

# VIPER MIG

## 105i SYNERGIC

Operating Manual | VMIG105i



**Please read and understand this instruction manual carefully before the installation and operation of this equipment.**





# WARRANTY



Thank you for your purchase of your VIPER Welding Machine.

We are proud of our range of plasma cutting and welding equipment that has a proven track record of innovation, performance and reliability.

Our product range represents the latest developments in Inverter technology put together by our professional team of highly skilled engineers. The expertise gained from our long involvement with inverter technology has proven to be invaluable towards the evolution and future development of our equipment range. This experience gives us the inside knowledge on what the arc characteristics, performance and interface between man and machine should be.

Within our team are specialist welders that have a proven history of welding knowledge and expertise, giving vital input towards ensuring that our machines deliver control and performance to the utmost professional level.

We employ an expert team of professional sales, marketing and technical personnel that provide us with market trends, market feedback and customer comments and requirements. Secondly they provide a customer support service that is second to none, thus ensuring our customers have confidence that they will be well satisfied both now and in the future.

VIPERMIG AND VIPERCUT welders and plasma cutters are manufactured to be compliant with - CAN/CSA Regulations, guaranteeing you electrical safety and performance.

## WARRANTY

- 1 Year from date of purchase.
- JASIC Technologies America Inc warranties all goods as specified by the manufacturer of those goods.
- This Warranty does not cover freight or goods that have been interfered with.
- All goods in question must be repaired by an authorized repair agent as appointed by this company.
- Warranty does not cover abuse, misuse, accident, theft, general wear and tear.
- New product will not be supplied unless JASIC Technologies America Inc has inspected product returned for warranty and agrees to replace product.
- Product will only be replaced if repair is not possible
- Please view full Warranty term and conditions supplied with machine or at [www.razorweld.com/warranty-registration/](http://www.razorweld.com/warranty-registration/) or at the back of this manual.

**REGISTER YOUR MACHINE ONLINE TO RECEIVE AN  
ADDITIONAL 6 MONTHS ON YOUR WARRANTY**

Visit : [www.razorweld.com/warranty-registration/](http://www.razorweld.com/warranty-registration/) to register your machine.



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**Welding and cutting equipment can be dangerous to both the operator and people in or near the surrounding working area, if the equipment is not correctly operated. Equipment must only be used under the strict and comprehensive observance of all relevant safety regulations.**

**Read and understand this instruction manual carefully before the installation and operation of this equipment.**

## Machine Operating Safety

- Do not switch the function modes while the machine is operating. Switching of the function modes during welding can damage the machine. Damage caused in this manner will not be covered under warranty.
- Disconnect the electrode-holder cable from the machine before switching on the machine, to avoid arcing should the electrode be in contact with the work piece.
- Operators should be trained and or qualified.



**Electric shock: It can kill.** Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and internal machine circuits are also live when power is on. In MIG/MAG welding, the wire, drive rollers, wire feed housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is dangerous.

- Connect the primary input cable according to standards and regulations.
- Avoid all contact with live electrical parts of the welding/cutting circuit, electrodes and wires with bare hands.
- The operator must wear dry welding gloves while he/she performs the welding/cutting task.
- The operator should keep the work piece insulated from himself/herself.
- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cable for wear and tear, replace the cable immediately if damaged, bare wiring is dangerous and can kill.
- Do not use damaged, under sized, or badly joined cables.
- Do not drape cables over your body.
- We recommend (RCD) safety switch is used with this equipment to detect any leakage of current to earth.



**Fumes and gases are dangerous.** Smoke and gas generated whilst welding or cutting can be harmful to people's health. Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

Do not breathe the smoke and gas generated whilst welding or cutting, keep your head out of the fumes

- Keep the working area well ventilated, use fume extraction or ventilation to remove welding/cutting fumes and gases.
- In confined or heavy fume environments always wear an approved air-supplied respirator.
- Welding/cutting 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/cut in locations near de-greasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapours to form highly toxic and irritating gases.
- Materials such as galvanized, lead, or cadmium plated steel, containing elements that can give off toxic fumes when welded/cut. Do not weld/cut these materials unless the area is very well ventilated, and or wearing an air supplied respirator.



**Arc rays: harmful to people's eyes and skin.** Arc rays from the welding/cutting process produce intense visible and invisible ultraviolet and infrared rays that can burn eyes and skin.

Always wear a welding helmet with correct shade of filter lens and suitable protective clothing including welding gloves whilst the welding/cutting operation is performed.

- Measures should be taken to protect people in or near the surrounding working area. Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.





**Fire hazard.** Welding/cutting on closed containers, such as tanks, drums, or pipes, can cause them to explode. Flying sparks from the welding/cutting arc, hot work piece, 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/cutting.

- The welding/cutting sparks & spatter may cause fire, therefore remove any flammable materials well away from the working area. Cover flammable materials and containers with approved covers if unable to be moved from the welding/cutting area.
- Do not weld/cut on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to the required Safety Standards to insure that flammable or toxic vapours and substances are totally removed, these can cause an explosion even though the vessel has been "cleaned". Vent hollow castings or containers before heating, cutting or welding. They may explode.
- Do not weld/cut where the atmosphere may contain flammable dust, gas, or liquid vapours (such as petrol)
- Have a fire extinguisher nearby and know how to use it. Be alert that welding/cutting sparks and hot materials from welding/cutting can easily go through small cracks and openings to adjacent areas. Be aware that welding/cutting on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.



**Gas Cylinders.** Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Because gas cylinders are normally part of the welding/cutting process, be sure to treat them carefully. CYLINDERS can explode if damaged.

- Protect gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs.
- Insure cylinders are held secure and upright to prevent tipping or falling over.
- Never allow the welding/cutting electrode or earth clamp to touch the gas cylinder, do not drape welding cables over the cylinder.
- Never weld/cut on a pressurised gas cylinder, it will explode and kill you.
- Open the cylinder valve slowly and turn your face away from the cylinder outlet valve and gas regulator.



**Gas build up.** The build up of gas can causes a toxic environment, deplete the oxygen content in the air resulting in death or injury. Many gases use in welding/cutting are invisible and odourless.

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



**Electronic magnetic fields.** MAGNETIC FIELDS can affect Implanted Medical Devices.

- Wearers of Pacemakers and other Implanted Medical Devices should keep away.
- Implanted Medical Device wearers should consult their doctor and the device manufacturer before going near any electric welding, cutting or heating operation.



**Noise can damage hearing.** Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.



**Hot parts.** Items being welded/cut generate and hold high heat and can cause severe burns.

Do not touch hot parts with bare hands. Allow a cooling period before working on the welding/cutting gun. Use insulated welding gloves and clothing to handle hot parts and prevent burns.

## CAUTION

### 1. Working Environment.

- i. The environment in which this welding/cutting equipment is installed must be free of grinding dust, corrosive chemicals, flammable gas or materials etc, and at no more than maximum of 80% humidity.
- ii. When using the machine outdoors protect the machine from direct sun light, rain water and snow etc; the temperature of working environment should be maintained within -10°C to +40°C. **(14-104F)**
- iii. Keep this equipment 30cm distant from the wall. **(1.5FT)**
- iv. Ensure the working environment is well ventilated.

### 2. Safety Tips.

#### i. Ventilation

This equipment is small-sized, compact in structure, and of excellent performance in amperage output. The fan is used to dissipate heat generated by this equipment during the welding/cutting operation. Important: Maintain good ventilation of the louvers of this equipment. The minimum distance between this equipment and any other objects in or near the working area should be 30 cm. Good ventilation is of critical importance for the normal performance and service life of this equipment.

#### ii. Thermal Overload protection.

Should the machine be used to an excessive level, or in high temperature environment, poorly ventilated area or if the fan malfunctions the Thermal Overload Switch will be activated and the machine will cease to operate. Under this circumstance, leave the machine switched on to keep the built-in fan working to bring down the temperature inside the equipment. The machine will be ready for use again when the internal temperature reaches safe level.

#### iii. Over-Voltage Supply

Regarding the power supply voltage range of the machine, please refer to "Main parameter" table. This equipment is of automatic voltage compensation, which enables the maintaining of the voltage range within the given range. In case that the voltage of input power supply amperage exceeds the stipulated value, it is possible to cause damage to the components of this equipment. Please ensure your primary power supply is correct.

- iv. Do not come into contact with the output terminals while the machine is in operation. An electric shock may possibly occur.

## MAINTENANCE

Exposure to extremely dusty, damp, or corrosive air is damaging to the welding/cutting machine. In order to prevent any possible failure or fault of this welding/cutting equipment, clean the dust at regular intervals with clean and dry compressed air of required pressure.

**Please note that:** lack of maintenance can result in the cancellation of the guarantee; the guarantee of this welding/cutting equipment will be void if the machine has been modified, attempt to take apart the machine or open the factory-made sealing of the machine without the consent of an authorized representative of the manufacturer.

## TROUBLE SHOOTING

**Caution:** Only qualified technicians are authorized to undertake the repair of this welding/cutting equipment. For your safety and to avoid Electrical Shock, please observe all safety notes and precautions detailed in this manual.

## **ATTENTION! - CHECK FOR GAS LEAKAGE**

At initial set up and at regular intervals we recommend to check for gas leakage

Recommended procedure is as follows:

1. Connect the regulator and gas hose assembly and tighten all connectors and clamps.
2. Slowly open the cylinder valve.
3. Set the flow rate on the regulator to approximately 8-10 L/min. **(0.35CFM)**
4. Close the cylinder valve and pay attention to the needle indicator of the contents pressure gauge on the regulator, if the needle drops away towards zero there is a gas leak. Sometimes a gas leak can be slow and to identify it will require leaving the gas pressure in the regulator and line for an extended time period. In this situation it is recommended to open the cylinder valve, set the flow rate to 8-10 L/min, **(0.35CFM)** close the cylinder valve and check after a minimum of 15 minutes.
5. If there is a gas loss then check all connectors and clamps for leakage by brushing or spraying with soapy water, bubbles will appear at the leakage point.
6. Tighten clamps or fittings to eliminate gas leakage.

**IMPORTANT! - We strongly recommend that you check for gas leakage prior to operation of your machine. We recommend that you close the cylinder valve when the machine is not in use.**

**JASIC Technologies America or authorized representatives or agents of JASIC Technologies America will not be liable or responsible for the loss of any gas.**



### FEATURES

INPUT VOLTAGE :AC 115 +- 15%OUTPUT

CURRENT: 40-105A NO LOAD VOLTAGE:

46V EFFICIENCY: 85%

POWER FACTOR: 0.74

INSULATION : B

WEIGHT: 13 POUNDS

DUTY CYCLE: 20%@105A

DIMENSIONS: 14" X 5.2" X 9.85"

### OVERVIEW

The VIPER 105i SYNERGIC is the easiest MIG welder to get you up and running. Simply set your wire size, adjust the Synergic power knob and the VIPER 105i SYNERGIC does the rest! Running off a 115V , this machine is perfect for small repairs and DIY welding projects.

### MACHINE PACKAGE: VMIG105i

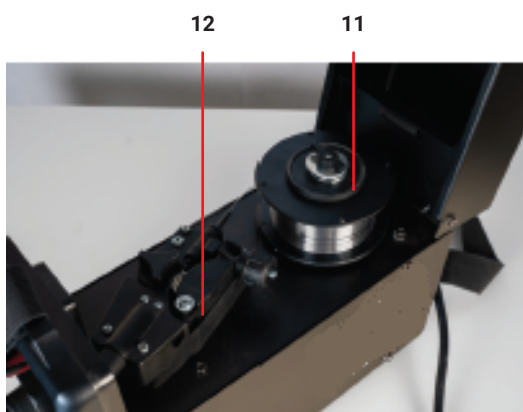
- VIPER 105 SYNERGIC MIG Welder
- 6.5ft Direct Connect Size 15 MIG Torch (including consumables)
- Earth Clamp & Lead
- Roll of Gasless wire (0.030)
- Operating Manual



- 1. SYNERGIC MIG Programs
- 2. Thermal Overload LED
- 3. SYNERGIC Control Knob
- 4. Positive Output
- 5. Polarity Cable
- 6. Negative Output
- 7. Direct Connect MIG Torch

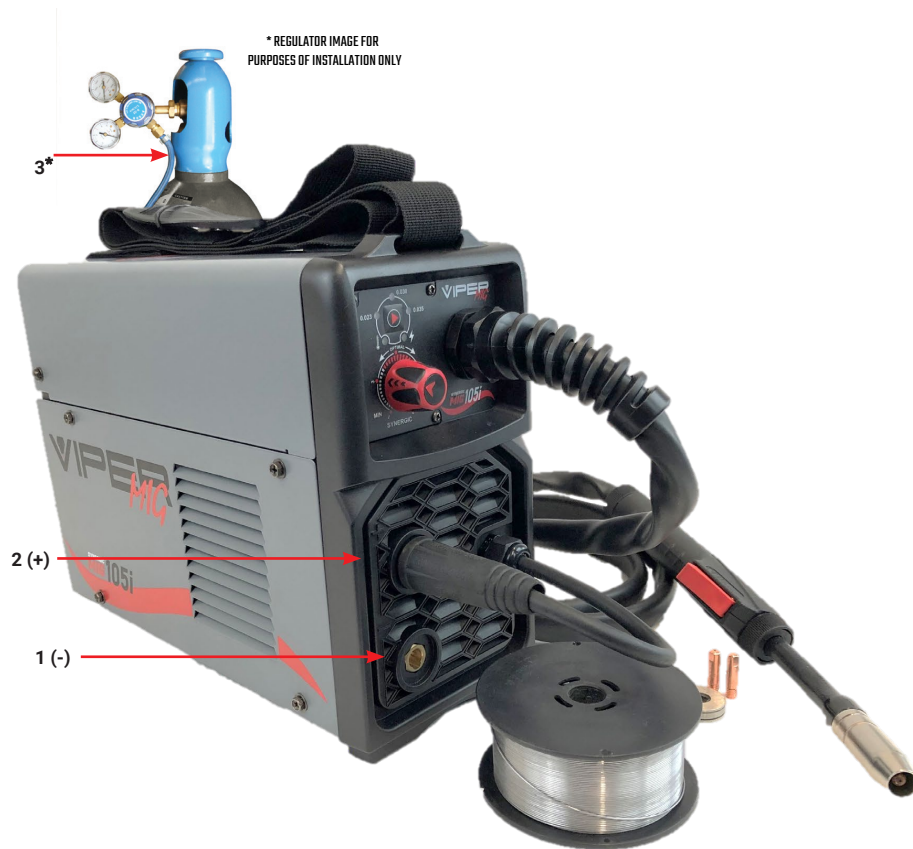


- 8. Power Cable
- 9. Power Switch
- 10. Gas Inlet

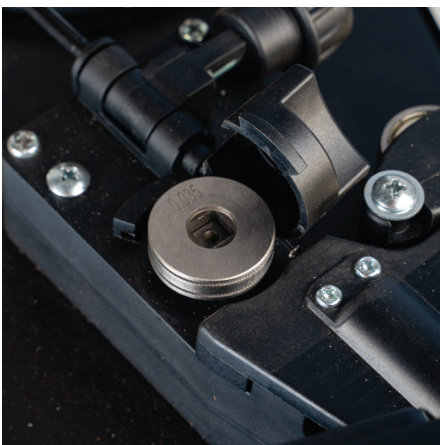


- 11. Wire Spool Holder
- 12. Wire Feed Assembly

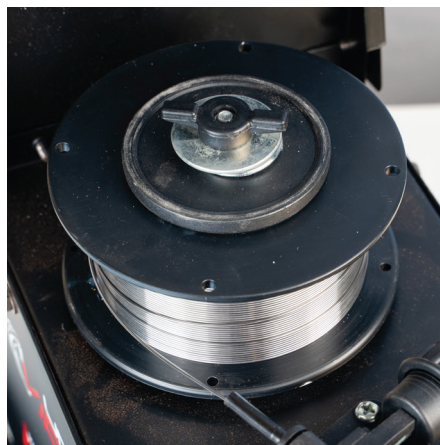




1. Insert the earth cable plug into the required polarity and tighten - negative (-) for gas shielded wires wires.
2. The weld power cable goes into the opposing positive (+) socket.
3. Connect Gas Line to Gas Regulator and connect the gas regulator to the Gas Cylinder.



(4) Fit the correct type and size of drive rollers.  
V Groove for Hard Wires. Knurled for Flux Cored.

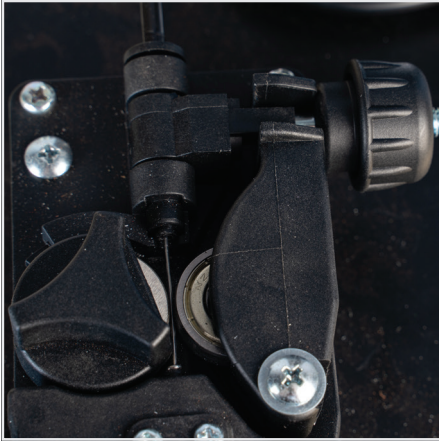


(5) Place wire onto spool holder - (spool retaining nut is left hand thread ) Feed the wire through the inlet guide tube into the drive roller. NOTE: VIPER MIG 105i is not suitable to weld Aluminum as it is a Synergic Welding Machine programmed for Solid Mild Steel wire and Flux Cored (Gasless) wires only.

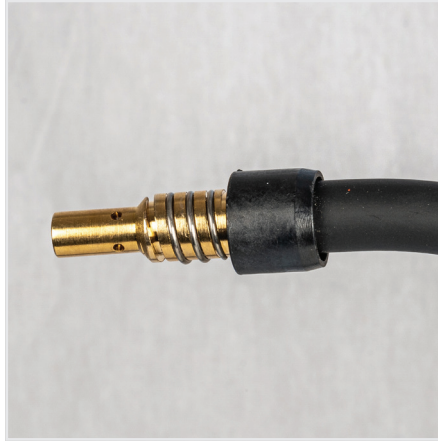


(6) Feed wire over the drive roller into the outlet guide tube, Push the wire through approx 6 Inches





(7) Close down the top roller bracket and clip the pressure arm into place. Apply a medium amount of pressure to the drive roller



(8) Remove the gas nozzle and contact tip from the front end of the MIG torch.



(9) Press and hold the Torch Trigger to feed the wire down the torch cable through to the torch head.



(10) Fit the correct size contact tip over the wire and fasten tightly into the tip holder.



(11) Fit the gas nozzle to the torch head.



(12) Carefully open the valve of the gas cylinder, set the flow to 8-10 L/min (0.35cfm)



(13) Select wire size, then adjust synergic control knob to suit work piece.

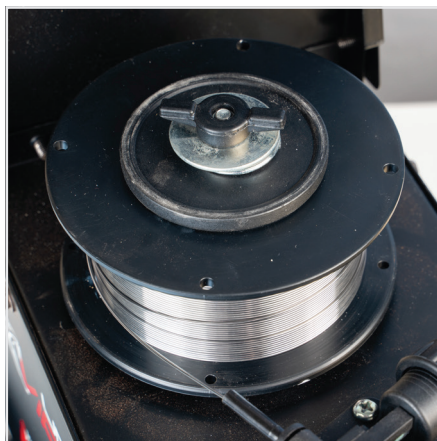




1. Insert the earth cable plug into the required polarity and tighten - positive (+) for flux cored wires wires.
2. The weld power cable goes into the opposing negative (-) socket.



(3) Fit the correct size Knurled drive roller for Gas Less Flux Core wire

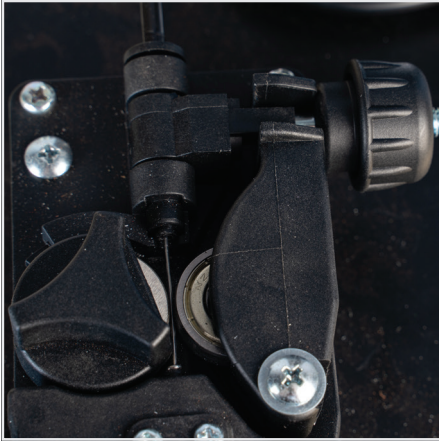


(4) Place wire onto spool holder - (spool retaining nut is left hand thread ) Feed the wire through the inlet guide tube into the drive roller.

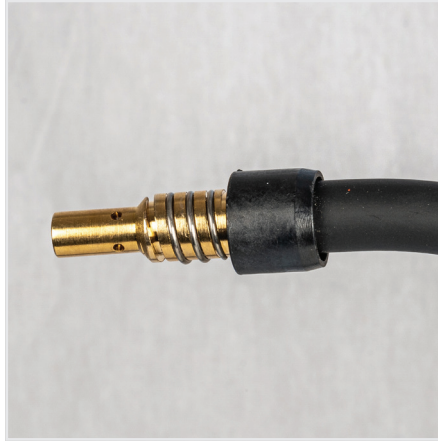


(5) Feed wire over the drive roller into the outlet guide tube, Push the wire through approx 6 Inches





(6) Close down the top roller bracket and clip the pressure arm into place. Apply a medium amount of pressure to the drive roller.



(7) Remove the gas nozzle and contact tip from the front end of the MIG torch.



(8) Press and hold the Torch Trigger to feed the wire down the torch cable through to the torch head.



(9) Fit the correct size contact tip over the wire and fasten tightly into the tip holder.



(10) Fit the gas nozzle to the torch head.



(11) Select wire size, then adjust synergic control knob to suit work piece.

Again the importance of smooth consistent wire feeding during MIG welding cannot be emphasized enough.

The correct installation of the wire spool and the wire into the wire feed unit is critical to achieving an even and consistent wire feed. A high percentage of faults with MIG welders emanate from poor set up of the wire into the wire feeder. The guide below will assist in the correct setup of your wire feeder.

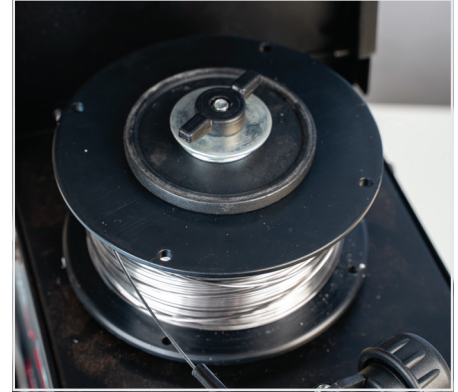
**NOTE:** VIPER MIG 105 is not suitable to weld Aluminum as it is a Synergic Welding Machine programmed for Solid Mild Steel wire and Flux Cored (Gasless) wires only.



(1) Remove the spool retaining nut.



(2) Note the tension spring adjuster and spool locating pin.



(3) Fit the wire spool onto the spool holder fitting the locating pin into the location hole on the spool. Replace the spool retaining nut tightly



(4) Snip the wire carefully, be sure to hold the wire to prevent the spool uncoiling. Carefully feed the wire into the inlet guide tube of the wire feed unit.



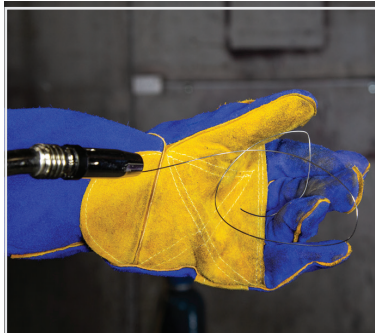
(5) Feed the wire through the drive roller and into the outlet guide tube of the wire feeder.



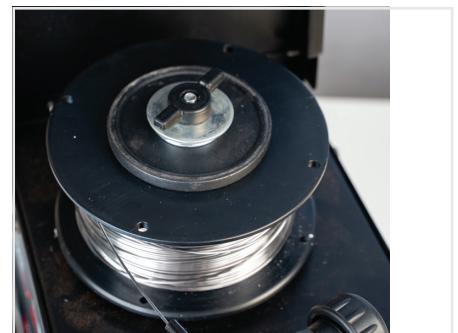
(6) Lock down the top pressure roller and apply a medium amount of pressure using the tension adjustment knob



(7) Press and hold the Torch Trigger to feed the wire down the torch cable through to the torch head.



(8) A simple check for the correct drive tension is to bend the end of the wire over hold it about 4 inches from your hand and let it run into your hand, it should coil round in your hand without stopping and slipping at the drive rollers, increase the tension if it slips.

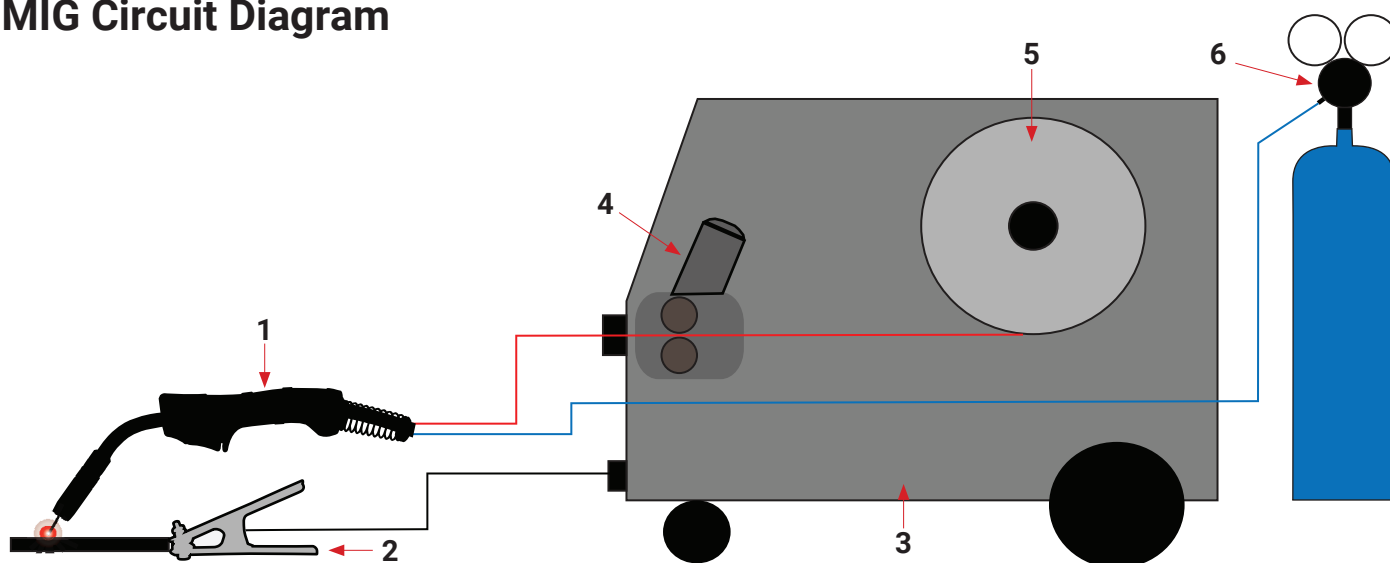


(9) The weight and speed of the wire spool turning creates an inertia that can cause the spool to run on and the wire loop over the side of the spool and tangle. If this happens increase the pressure on the tension spring inside the spool holder assembly using the tension adjustment screw.

### MIG (Metal Inert Gas) Welding

**Definition of MIG Welding** - MIG (metal inert gas) welding also known as GMAW (gas metal arc welding) or MAG (metal active gas welding), is a semi-automatic or automatic arc welding process in which a continuous and consumable wire electrode and a shielding gas are fed through a welding gun. A constant voltage, direct current power source is most commonly used with MIG welding. There are four primary methods of metal transfer in MIG welding, called short circuit (also known as dip transfer) globular transfer, spray transfer and pulsed-spray, each of which has distinct properties and corresponding advantages and limitations. To perform MIG welding, the basic necessary equipment is a welding gun, a wire feed unit, a welding power supply, an electrode wire, and a shielding gas supply. Short circuit transfer is the most common used method whereby the wire electrode is fed continuously down the welding torch through to and exiting the contact tip. The wire touches the work piece and causes a short circuit the wire heats up and begins to form a molten bead, the bead separates from the end of the wire and forms a droplet that is transferred into the weld pool. This process is repeated about 100 times per second, making the arc appear constant to the human eye.

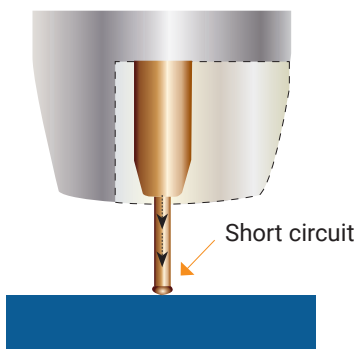
### MIG Circuit Diagram



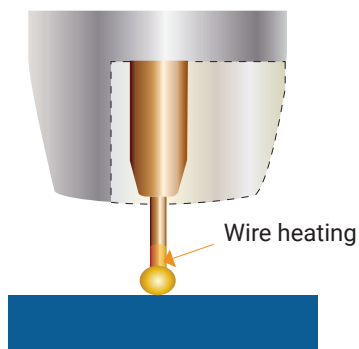
1. MIG Torch - 2. Work Piece - 3. Power Source - 4. Wire Feeder - 5. Wire Spool - 6. Gas

### MIG (Metal Inert Gas) Welding

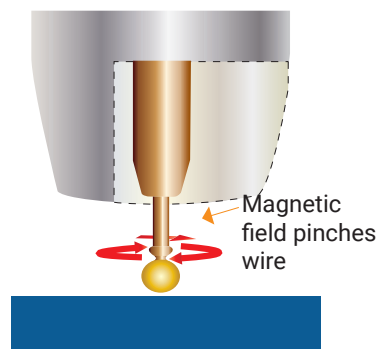
**Short Circuit Transfer** - Short circuit transfer is the most common used method whereby the wire electrode is fed continuously down the welding torch through to and exiting the contact tip. The wire touches the work piece and causes a short circuit the wire heats up and begins to form a molten bead, the bead separates from the end of the wire and forms a droplet that is transferred into the weld pool. This process is repeated about 100 times per second, making the arc appear constant to the human eye.



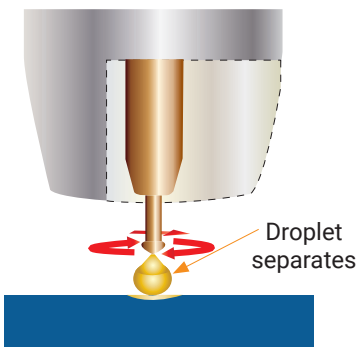
The wire approaches the work piece and touches the work creating a short circuit between the wire and the base metal, because there is no space between the wire and the base metal there is no arc and current flows through the wire.



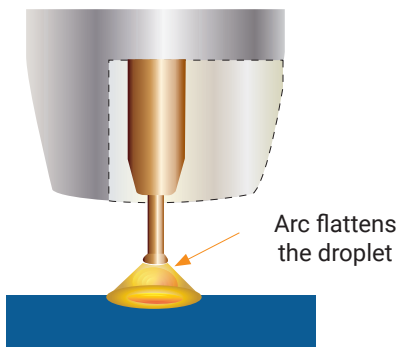
The wire cannot support all the current flow, resistance builds up and the wire becomes hot and weak and begins to melt



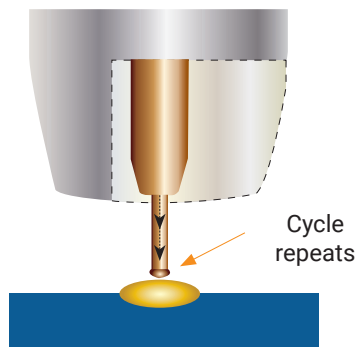
The current flow creates a magnetic field that begins to pinch the melting wire forming it into droplet



The pinch causes the forming droplet to separate and fall towards the now creating weld pool.



An arc is created at the separation of the droplet and the heat and force of the arc flattens out the droplet into the weld pool. The heat of the arc melts the end of the wire slightly as it feeds towards the base metal



The wire feed speed overcomes the heat of the arc and the wire again approaches the work to short circuit and repeat the cycle.



### Basic MIG Welding

Good weld quality and weld profile depends on gun angle, direction of travel, electrode extension (stick out), travel speed, thickness of base metal, wire feed speed (amperage) and arc voltage. To follow are some basic guides to assist with your setup.

### Gun Position - Travel Direction, Work Angle

Gun position or technique usually refers to how the wire is directed at the base metal, the angle and travel direction chosen. Travel speed and work angle will determine the characteristic of the weld bead profile and degree of weld penetration.

### Push Technique

The wire is located at the leading edge of the weld pool and pushed towards the un-melted work surface. This technique offers a better view of the weld joint and direction of the wire into the weld joint. Push technique directs the heat away from the weld puddle allowing faster travel speeds providing a flatter weld profile with light penetration - useful for welding thin materials. The welds are wider and flatter allowing for minimal clean up / grinding time.

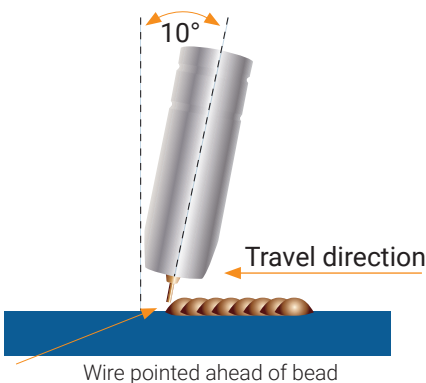
### Perpendicular Technique

The wire is fed directly into the weld, this technique is used primarily for automated situations or when conditions make it necessary. The weld profile is generally higher and a deeper penetration is achieved.

### Drag Technique

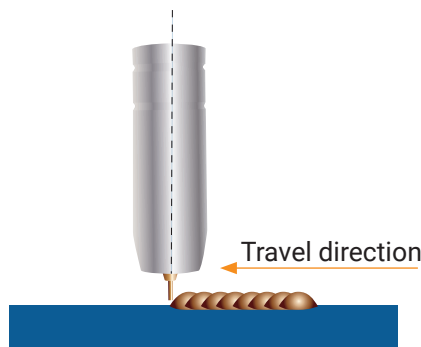
The gun and wire is dragged away from the weld bead. The arc and heat is concentrated on the weld pool, the base metal receives more heat, deeper melting, more penetration and the weld profile is higher with more build up.

(A) Push Technique



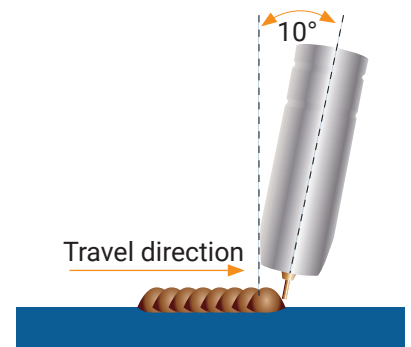
Wire pointed ahead of bead

(B) Gun Perpendicular



Narrower weld profile  
even penetration

(C) Drag Technique



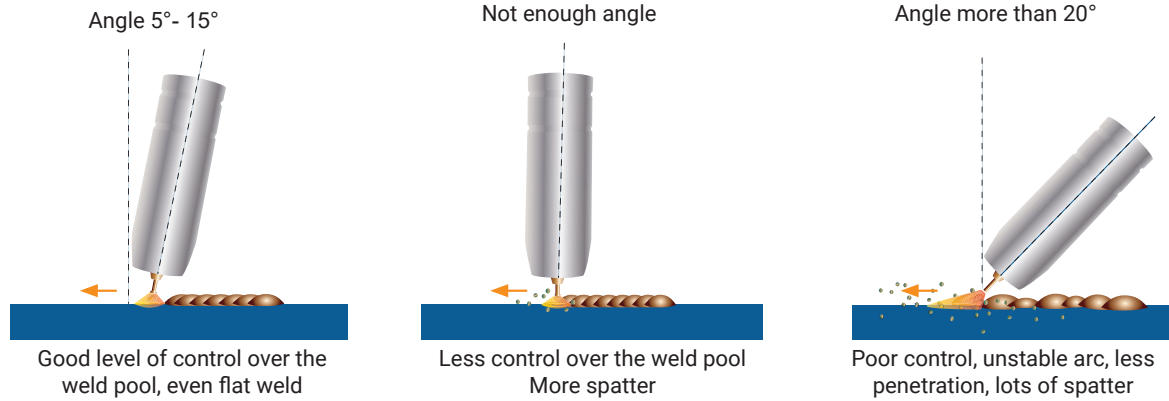
Wire pointed back into bead

Narrow higher weld profile  
more penetration

Flat even weld profile light  
penetration

### Travel Angle

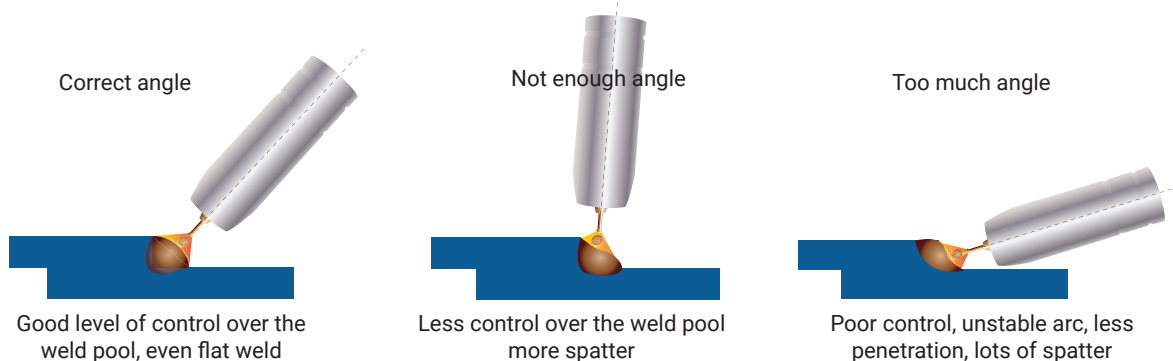
Travel angle is the right to left angle relative to the direction of welding. A travel angle of 5° - 15° is ideal and produces a good level of control over the weld pool. A travel angle greater than 20° will give an unstable arc condition with poor weld metal transfer, less penetration, high levels of spatter, poor gas shield and poor quality finished weld.



### Angle to Work

The work angle is the forward back angle of the gun relative to the work piece.

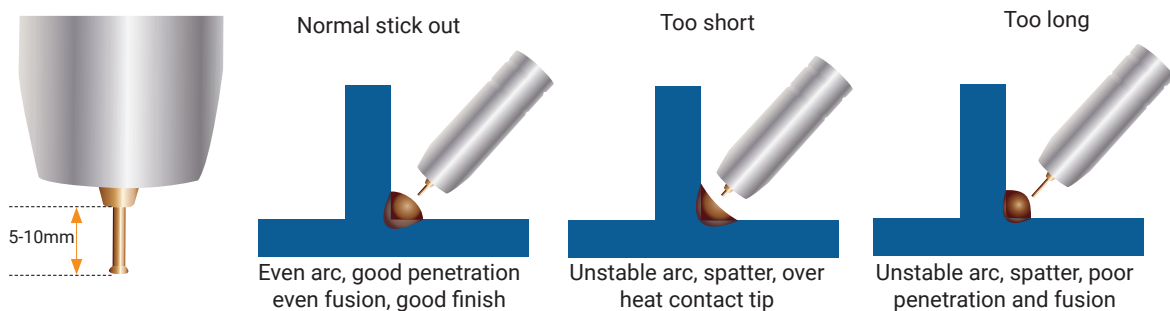
The correct work angle provides good bead shape, prevents undercut, uneven penetration, poor gas shield and poor quality finished weld.



### Stick Out

Stick out is the length of the unmelted wire protruding from the end of the contact tip.

A constant even stick out of 5-10mm (0.2-0.4 Inch) will produce a stable arc, and an even current flow providing good penetration and even fusion. Too short stick out will cause an unstable weld pool, produce spatter and over heat the contact tip. Too long stick out will cause an unstable arc, lack of penetration, lack of fusion and increase spatter.

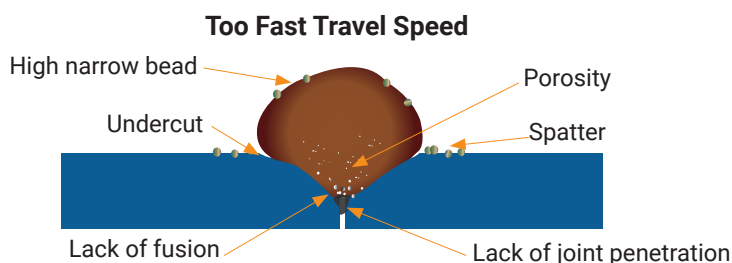


## Travel Speed

Travel speed is the rate that the gun is moved along the weld joint and is usually measured in mm per minute. Travel speeds can vary depending on conditions and the welders skill and is limited to the welders ability to control the weld pool. Push technique allows faster travel speeds than Drag technique. Gas flow must also correspond with the travel speed, increasing with faster travel speed and decreasing with slower speed. Travel speed needs to match the amperage and will decrease as the material thickness and amperage increase.

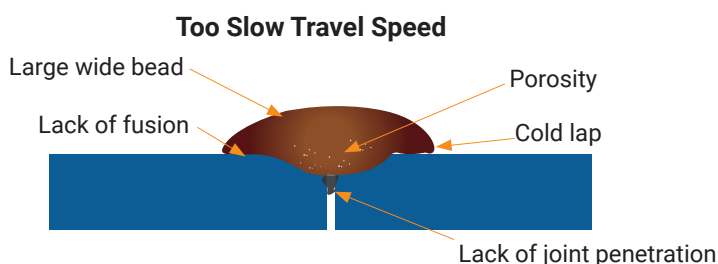
## Too Fast Travel Speed

A too fast travel speed produces too little heat per mm of travel resulting in less penetration and reduced weld fusion, the weld bead solidifies very quickly trapping gases inside the weld metal causing porosity. Undercutting of the base metal can also occur and an unfilled groove in the base metal is created when the travel speed is too fast to allow molten metal to flow into the weld crater created by the arc heat.



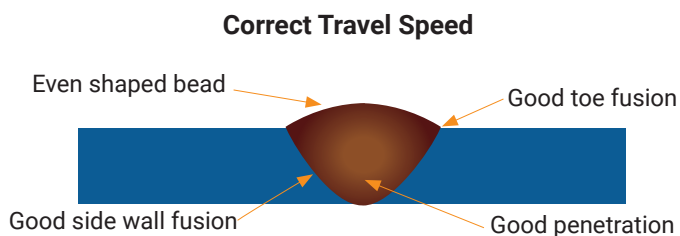
## Too Slow Travel Speed

A too slow travel speed produces a large weld with lack of penetration and fusion. The energy from the arc dwells on top of the weld pool rather than penetrating the base metal. This produces a wider weld bead with more deposited weld metal per mm than is required resulting in a weld deposit of poor quality.



## Correct Travel Speed

The correct travel speed keeps the arc at the leading edge of the weld pool allowing the base metal to melt sufficiently to create good penetration, fusion and wetting out of the weld pool producing a weld deposit of good quality.



### Wire types and sizes

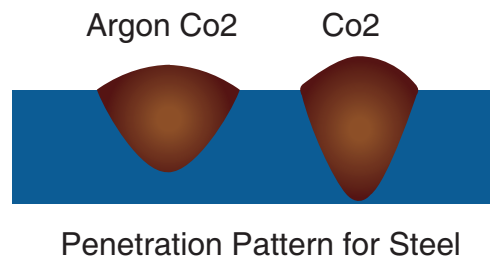
Use the correct wire type for the base metal being welded. Use stainless steel wire for stainless steel, aluminum wires for aluminum and steel wires for steel.

Use a smaller diameter wire for thin base metals. For thicker materials use a larger wire diameter and larger machine, check the recommended welding capability of your machine.

### Gas selection

The purpose of the gas in the MIG process is to protect / shield the wire, the arc and the molten weld metal from the atmosphere. Most metals when heated to a molten state will react with the air in the atmosphere, without the protection of the shielding gas the weld produced would contain defects like porosity, lack of fusion and slag inclusions. Additionally some of the gas becomes ionised (electrically charged) and helps the current flow smoothly.

The correct gas flow is also very important in protecting the welding zone from the atmosphere. Too low flow will give inadequate coverage and result in weld defects and unstable arc conditions. Too high flow can cause air to be drawn into the gas column and contaminate the weld zone. Use the correct shielding gas. Co<sub>2</sub> is good for steel and offers good penetration characteristics, the weld profile is narrower and slightly more raised than the weld profile obtained from Argon Co<sub>2</sub> mixed gas. Argon Co<sub>2</sub> mix gas offers better weld ability for thin metals and has a wider range of setting tolerance on the machine. Argon 80% Co<sub>2</sub> 20% is a good all round mix suitable for most applications.



### FRONT END CONSUMABLES

#### VIPER 105 SYNERGIC CONTACT TIPS

Part-No	Description	QTY
15-23	Contact Tip Steel (0.023)	QTY5
15-30	Contact Tip Steel (0.030)	QTY5
15-35	Contact Tip Steel (0.035)	QTY5



#### VIPER 105 SYNERGIC TIP HOLDER

Part-No	Description	QTY
15TA	Contact Tip Holder	QTY2
15NS	Shroud Spring	QTY2



#### VIPER 105 SYNERGIC GAS NOZZLE

Part-No	Description	QTY
15-NZ12	Conical Nozzle	QTY2
15-NZ16	Cylindrical Nozzle	QTY2



#### VIPER 105 SYNERGIC ADDITIONAL TORCH PARTS

Part-No	Description	QTY
15-SN50	Swan Neck Assembly	QTY1
LN2335-7	Torch Liner	QTY1



These parts are manufactured in China and are offered as replacement parts suitable for "BINZEL®" style torches.

The following chart addresses some of the common problems of MIG welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

1: Excessive Spatter	
Possible Reason	Suggested Remedy
Wire feed speed set too high	Adjust SYNERGIC Control Knob
Voltage too high	Adjust SYNERGIC Control Knob
Wrong polarity set	Select the correct polarity for the wire being used - see machine setup guide
Stick out too long	Bring the torch closer to the work
Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal
Contaminated MIG wire	Use clean dry rust free wire. Do not lubricate the wire with oil, grease etc
Inadequate gas flow or too much gas flow	Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 6-12 l/min flow rate. Check hoses and fittings for holes, leaks etc Protect the welding zone from wind and drafts
2: Porosity - small cavities or holes resulting from gas pockets in weld metal.	
Possible Reason	Suggested Remedy
Wrong gas	Check that the correct gas is being used
Inadequate gas flow or too much gas flow	Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 10 - 15 l/min flow rate. (0.35CFM) Check hoses and fittings for holes, leaks etc. Protect the welding zone from wind and drafts
Moisture on the base metal	Remove all moisture from base metal before welding
Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal
Contaminated MIG wire	Use clean dry rust free wire. Do not lubricate the wire with oil, grease etc
Gas nozzle clogged with spatter, worn or out of shape	Clean or replace the gas nozzle
Missing or damaged gas diffuser	Replace the gas diffuser
3: Wire stubbing during welding	
Possible Reason	Suggested Remedy
Holding the torch too far away	Bring the torch closer to the work and maintain stick out of 0.2 -0.4 Inch
Welding voltage set too low	Adjust SYNERGIC Control Knob
Wire Speed set too high	Adjust SYNERGIC Control Knob
4: Lack of Fusion – failure of weld metal to fuse completely with base metal or a preceding weld bead.	
Possible Reason	Suggested Remedy
Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal
Not enough heat input	Select a higher voltage range and /or adjust the wire speed to suit
Improper welding technique	Keep the arc at the leading edge of the weld pool. Gun angle to work should be between 5 & 15° Direct the arc at the weld joint  Adjust work angle or widen groove to access bottom during welding Momentarily hold arc on side walls if using weaving technique
5: Excessive Penetration – weld metal melting through base metal	
Possible Reason	Suggested Remedy
Too much heat	Select a lower voltage range and /or adjust the wire speed to suit Increase travel speed
6: Lack of Penetration – shallow fusion between weld metal and base metal	
Poor in incorrect joint preparation	Material too thick. Joint preparation and design needs to allow access to bottom of groove while maintaining proper welding wire extension and arc characteristics  Keep the arc at the leading edge of the weld pool and maintain the gun angle at 5 & 15° keeping the stick out between 0.2-0.4 Inch
Not enough heat input	Select a higher voltage range and /or adjust the wire speed to suit Reduce travel speed
Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal.



The following chart addresses some of the common WIRE FEED problems during MIG welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

1: Inconsistent / interrupted wire feed	
<i>Possible Reason</i>	<i>Suggested Remedy</i>
Wrong polarity selected	Select the correct polarity for the wire being used - see machine setup guide
Incorrect wire speed setting	Adjust SYNERGIC Control Knob
Voltage setting incorrect	Adjust SYNERGIC Control Knob
MIG torch lead kinked or too sharp angle being held	Remove the kink, reduce the angle or bend
Contact tip worn, wrong size, wrong type	Replace the tip with correct size and type
Liner worn or clogged (the most common causes of bad feeding)	Try to clear the liner by blowing out with compressed air as a temporary cure, it is recommended to replace the liner
Wrong size liner	Install the correct size liner
Blocked or worn inlet guide tube	Clear or replace the inlet guide tube
Wire misaligned in drive roller groove	Locate the wire into the groove of the drive roller
Incorrect drive roller size	Fit the correct size drive roller e.g.; 0.030 wire requires 0.030 drive roller
Wrong type of drive roller selected	Fit the correct type roller (e.g. knurled rollers needed for flux cored wires)
Worn drive rollers	Replace the drive rollers
Drive roller pressure too high	Can flatten the wire electrode causing it to lodge in the contact tip - reduce the drive roller pressure
Too much tension on wire spool hub	Reduce the spool hub brake tension
Wire crossed over on the spool or tangled	Remove the spool untangle the wire or replace the wire
Contaminated MIG wire	Use clean dry rust free wire. Do not lubricate the wire with oil, grease etc

## WARRANTY

JASIC Technologies America Inc ('Us', 'We') warrants that the following products under VIPERMIG supplied by Us and purchased by you from an Authorised VIPERMIG Dealer throughout the U.S.A & Canada are free of Material and Faulty Workmanship defects except for those products listed under 'Warranty Exclusions'.

These terms and conditions supersede and exclude all former and other representations and arrangements relating to any warranties on these products.

## WARRANTY PERIOD

We offer the following 'Warranty Periods' from 'date of purchase':

An Extended Warranty Period of 6 months total shall apply only to Machinery where offered and warranty is registered online.

### RAZORWELD + VIPER WELDING MACHINES

#### **VIPER DIY Series (Power Source Only) VIPERMIG**

	<b>1 Year</b>	<b>(Clause 1)</b>
RAZORWELD JASIC Inverter MIG (Power Source Only) RAZOR RANGE	3 Years	(Clause 4)
RAZORWELD JASIC Inverter MIG SWF (Power Source / Separate Wire Feeder Only)	3 Years	(Clause 4)
RAZORWELD JASIC Inverter TIG (Power Source Only)	3 Years	(Clause 4)
RAZORWELD JASIC Inverter PLASMA (Power Source Only)	3 Years	(Clause 4)
RAZORWELD Water Cooler	1 Year	(Clause 1)
RAZORWELD JASIC Series (Power Source Only)	3 Years	(Clause 4)
UNI-FLAME Regulators Argon/ Acetylene / Oxygen / LPG / Bobbin Flowmeter	1 Year	
UNI-FLAME Automatic Welding Helmet	2 Years	
RAZORWELD Automatic Welding Helmets	2 Years	
TORCHES -GMAW, GTAW, MMAW, PLASMA, EARTH LEADS, INTERCONNECTING CABLES, GAS HOSE	3 Months	(Clause 3)

(Clause 1) 1 year warranty on transformers, inductor and rectifier. 1 year warranty on PCB, and all other components.

(Clause 2) Gas Hose, Flashbacks are subject to and covered by the Manufacturer's Individual Warranty, Contact the manufacturer for details

(Clause 3) This only Covers Manufactures defaults on all accessories for the first three months after date of purchase. It does not cover operator abuse or mistreatment of the torch

(Clause 4) 3 years warranty on transformer , inductor and Rectifier , 1 year on PCB and all other components :Does not cover operator abuse or mistreatment of the machine

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## NOTES:

# VIPER MIG

## Vipermig105i

JASIC TECHNOLOGIES AMERICA INC  
25503 74th Ave , S, Kent WA 98032  
[WWW.RAZORWELD.COM](http://WWW.RAZORWELD.COM)  
Ph: (+1) 253-859-6277  
Fax: (+1) 253-859-6286  
[E:SALES@RAZORWELD.COM](mailto:E:SALES@RAZORWELD.COM)