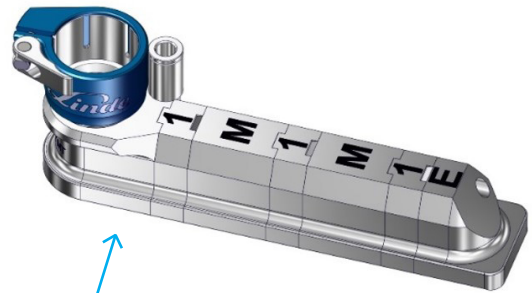


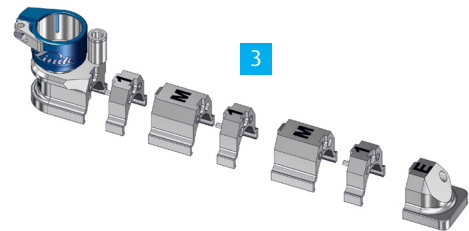


ARCLINE[®] MT Quick Start Guide

Pipe diameter		Material Thickness (mm)		
		1	2-3	4
mm	Inch	<i>Mother module + following parts</i>		
60.3	2"	9-E	9-M-9-E	9-M-9-M-9-E
76.1	2 1/2"	9-E	9-M-8-E	9-M-8-M-8-E
88.9	3"	8-E	8-M-8-E	8-M-8-M-8-E
101.6	3 1/2"	8-E	8-M-8-E	8-M-8-M-6-E
114.3	4"	7-E	7-M-7-E	7-M-7-M-7-E
139.7	5"	6-E	6-M-6-E	6-M-6-M-6-E
168.3	6"	6-E	6-M-5-E	6-M-5-M-5-E
193.7	7"	5-E	5-M-5-E	5-M-5-M-5-E
219.1	8"	5-E	5-M-5-E	5-M-5-M-5-E
273	10"	4-E	4-M-4-E	4-M-4-M-4-E
323.9	12"	4-E	4-M-3-E	4-M-3-M-4-E
355.6	14"	4-E	4-M-2-E	4-M-2-M-3-E
406.4	16"	3-E	3-M-3-E	3-M-3-M-3-E
457.2	18"	3-E	3-M-3-E	3-M-3-M-2-E
508	20"	3-E	3-M-3-E	3-M-3-M-2-E
609.6	24"	2-E	2-M-2-E	2-M-2-M-2-E
711	28"	2-E	2-M-2-E	2-M-2-M-2-E
813	32"	2-E	2-M-2-E	2-M-2-M-2-E
914	36"	2-E	2-M-1-E	2-M-1-M-2-E
1016	40"	2-E	2-M-1-E	2-M-1-M-2-E
1120	44"	2-E	2-M-1-E	2-M-1-M-2-E
1220	48"	2-E	2-M-1-E	2-M-1-M-2-E
1320	52"	2-E	2-M-1-E	2-M-1-M-2-E
1420	56"	2-E	2-M-1-E	2-M-1-M-2-E
1520	60"	2-E	2-M-1-E	2-M-1-M-2-E
1620	64"	2-E	2-M-1-E	2-M-1-M-2-E
1720	68"	2-E	2-M-1-E	2-M-1-M-2-E
1820	72"	1-E	1-M-1-E	1-M-1-M-1-E
2020	80"	1-E	1-M-1-E	1-M-1-M-1-E
flat	flat	1-E	1-M-1-E	1-M-1-M-1-E



Example: flat plate, thickness 4 mm



Key

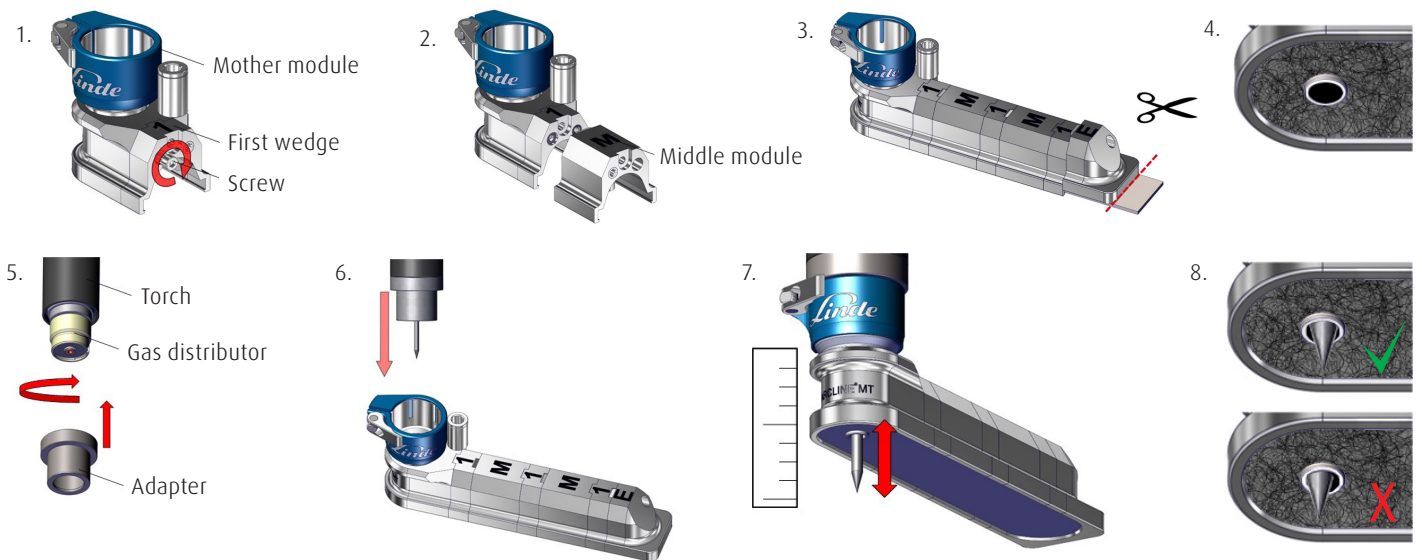
- 1 and 2 - Check the required parts for your application
- 3 - Assemble your parts (details see back page)
- 4 and 5 - Set the flow according to the length of your trail (number of middle modules) and your gas composition

E - End module, M - Middle module, 1-9 - Wedges

Number of middle modules	Gas flow (l/min)		
	I1 -Ar	R1 - ArH-2	R1 - ArH-5
0	26	18	14
1	39	27	21
2	52	36	28
3	65	45	35
4	78	54	42

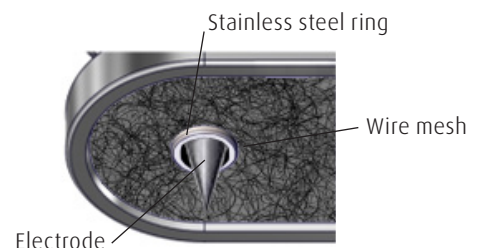
Step-up instructions:

1. Always start with the **Mother module** and attach the first wedge to it by putting the “nose” of the wedge into the gap of the mother module and screw both parts hand tight using the Allen key.
2. Continue with a **middle module** marked by an “M” and assemble it to the previous wedge of your trail. Ensure every wedge and middle module is equipped with an O-ring.
3. Repeat these steps until you reach the end module. **Before you assemble the End module** marked by an “E” feed the metallic gas distribution mesh through the grooves left and right of the trail. Hold the end module to the last wedge and cut the mesh exactly at the edge of the end module using the scissors from the starter kit. Finally, assemble the end module.
4. Assemble the mesh with the metallic ring orientated to the workpiece. (The stainless ring should be visible from the outside.)
5. Use the **jumbo gas distributor** of your torch. Instead of screwing the ceramic shielding gas nozzle, screw the adapter to it and check that there is no gap between torch and adapter. If you identify a gap, use the PTFE ring that came with the shielding gas nozzle provided by your torch manufacture.
6. Push the adapter in the Lockdown Feedneck and tighten the Lockdown Feedneck of the mother module. Connect your trail with a gas tube. For manual welding we recommend to use the smaller tube (adapter is in your starter kit).
7. Place the electrode through the ARCLINE MT. We recommend to set the electrode stick out to maximum 8 mm if an arc length of 3 mm is used (maximum distance trail to workpiece ~ 11 mm).
8. Ensure electrode sits central within the ring.



Insulation – check before ignition:

1. Ensure that the mesh wire does NOT protrude over the ceramic ring.
2. Check that the ceramic ring sits properly inside the mesh.
3. Set the electrode stickout around 8mm.
4. Ensure stainless steel ring is oriented to the workpiece.
5. Use an adequate arc length of around 3 mm.



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 please scan the QR code.

