

1. IDENTIFICATION

Manufacturer/Supplier Name WWS Weldability		Telephone Number 01462 482200	
Address: Peters House, Orbital Centre, Icknield Way, Letchworth Garden City, Hertfordshire, SG6 1ET			
Product Type: OXY / FUEL GAS ECONOMISER			
Trade Name OXY / FUEL GAS ECONOMISER		AWS Classification/Part number AE2000	

INSTRUCTIONS FOR USE

ADJUSTMENT OF BLOWPIPE HOOK

When dispatched the blowpipe arm is pushed back to reduce space for packing. Slacken central locking screw on the triangular rocker and pull the blowpipe hook out to its full extent then relock the screw.

FIXING AND OPERATING

Screw the gas saver firmly to the bench or other suitable support in such a position that the blowpipe can readily be hung up on the hook. The weight of the blowpipe hanging on the hook causes the two gas valves to be depressed, thus cutting off both gases simultaneously.

The lengths of hose between the gas saver and blowpipe should be as short as convenient.

If a high oxygen pressure is used the oxygen contained in the tube between the gas saver and blowpipe will take a short time to exhaust from the tubing after the flame has gone out, so do not think this indicates a leaky valve. To avoid this waste as far as possible use a low pressure of oxygen as you can. If a leak is suspected remove the tubes from the outlet side of the gas saver and test with soapy water.

ADJUSTMENT OF VALVES

The gas savers are carefully adjusted so that both gases shut off when the blowpipe is hanging on the hook and they should not be tampered with unnecessarily. If however, after prolonged use either valve commences to leak, remove the hose on the outlet side of the valve by undoing the union nuts. The valve which leaks can then be adjusted by slackening the lock nut and screwing down the adjusting screw in the triangular rocker above the leaky valve about one-eighth to one quarter of a turn and relocking the nut. If screwed down too much the other valve will be lifted off its seat and leak, so that care in adjustment is necessary. The stop on the underside of the triangular rocker must contact the body of the valve when the blowpipe is hung up otherwise the heavy pressure on the rubber valve seat will cause this to be cut and damaged.

PILOT LIGHT

The pilot light can be adjusted by turning the top section of the burner. The flame should be kept as small as possible and the jet cleaned from time to time with a very fine wire or a no 80 drill.

When lighting the blowpipe do not allow the flame to play on the body of the gas saver, as the heat will destroy the rubber diaphragms.

Notes:

- Maximum working pressure 150 PSI Oxygen/Air
- 9 PSI Acetylene
- 30 PSI Propane

