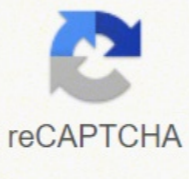




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How do you set up miller syncrowave 250 dx for aluminum

05-06-2009 #1 at home i have a millermatic 185 with a spool gun that i weld alumium with. it does ok but i want to try and tig some. at work we have a 250dx that i know NOTHING about. how do i set up and weld aluminum with it? thanks and sorry for the NOOB question. I have been reading and searching but i have not found a answer. Thanks chris 05-06-2009 #2 if its one like we have it has buttons to push with little lights referenced by print next to the light. press tig button next row select remote next row select remote next row select remote next row set the high frequency to continuous. It might actually do it for you on the last step. then step on the pedal and set your gas. pure tungsten is usually what ya use. ive found out from the guys here that 2% works and it does work pretty well. in fact i might even stop buying anything but red. good luck and hope the machine works. one of ours doesnt! 05-06-2009 #3 thanks. were would i set the machine for 1/4" aluminum? i have never used this machine so really know nothing about it. 05-06-2009 #4 Ed Conley MM252 MM211 (Sold) Passport Plus & Spool gun Lincoln SP135 Plus- (Gone to a good home) Klutch 120v Plasma cutter SO 2020 bender Beer in the fridge 05-06-2009 #5 i tried that, it does not come up 05-06-2009 #6 Originally Posted by SatisTraction i tried that, it does not come up What didn't come up? here is a link to the manual the other was just to get you to Miller If you look around their site you might find a Tig guide too Ed Conley MM252 MM211 (Sold) Passport Plus & Spool gun Lincoln SP135 Plus- (Gone to a good home) Klutch 120v Plasma cutter SO 2020 bender Beer in the fridge 05-07-2009 #10 There's the difference. I went to Miller/resources/owners manual/Syncrowave 250 DX/search Still isn't working at 11:30pm/MDT The link to the TIG Handbook works fine. Last edited by Craig in Denver; 05-07-2009 at 01:43 AM. 9-11-2001.....We Will Never Forget Retired desk jockey. Hobby weldor with a little training. Craftsman O/A---Flat, Vert, Ovhd, Horz. Miller Syncrowave 250 05-07-2009 #11 Hey Guys, We've got a Lamborgini at the track. How do I drive it around the track at 200 MPH? Now really. Makes about as much sense as the OP's original question. Notice I said nothing about "stupid questions". I'm really trying to learn to be more "politically correct", but dangd if it isn't difficult. Syncro 250 DX Dynasty 200 DX MM 251 w/30A SG XMT 304 w/714 Feeder & Optima Pulser HH187 Dialarc 250 AC/DC Hypertherm PM 1250 Smith, Harris, Victor O/A Smith and Thermco Gas Mixers Access to a full fab shop with CNC Plasma, Water Jet, etc. 05-08-2009 #12 2% Thoriated Tungsten-Transformer Based Welder-Aluminum=BAD Anyone who recommends using 2% Thoriated (Red) tungsten, for welding aluminum (AC), in a Syncrowave 250 (transformer based), must have never tried it himself. Here's what happens for those who would like to know (if you don't believe me, try it yourself). First, the tungsten, even if prepped to a crayon shape and the tip blunted, starts to form a series of small balls around the circumference of the tungsten. If you keep welding, these small balls fall (or should I say are blown) off into the weldbead, thereby contaminating the weld. As the tungsten tip deteriorates, the arc becomes extremely unstable. If you look carefully, there will be several small splits in the tungsten near the tip. Miller electric has NEVER recommended the use of thoriated tungsten for AC welding in a transformer based machine. Zirconiated tungsten, for Sync users, is a better option. To quote from an Arc-Zone publication: "Better start up than pure tungsten. Balls up well and has a more stable arc than pure tungsten. Better current carrying capacity and high resistance to contamination during welding". Personally, I use the 2% Lanthanated tungstens in my Sync 250 for AC welding. I've found that the tip will still ball, but remains stable. The ball will never get as large as the ball found with pure (green) tungsten. Over the last twenty years the tungsten manufacturer's have made great strides to develop tungstens which take advantage of the advances in tig welding machines. No longer are we tig welding with a sine wave machine with a HF box attached. The squarewave machines perform best with other than pure tungsten. The advanced squarewave machines take all that to a different level. Miller even goes so far as to RECOMMEND NOT using pure in their inverter machines. They don't say you CAN'T because that would imply that it's physically impossible, which it's not. It's just that the results will be less than acceptable. It appears there are posters who make recommendations to others without ever trying their recommendations themselves. If they had, they'd understand why their guidance was inaccurate. Way too much, "I heard, I saw, I read" guidance is put out on the boards. Lots of good information is put out, but a lot of bad information also is put out as the gospel. Syncro 250 DX Dynasty 200 DX MM 251 w/30A SG XMT 304 w/714 Feeder & Optima Pulser HH187 Dialarc 250 AC/DC Hypertherm PM 1250 Smith, Harris, Victor O/A Smith and Thermco Gas Mixers Access to a full fab shop with CNC Plasma, Water Jet, etc. 05-11-2009 #13 Originally Posted by SundownIII Hey Guys, We've got a Lamborgini at the track. How do I drive it around the track at 200 MPH? Now really. Makes about as much sense as the OP's original question. Notice I said nothing about "stupid questions". I'm really trying to learn to be more "politically correct", but dangd if it isn't difficult. yes i know it is a bit of a large and out there question. i am not asking you to teach me how to weld but i am asking for a starting point. bear with me and i will get to the good questions later. I have the tools and some experience with other forms of welding. now i want to try this out. thanks for the useful replies. chris 05-11-2009 #14 in my original post i said pure is what ya should be using but a few weeks ago i tried 2% thoriated after the guys here said it works. it does work pretty well. i didnt try it for an etended period of time but i have seen it split and everything else like richard said a few posts ago. you dont want the ball on your tungsten big anyway. its recommended that your ball should be no more than 1 1/2 times your tungsten diameter. should always go with recommendations from the people who make the stuff as richard so eloquently put it.so stay with the green. but in a pinch, red will do ya pretty well too. at least our syncrowaves run it alright. 05-11-2009 #15 Originally Posted by SundownIII 2% Thoriated Tungsten-Transformer Based Welder-Aluminum=BAD Anyone who recommends using 2% Thoriated (Red) tungsten, for welding aluminum (AC), in a Syncrowave 250 (transformer based), must have never tried it himself. Here's what happens for those who would like to know (if you don't believe me, try it yourself). First, the tungsten, even if prepped to a crayon shape and the tip blunted, starts to form a series of small balls around the circumference of the tungsten. If you keep welding, these small balls fall (or should I say are blown) off into the weldbead, thereby contaminating the weld. As the tungsten tip deteriorates, the arc becomes extremely unstable. If you look carefully, there will be several small splits in the tungsten near the tip. Miller electric has NEVER recommended the use of thoriated tungsten for AC welding in a transformer based machine. Zirconiated tungsten, for Sync users, is a better option. To quote from an Arc-Zone publication: "Better start up than pure tungsten. Balls up well and has a more stable arc than pure tungsten. Better current carrying capacity and high resistance to contamination during welding". Personally, I use the 2% Lanthanated tungstens in my Sync 250 for AC welding. I've found that the tip will still ball, but remains stable. The ball will never get as large as the ball found with pure (green) tungsten. Over the last twenty years the tungsten manufacturer's have made great strides to develop tungstens which take advantage of the advances in tig welding machines. No longer are we tig welding with a sine wave machine with a HF box attached. The squarewave machines perform best with other than pure tungsten. The advanced squarewave machines take all that to a different level. Miller even goes so far as to RECOMMEND NOT using pure in their inverter machines. They don't say you CAN'T because that would imply that it's physically impossible, which it's not. It's just that the results will be less than acceptable. It appears there are posters who make recommendations to others without ever trying their recommendations themselves. If they had, they'd understand why their guidance was inaccurate. Way too much, "I heard, I saw, I read" guidance is put out on the boards. Lots of good information is put out, but a lot of bad information also is put out as the gospel. 2% thoriated works ok if the diameter is large enough and the part is pre-heated and /or helium is used. You just have to keep an eye on the current. 05-11-2009 #16 hey richard im gonna have to buy some of that lanthanated, is it pretty expensive? 05-11-2009 #17 El Lloydeo, Lanthanated is not that much more than thoriated. I get mine from Tungsten-Direct on the internet. For instance: 3/32" Lanthanated \$17.95 3/32" Thoriated \$11.15 1/8" Lanthanated \$26.85 1/8" Thoriated \$18.90 Good people to deal with. Have one of the best selections of tungsten I've seen. Satis Traction: Set the Sync on AC Set your balance on about 7.5-8.0 Set amps at about 1 per .001 of material (may want to try about 10% less, ie for 1/4" aluminum try about 205-210 A For up to about 180A use a 3/32" tungsten, higher go to a 1/8" Set preflow at about .04 sec Set postflow at 1sec/10A welding output. Hit the pedal hard (don't try to sneak up on the power). Should get a puddle in 2-3 sec. Back off on the heat as the bead progresses. Aluminum will build heat in the base material. At the end of the bead, back off on the power while adding filler (prevents a divot). Hope the sync uses a water cooled torch cause trying to weld thicker aluminum with an air cooled torch will get old in a hurry. Good Luck Syncro 250 DX Dynasty 200 DX MM 251 w/30A SG XMT 304 w/714 Feeder & Optima Pulser HH187 Dialarc 250 AC/DC Hypertherm PM 1250 Smith, Harris, Victor O/A Smith and Thermco Gas Mixers Access to a full fab shop with CNC Plasma, Water Jet, etc. 05-11-2009 #18 Satis Traction. Also, I would highly recommend getting your hands on a copy of Miller's Tig Handbook. It's one of the better tig references I've seen. It can be downloaded from their site (millerwelds.com) or an even better option is to order it in hardcopy. If ordering the hardcopy, I'd recommend ordering the Student Package for \$25 (shipping included). It not only includes the tig handbook but also a bunch of other good material such as a GMAW handbook, GMAW-P handbook, welding calculators, etc. etc. Best \$25 you'll spend on welding supplies. Syncro 250 DX Dynasty 200 DX MM 251 w/30A SG XMT 304 w/714 Feeder & Optima Pulser HH187 Dialarc 250 AC/DC Hypertherm PM 1250 Smith, Harris, Victor O/A Smith and Thermco Gas Mixers Access to a full fab shop with CNC Plasma, Water Jet, etc. 05-11-2009 #19 thanks for the advice. I will get to work on it!!

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