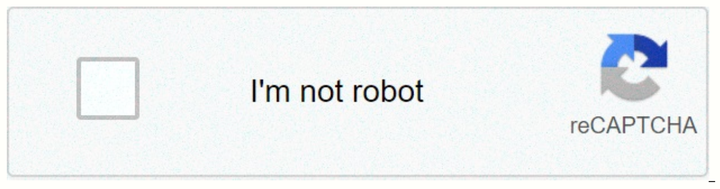

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Eastwood tig 200 digital aluminum settings

Published: February 6, 2018 By: MattM Today we are going to give a crash course in TIG welding aluminum and hopefully we can help you collect some tips along the way. TIG aluminum welding is something many beginners have trouble getting started with. We saw welders returned because the user thought it was not working properly when it was an incorrect setting or a technical problem. I'm going to try to show you the right technique when you're welding aluminum and some tips for beginners. At the front of the Eastwood TIG 200 AC/DC is a power amperage setting. This knob is adjusted where when it is being welded with the switch on the trigger. Otherwise, you will use the pedal to vary your amperage. Underneath the amperage knob we have our prefluid setting. The preflud setting is the amount of time that the welder will turn off the protective gas before it starts an arc. This means that when I hit that pedal there will be a delay before the arc begins. Next to that knob is what we call our slack effect setting and I'm going to talk about that in depth a little bit more, but that's only used for the AC side when you're welding aluminum or any other metal that requires air conditioning. The last knob of the TIG 200 is our pole flow. This setting allows you to determine the amount of time that the welder continues to flow protective gas over the weld. This will prevent the weld from being shocked by impurities in the air, as it is switching from a liquid to a solid state. Today we are going to weld on the AC side, so let's flip the AC/DC switch to the AC configuration. It is useful to learn what all common types of aluminum are and how they react when welding. When welding in old or used aluminum, it will be dirty and could be a lower quality aluminum depending on usage and age. The AC clearing or balancing effect is one of the most important adjustments when welding aluminum. When you are welding aluminum in AC your soldering iron is bouncing between the positive electrode and the negative electrode. If you think of it as a sine wave when it's going up and down your soldering iron, it's alternating current that goes from positive electrode negative electrode. So why is AC important? Let's show you some aluminum samples. Aluminum is always in a corrosion state on the surface and this creates an oxide coating that will contaminate the weld. The positive electrode will clean the metal and burn that corrosion or rust that is on the surface. When you're welding you'll see the bow dance around while it's cleaning until the metal is clean and the bow stabilizes. The alternation between positive and negative electrode happens quickly and all kinds seems to happen in a process as it is welded. When you go to the negative side of the electrode you are putting the heat in the part so that you can weld. you see in this sample piece there is a white halo around the weld. That halo is our cleaning area and must come out around the actual weld seem to be kept from any contaminant that enters the weld puddle. The Compensation Effect or AC Balance control ranges from six positive to six negative. I've discovered that the sweet spot for most jobs are just about three negatives. The more negative you go with the whitening effect, the more penetration you get, but the smaller your cleaning area. This means that you need to have a good flow of protective gas, your metal needs to be clean, and your technique should be good too. Sometimes, when repairing used parts, aluminum is dirty for years of abuse or the type of aluminum is lower grade and you may need to go further to the positive side to get the extra cleaning effect. I can go to a negative one for a project and what that will do is expand its cleaning area, but the welding penetration will be reduced. This setting is about getting the right amount of cleaning while still getting the right penetration and you can take some test passes to get your machine checked. You can see the first weld on this sample part that I maxed the machine into negative six Cleaning Effect. The clean area with the white halo is small and barely surrounds the welding puddle. Any change in the angle of the deviated torch or contaminant would damage this weld so the margin of error is minimal. Then I skipped the scale and you can see that the cleaning band gets bigger around the outside of the weld. You can see that the sweet spot is just about three or four negatives. You can see the closer I got to zero or positive side the larger the cleaning area and the welding puddle gets. We're getting a clean weld, but the welding puddle and heat are also increasing dramatically. It may not be a problem in this sample, but if you're welding something that's really crucial that you can't touch the edge or something next to you just can't warm up then that's where you're going to want to stick more to the negative side as much as you can. If you want some extra help with keeping the heat and the weld puddle small, you can keep the machine more to the negative side and spend more time preparing the part. You can preheat aluminum in an oven or with a contaminant baking torch in the pores. It can also be diligent with cleaning the part. You can start with a sander or stainless wire brush to clean the surface and then continue with acetone. The last accounts are on the bright side. That means he's hanging on that side. longer. What you're doing is putting a lot of heat on the electrode itself instead of the workpiece. This means that it is cleaning a large area, but if you allow it to go too long in this setting the tungsten will overheat and the tip could even melt or fall off contaminate the weld. In most home garages and welding projects there is not much reason why you should be using the positive side of the cleaning effect. In my opinion, proper cleaning of the workpiece is probably the number one problem beginners have with TIG welding aluminum. Think of welding aluminum as if you were in an operating room. That's how clean you should strive to get your parts ready if possible. The cleaner the aluminum, the better it will be welded. This piece here is a new piece of metal yard aluminum. This has a protective coating that prevents it from oxidizing quickly when in storage. It may seem clean, but once you start welding you will find contaminants floating in your weld. If the metal is clean or new to begin with, you can take a can of acetone or our Low Pre voc and a scratch pad or stainless wire brush and scrape the piece upwards. Aluminum should look dull and brushed once the coating has been removed. Once the part is cleaned and the acetone or PRE evaporates, it is ready to weld. For modern inverter welders we suggest the use of a hybrid tungsten as a purple band of tungsten E3. This will allow you to weld on any type of material without changing tungsten like older transformer TIG welders. When sharpening your tungsten, we suggest grinding the tip to a sharp spot and then putting a small plane at the end. If you want to change the shape of your arc you can put a larger plane on the tip or change the angle of your grinding. Now that the soldering iron is on I want to mention that we suggest using 100% Argon to protect the gas in 99% of its TIG welding jobs. This is true for most materials, whether aluminum, stainless steel or carbon steel. I also like to crank my highest protective gas flow for aluminum to help with gas coverage when welding. For this weld I have it set to about 130 amps max. Most of the time I'm going to weld a little underneath that, but that's about the point that gives me the range of motion on the pedal that I like. This range of motion is important as it allows me to change things on the fly and if I need to get a little more amperage from the machine to heat an area that I can and then I can go back to the end of the workpiece. I'm going to start by starting a bow and you can see it's cleaning up that little white halo you see, and the bow is dancing like we're talking. Once I have a little heat in the metal and it is cleaned enough I can slowly give the pedal more pressure that increases amperage and heat. You'll see that the welding puddle starts to open and where aluminum has become a liquid. Next, you'll start to see a small opening at the front of the puddle and you want to add your fill bar to the front edge where it opens. Be careful not to hang your filler rod on the tungsten side for as it could cause the filler rod to start melting only by the heat coming out of the weld. After putting your first touch of filler rod in the puddle you can move about half the weld distance and add another filler tip. Continue repeating this process as you go, making sure you are allowing the cleanup action to continue to work as you move. The hotter the workpiece, the faster it will have to move, or it will have to be removed from the amperage to compensate. As near the end of the weld seam I like to slowly rewind the pedal and add one last touch of fill bar to the end of the puddle and continue to recoil from the pedal, moving the torch to the bottom edge of the puddle until it is completely off the pedal. Be sure to leave the torch floating over the weld to allow the protective gas to cover the weld puddle until it stops completely. If you remove the torch instantly, you take that protective gas from the weld and it is shocked and could cause a well or crack at the end of the weld. The hole or crack may spread and fail over time. You can see in the top weld above is a crater in the center of the last weld bit and small cracks coming from the crater. This is what you will normally see if the protective gas was extracted from the weld too quickly. We hope these tips and tricks will help you start your learning curve in TIG welding aluminum. Aluminum.

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