**ESAB BUDDY TIG 160 - TIG ( and MMA) WELDER – GETTING STARTED**

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**Manual**

<http://pdfmanuals.esab.com/private/Library/InstructionManuals/0463%20267%20001%20GB.pdf>

**To start welding** on 2mm aluminium suggested settings

Argon or Argon / CO2 Gas flow 20psi / 15cfh

Tungsten (ceriated) electrode 2.4mm dia

Filler rod 2.4mm dia

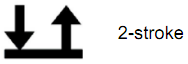
Switch DOWN for

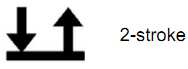
HF Start

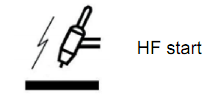
(high frequency)

Switch DOWN for

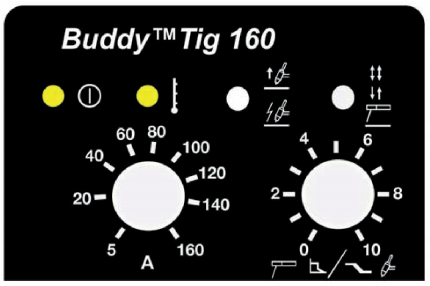
2-STROKE control mode



Switch DOWN for 2-STROKE control using the trigger switch 



Around 80 amps



Slope Down set to 3 to minimise craters



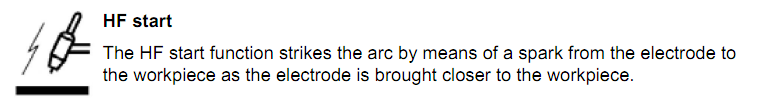
Complete risk assessment for MMA

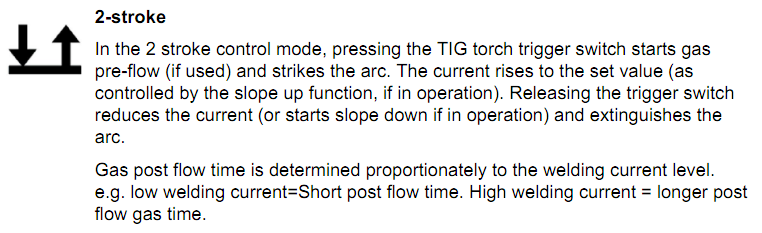
Calculating the settings for materials and thicknesses are not provided by ESAB. Try the following <https://www.millerwelds.com/resources/weld-setting-calculators/tig-welding-calculator>

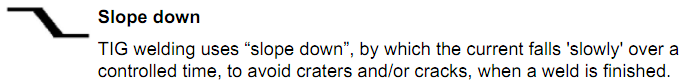


TRIGGER SWITCH

GAS VALVE (fitted on some models)







**TIG FILLER RODS FOR A RANGE OF MATERIALS**

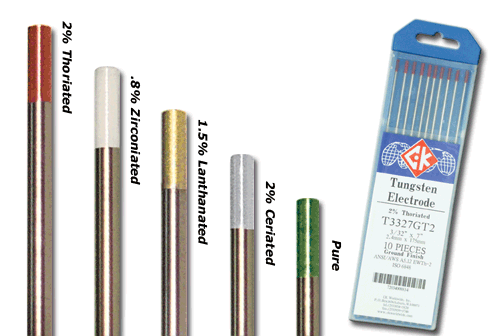
<http://www.esab.co.uk/gb/en/products/index.cfm?fuseaction=home.productsbycategory&catId=55>

**TUNGSTEN ELECTRODES – RANGE**

<http://www.esab.co.uk/gb/en/products/index.cfm?fuseaction=home.product&productCode=450506&tab=4>



This is a high-quality range of tungsten electrodes available in ceriated, pure and lanthanated (Gold Plus) versions. ESAB tungsten electrodes have excellent welding and ignition properties. They are delivered in plastic boxes, each containing ten electrodes. The standard electrodes are 175 mm long, the Eco range is 150 mm long.

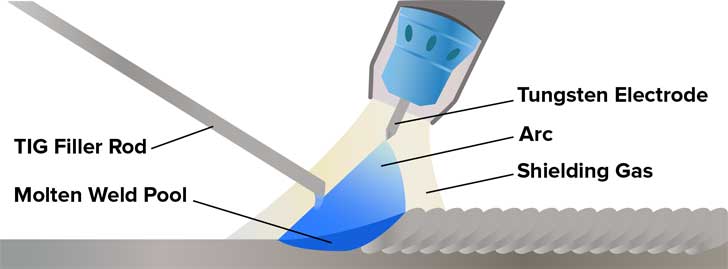


**TUNGTEN ELECTRODES**

**COLOUR CODE**

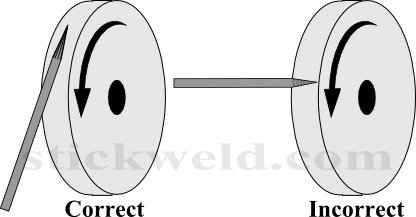
2% CERIATED (Grey) is one of the most used rods for both steels (DC) and aluminium alloys(AC)

**IN PRACTICE KEEP THE TIP OF THE ELECTRODE THE SAME DISTANCE FROM THE WORKPIECE 1 to 1.5 times DIAMETER OF THE ELECTRODE BEFORE ACTIVATING THE TRIGGER SWITCH**



**KEEP THE TUNGSTEN ELECTRODE POINT THE CORRECT SHAPE BY GRINDING**





### How do I position my TIG torch for different types of welds?

<https://www.wellyweld.com/tech-tips.aspx>