

Operational Controls for MF33 Front Panel



1. **Burn back adjustment** - This determines how much of the wire is left sticking out of the contact tip when welding is stopped. Too much wire and there is a chance of it 'freezing' in the weld pool as it cools, too little and there is a chance that the wire will burn back into the contact tip, necessitating changing of the tip. Adjusting the control anti-clockwise increases the amount of wire sticking out of the tip and adjusting it clockwise reduces it.
2. **Wire speed control** - Adjusts the speed of the wire feed system up to a maximum of 23m/min.
3. **Voltage control** - Controls the welding voltage when used in conjunction with a Newarc R4/5000 multi-process or constant voltage power source.
4. **Latch** - Changes the mode of operation of the MIG torch switch between 2T and 4T. In 2T, the MIG torch switch is pressed to start welding and released to stop. In 4T, the torch switch is pressed and released to start welding and pressed and released again to stop welding.