief device downstream of the regulator or outlet valve to protect the process equipment if operating pressures rise.

SECTION 5 – SYSTEM SHUTDOWN



1. Close the cylinder valve.
2. Release all gas from the regulator and/or system so that both gauges read zero (0). Before venting the gas to the atmosphere, render it harmless by employing a suitable disposable system.
3. Turn the adjusting handle counterclockwise until all spring load is released.
4. Close the outlet valve (if used).
5. Disconnect the regulator.
6. If the regulator is to remain out of service, protect the inlet and outlet fittings from dirt, contamination or mechanical damage.
7. Replace the cylinder valve cap.

SECTION 6 – PERFORMANCE CHARACTERISTICS



The following information is intended to help you determine if the regulator is performing properly.

A. Indications Of Proper Performance

- The delivery pressure drops when flow is started and/or increased.
- The delivery pressure rises when flow is stopped. This difference in delivery pressure between flow and no flow condition is called “lockup.”
- The delivery pressure of a single stage regulator increases as the supply/cylinder pressure decays (as the cylinder is emptied). This will not happen with a 2-stage regulator until the supply pressure drops below the first-stage set pressure of 250 psig (1724 kPa). The exception is 250 psig (1724 kPa) delivery range regulators, which are set at 400 psig (2758 kPa).

B. Indications Of Improper Performance

- The delivery pressure continues to rise when flow is stopped (lock-up) without a change in adjusting-handle position. This condition indicates valve seat wear or contamination with foreign materials (which allows gas to leak to the delivery side). This condition is referred to as “creep.” If this condition exists, remove regulator from service and have it repaired or replaced.
- A significant drop in delivery pressure during normal flow conditions indicates internal blockage. Check inlet connection filters for contamination. If this condition exists, remove regulator from service and have it repaired or replaced.

SECTION 7 – CARE AND MAINTENANCE



⚠ Periodic inspection and maintenance of the pressure regulator is essential for continued safe and satisfactory operation. The frequency of servicing will depend on duty cycle and type of gas.


Inspect regulator monthly. If the regulator is used under normal, non-corrosive conditions, perform annual maintenance (such as removing deposits left by gas and replacing any worn or damaged parts). Inspect and maintain the regulator more frequently if the system is subject to a high duty cycle or is used in corrosive conditions. Regulators requiring service repair should be sent to a Factory Authorized Service Agent.

A. Inspection


Follow these steps to inspect regulator:

1. Inspect gauges to assure they read zero (0) when all pressure is released from the system.

2. With adjusting handle turned counterclockwise (to release all spring tension), slowly open cylinder valve. The high pressure (supply) gauge should read cylinder pressure and the low pressure (delivery) gauge should read zero (0).
3. With valve at outlet of regulator closed and adjusting handle tension released, leave pressure on inlet for 5–10 minutes. The low pressure (delivery) pressure gauge should not indicate any pressure increase. A pressure increase indicates leakage past the regulator valve seat.

 **If leakage is indicated, remove regulator from service and have it repaired or replaced.**

4. Turn adjusting handle clockwise to set a nominal delivery pressure. If you are unable to attain desired pressure setting or if delivery pressure continues to rise above set point, remove regulator from service and have it repaired or replaced.
5. If unit functions properly in the previous step, close cylinder valve and note the readings of both the high pressure (supply) and low pressure (delivery) pressure gauges. After 5–10 minutes, a drop in reading of either gauge indicates a leak in the system.

 **Use an approved oil-free leak detection fluid to locate possible leaks at the inlet, any threaded port, through the regulator diaphragm, or through the outlet valve. PTFE tape is an acceptable pipe thread sealant. If other sealing materials are preferred, those materials must be compatible with the gas that is being used in the system.**

6. If leak is at the inlet or at a threaded port, relieve all pressure from the regulator and then tighten. If leak continues or is found at the diaphragm and outlet valve, remove regulator from service and have it repaired or replaced.

B. Storage

1. Regulators taken out of service for extended periods should receive proper care to extend their service life.
2. Regulators should be wiped clean with a clean, dry, lint-free cloth and sealed in a plastic bag for storage in a dry area at room temperature.

C. Repair Service

Any regulator in need of service should be returned to a Factory Authorized Service Agent for evaluation.

SECTION 8 – WARRANTY

Effective January 1, 2017

Warranty applies to all Hobart welding equipment with a serial number preface of MH or newer.

This limited warranty supersedes all previous Hobart warranties and is exclusive with no other guarantees or warranties expressed or implied. Hobart products are serviced by Hobart or Miller Authorized Service Agencies.

LIMITED WARRANTY – Subject to the terms and conditions below, Hobart Brothers Co. and Miller Electric Mfg. Co., Appleton, Wisconsin, warrants to its original retail purchaser that new Hobart 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 Hobart. 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, Hobart/Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Hobart/Miller must be notified in writing within thirty (30) days of such defect or failure, at which time Hobart/Miller will provide instructions on the warranty claim procedures to be followed. If notification is submitted as an online warranty claim, the claim must include a detailed description of the fault and the troubleshooting steps taken to identify failed components and the cause of their failure.

Hobart/Miller shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the delivery date of the equipment to the original retail purchaser, and not to exceed twelve months after the equipment is shipped to a North American distributor or twelve months after the equipment is shipped to an International distributor.

1 Year — Parts and Labor Unless Specified
(90 days for industrial use)

- * Flowgauge and Flowmeter Regulators (No Labor)
- * Regulators

Hobart's warranty shall not apply to:

Equipment that has been modified by any party other than Hobart/Miller, 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.

HOBBART 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 Hobart's/Miller's option: (1) repair; or (2) replacement; or, where authorized in writing by Hobart/Miller in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized Hobart/Miller service station; 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. Hobart's/Miller's option of repair or replacement will be F.O.B., Factory at Appleton, Wisconsin, or F.O.B. at a Hobart/Miller authorized service facility as determined by Hobart/Miller. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

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Visit our website at
www.HobartWelders.com