

Part # 520.1484



Processes

MIG(GTAW) Arc Welding

Flux-Cored(FCAW) Arc Welding

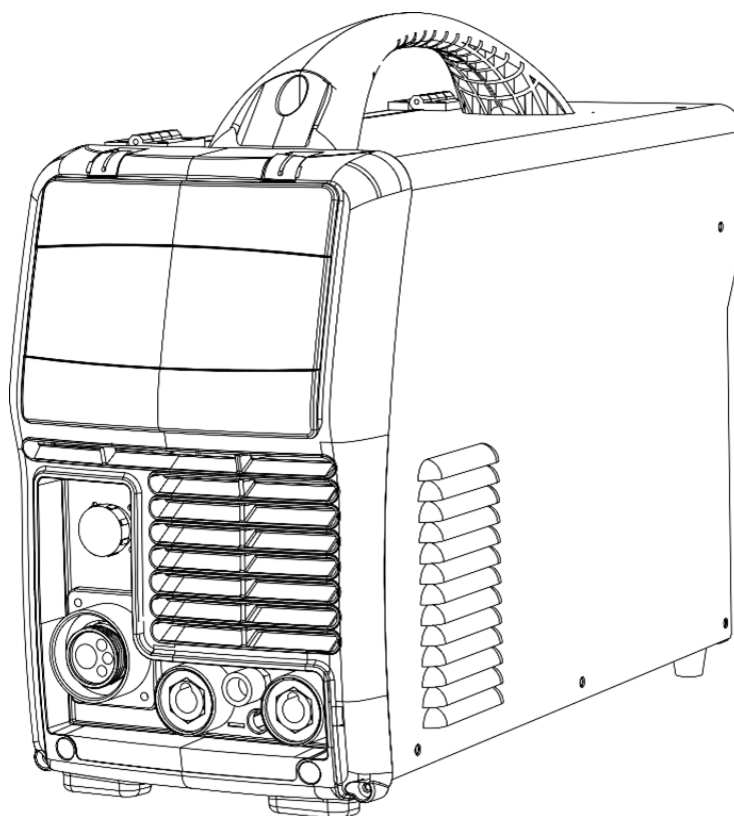
TIG (GTAW) Welding

STICK (SMAW) Welding

115VAC @ 50/60Hz



OPERATORS' MANUAL



140-Amp Multi-MIG Welder Synergic MIG, DC TIG & Stick

IMPORTANT: Read this Owner's Manual Completely before attempting to use this equipment. Save this manual and keep it handy for quick reference. Pay particular attention to the safety instructions we have provided for your protection. Contact your distributor if you do not fully understand this manual.

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§1 Safety

Notice: The instructions are for reference only. The manufacturer reserves the right to change descriptions and features due to product changes & upgrades.

The device is manufactured using state-of-the-art technology and according to recognized safety standards. If used incorrectly or misused, the machine can cause:

- Injury or death to the operator.
- Damage to the device and other material assets belonging to the operating company.
- Inefficient operation of the device.



General

All persons involved in commissioning, operating, maintaining, and servicing the device must:

- Be suitably qualified.
- Have sufficient knowledge of welding.
- Read and follow these operating instructions carefully.

The operating instructions must always be at hand wherever the device is being used. In addition to the operating instructions, attention must also be paid to any generally applicable and local regulations regarding accident prevention and environmental protection.

This is for your personal safety!

Environment

Products are limited to use under suitable conditions. In extreme cases, the use of products, such as high temperature, low temperature, electrical storm weather, may shorten the life of the machine and even cause damage, please avoid the above situation.



Excessive ambient temperature will cause the machine heat dissipation to be inadequate, resulting in damage to the internal components of the machine. Maximum operating ambient temperature is 104°F (40°C).



Low temperature may lead to performance degradation or damage of mechanical components inside the machine. Minimum operating temperature is 14°F (-10°C).



High humid environment may lead to oxidation of cabinet and circuit components. Operating machine in wet environments may lead to short circuit and other abnormalities. Avoid using in the water environments.

Areas

Mechanical moving parts risk damage to your body and others. The corresponding notices are as follows.



Items being welded generate and hold high heat and can cause severe burns. Don't touch hot parts with bare hands. Allow a cooling period before working on the welding gun. Use insulated welding gloves and clothing to handle hot parts and prevent burns.



A high risk of injury exists when the welding wire emerges from the welding torch. Always keep the torch well away from the body.



Keep all equipment safety guards, covers and devices in position and in good repair. Keep hands, hair, clothing, and tools away from V-rolls, fans and all other moving parts when starting, operating or repairing equipment, for example:



- Fans
- Cogs
- Rollers
- Shafts
- Wire spools and welding wire

By product

Infrared light radiation and harmful gas will inevitably occur in the welding process. In order to avoid danger, it is necessary to make corresponding preparations in advance.



Arc rays from the welding process produce intense visible and invisible ultraviolet and infrared rays that can burn eyes and skin.

- Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding.
- Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.
- Protect other nearby personnel with suitable, non-flammable screening and warn them not to watch the arc without protection.



Noise from some processes can damage hearing. You must protect your ears from loud noise to prevent permanent loss of hearing.

- To protect your hearing from loud noise, wear protective ear plugs and/or earmuffs. Protect others in the workplace.
- Noise levels should be measured to be sure the decibels (sound) do not exceed safe levels.



The buildup of gas can cause a toxic environment, deplete the oxygen content in the air resulting in death or injury. Many welding shield gases are invisible and odorless.

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air respirator.



Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases.

- Do not breathe the smoke and gas from welding or cutting! Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone. Additional precautions are also required when welding galvanized steel.
- Do not weld in locations near chlorinated hydrocarbon vapors coming from degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with solvent vapors to form phosgene, a highly toxic gas, and other irritating products.
- Shielding gases used for arc welding can displace air and cause injury or death. Always use enough ventilation, especially in confined areas, to ensure breathing air is safe.
- Read and understand the manufacturer's instructions for this equipment and the consumables to be used, including the material safety data sheet and follow your employer's safety practices.

Explosion

In the process of arc welding, there is a chance for fire, explosion and gas leakage. Before using the product, know the correct preventive measures in order to avoid accidents and or explosions.

Spatter from the welding arc, hot work piece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosions, overheating or fire.



- Welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Avoid welding near hydraulic lines as they contain flammable oil.
- Have a fire extinguisher readily available. Where compressed gases are to be used at the job site, special precautions should be used to prevent hazardous situations.
- Vent hollow castings or containers before heating, cutting, or welding. They may explode.
- Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuff-less pants, high shoes and a cap over your hair.
- Connect the work cable to the work as close to the welding area as practical. Work cables connected to the building framework or other locations away from the welding area increase the possibility of the welding current passing through lifting chains, crane cables or other alternate circuits. This can create fire hazards or overheat lifting chains or cables until they fail.

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode.



- Protect gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames sparks, and arcs.
- Ensure cylinders are held secure and upright to prevent tipping or falling over.
- Never allow the welding electrode or earth clamp to touch the gas cylinder, do not drape welding cables over the cylinder.
- Open the cylinder valve slowly and turn your face away from the cylinder outlet valve and gas regulator.



Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used.

Cylinder

- Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.
- Cylinders should be located:
 - Away from areas where they may be struck or subjected to physical damage.
 - A safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.
- Never allow the electrode, electrode holder or any other electrically “hot” parts to touch a cylinder.
- Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
- Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.

Electricity

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and internal machine circuits are also live when power is on.



Different products have different requirements for input voltage, such as single-phase and three-phase. If the machine with three-phase electricity as input appears phase absence or voltage fluctuation, it may cause serious damage to the product interior.



All products must be well grounded before they are connected to the power supply. In case of abnormal case such as shell leakage, please disconnect the power supply immediately and notify the professionals for maintenance.



Don't sling or pull cable leads around either the body or parts of the body. The electrode (rod electrode, tungsten electrode, welding wire, etc.) must

- Never be immersed in any liquid.
- Never be touched when current is flowing.



When the machine is connected to the power supply, there is electricity inside the machine. Please do not touch the wires, circuit boards and related electrical parts to avoid life hazards.



During MIG/MAG or TIG welding, the welding wire, the wire spool, the drive rollers and all metal parts that are in contact with the welding wire are live. Always set the wire-feed unit up on a sufficiently insulated surface or use a suitable, insulated wire-feed unit mount.

Supporting measures for avoidance of EMC problems:

1. Main LINE supply

If electromagnetic interference arises despite correct mains connection, additional measures are necessary.



EMC

2. Welding power leads must be kept as short as possible, must run close together and be kept well apart from other leads

3. Equipotential bonding

4. Earthing of the workpiece

If necessary, establish an earth connection using suitable capacitors.

5. Shielding, if necessary

- Shield off other nearby devices.
- Shield off entire welding installation.

Radiation Class A Device.

- Only can be used in the industrial area.
- If it is used in other areas, it may cause connection and radiation problems of circuit.



EMC Class

Radiation Class B device.

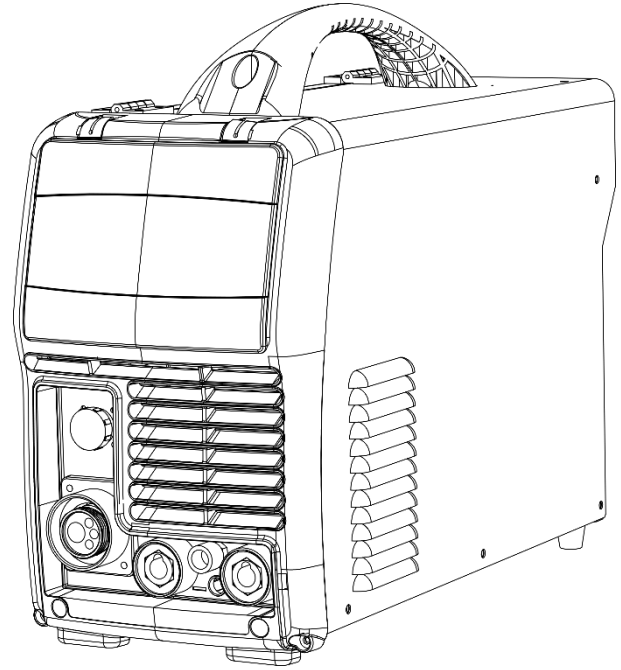
- Satisfy the emissions criteria for residential and industrial areas.
- This is also true for residential areas in which the energy is supplied from the public low-voltage mains.

EMC device classification as per the rating plate or technical data.

§2 Overview

§2.1 Features

- New LCD panel for easy operator interface and process set-up.
- Touch pads for accurate pre-setting of welding parameters & process.
- Latest PFC inverter technology allows 115 & 230VAC input power.
- MIG with **Synergic** (auto set or smart) programs for mild steel, stainless steel and CuSi
 - 2T /4T welding mode
 - function parameter adjustment
- DC TIG
 - Lift-arc ignition (prevents tungsten sticking during arc ignition)
 - 2T /4T Trigger Control
 - Adjustable Down slope
 - Adjustable Post Flow
- MMA function (Stick electrode)
 - Hot start (improves electrode starting)
 - Adjustable Arc Force
- Internal 2-roll wire feeder, gear driven for up to 8-inch (200mm) spool.
- Euro-connect MIG torch receptacle for professional coaxial power cable.
- Standard Dinse cable receptacles for maximum power transfer.
- 9-Pin control receptacle for TIG torch or foot pedal and spool gun.
- IP21S rating for environmental/safety protection.
- **Spool gun ready** with SG torch receptacles and selection switch.



§2.2 Technical Data

Models Parameters	MULTI-MIG 140M		
Input Voltage (V)	1-110±10%		
Frequency (HZ)	50/60		
	MIG	TIG	MMA
Input Current (A)	50	24	38
Input Power (kVA)	5.44	2.67	4.15
Welding Current (A)	30~140	10~100	10~100
No-load Voltage (V)	50	50	50
Duty cycle (40℃)	35% 140A 60% 105A 100% 85A	35% 100A 60% 75A 100% 60A	
Power Factor (%)	0.68		
Diameter (mm)	Fe: 0.6/0.8/0.9/1.0 SS: 0.8/1.0 Flux-Cored: 0.6/0.8/0.9/1.0 CuSi3: 1.0		
Protection class	IP21S		
Circuit breaker	JD03-A1 30A		
Dimensions (mm)	510*210*410		
Weight (Kg)	13.5		

Note: The above parameters are subject to change with future machine improvement!

§2.3 Brief Introduction

Multi-MIG series of welding machines is a new inverter-based MIG/MMA/TIG welding machine with synergic (Smart / Auto set) programs. The MIG function allows you to weld with gas shielded wire applications giving excellent, professional welding results. Easy step-less adjustment of voltage and wire feed coupled with the screen allows easy setting of welding parameters. Multi-MIG series of welding machines features MIG welding with Synergic welding programs designed for ease of use with your selected gas mixture. The operator selects the material, gas, wire diameter and thickness then simply start welding. Once this is done the operator can make fine adjustments to the voltage for even greater control of the weld pool. The added Lift-Arc DC TIG capability delivers perfect arc ignition every time and a remarkably smooth stable arc produces high quality TIG welds. TIG functionality includes adjustable down slope & post gas. The stick welding (MMA) capability delivers easy electrode welding with high quality results, including cast Iron,

stainless and low hydrogen. An additional feature is the spool gun ready function that allows the simple connection of spool gun for the use of thin or softer wires that don't have the column strength to feed through MIG torches, such as aluminum wire.

Multi-MIG series of arc welding machine is an industrial quality machine that is suitable for all positions welding for various plates made of stainless steel, carbon steel, alloy steel, etc. Applications applied to pipe installment, petrochemical, architecture equipment, collision repair and common steel fabrication.

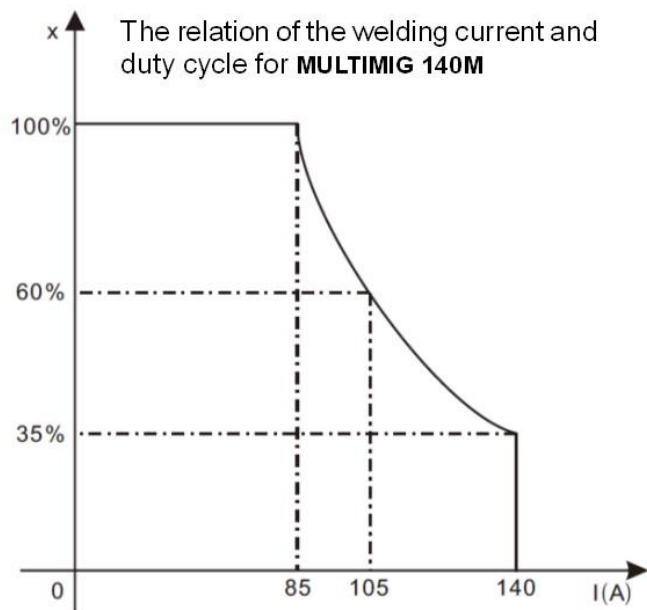
Multi-MIG series of welding machines has built-in automatic protection functions to protect the machines from over-voltage, over-current and over-heat. If any one of the above problems happens, the error code is displayed on the screen and output current will be shut off automatically for the machine to protect itself and prolong equipment life.

§2.4 Duty cycle and Over-heat

The letter "X" stands for Duty Cycle, which is defined as the portion of the time a welding machine can weld continuously with its max. rated output current within 10-minute cycle time at 104°F ambient for UL/CSA certification.

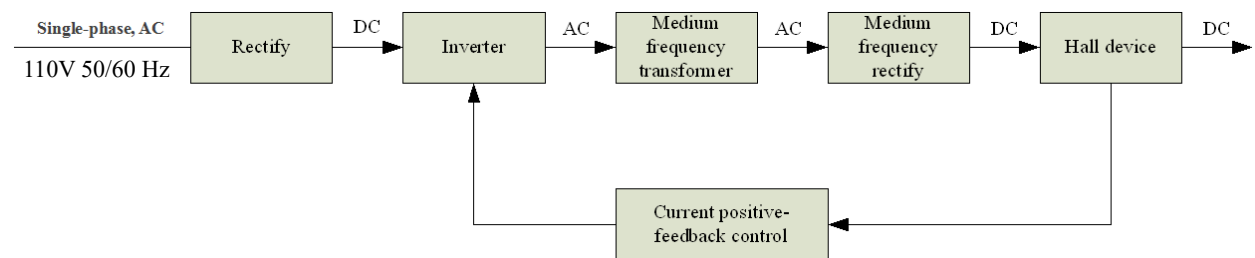
The relation between the duty cycle "X" and the output welding current "I" is shown as the right figure.

If the welding machine is overheating, the IGBT over-heat sensor will send a signal to the welding machine control unit to cut the output welding current OFF and the error code is displayed on the screen. In that case, the machine should not be welding again for 10~15 minutes to cool down with the fan running. When operating the machine again, the welding output current or the duty cycle should be reduced.



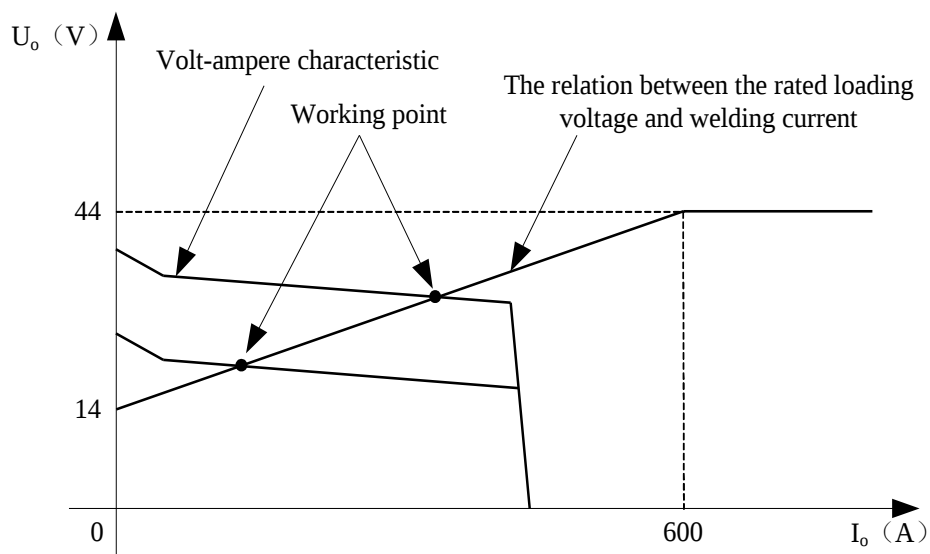
§2.5 Working Principle

The working principle of Multi-MIG series welding machine is shown as the following figure. single-phase 115V work frequency AC is rectified into DC, then is converted to medium frequency AC by inverter device (IGBT), after reducing voltage by medium transformer (the main transformer) and rectifying by medium frequency rectifier (fast recovery diodes) and is outputted by inductance filtering. In MIG welding mode, meanwhile, the welding current parameter can be adjusted continuously and infinitely to meet with the requirements of welding mode.



§2.6 Volt-Ampere Characteristic

Multi-MIG series of welding machines has an excellent volt-ampere characteristic, whose graph is shown as the following figure. The relation between the rated loading voltage U_2 and welding current I_2 is as follows: $U_2=14+0.05I_2$ (V).

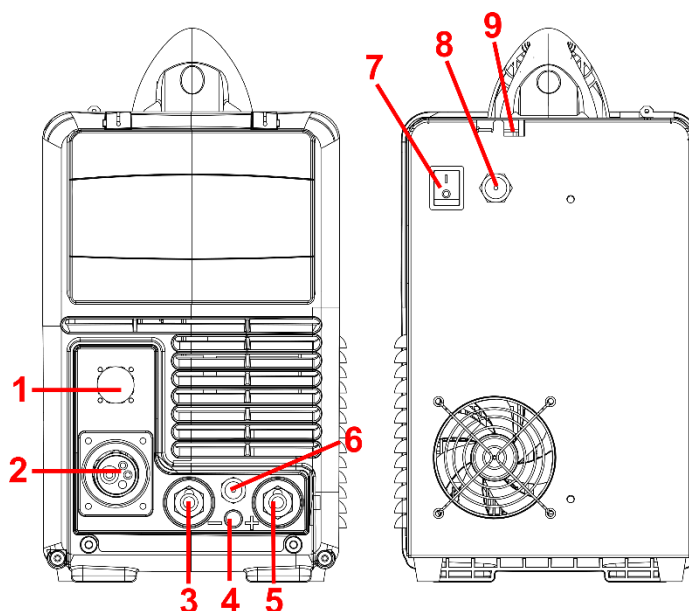


§3 Panel Functions & Descriptions

§3.1 Machine Layout Description

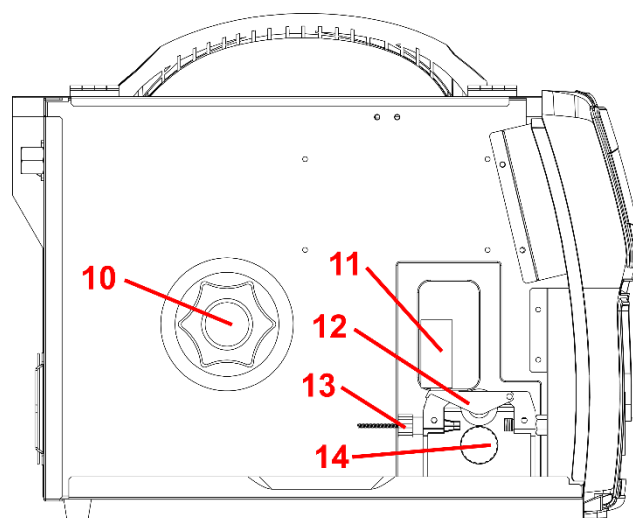
Front and rear panel layout of welding machine

1. Control socket for TIG or spool gun (9-pin).
2. MIG torch euro connector.
3. Negative (-) welding power output connection socket.
4. Power connection for polarity change. (Flux-cored)
5. Positive (+) welding power output connection socket.
6. TIG torch gas connector.
7. Power switch.
8. Gas inlet connector.
9. Input power cable.



Wire Feeder of welding machine

10. Spool holder.
11. Wire feed tension adjustment.
12. Wire feed tension arm.
13. Wire feeder inlet guide.
14. Wire drive roller.



§3.2 Layout for Control panel

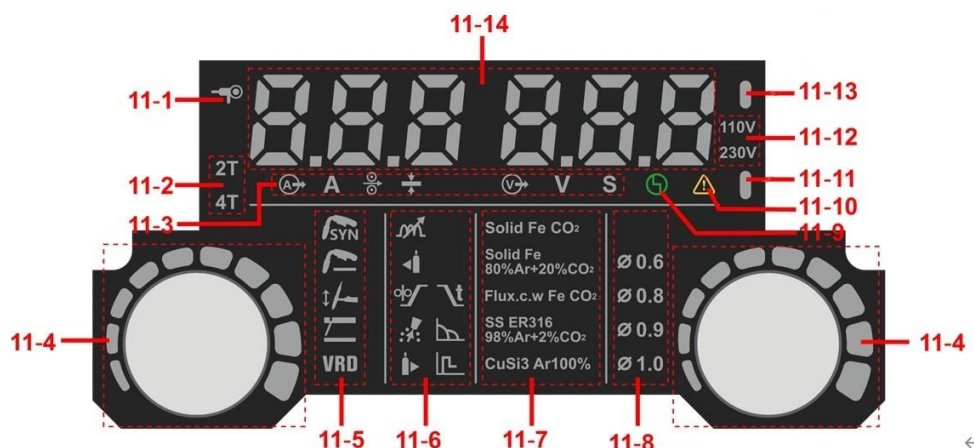
§3.2.1 Control panel



1. **Spool gun select button:** Press to select spool gun in MIG Manual welding mode.
2. **Trigger mode select button:** Press to select 2T (ON/OFF) or 4T (Latching) trigger.
3. **LH select / adjust knob:** Press to select parameters and turn to adjust values, such as welding current. In MIG welding mode, press it to select parameters.
4. **Welding mode select button:** Press to select MMA / TIG Lift / MIG Manual / MIG Synergic welding mode.
5. **Process parameter select button:** Press to select welding process parameters.
6. **Synergic material select button:** Press to select wire material and shield gas in MIG Synergic welding mode.
7. **Synergic wire select button:** Press to select wire diameter in MIG Synergic welding mode.
8. **RH select / adjust knob:** Press to select parameters and turn it to adjust .
9. **Air check button:** Press to confirm gas cylinder contents, pressure and flow.
10. **Manual wire feed button:** Press and hold to feed wire into MIG torch on install.
11. **Screen:** It will show all welding parameters, such as welding mode, welding current and other parameters set or error code. *

* Denotes more detailed explanation of function to follow.

Multifunction screen (11)



- 11-1. Spool gun display:** Select spool gun welding mode by pressing the spool gun button (in MIG Manual), and the corresponding icon on the screen will light up.
- 11-2. Trigger mode display:** Select the desired trigger mode by pressing the trigger mode button, and the corresponding icon on the screen will light up.
- 11-3. Welding parameter display:** Select the welding parameters to be adjusted by pressing the L/R parameter select/adjust knob (in MIG), and the corresponding icon on the screen will light up.
- 11-4. Progress bar display:** When you turn the knob, the progress bar will illuminate.
- 11-5. Welding mode display:** Select the desired welding mode by pressing the welding mode button, and the corresponding display icon will illuminate.
- 11-6. Process parameter display:** Select the welding parameters by pressing the parameter select button, and the corresponding display icon will illuminate.
- 11-7. Synergic-material display:** Select the desired synergic-material by pressing the synergic-material select button, and the corresponding display icon will illuminate.
- 11-8. Synergic-diameter display:** Select the desired synergic-diameter by pressing the synergic-diameter select button, and the corresponding display icon will illuminate.
- 11-9. Power display:** The corresponding icon on the screen will illuminate when machine is switched "ON".
- 11-10. Alarm display:** The corresponding icon on the screen will illuminate when over voltage, over current, input phase loss or electrical overheating (due to exceeding duty cycle) is detected, and protection is activated.

11-11. Air check display: Icon on the screen will illuminate when the air check energized.

11-12. Input voltage display: Displays the input voltage of the welder.

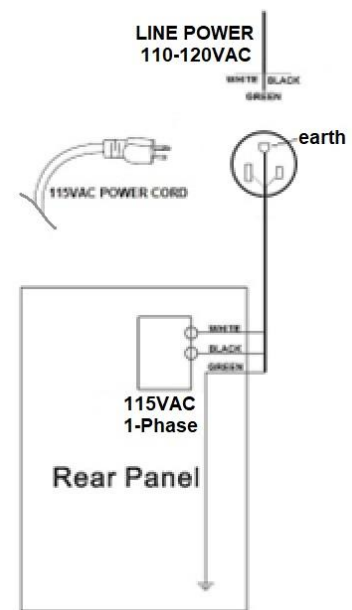
11-13. Manual wire feed display: Icon on the screen will illuminate when manual wire feed is engaged.

11-14. Digital multifunction display: Before welding this displays the setting selected or being adjusted. During welding it displays welding current and welding voltage.

12- Machine Power Connections

The Multi-Mig machine features high efficiency inverter power supply allowing it to be connected to any 110-120VAC, single-phase power outlet.

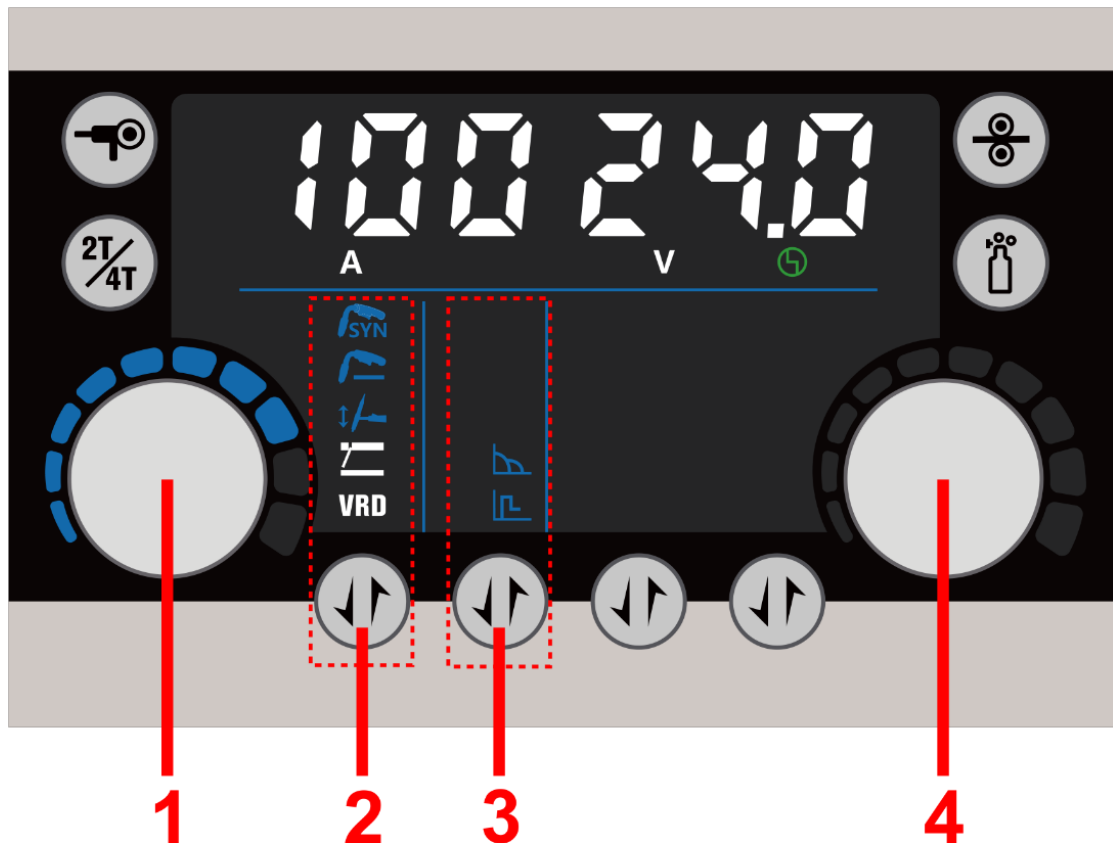
110-120VAC LINE CONNECTION: Machine is provided with NEMA 5-15P power cord. This allows the machine to be plugged into a standard 115V outlet with **20 amp (min.) circuit breaker**.



WARNING: Any modification or removal of factory installed service power cords or plugs will VOID MACHINE WARRANTY?

NOTICE: In the event NEMA5-15R outlet, with rated circuit breaker amperage are not available, it should be installed by a licensed electrician in accordance with national & local codes.

§3.2.2 MMA display introduction



1. **LH select / adjust knob:** Turn to adjust the welding current.
2. **Welding mode button:** Press to select MMA VRD, and the corresponding icon on the screen will illuminate.
3. **Process parameter select button:** Press to select Hot Start or Arc Force, and the corresponding icon on the screen will illuminate. Turn RH select / adjust knob (4) to adjust values.
4. **RH select / adjust knob:** Turn to adjust the welding parameter values.

Hot start

Hot start provides extra power when the weld starts to counteract the high resistance of the electrode and workpiece as the arc is started. Setting range: 0~10.

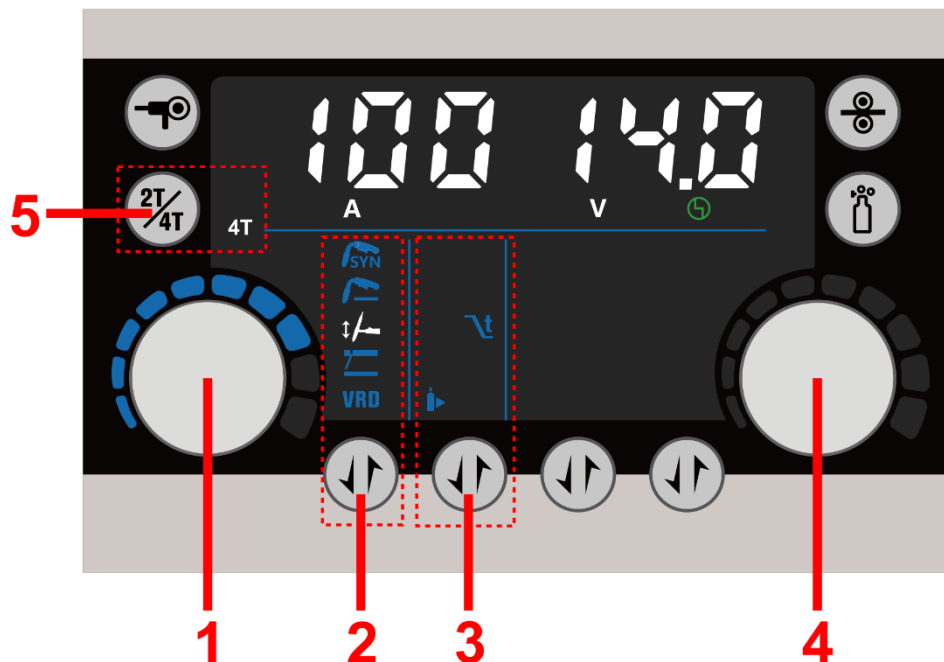
Arc force

An MMA welding power source is designed to produce constant output current. This means with different types of electrodes and arc lengths; the welding voltage varies to keep the current constant. This can cause instability in some welding conditions as MMA

welding electrodes will have a minimum voltage they can operate with and still have a stable arc.

Arc Force control boosts the welding power if it senses the welding voltage is getting too low. The higher the arc force adjustment, the higher the minimum voltage that the power source will allow. This effect will also cause the welding current to increase. 0 is Arc Force off, 10 is maximum Arc Force. This is practically useful for electrode types that have a higher operating voltage requirement or joint types that require a short arc length such as out of position welds.

§3.2.3 TIG Lift display introduction



1. **LH select / adjust knob:** Turn to adjust the welding current.
2. **Welding mode button:** Press to select TIG LIFT, and the corresponding icon on the screen will illuminate.
3. **Process parameter select button:** Press to select Down Slope or Post Flow, and the corresponding icon on the screen will illuminate. Turn RH select / adjust knob (4) to adjust values.
4. **RH select / adjust knob:** Turn to adjust the welding process parameter values.
5. **Trigger mode button:** Press to select 2T (ON/OFF) or 4T (Latching) trigger mode, and the corresponding icon on the screen will illuminate.

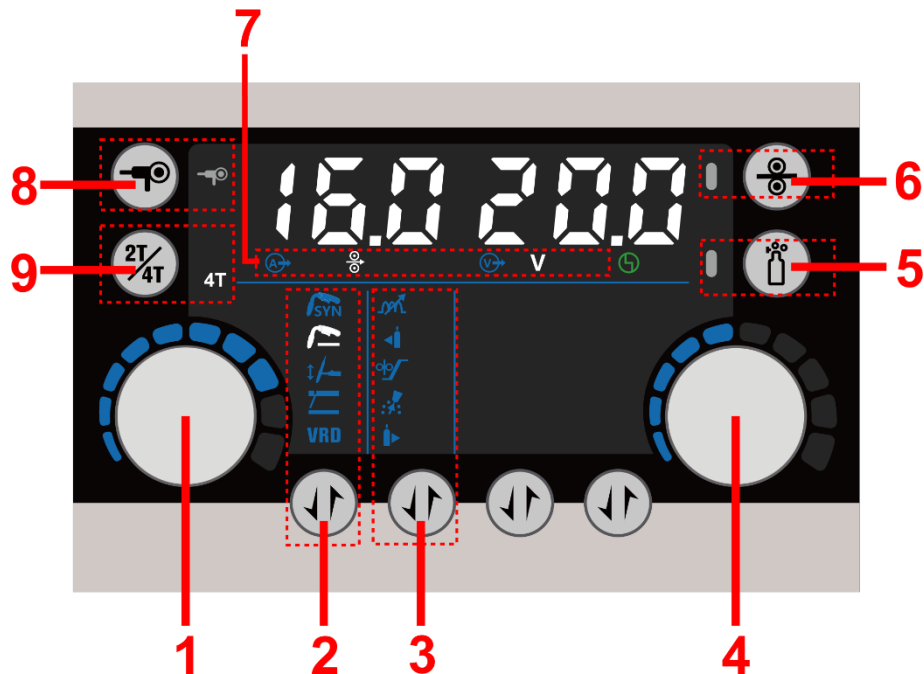
Down Slope

When the trigger is released, the welding current will reduce gradually over the time selected down to 0. This allows the operator to complete the weld without leaving a 'crater' at the end of the weld pool. Unit (S) and setting range (0-10.0S).

Post Flow

Controls time the shielding gas continues to flow after the arc has stopped. This protects the weld area and tungsten electrode from contamination while it is still hot enough to react with atmospheric gases. Unit (Seconds) and setting range (0-10.0S).

§3.2.4 MIG Manual display introduction



1. **LH select / adjust knob:** Press to select welding parameter and turn to adjust.
1. **Welding mode button:** Press to select MIG Manual, and the corresponding icon on the screen will illuminate.
2. **Process parameter select button:** Press to select inductance / Pre Flow / Slow Feed / Burn Back / Post Flow, and the corresponding icon on the screen will illuminate. Turn RH select / adjust knob (4) to adjust values.
3. **RH select / adjust knob:** Press to select welding parameter and turn to adjust values.
4. **Air check button:** When the air check button is pressed, the corresponding icon on the screen will illuminate and shield gas will flow.

5. **Manual wire button:** When the manual wire button is pressed, the corresponding icon on the screen will illuminate.
6. **Welding parameter display:** Select the welding parameters to be adjusted by pressing the parameter select/adjust knob and turn it to adjust values.
7. **Spool gun button:** Press to select and spool gun icon on the screen will illuminate.
8. **Trigger mode button:** Press it to select 2T (ON/OFF) or 4T (Latching) trigger mode, and the corresponding icon on the screen will illuminate.

MIG Wave Control (inductance)

This setting changes the MIG waveform to simulate changing the inductance of the welding circuit. Inductance controls the rate of the current rise and fall as the welding wire contacts the workpiece (known as a short circuit). More inductance increases the short circuit time and decreases the short circuit frequency rate. This causes a wider and more penetrating arc, useful for thicker weld joints. Less inductance will create a narrow more focused arc. Inductance change will have no practical effect on MIG spray transfer process (as opposed to short circuit process).

Pre flow

Controls the period shielding gas will flow for when the torch is triggered before the arc starts. This purges the work area of atmospheric gas which could contaminate the weld before the weld starts. Unit (Seconds), Range: 0-5.

Slow feed

This function is used to regulate the acceleration of wire feeding from start to set point. Unit (Seconds), Range: 0-10.

Burn back

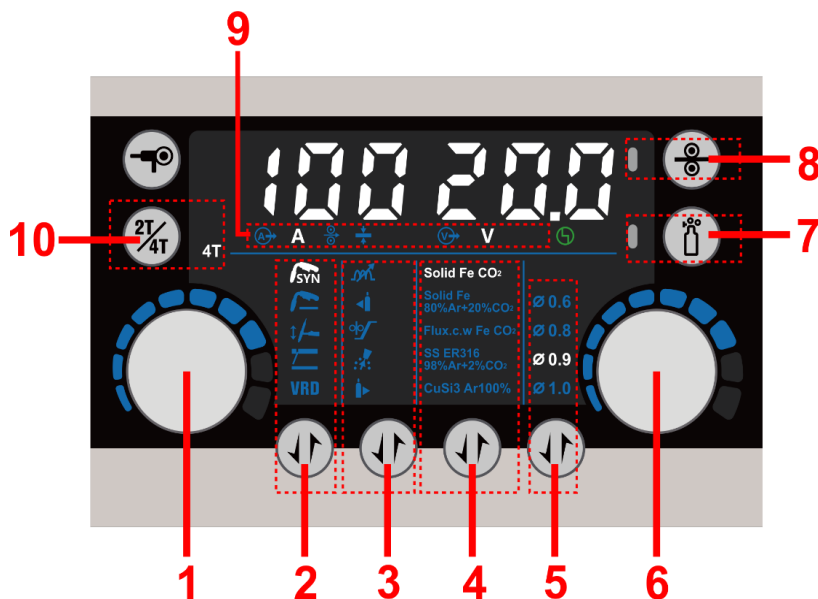
Burn back adjustment controls the short period of time that the wire feed will continue to run for after the main welding current stops. If the wire feed and current is stopped at exactly the same time, the wire will still be hot and 'burn back' into the contact tip. If this occurs, increasing the burn back adjustment will cause the wire feeder to run for longer after the arc has stopped. If the burn back adjustment is too high, the operator will be left with excess wire 'stickout' from the contact tip that will require correcting before starting the next weld. Unit (Seconds), Range: 0-10.

Post flow

Controls the period the shielding gas continues to flow for after the arc is stopped. This protects the weld area from contamination while it is still hot enough to react with atmospheric gases, after the weld is finished. Unit (Seconds), Range: 0-10.

§3.2.5 MIG SYNERGIC display introduction

The operator simply selects **synergic MIG**, **wire type** (with corresponding shielding gas) and **wire size** with touchpads under display. Once these have been entered, the final input is **material thickness**, and this is entered by pressing the LH Select/Adjust knob 3-times to illuminate the thickness icon and turning to set thickness. To “fine tune” the program, push RH Select/Adjust knob to illuminate Voltage icon and turn to adjust. To reset the voltage for a synergic program back to factory default, change to another program and back again.



- 1. LH select / adjust knob:** Once MIG SYN mode is selected (See #2), press knob three times to select final Synergic parameter of material thickness (Thickness icon will illuminate) and turn to adjust material thickness.
- 2. Welding mode button:** Press to select MIG SYN, and the corresponding icon on the screen will illuminate. Now the machine is in MIG SYN mode.

3. **Process parameter select button:** Press to select Inductance / Pre Flow / Slow Feed / Burn Back / Post Flow, and the corresponding icon on the screen will illuminate. Turn RH select / adjust knob (6) to adjust values.
4. **Synergic - wire type select button:** Press to select steel (Fe), flux-cored (Fx), stainless steel (SS) or silicone bronze/aluminum (CuSi) welding wire.
5. **Synergic – wire diameter select button:** Press to select wire diameter, and the corresponding icon on the screen will illuminate.
6. **RH select / adjust knob:** Press to adjust (fine tune) welding parameters of crater voltage (only MIG 4T) or welding voltage (icon will illuminate) if desired after test weld and turn to adjust values.
7. **Air check button:** When the air check button is pressed, the corresponding icon on the screen will illuminate and shield gas will flow.
8. **Manual wire button:** When the manual wire button is pressed, the corresponding icon on the screen will illuminate and wire will feed through the torch.
9. **Welding parameter display:** Select the welding parameters to be adjusted by pressing the select / adjust knob and turn to adjust values.
10. **Trigger mode button:** Press it to select 2T (ON/OFF) or 4T (Latching) trigger mode, and the corresponding icon on the screen will illuminate

§4 Installation & Operation

§4.1 Installation & Operation for MMA Electrode Welding

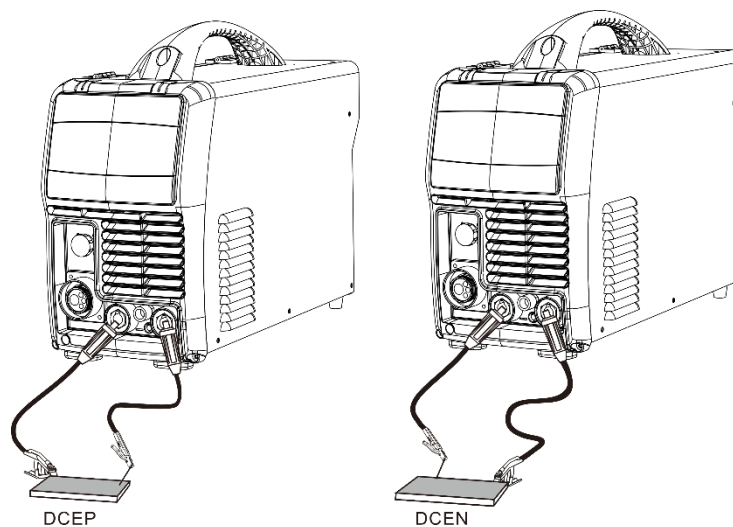
§4.1.1 Set-Up Installation

Two Dinse sockets are available on this welding machine, One Positive (+) and one Negative (-) polarity, to connect MMA/Electrode holder cable and earth clamp cable. Various electrodes require different polarity for optimum results and careful attention should be paid to the polarity, refer to the electrode manufacturers information for the correct polarity.

DCEP: Electrode connected to Positive (+) output socket.

DCEN: Electrode connected to Negative (-) output socket.

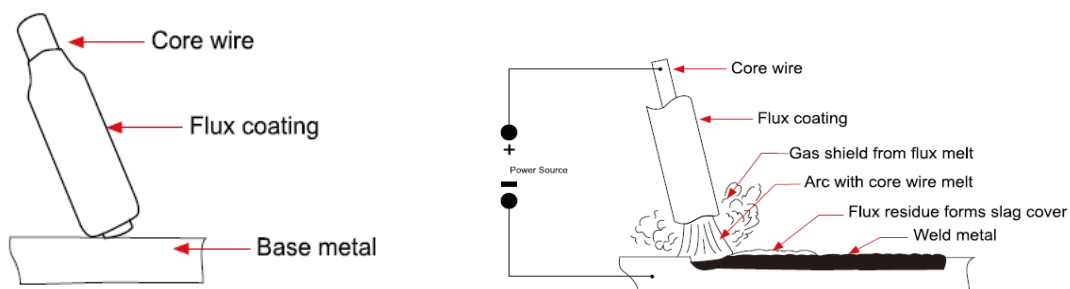
MMA (DC): Choosing the connection of DCEN or DCEP according to the different electrodes. Please refer to the electrode manual.



- (1) Turn the power source on and press the welding mode key to MMA welding mode.
- (2) Set the welding current relevant to the electrode type and size being used as recommended by the electrode manufacturer.
- (3) Set the Hot Start and Arc Force as required using knobs and buttons.
- (4) Place the electrode into the electrode holder and clamp tight.
- (5) Strike the electrode against the work piece to create an arc and hold the electrode steady to maintain the arc.

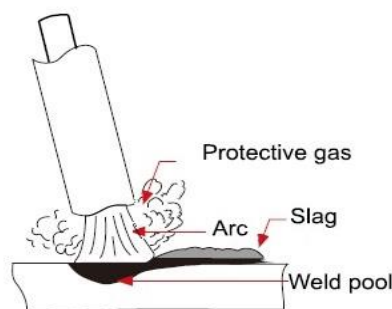
§4.1.2 MMA/Stick Electrode Welding

One of the most common types of arc welding is manual metal arc welding (MMA) or stick welding. An electric current is used to strike an arc between the base material and a consumable electrode rod or 'stick'. The electrode rod is made of a material that is compatible with the base material being welded and is covered with a flux that releases a gaseous vapor that serve as a shielding gas and providing a layer of slag, both of which protect the weld area from atmospheric contamination. The electrode core itself acts as filler material the residue from the flux that forms slag covering over the weld metal must be chipped away after welding.



MMA / Stick Electrode

- The arc is initiated by momentarily touching the electrode to the base metal.
- The melted electrode metal is transferred across the arc into the molten pool and becomes weld metal.
- The deposit is covered and protected by slag from the electrode flux coating.



Flux Properties

- producing a protective gas around the weld area
- providing fluxing elements and deoxidizer
- creating a protective slag coating over the weld
- establishing arc characteristics
- adding alloying elements

Stick electrodes serve many purposes in addition to filler metal to the molten pool. These additional functions are provided mainly by the various coverings on the electrode.

§4.1.3 MMA Welding Fundamentals

Electrode Selection

As a rule, select an electrode of similar composition to the parent metal. However, for some metals there is a choice of several electrodes, each of which has properties to suit specific classes of work. It is recommended to consult your welding supplier.

Average Thickness of Material	Max Recommended Electrode Diameter
1.0-2.0 mm	2.5 mm
2.0-5.0 mm	3.2 mm
5.0-8.0 mm	4.0 mm
>8.0 mm	5.0 mm

The size of the electrode generally depends on the thickness of the section being welded, and the thicker the section the larger the electrode required. The maximum size of electrodes that may be used for various thicknesses based on a general-purpose type 6013 electrode.

Welding Current (Amperage)

Electrode Size ø mm	Current Range (Amps)
2.5 mm	60-95
3.2 mm	100-130
4.0 mm	130-165
5.0 mm	165-260

Correct current selection for a particular job is an important factor in arc welding. With the current set too low, difficulty is experienced in striking and maintaining a stable arc. The electrode tends to stick to the work, penetration is poor and beads with a distinct rounded profile will be deposited. Too high

current is accompanied by overheating of the electrode resulting undercut and burning through of the base metal and producing excessive spatter. Normal current for a particular job may be considered as the maximum, which can be used without burning through the work, over-heating the electrode or producing a rough spattered surface. The table shows current ranges generally recommended for a general-purpose type 6013 electrode.

Arc Length

To strike the arc, the electrode should be gently scraped on the work until the arc is established. There is a simple rule for the proper arc length; it should be the shortest arc that gives a good surface to the weld. An arc too long reduces penetration, produces spatter, and gives a rough surface finish to the weld. An excessively short arc will cause sticking of the electrode and result in poor quality welds. General rule of thumb for down hand welding is to have an arc length no greater than the diameter of the core wire.

Electrode Angle

The angle that the electrode makes with the work is important to ensure a smooth, even transfer of metal. When welding in down hand, fillet, horizontal or overhead the angle of the electrode is generally between 5 and 15 degrees towards the direction of travel. When vertical up welding, the angle of the electrode should be between 80 and 90 degrees to the work piece.

Travel Speed

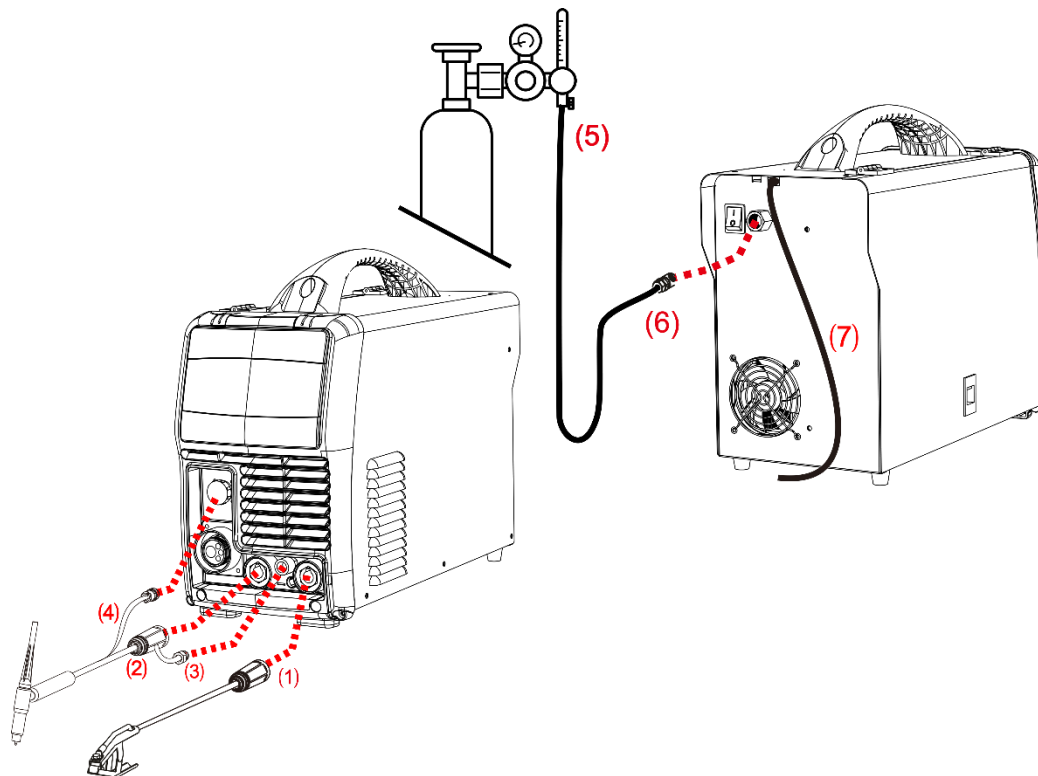
The electrode should be moved along in the direction of the joint being welded at a speed that will give the size of run required. At the same time, the electrode is fed downwards to always keep the correct arc length. Excessive travel speeds lead to poor fusion, lack of penetration etc., while too slow a rate of travel will frequently lead to arc instability, slag inclusions and poor mechanical properties.

Material and Joint Preparation

The material to be welded should be clean and free of any moisture, paint, oil, grease, mill scale, rust or any other material that will hinder the arc and contaminate the weld material. Joint preparation will depend on the method used include sawing, punching, shearing, machining, flame cutting and others. In all cases edges should be clean and free of any contaminants. The type of joint will be determined by the chosen application.

§4.2 Installation & Operation for TIG Welding

§4.2.1 Set-Up for TIG Welding



- (1) Insert the earth cable plug into the positive socket on the front of the machine and twist to lock in place.
 - (2) Plug the welding torch into the negative socket on the front panel and twist to lock.
 - (3) Connect the gas line of TIG torch to outlet gas connector on the front of the machine.
 - (4) Connect the control cable of TIG torch or foot pedal to control socket of the machine.
 - (5) Connect the gas regulator to the gas cylinder and the gas line to the gas regulator.
 - (6) Connect the gas line to the machine inlet gas connector located on the rear panel.
 - (7) Connect the power cable of welding machine to the electrical outlet.
 - (8) Carefully open the valve of the gas cylinder, set the required gas flow rate.
 - (9) Select TIG function on the front panel.
 - (10) Set torch operation for 2T or 4T mode.
 - (11) Select welding current as required. The selected welding current will show on display.
- Set down slope time as required. The down slope time will show on the digital display.



(12) Assemble front end parts of the TIG torch, fitting a sharpened tungsten suitable for the material to be welded.



(13) Lay the outside edge of the cup on work piece with the tungsten Electrode 1-2mm from the work piece. Press and hold the trigger button on TIG torch to start the gas flow.



(14) With a small movement rotate the gas cup forward so that the tungsten electrode touches the work piece.



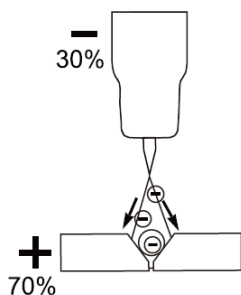
(15) Now rotate the Gas Cup in the reverse direction to lift the Tungsten electrode from the work piece to create the arc.



(16) Release the trigger or foot pedal to stop the welding.

IMPORTANT! – It is recommended that you check for gas leaks prior to operation and that the operator close the cylinder valve when the machine is not in use.

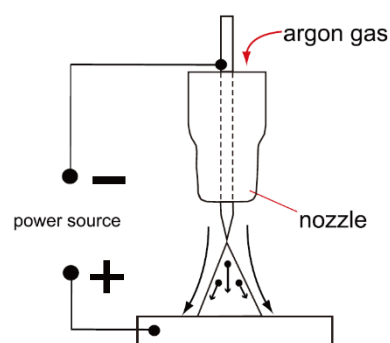
§4.2.2 DCTIG Welding



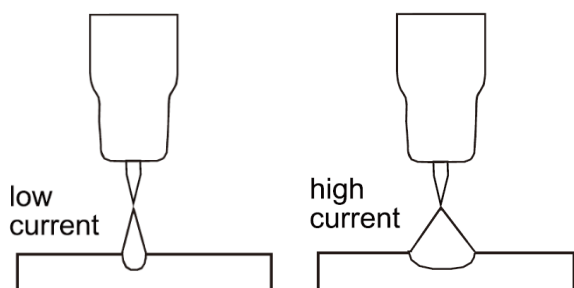
The DC power source uses what is known as DC (direct current) in which the main electrical component, known as electrons, flow in only one direction from the negative terminal (-) to the positive terminal (+). In the DC electrical circuit there is an electrical principle at work which provides that, in a DC circuit, **70% of the energy (heat) is always on the positive side**. This is important

because it determines what terminal to connect the TIG torch.

DC TIG welding is a process in which an arc is struck between a tungsten electrode and the metal workpiece. The weld area is shielded by an inert gas flow to prevent contamination of the tungsten, molten pool and weld area. When the TIG arc is struck the inert gas is ionized and superheated changing its' molecular structure which converts it into a plasma stream. This plasma stream that



flows between the tungsten and the work piece is the TIG arc and can be as hot as 19,000°C. It is a very pure and concentrated arc which provides the controlled melting of most metals into a weld pool. TIG welding offers the user the greatest amount of flexibility to weld the widest range of materials, thickness, and profiles. DC TIG welding is also the cleanest weld with no sparks or spatter.

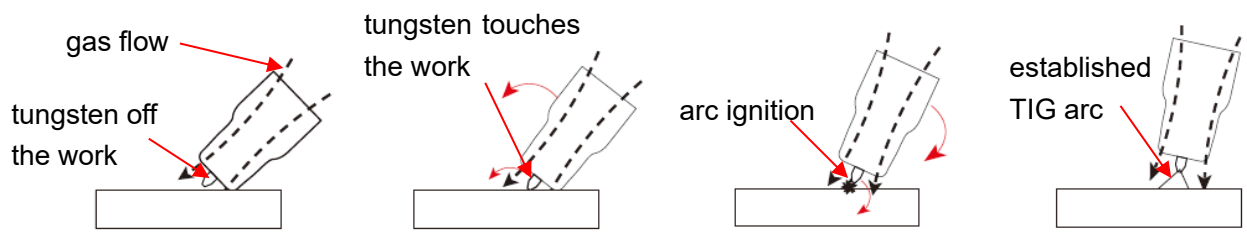


The intensity of the arc is proportional to the current that flows from the tungsten. The welder regulates the welding current to adjust the power of the arc. Typically, thin material requires a less powerful arc with less heat to melt the material so less current (amps) is

required, thicker material requires a more powerful arc with more heat so more current (amps) are necessary to melt the material.

LIFT ARC IGNITION for TIG Welding

Lift Arc is a form of arc ignition where the machine has voltage on the electrode to only a few volts, with a current limit of one or two amps (well below the limit that causes metal to transfer and contamination of the weld or electrode). When the machine detects that the tungsten has left the surface and a spark is present, it immediately (within microseconds) increases power, converting the spark to a full arc. It is a simple, safe lower cost alternative arc ignition process to HF (high frequency) and a superior arc start process to scratch start.



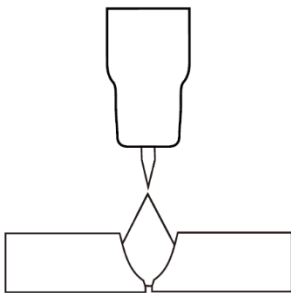
Lay the nozzle on the job without the tungsten touching the work.

Rock the torch sideways so that the tungsten touches the work & hold momentarily.

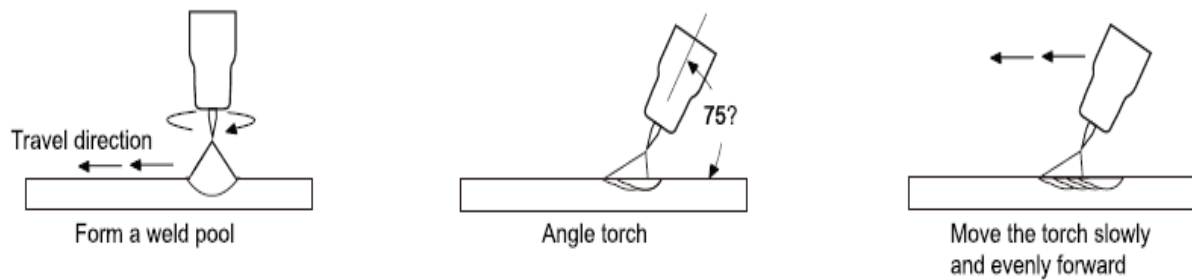
Rock the torch back in the opposite direction, the arc will ignite as the tungsten lifts off.

Lift the torch to maintain the arc.

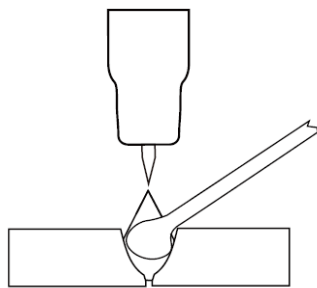
§4.2.3 TIG Welding Fusion Technique



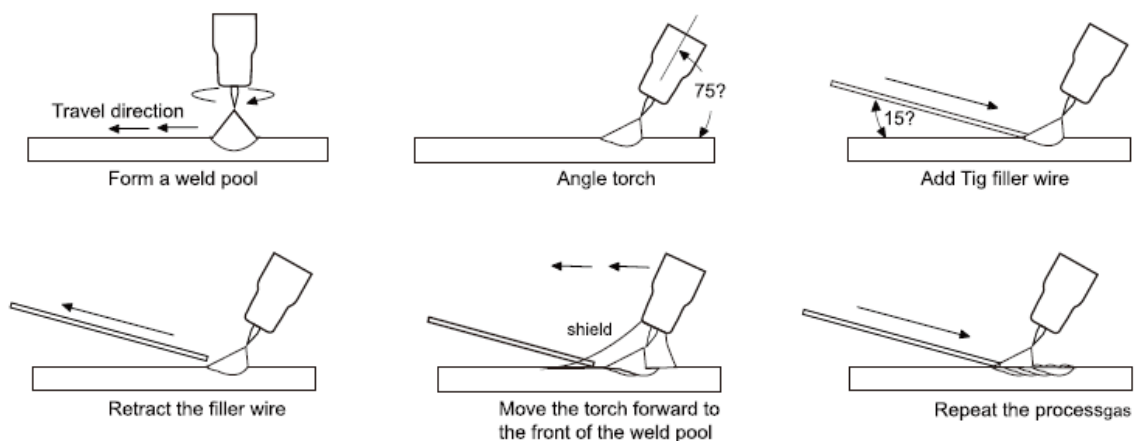
Manual TIG welding is often considered the most difficult of all the welding processes. Because the welder must maintain a short arc length, great care and skill are required to prevent contact between the electrode and the workpiece. TIG welding normally requires two hands and in most instances requires the welder to manually feed a filler wire into the weld pool with one hand while manipulating the welding torch in the other. However, some welds combining thin materials can be accomplished without filler metal like edge, corner, and butt joints. This is known as Fusion welding where the edges of the metal pieces are melted together using only the heat and arc force.



TIG Welding with Filler Wire Technique



It is necessary in many situations with TIG welding to add a filler wire into the weld pool to build up weld reinforcement and create a strong weld. Once the arc is started the torch tungsten is held in place until a weld pool is created, a circular movement of the tungsten will assist in creating a weld pool of the desired size. Once the weld pool is established tilt the torch at about a 75° angle and move smoothly and evenly along the joint. The filler metal is introduced to the leading edge of the weld pool. The filler wire is usually held at about a 15° angle and fed into the leading edge of the molten pool, the arc will melt the filler wire into the weld pool as the torch is moved forward. A “dabbing” technique can be used to control the amount of filler wire added. The wire is fed into the molten pool and retracted in a repeating sequence as the torch is moved slowly and evenly forward. It is important during the welding to keep the molten end of the filler wire inside the gas shield as this protects the end of the wire from being oxidized and contaminating the weld pool.



§4.2.4 Tungsten Electrodes

Tungsten is a rare metallic element used for manufacturing TIG welding electrodes. The TIG process relies on tungsten's hardness and high-temperature resistance to carry the welding current to the arc. Tungsten has the highest melting point of any metal, 3,410 degrees Celsius. Tungsten electrodes are a consumable and come in a variety of sizes, they are made from pure tungsten or an alloy of tungsten and other rare earth elements. Choosing the correct tungsten depends on the material being welded, amps required and whether you are using AC or DC welding current. Tungsten electrodes are color-coded at the end for easy identification.

Thoriated (RED)



Thoriated tungsten electrodes (AWS classification EWTh-2) contain a minimum of 97.30 percent tungsten and 1.70 to 2.20 percent thorium and are called 2% thoriated. They are the most commonly used DC electrodes today and are preferred for their longevity and ease of use. Thorium however is a low-level radioactive hazard and many users have switched to other alternatives. Regarding the radioactivity, thorium is an alpha emitter but when it is enclosed in a tungsten matrix the risks are negligible. Thoriated tungsten should not get in contact with open cuts or wounds. The more significant danger to welder can occur when thorium oxide gets into the lungs. This can happen from the exposure to vapors during welding or from ingestion of material/dust in the grinding of the tungsten. Follow the manufacturer's warnings, instructions, and the Material Safety Data Sheet (MSDS).

Pure (Green)



Pure tungsten electrodes (AWS classification EWP/WP) contain a minimum of 99.5% percent tungsten. Pure Tungsten Electrodes provide conductivity similar to zirconiated electrodes. Pure Tungsten Electrodes work well on AC constant current power sources, such as transformer, for aluminum and magnesium alloys in low to medium temperature applications. They can be used DC electrode negative with a pointed end, or balled for use with AC power sources, they tend to split at higher amperages and should be used for non-critical welds only.

Ceriated (Grey)

Ceriated tungsten electrodes (AWS classification EWCe-2) contain a minimum of 97.30 percent tungsten and 1.80 to 2.20 percent cerium and are referred to as 2% ceriated. Ceriated tungsten performs best in DC welding at low current settings. They have excellent arc starts at low amperages and become popular in such applications as orbital tube welding, thin sheet metal work. They are best used to weld carbon steel, stainless steel, nickel alloys, and titanium, and in some cases it can replace 2% Thoriated electrodes. Ceriated tungsten is best suited for lower amperages it should last longer than Thoriated tungsten higher amperage applications are best left to Thoriated or Lanthanated tungsten.

Lanthanated (Gold)

Lanthanated tungsten electrodes (AWS classification EWLa-1.5) contain a minimum of 97.80 percent tungsten and 1.30 percent to 1.70 percent lanthanum and are known as 1.5% lanthanated. These electrodes have excellent arc starting, a low burn off rate, good arc stability, and excellent re-ignition characteristics. Lanthanated tungsten also share the conductivity characteristics of 2% Thoriated tungsten. Lanthanated tungsten electrodes are ideal if you want to optimize your welding capabilities. They work well on AC or DC electrode negative with a pointed end, or they can be balled for use with AC sine wave power sources. Lanthanated tungsten maintains a sharpened point well, which is an advantage for welding steel and stainless steel on DC or AC from square wave power sources.

Zirconiated (White)

Zirconiated tungsten electrodes (AWS classification EWZr-1) contain a minimum of 99.10 percent tungsten and 0.15 to 0.40 percent zirconium oxide. Most commonly used for AC welding, Zirconiated tungsten produces a very stable arc and is resistant to tungsten spitting. It is ideal for AC welding because it retains a balled tip and has a high resistance to contamination. Its current-carrying capacity is equal to or greater than that of thoriated tungsten. Zirconiated tungsten is not recommended for DC welding.

Tungsten Electrodes Rating for Welding Currents

Tungsten Diameter mm	DC Current Amps Torch Negative 2% Thoriated	AC Current Amps Un-Balanced Wave 0.8% Zirconiated	AC Current Amps Balanced Wave 0.8% Zirconiated
1.0mm	15-80	15-80	20-60
1.6mm	70-150	70-150	60-120
2.4mm	150-250	140-235	100-180
3.2mm	250-400	225-325	160-250
4.0mm	400-500	300-400	200-320

§4.2.5 Tungsten Preparation

Always use **DIAMOND** wheels when grinding and cutting. While tungsten is a very hard material, the surface of a diamond wheel is harder, and this makes for smooth grinding. Grinding without diamond wheels, such as Aluminum oxide wheels, can lead to jagged edges, imperfections, or poor surface finishes not visible to the eye that will contribute to weld inconsistency and weld defects.

Always ensure to grind the tungsten in a longitudinal direction on the grinding wheel. Tungsten electrodes are manufactured with the molecular structure of the grain running lengthwise and thus grinding crosswise is “grinding against the grain”. If electrodes are ground crosswise, the electrons have to jump across the grinding marks and the arc can start before the tip and wander. Grinding longitudinally with the grain, the electrons flow steadily and easily to the end of the tungsten tip. The arc starts straight and remains narrow, concentrated and stable.



Electrode Shape & Angle

The shape of the tungsten electrode tip is an important process variable in precision arc welding. A good selection of tip/flat size will balance the need for several advantages. The bigger the flat, the more likely arc wander will occur and the more difficult it will be to arc start. However, increasing the flat to the maximum level that still allows arc start and eliminates arc wander will improve the weld penetration and increase the electrode life. The included angle determines weld bead shape and size. Generally, as the included angle increases, penetration increases and bead width decreases.

Some welders still grind electrodes to a sharp point, which makes arc starting easier. However, they risk decreased welding performance from melting at the tip.



Electrode Included Angle/Taper - DC Welding

Tungsten electrodes for DC welding should be ground longitudinally and concentrically with diamond wheels to a specific included angle in conjunction with the tip/flat preparation. Different angles produce different arc shapes and offer different weld penetration capabilities.

Blunter electrodes with larger included angle provide:

- Last Longer
- Have better weld penetration.
- Have a narrower arc shape.
- Can handle higher amperage.



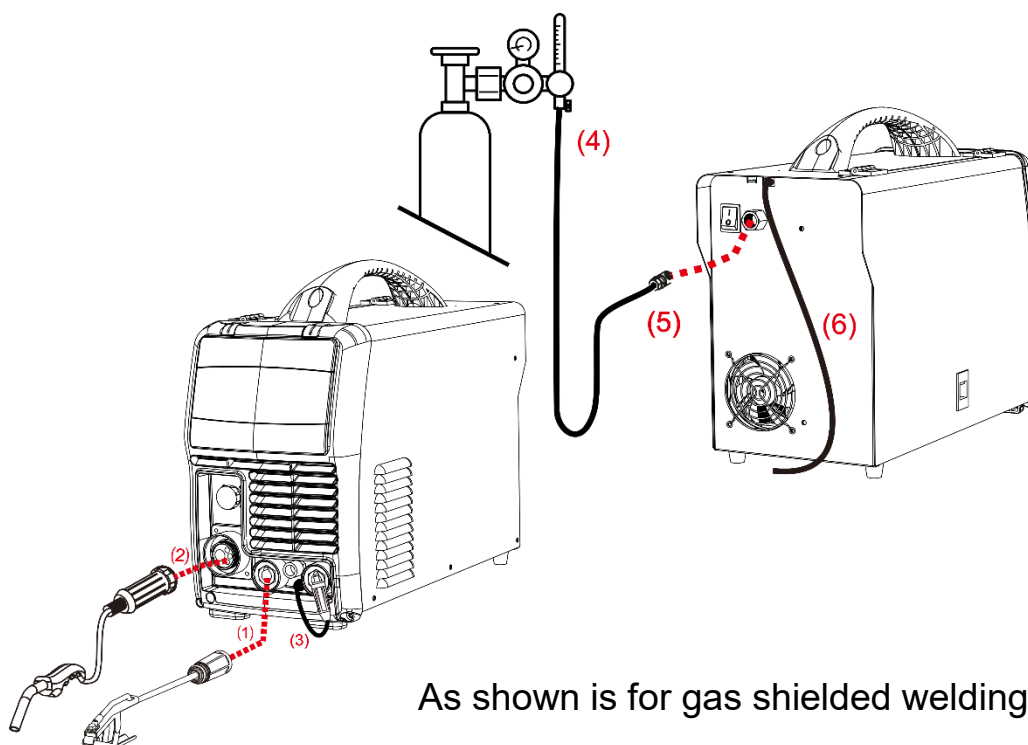
Sharper electrodes with smaller included angle provide:

- Offer less arc weld.
- Have a wider arc.
- Have a more consistent arc.

Tungsten Diameter	Diameter at the Tip - mm	Constant Included Angle - Degrees	Current Range Amps	Current Range Pulsed Amps
1.0mm	.250	20	05 - 30	05 - 60
1.6mm	.500	25	08 - 50	05 - 100
1.6mm	.800	30	10 - 70	10 - 140
2.4mm	.800	35	12 - 90	12 - 180
2.4mm	1.100	45	15 - 150	15 - 250
3.2mm	1.100	60	20 - 200	20 - 300
3.2mm	1.500	90	25 - 250	25 - 350

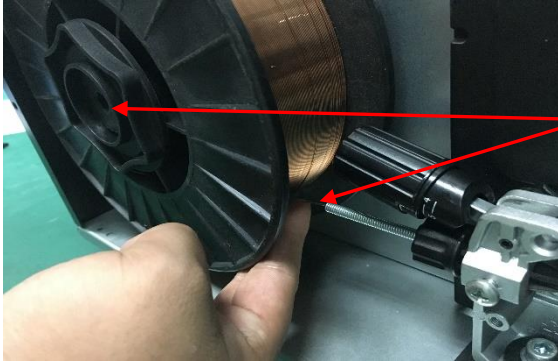
§4.3 Installation & Operation for MIG Welding

§4.3.1 Set up installation for MIG Welding

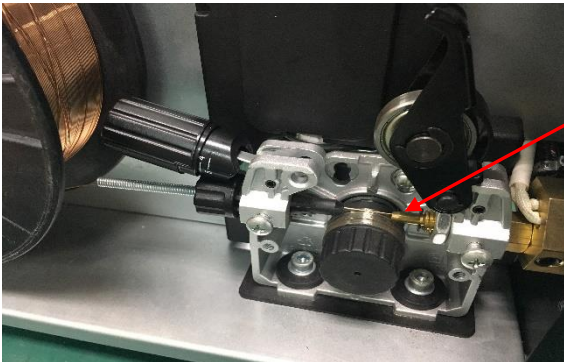


- (1) A- Insert the earth cable into the Negative (-) socket and twist to tighten. (MIG)
B- Insert the earth cable into the Positive (+) socket and twist to tighten. (Flux-cored)
- (2) Plug the MIG welding gun into MIG torch euro-connector on the front panel and tighten locking nut securely.
- (3) A- Insert the torch polarity cable plug into the Positive (+) socket. (MIG)
B - Insert the torch polarity cable plug into the Negative (-) socket. (Flux- cored)

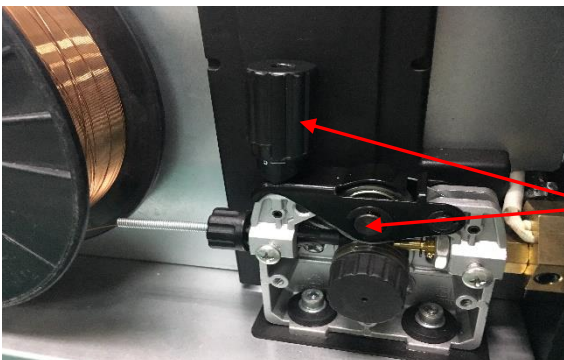
- (4) Connect the gas regulator to the gas cylinder and connect the gas line to the regulator.
(MIG, gas shielded wire only)
- (5) Connect the gas line to gas connector on the rear panel. (Gas shielded wire only)
- (6) Connect the power cord of welding machine with the outlet on electrical box.



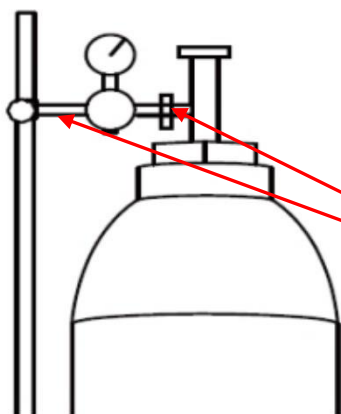
- (7) Place wire onto spool holder - (spool retaining nut is left hand thread) Feed wire through the inlet guide tube on to the drive roller.



- (8) Feed wire over drive roller into outlet guide wire tube, push wire through approximately 6" (150mm).



- (9) Close down the top roller bracket and clip the pressure arm into place with a medium amount of pressure applied.



(10) Carefully open the valve of the gas cylinder, set the required gas flow rate on regulator.

- (11) Remove the gas nozzle and contact tip from the torch neck.
- (12) Press and hold the manual wire button to feed the wire through to the torch neck, release the manual wire button when the wire exits the torch neck.
- (13) Fit the correct sized contact tip and feed the wire through it, screw the contact tip into the tip holder and secure tip with wrench. Tip must be more than “finger tight”.
- (14) Fit the gas nozzle to the torch head.
- (15) Carefully open the gas cylinder valve, set the required gas flow rate on the regulator.
- (16) Select the desired MIG function, select the wire diameter and gas type being used as shown on the display.
- (17) Select torch switch mode: 2T/ 4T.
- (18) Set the required welding parameters to suit the material thickness being welded.

§4.3.2 Wire Feed Roller Selection

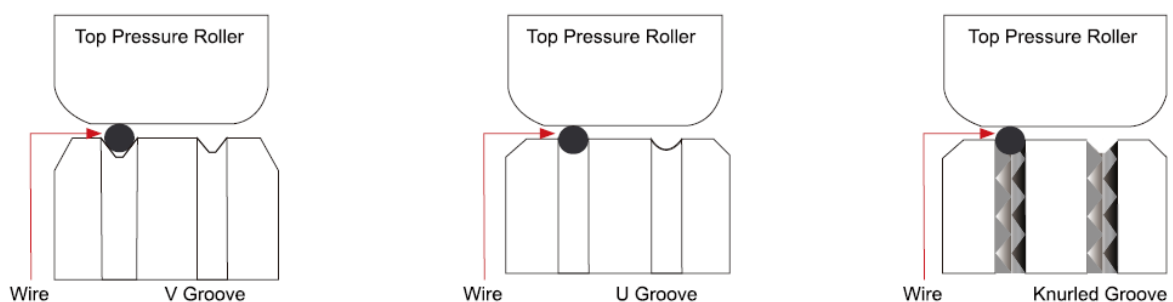
The importance of smooth consistent wire feeding during MIG welding cannot be emphasized enough. Simply put, the smoother the wire feed: the better the weld.

Feed rollers or drive rollers are used to feed the wire mechanically through the length of the welding gun cable. Feed rollers are designed to be used for certain types of welding wire and they have different types of grooves machined in them to accommodate the different types of wire. The wire is held in the groove by the top roller of the wire drive unit and is referred to as the pressure roller, pressure is applied by a tension arm that can be adjusted to increase or decrease the pressure as required. The type of wire will determine how much pressure can be applied and what type of drive roller is best suited to obtain optimum wire feed.

Solid Hard Wire – Steel & Stainless Steel requires a drive roller with a **“V” shape** groove for optimum grip and drive capability. Solid wires can have more tension applied to the wire from the top pressure roller that holds the wire in the groove and the “V” shape groove is more suited for this. Solid wires are more forgiving to feed due to their higher cross-sectional column strength, they are stiffer and don’t deflect so easily.

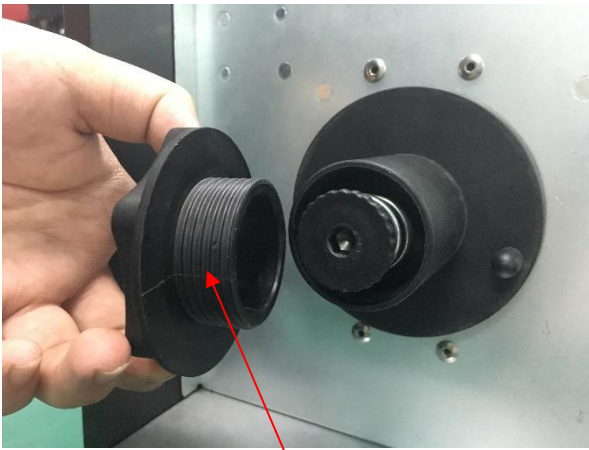
Soft Wire – Such as aluminum, require a **“U” shape** groove. Aluminum wire has a lot less column strength, can bend easily and is therefore more difficult to feed. Soft wires can easily buckle at the wire feeder where the wire is fed into inlet guide tube of the torch. The U-shaped roller offers more surface area grip and traction to help feed the softer wire. Softer wires also require less tension from the top pressure roller to avoid deforming the shape of the wire, too much tension will push the wire out of shape and cause it to catch in the contact tip.

Flux Core/ Gasless Wire - These wires are made up of a thin metal sheath that has flux and metal compounds layered onto the surface and then rolled into a cylinder to form the finished wire. The wire cannot take too much pressure from the top roller as it can be crushed and deformed if too much pressure is applied. A **knurled-V** drive roller has been developed and it has small serrations in the groove, the serrations grip the wire and assist to drive it without too much pressure from the top roller. The downside to the knurled wire feed roller on flux cored wire is it will slowly over time bit by bit eat away at the surface of the welding wire, and these small pieces will eventually go down into the liner. This will cause clogging in the liner and added friction that will lead to welding wire feed problems. A V-groove wire can also be used for flux core wire without the wire particles coming off the wire surface. However, it is considered that the knurled roller will give a more positive feed of flux core wire without any deformation of the wire shape.

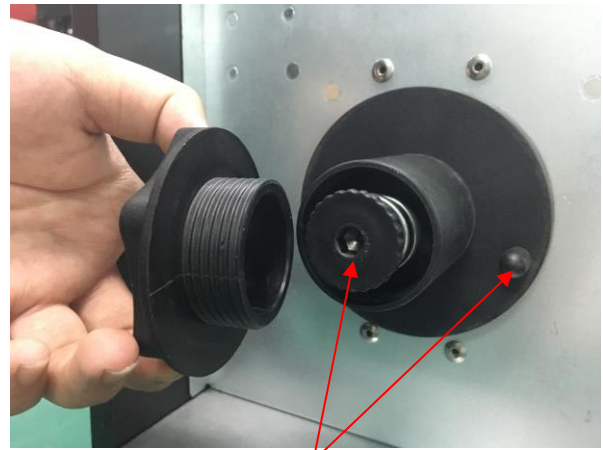


§4.3.3 Wire Installation and Set-Up Guide

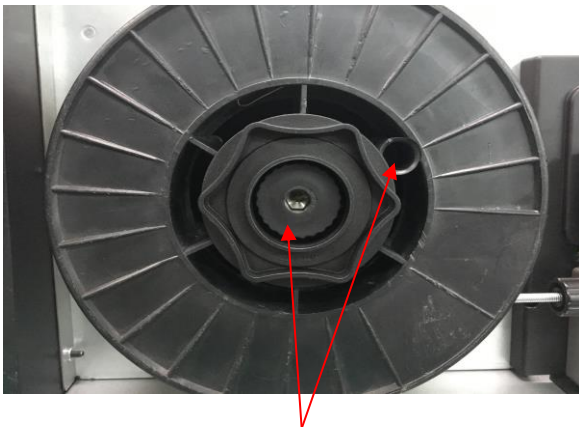
Again, the importance of smooth consistent wire feeding during MIG welding cannot be emphasized enough. The correct installation of the wire spool and the wire into the wire feed unit is critical to achieving an even and consistent wire feed. A high percentage of faults with MIG welders emanate from poor set up of the wire into the wire feeder. The guide below will assist in the correct setup of your wire feeder.



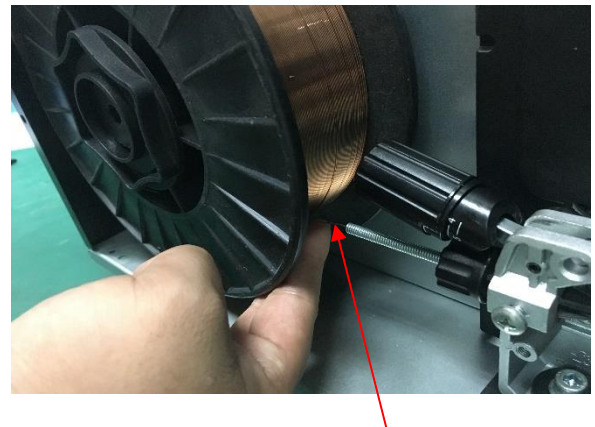
(1) Remove the spool retaining nut.



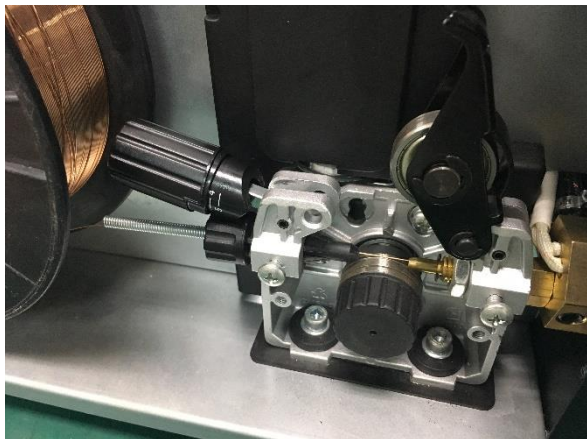
(2) Note the tension spring adjuster and spool locating pin.



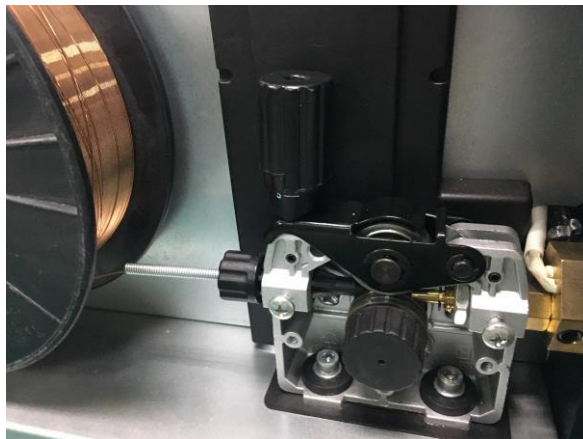
(3) Fit the wire spool onto the spool holder fitting the locating pin into the location hole on the spool. Replace the spool retaining nut tightly.



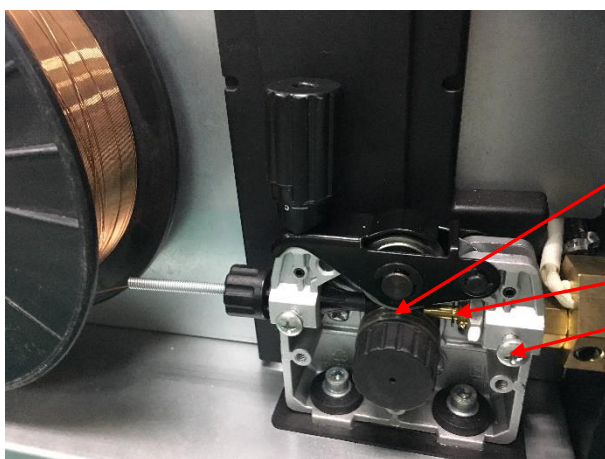
(4) Snip the wire carefully, be sure to hold the wire to prevent the spool uncoiling. Carefully feed the wire into the inlet guide tube of the wire feed unit.



(5) Feed the wire through the drive roller and into the outlet guide tube of the wire feeder.



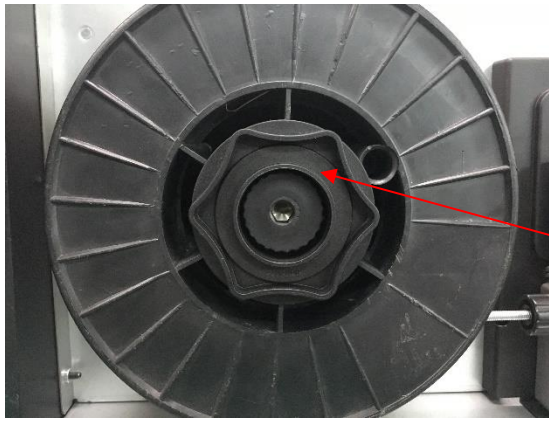
(6) Lock down the top pressure roller and apply a medium amount of pressure using the tension adjustment knob.



(7) Check that the wire passes through the center of the outlet guide tube without touching the sides. Loosen the locking screw and then loosen the outlet guide tube retaining nut too make adjustment if required. Carefully retighten the locking nut and screw to hold the new position.



(8) A simple check for the correct drive tension is to bend the end of the wire over hold it about 4" (100mm) from your hand and let it run into your GLOVED hand, it should coil round in your glove without stopping and slipping at the drive rollers, increase the tension if it slips.



(9) The weight and speed of the wire spool turning creates an inertia that can cause the spool to run on and the wire loop over the side of the spool and tangle. If this happens increase the pressure on the tension spring inside the spool holder assembly using the tension adjustment screw under spool screw.

§4.3.4 MIG Torch Liner Types and Information

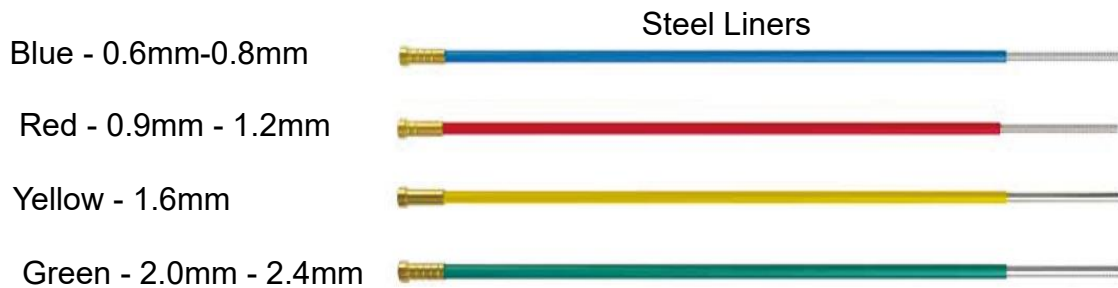
MIG Torch Liners

The liner is both one of the simplest and most important components of a MIG gun. Its sole purpose is to guide the welding wire from the wire feeder, through the gun cable and up to the contact tip.

Steel Liners

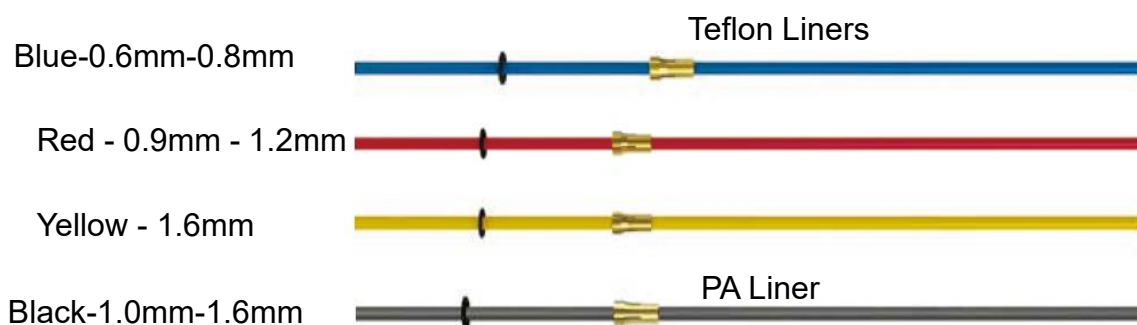
Most MIG gun liners are made from coiled steel wire also known as piano wire, which provides the liner with good rigidity and flexibility and allows it to guide the welding wire smoothly through the welding cable as it bends and flex during operational use. Steel liners are primarily used for feeding solid steel wire, other wires such as Aluminum, Silicon Bronze, etc. will perform better using a Teflon or Polyamide line. The internal diameter of the liner is important and relative to the wire diameter being used. The correct inside diameter will assist in smooth feeding and prevention of the wire kinking and bird-nesting at the drive rollers. Also bending the cable too tightly during welding increases the friction between the liner and the welding wire making it more difficult to push the wire through the liner resulting in poor wire feeding, premature liner wear and bird-nesting. Dust, grime and metal particles can accumulate inside the liner over time causing friction and blockages; therefore, it is recommended to periodically blow out the liner with compressed air. Small diameter welding wires, 0.6mm through 1.0mm have relatively low columnar strength, and if matched with an oversized liner, can cause the wire to wander or drift within the liner. This in turn leads to poor wire feeding and premature liner failure due to excessive wear. By contrast, larger diameter welding wires, 1.2mm through 2.4mm have

much higher columnar strength but it is important to make sure the liner has enough internal diameter clearance. Most manufacturers will produce liners sized to match wire diameters and length of welding torch cable and most are color coded to suit.



Teflon and Polyamide (PA) Liners

Teflon liners are well suited for feeding soft wires with poor column strength like aluminum and silicon bronze wires. The interiors of these liners are smooth and provide stable feeding, especially on small diameter welding wire. Teflon can be good for higher heat applications with brass neck liners. Teflon has good abrasion resistance characteristics and can be used with a variety of wire types such as silicon bronze, stainless steel as well as aluminum. A note of caution to carefully inspect the end of the welding wire prior to feeding it down the liner. Sharp edges and burrs can score the inside of the liner and lead to blockages and accelerated wear. Polyamide Liners (PA) are made of carbon infused nylon and are ideal for softer aluminum, copper alloy welding wires and push pull torch applications. These liners are generally fitted with a floating collet to allow the liner to be inserted all the way to the feed rollers.



Copper - Neck Liners

For high heat applications copper wound jumper or neck liner on the end of the liner at the neck end will increase the working temperature of the liner as well as improve the electrical conductivity of the welding power transfer to the wire. It is recommended for all Aluminum and Silicone Bronze welding applications.

Copper Neck Liner



§4.3.5 Torch & Wire Feed Set-Up for Aluminum Wire

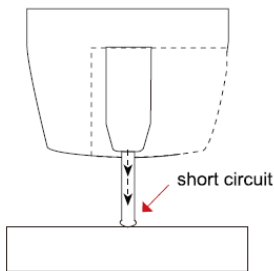
The same method is used for Teflon and/or Polyamide Liners (PA).

§4.3.6 MIG Welding

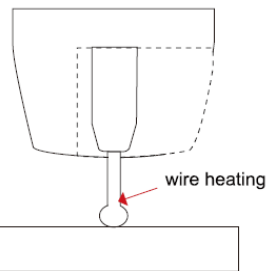
Definition of MIG Welding

MIG (metal inert gas) welding also known as GMAW (gas metal arc welding) or MAG (metal active gas welding), is a semi-automatic or automatic arc welding process in which a continuous and consumable wire electrode and a shielding gas are fed through a welding gun. A constant voltage, direct current power source is most commonly used with MIG welding. There are four primary methods of metal transfer in MIG welding, called short circuit (also known as dip transfer) globular transfer, spray transfer and pulsed-spray, each of which has distinct properties and corresponding advantages and limitations.

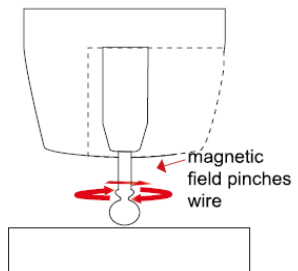
Short Circuit Transfer - Short circuit transfer is the most common used method whereby the wire electrode is fed continuously down the welding torch through to and exiting the contact tip. The wire touches the work piece and causes a short circuit. The wire heats up and begins to form a molten bead, the bead separates from the end of the wire and forms a droplet that is transferred into the weld pool. This process is repeated about 100 times per second, making the arc appear constant to the human eye.



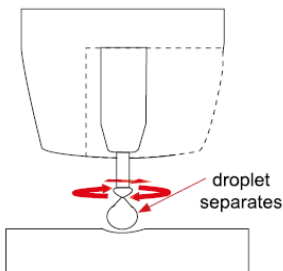
The wire touches the work creating a short circuit. Because there is no space between the wire and the base metal there is no arc.



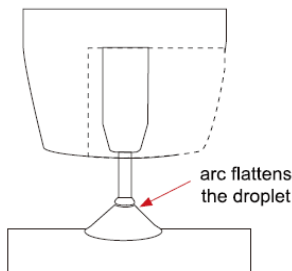
The wire cannot support all the current flow, so resistance builds up and the wire begins to melt.



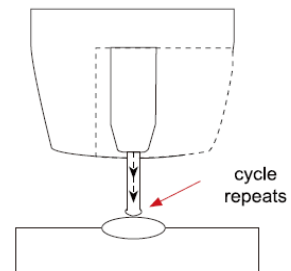
The current flow creates a magnetic field that begins to pinch the melting wire forming it into droplet.



The pinch causes the forming droplet to separate and falls towards the now creating weld pool.



An arc is created at the separation of the droplet and the heat and force of the arc flattens-out the droplet into the weld pool.



The wire feed speed overcomes the heat of the arc and the wire again approaches the work to short circuit and repeat the cycle.

Basic MIG Welding

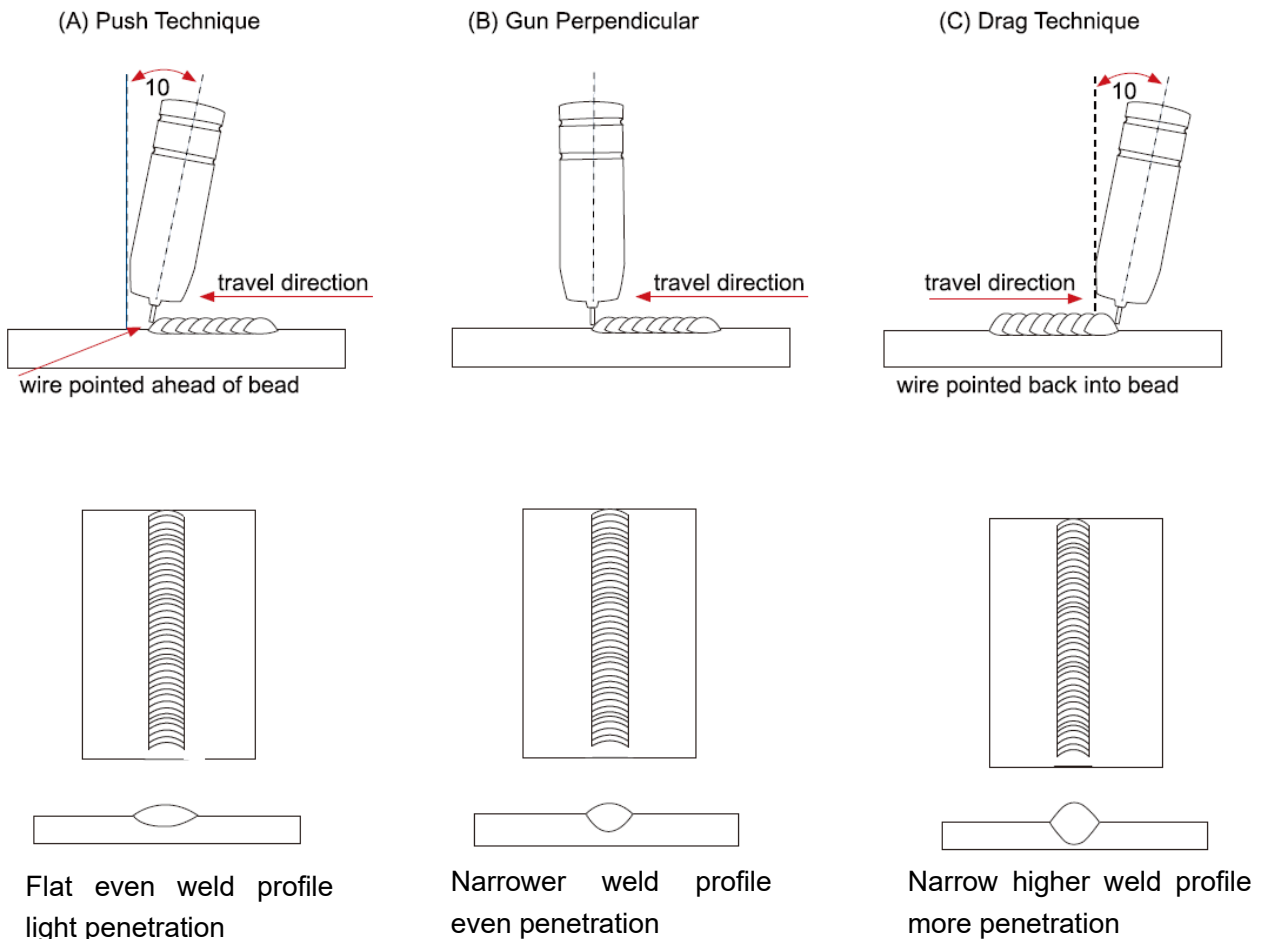
Good weld quality and weld profile depends on gun angle, direction of travel, electrode extension (stick out), travel speed, thickness of base metal, wire feed speed and arc voltage. To follow are some basic guides to assist with your setup.

Gun Position - Travel Direction, Work Angle: Gun position or technique usually refers to how the wire is directed at the base metal, the angle and travel direction chosen. Travel speed and work angle will determine the characteristic of the weld bead profile and degree of weld penetration.

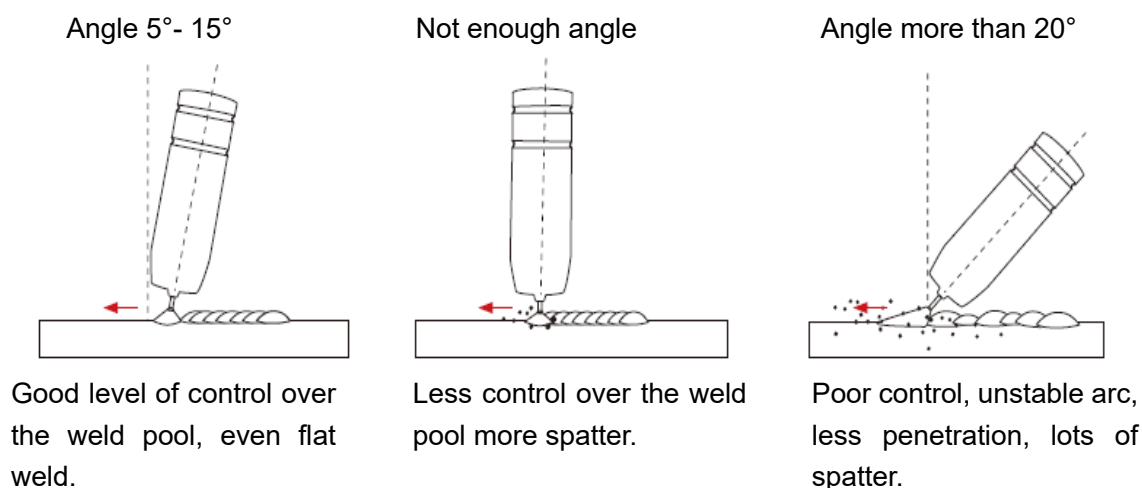
Push Technique - The wire is located at the leading edge of the weld pool and pushed towards the un-melted work surface. This technique offers a better view of the weld joint and direction of the wire into the weld joint. Push technique directs the heat away from the weld puddle allowing faster travel speeds providing a flatter weld profile with light penetration - useful for welding thin materials. The welds are wider and flatter allowing for minimal clean-up and grinding time.

Perpendicular Technique - The wire is fed directly into the weld; this technique is used primarily for automated situations or when conditions make it necessary. The weld profile is generally taller and a deeper penetration is achieved.

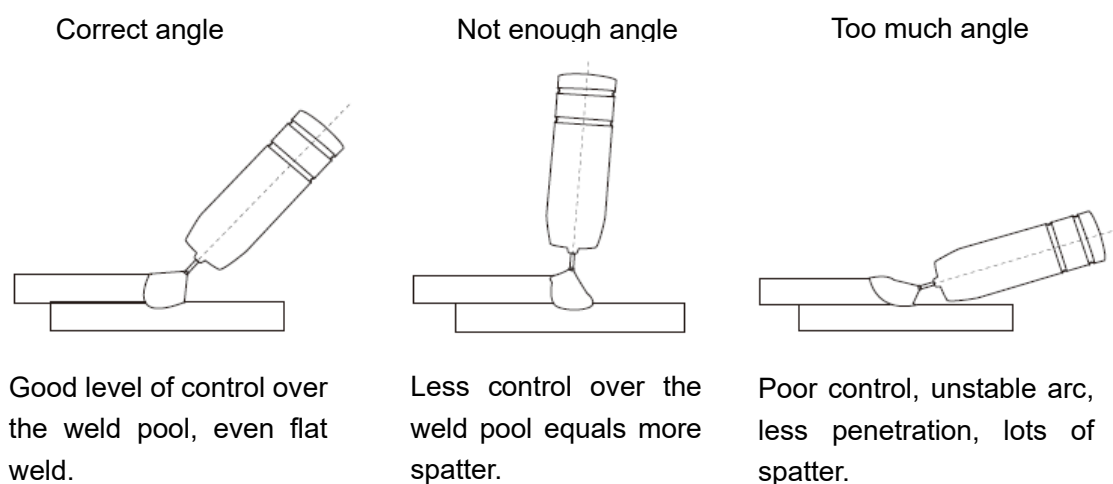
Drag Technique - The gun and wire are dragged away from the weld bead. The arc and heat is concentrated on the weld pool, the base metal receives more heat, deeper melting, more penetration and the weld profile is higher with more build up.



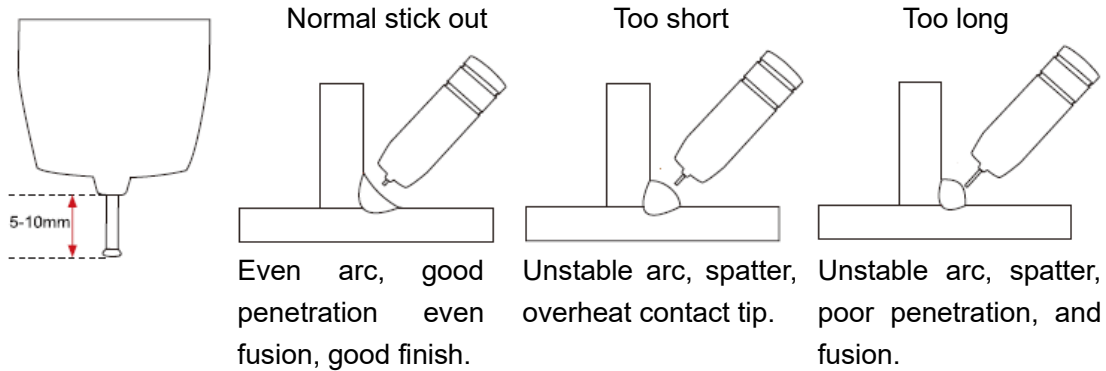
Travel Angle - Travel angle is the right to left angle relative to the direction of welding. A travel angle of 5° ~ 15° is ideal and produces a good level of control over the weld pool. A travel angle greater than 20° will give an unstable arc condition with poor weld metal transfer, less penetration, high levels of spatter, poor gas shield and poor quality finished weld.



Angle to Work - The work angle is the forward back angle of the gun relative to the work piece. The correct work angle provides good bead shape, prevents undercut, uneven penetration, poor gas shield and poor-quality finished weld.

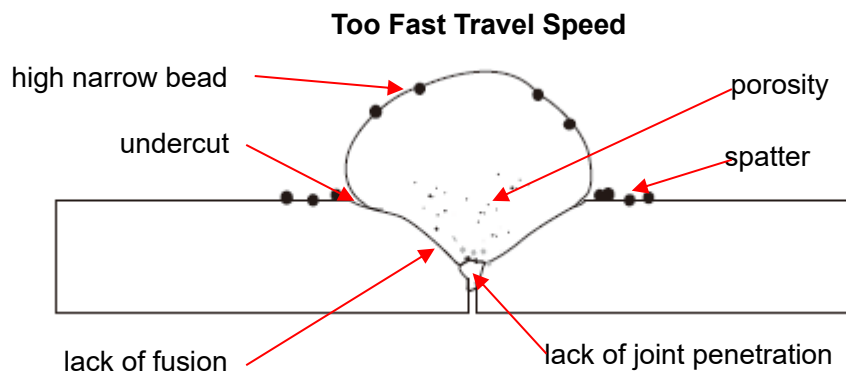


Stick Out- Stick out is the length of the un-melted wire protruding from the end of the contact tip. A constant even stick out of ¼" (5-10mm) will produce a stable arc, and an even current flow providing good penetration and even fusion. Too short stick out will cause an unstable weld pool, produce spatter, and overheat the contact tip. Too long stick out will cause an unstable arc, lack of penetration, lack of fusion and increase spatter.



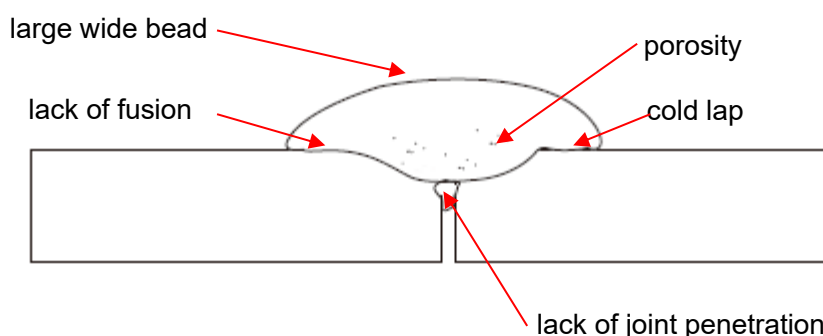
Travel Speed - Travel speed is the rate that the gun is moved along the weld joint and is usually measured in inches per minute (IPM). Travel speeds can vary depending on conditions and the welder's skill and is limited to the welder's ability to control the weld pool. Push technique allows faster travel speeds than drag technique. Gas flow must also correspond with the travel speed, increasing with faster travel speed and decreasing with slower speed. Travel speed needs to match the amperage and will decrease as the material thickness and amperage increase.

Too Fast Travel Speed - A too fast travel speed produces too little heat per mm of travel resulting in less penetration and reduced weld fusion, the weld bead solidifies very quickly trapping gases inside the weld metal causing porosity. Undercutting of the base metal can also occur and an unfilled groove in the base metal is created when the travel speed is too fast to allow molten metal to flow into the weld crater created by the arc heat.



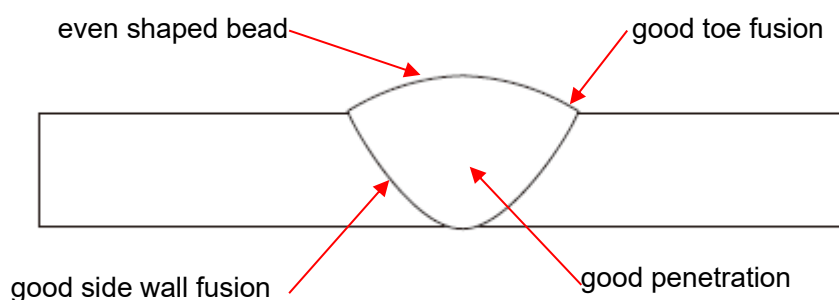
Too Slow Travel Speed - A too slow travel speed produces a large weld with lack of penetration and fusion. The energy from the arc dwells on top of the weld pool rather than penetrating the base metal. This produces a wider weld bead with more deposited weld metal per mm than is required resulting in a weld deposit of poor quality.

Too Slow Travel Speed



Correct Travel Speed - The correct travel speed keeps the arc at the leading edge of the weld pool allowing the base metal to melt sufficiently to create good penetration, fusion and wetting out of the weld pool producing a weld deposit of good quality.

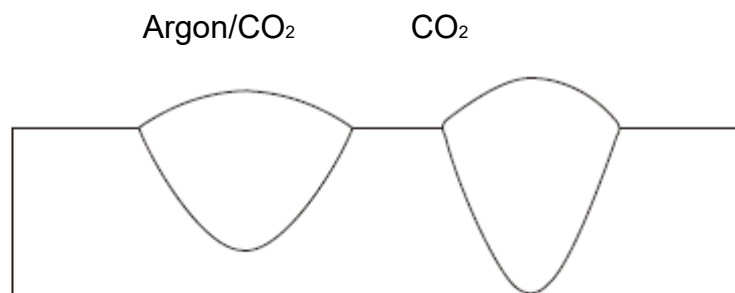
Correct Travel Speed



Gas selection - The purpose of the gas in the MIG process is to protect / shield the wire, the arc and the molten weld metal from the atmosphere. Most metals when heated to a molten state will react with the air in the atmosphere, without the protection of the shielding gas the weld produced would contain defects like porosity, lack of fusion and slag inclusions.

The correct gas flow is also very important in protecting the welding zone from the atmosphere.

Use the correct shielding gas. CO₂ is good for steel and offers good penetration, the weld profile is narrower and slightly more raised than the weld profile obtained from Argon/CO₂ mixed gas. Argon CO₂ (Argon 80% & CO₂ 20%) mix gas offers better weld ability for thin metals and has a wider range of setting tolerance on the machine.



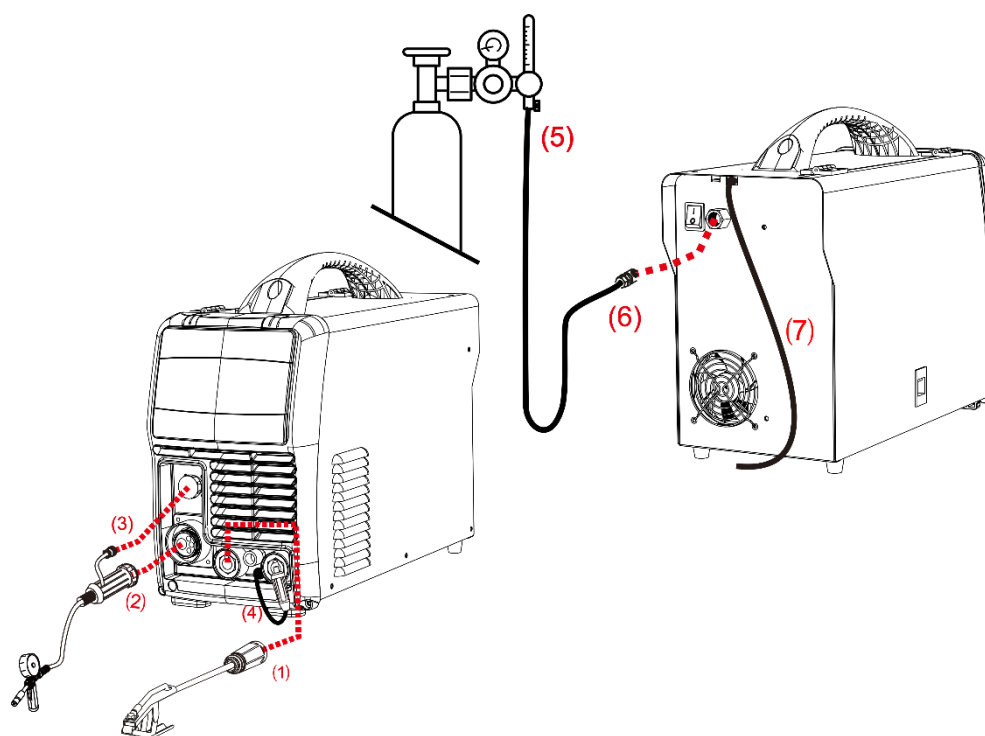
Penetration Pattern for Steel

Argon gas at 100% mixture is good for aluminum and silicone bronze applications. It offers good penetration and weld control. CO₂ is not recommended for these metal alloys.

Wire types and sizes - Use the correct wire type for the base metal being welded. Use stainless steel wire for stainless steel, aluminum for aluminum and steel wires for steel. Use a smaller diameter wire for thin base metals. For thicker materials use a larger wire diameter and larger machine, check the recommended welding capability of your machine. As a guide refer to the “Welding Wire Thickness Chart” below.

WELDING WIRE DIAMETER CHART					
MATERIAL THICKNESS	RECOMMENDED WIRE DIAMETERS				
	0.8	0.9	1.0	1.2	1.6
0.8mm					
0.9mm					
1.0mm					
1.2mm					
1.6mm					
2.0mm					
2.5mm					
3.0mm					
4.0mm					
5.0mm					
6.0mm					
8.0mm					
10mm					
14mm					
18mm					
22mm					
For material thickness of 5.0mm and greater, multi-pass runs or a beveled joint design may be required depending on the amperage capability of your machine.					

§4.4 Installation & Operation for Spool Gun



(1) Insert the earth cable plug into the negative (-) socket on the front of the machine and twist to tighten.

(2) Plug the Spool Gun into the euro-connect socket on the front panel and tighten.

IMPORTANT: When connecting the torch be sure to tighten the adaptor nut completely tight. A loose connection can result in arcing between the gun and machine connector and that causes serious damage to both the torch and machine connections.

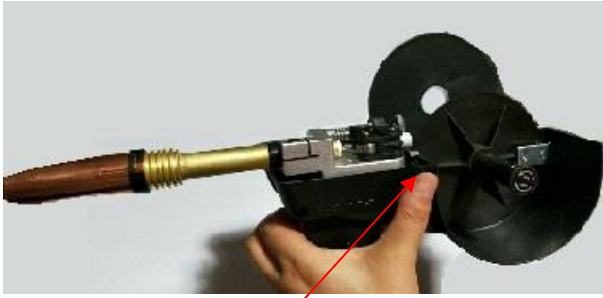
(3) Connect the Spool Gun control cable to the control socket on the front of the machine.

(4) Insert the torch polarity cable plug into the positive socket and twist to tighten.

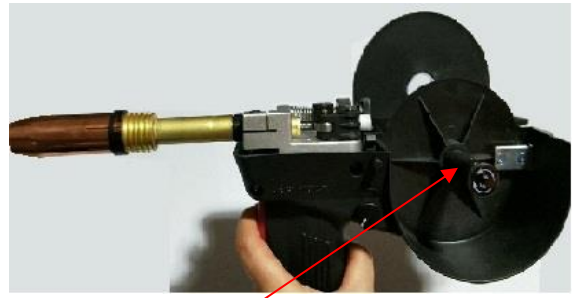
(5) Connect the gas regulator to the gas cylinder and connect the gas line to the regulator.

(6) Connect the gas line to gas connector on the rear panel.

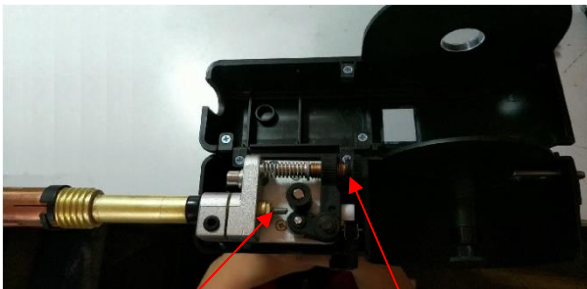
(7) Connect the power cord of welding machine with the outlet on electrical box.



(8) Remove the spool cover by pressing button and lifting off the cover.



(9) Place a spool of wire inside the spool holder on post.



(10) Feed the wire through the drive rolls and into the inlet guide tube. Tighten the wire tension swing arm.



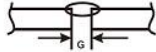
(11) Pull the trigger to drive the wire down the neck until it exits the contact tip.

(12) Carefully open the gas cylinder valve and set the required gas flow rate.

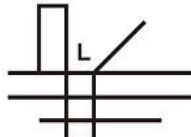
(13) Set welding parameters using the knobs as shown on digital displays.

§4.5 Welding Parameters

Process reference for CO₂ butt welding of low carbon steel solid welding wire

Butt-joint 	Material thickness (MM)	Root gap G(MM)	Wire diameter (MM)	Welding current (A)	Welding voltage (V)	Welding speed (CM/MIN)	Gas-flow rate (L/MIN)
	0.8	0	0.8	60-70	16-16.5	50-60	10
	1.0	0	0.8	75-85	17-17.5	50-60	10-15
	1.2	0	0.8	80-90	17-18	50-60	10-15
	2.0	0-0.5	1.0/1.2	110-120	19-19.5	45-50	10-15
	3.2	0-1.5	1.2	130-150	20-23	30-40	10-20
	4.5	0-1.5	1.2	150-180	21-23	30-35	10-20
	6	0	1.2	270-300	27-30	60-70	10-20
	6	1.2-1.5	1.2	230-260	24-26	40-50	15-20

Process reference for CO₂ corner welding of low carbon steel solid welding wire

Corner joint 	Material thickness (MM)	Wire diameter (MM)	Welding current (A)	Welding voltage (V)	Welding speed (CM/MIN)	Gas-flow rate (L/MIN)
	1.0	0.8	70-80	17-18	50-60	10-15
	1.2	1.0	85-90	18-19	50-60	10-15
	1.6	1.0/1.2	100-110	18-19.5	50-60	10-15
	1.6	1.2	120-130	19-20	40-50	10-20
	2.0	1.0/1.2	115-125	19.5-20	50-60	10-15
	3.2	1.0/1.2	150-170	21-22	45-50	15-20
	3.2	1.2	200-250	24-26	45-60	10-20
	4.5	1.0/1.2	180-200	23-24	40-45	15-20
	4.5	1.2	200-250	24-26	40-50	15-20
	6	1.2	220-250	25-27	35-45	15-20
	6	1.2	270-300	28-31	60-70	15-20
	8	1.2	270-300	28-31	60-70	15-20
	8	1.2	260-300	26-32	25-35	15-20
	8	1.6	300-330	25-26	30-35	15-20
	12	1.2	260-300	26-32	25-35	15-20

§4.6 Operation Environment

- ▲ Height above sea level ≤ 1000 M.
- ▲ Operation temperature range 14 ~ 104°F (-10 ~ +40°C).
- ▲ Air relative humidity is below 90%.
- ▲ Preferable site the machine some angles above the floor level does not exceed 15°.
- ▲ Protect the machine against high moisture, water and against direct sunshine.
- ▲ Take care that there is sufficient ventilation during welding. There must be at least 1-1/2" (38cm) free distance between the machine and wall.

§4.7 Operation Notices

- ▲ Read Section §1 carefully before starting to use this equipment.
- ▲ Ensure that the input is 115VAC, single-phase: 50/60Hz.
- ▲ Before operation, clear the working area. Do not watch the arc in unprotected eyes.
- ▲ Ensure good ventilation of the machine to improve duty cycle and life.
- ▲ Turn off power supply when the operation finished for energy consumption efficiency.
- ▲ When power switch shuts off protectively because of failure. Don't restart it until problem has been resolved. Otherwise, permanent damage could occur.
- ▲ In case of problems, contact your local dealer.

§5 Welding Trouble Shooting

§5.1 Troubleshooting

- Before the welding machines are dispatched from the factory, they have already been tested and calibrated accurately. **Do not change settings on the equipment!**
- Maintenance must be performed by the operator daily. If any wire becomes frayed or is loose, it may be a potential danger to the user!
- Only professional maintenance staff that are authorized by the manufacturer should service the machine!
- **Be sure to shut off the Main Input Power before doing any repair work on the welding machine and wait 5 minutes for capacitor voltage to decrease!**
- If there is any problem and there are no authorized professional maintenance personnel on site, please contact the local agent or the distributor!

If there are some simple troubles with the welding machine, you can consult the following Chart:

NO.	Troubles		Reasons	Solution
1	Turn ON power but the power light is not illuminated.		Switch damaged	Replace
			Fuse damaged	Replace
			Power cord damaged	Replace
2	After welding machine is over-heat, the fan doesn't work		Fan damaged	Replace
			The cable is loose	Screw the cable tight
3	Press the gun switch, no output shielded gas	No output gas when test gas	No gas in the gas cylinder	Replace
			Gas hose leaks gas	Replace
			Electromagnetic valve damaged	Replace
		Output gas when test gas	Control switch damaged	Repair the switch
			Control circuit damaged	Check the PCB
4	Wire-feeder doesn't work	Wire reel doesn't work	Motor damaged	Check & Replace
			Control circuit damaged	Check the PCB
		Wire reel works	The idler roll is loose or weld wire skids	Adjust tension screws
			The drive roll doesn't fit with the diameter of weld wire	Change the roll
			Wire reel damaged	Replace

WELDING TROUBLE SHOOTING

			Wire feed pipe is jammed	Repair or replace
			Tip is jammed because of splash	Repair or replace
5	No striking arc and no output voltage		Output cable is connected incorrectly or loosen	Secure or replace
			Control circuit damaged	Check the circuit
6	Welding stops, and alarm light is on	Machine has self-protection		Check over-voltage, over-current, over-temperature, lower-voltage and over-temperature.
7	Welding current is run away and can be not controlled		The potentiometer damaged	Check or replace
			The control circuit damaged	Check the circuit
8	The crater current can be not adjusted	The PCB damaged		Check it
9	No post-gas	The PCB damaged		Check it

§5.2 MIG Welding - Trouble Shooting

The following chart addresses some of the common problems of MIG welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

NO.	Trouble	Possible Reason	Suggested Remedy
1	Excessive Spatter	Wire feed speed set too high	Select lower wire feed speed
		Voltage too high	Select a lower voltage setting
		Wrong polarity set	select the correct polarity for the wire being used - see machine setup guide
		Stick out too long	Bring the torch closer to the work
		Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal
		Contaminated MIG wire	Use clean, dry, rust-free wire. Do not lubricate the wire with oil, grease etc.
		Inadequate gas flow or too much gas flow	Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 20-40 CFH (6-12 l/min) flow rate. Check hoses and fittings for leaks. Protect the welding zone from wind and drafts
2	Porosity - small cavities or holes resulting from gas pockets in weld metal.	Wrong gas	Check that the correct gas is being used
		Inadequate gas flow or too much gas flow	Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 20-40 CFh (6-12 l/min) flow rate. Check hoses and fittings for leaks. Protect the welding zone from wind and drafts
		Moisture on the base metal	Remove all moisture from base metal before welding
		Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal
		Contaminated MIG wire	Use clean, dry, rust free wire. Do not

WELDING TROUBLE SHOOTING

			lubricate the wire.
		Gas nozzle clogged with spatter, worn or out of shape	Clean or replace the gas nozzle
		Missing or damaged gas diffuser	Replace the gas diffuser
		MIG torch euro connect O-ring missing or damaged	Check and replace the O-ring
3	Wire stubbing during welding	Holding the torch too far away	Bring the torch closer to the work and maintain stick out of 5~10mm
		Welding voltage set too low	Increase the voltage
		Wire Speed set too high	Decrease the wire feed speed
4	Lack of Fusion – failure of weld metal to fuse completely.	Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal
		Not enough heat input	Select a higher voltage range and /or adjust the wire speed to suit
		Improper welding technique	Keep the arc at the leading edge of the weld pool. Gun angle to work should be between 5 & 15°. Direct the arc at the weld joint Adjust work angle or widen groove to access bottom during welding. Momentarily hold arc on side walls if using weaving technique
5	Excessive Penetration – weld metal melting through base metal	Too much heat	Select a lower voltage range and /or adjust the wire speed to suit Increase travel speed
6	Lack of Penetration – shallow fusion between weld metal and base metal	Poor in incorrect joint preparation	Material too thick. Joint preparation and design need to allow access to bottom of groove while maintaining proper welding wire extension and arc characteristics. Keep the arc at the leading edge of the weld pool and maintain the gun angle at 5 & 15° keeping the stick out between 5-10mm
		Not enough heat input	Select a higher voltage range and /or adjust the wire speed to suit reduce travel speed.
		Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal

85.3 MIG Wire Feed - Trouble Shooting

The following chart addresses some of the common WIRE FEED problems during MIG welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

NO.	Trouble	Possible Reason	Suggested Remedy
1	No wire feed	Wrong mode selected	Check that the TIG/MMA/MIG selector switch set to MIG position
		Wrong torch selector switch	Check that the Wire Feeder / Spool Gun selector switch is set to Wire Feeder position for MIG welding and Spool Gun when using the Spool gun
2	Inconsistent/ interrupted wire feed	Adjusting wrong dial	Be sure to adjust the wire feed and voltage dials for MIG welding. The amperage dial is for MMA and TIG welding mode
		Wrong polarity selected	Select the correct polarity for the wire being used. (see machine setup guide)
		Incorrect wire speed setting	Adjust the wire feed speed
		Voltage setting incorrect	Adjust the voltage setting
		MIG torch lead too long	Small diameter wires and soft wires like aluminum don't feed well through long torch leads - replace the torch with a lesser length torch
		MIG torch lead kinked or too sharp angle being held	Remove the kink, reduce the angle or bend
		Contact tip worn, wrong size, wrong type	Replace the tip with correct size and type
		Liner worn or clogged (the most common causes of bad feeding)	Try to clear the liner by blowing out with compressed air as a temporary cure, it is recommended to replace the liner
		Wrong size liner	Install the correct size liner
		Blocked or worn inlet guide tube	Clear or replace the inlet guide tube
		Wire misaligned in drive roller groove	Locate the wire into the groove of the drive roller
		Incorrect drive roller size	Fit the correct size drive roller; 0.8mm wire requires 0.8mm roller.
		Wrong type of drive roller selected	Fit the correct type roller (e.g. knurled rollers needed for flux cored wires)
		Worn drive rollers	Replace the drive rollers
		Drive roller pressure too high	Can flatten the wire electrode causing it to lodge in the contact tip - reduce the drive roller pressure
		Too much tension on wire spool hub	Reduce the spool hub brake tension
		Wire crossed over on the spool or tangled	Remove the spool untangle the wire or replace the wire
		Contaminated MIG wire	Use clean, dry, rust free wire. Do not lubricate the wire.

§5.4 DC TIG Welding - Trouble Shooting

The following chart addresses some of the common problems of DC TIG welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

NO.	Trouble	Possible Reason	Suggested Remedy
1	Tungsten burning away quickly	Incorrect Gas or No Gas	Use pure Argon. Check cylinder has gas, connected, turned on and torch valve is open
		Inadequate gas flow	Check the gas is connected, check hoses, gas valve and torch are not restricted.
		Back cap not fitted correctly	Make sure the torch back cap is fitted so that the O-ring is inside the torch body
		Torch connected to DC +	Connect the torch to the DC- output terminal
		Incorrect tungsten being used	Check and change the tungsten type if necessary
		Tungsten being oxidized after weld is finished	Keep shielding gas flowing 10–15 seconds after arc stoppage. 1 second for each 10amps of welding current.
2	Contaminated tungsten	Touching tungsten into the weld pool	Keep tungsten from contacting weld puddle. Raise the torch so that the tungsten is off the work piece 2 - 5mm
		Touching the filler wire to the tungsten	Keep the filler wire from touching the tungsten during welding, feed the filler wire into the leading edge of the weld pool in front of the tungsten
3	Porosity - poor weld appearance and color	Wrong gas/ poor gas flow/ gas leak	Gas is connected, valve ON, check hoses, gas valve and torch are not restricted. Set the gas flow between 20-40 CFH (6-12 l/min). Check hoses and fittings for leaks
		Contaminated base metal	Remove moisture and materials like paint, grease, oil, and dirt from base metal
		Contaminated filler wire	Remove all grease, oil, or moisture from filler metal
		Incorrect filler wire	Check the filler wire and change if necessary
4	Yellowish residue / smoke on the alumina nozzle & discolored tungsten	Incorrect Gas	Use pure Argon gas
		Inadequate gas flow	Set the gas flow between 20-40 CFH (10-20 l/min) flow rate
		Alumina gas nozzle too small	Increase the size of the alumina gas nozzle
5	Unstable Arc during DC welding	Torch connected to DC +	Connect the torch to the DC- output terminal
		Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal.
		Tungsten is contaminated	Remove 10mm of contaminated tungsten and re grind the tungsten
		Arc length too long	Lower torch so that the tungsten is off

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			of the work piece 2 - 5mm
6	Arc wanders during DC welding	Poor gas flow	Check and set the gas flow between 20-40 CFH flow rate
		Incorrect arc length	Lower torch so that the tungsten is off the work piece 2 - 5mm
		Tungsten incorrect or in poor condition	Check that correct type of tungsten is being used. Remove 10mm from the weld end of the tungsten and re sharpen rod.
		Poorly prepared tungsten	Grind marks should run lengthwise with tungsten, not circular. Use proper grinding method and wheel.
		Contaminated base metal or filler wire	Remove contaminating materials like paint, grease, oil, and dirt, including mill scale from base metal. Remove all grease and oil from filler metal
7	Arc difficult to start or will not start DC welding	Incorrect machine set up	Check machine set up is correct
		No gas, incorrect gas flow	Check the gas is connected and cylinder valve open, check hoses, gas valve and torch are not restricted. Set the gas flow between 20-40 CFH flow rate
		Incorrect tungsten size or type	Check and change the size and or the tungsten if required
		Loose connection	Check all connectors and tighten
		Earth clamp not connected to work	Connect the earth clamp directly to the work piece wherever possible

§5.5 MMA Welding - Trouble Shooting

The following chart addresses some of the common problems of MMA welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

NO.	Trouble	Possible Reason	Suggested Remedy
1	No arc	Incomplete welding circuit	Check earth lead is connected. Check all cable connections.
		Wrong mode selected	Check the MMA selector switch is selected
		No power supply	Check that the machine is switched ON and has a power
2	Porosity – small cavities or holes resulting from gas pockets in weld metal	Arc length too long	Shorten the arc length
		Work piece dirty, contaminated or moisture	Remove moisture and materials like paint, grease, oil, and dirt, including mill scale from metal
		Damp electrodes	Use only dry electrodes
3	Excessive Spatter	Amperage too high	Decrease the amperage or choose a larger electrode
		Arc length too long	Shorten the arc length
4	Weld sits on top, lack of fusion	Insufficient heat input	Increase the amperage or choose a larger electrode
		Work piece dirty, contaminated or moisture	Remove moisture and materials like paint, grease, oil, and dirt, including mill scale from metal
		Poor welding technique	Use the correct welding technique or seek assistance for the correct technique
5	Lack of penetration	Insufficient heat input	Increase the amperage or choose a larger electrode
		Poor welding technique	Use the correct welding technique or seek assistance for the correct technique
		Poor joint preparation	Check the joint design and fit up, make sure the material is not too thick for wire size.
6	Excessive penetration - burn through	Excessive heat input	Reduce the amperage or use a smaller electrode
		Incorrect travel speed	Try increasing the weld travel speed
7	Uneven weld appearance	Unsteady hand, wavering hand	Use two hands where possible to steady up, practice your technique
8	Distortion – movement of base metal during welding	Excessive heat input	Reduce the amperage or use a smaller electrode
		Poor welding technique	Use the correct welding technique or seek assistance for the correct technique
		Poor joint preparation and or joint design	Check the joint design and fit up, make sure the material is not too thick. Seek assistance for the correct joint design and fit up
9	Electrode welds with different or unusual arc characteristic	Incorrect polarity	Change the polarity, check the electrode manufacturer for correct polarity

§6 Maintenance & Troubleshooting

§6.1 Maintenance

The operator must understand the maintenance procedure of inverter welding machine and complete simple examinations, cleanings and inspections. Do your best to protect the machine from contamination by leaving unit OFF when not in use to lengthen service life of inverter arc welding machine. Inverter machines have transistors that are cooled by aluminum heat sinks. When the power supply is ON, the cooling fan brings dirt & dust into the machine covering the heat sinks and reducing cooling capacity over time.

- **Warning: For safety while maintaining the machine, please shut off the main input power and wait for 5 minutes, until capacitors voltage drops to safe voltage 36V!**

Date	Maintenance items
Daily examination	Observe that the knobs and switches in the front and at the back of arc welding machine are flexible and put correctly in place. If any knob has not been put correctly in place, please correct. If you can't correct or fix the knob, please replace immediately. If any switch is not flexible or it can't be put correctly in place, please replace immediately! Please get in touch with the maintenance service department if there are no accessories. After turn-on power, watch/listen if the arc-welding machine has shaking, whistle calling or peculiar smell. If there is one of the above problems, find out the reason and clear it. If you can't find out the reason, please contact your local service repair station or distributor/Agent. Observe that the display value of LCD is intact. If the display number is not intact, please adjust it. If it still doesn't work, please maintain or replace the display PCB. Observe that the min./max.Values on LCD agree with the set value. If there is any difference and it has affected the normal welding results, please adjust it. Check whether the fan is damaged and whether it is normal to rotate or control. If the fan is damaged, please change it immediately. If the fan does not rotate but it starts when blades are rotated in direction of fan, the start capacity should be replaced. Observe whether the fast connector is loose or overheated. If the arc-welding machine has the above problems, it should be fastened or changed. Observe whether the current output cable is damaged. If it is damaged, it should be insulated or changed.
Monthly examination	Using the dry compressed air to clear the inside of arc welding machine. Especially for clearing up the dusts on aluminium heat-sinks, inductors, IGBT modules, fast recover diodes, PCB's, etc. Check the screws and bolts in the machine. If any are loose, please tighten. Check all torches, earth clamp and hose connections to insure they are securely in place. Loose connections can cause major failures.
Quarter-yearly examination	Check whether the actual current accords with the displaying value. If they did not accord, they should be regulated. The actual welding current value can be measured by and adjusted by plier-type ampere meter.
Yearly examination	Measure the insulating impedance among the main circuit, PCB and case, if it below 1MΩ, insulation is thought to be damaged and needs to be changed to strengthen insulation.

§6.2 List of Error Codes

Error Type	Code	Description
Thermal relay	E01	Over-heating (1st thermal relay)
	E02	Over-heating (2nd thermal relay)
	E03	Over-heating (3rd thermal relay)
	E04	Over-heating (4th thermal relay)
	E09	Over-heating (Program default)
Welding machine	E10	Phase loss
	E11	N/A
	E12	No gas
	E13	Under voltage
	E14	Over voltage
	E15	Over current
	E16	Wire feeder overload
Switch	E20	Button fault on operating panel when switch on the machine
	E21	Other faults on operating panel when switch on the machine
	E22	Torch fault when switch on the machine
	E23	Torch fault during normal working process
Accessory	E30	Cutting torch disconnection
	E31	N/A
Communication	E40	Connection problem between wire feeder and power source
	E41	Communication error

§6.3 Multi-Mig Accessories

The Multi-MIG series machines are supplied with SL15 MIG gun, 200A copper jaw clamp earth cable assembly, Dual gauge gas regulator & hose with brass fittings, ER70S6-030 welding wire on 8" spool and operator manual. Optional Multi-Mig accessories include:

Cart: Machine cart, 3-shelf, with gas cylinder support in powder-coated steel

Foot Control: TIG foot ON/OFF and output power control w/ cable assembly 12.5 ft.

TIG Torch-C.: TIG-17 torch, trigger control with direct-connect cable assembly 12.5 ft.

TIG Torch-P: TIG-17 torch, trigger & thumbwheel power control w/cable assembly 12.5ft.

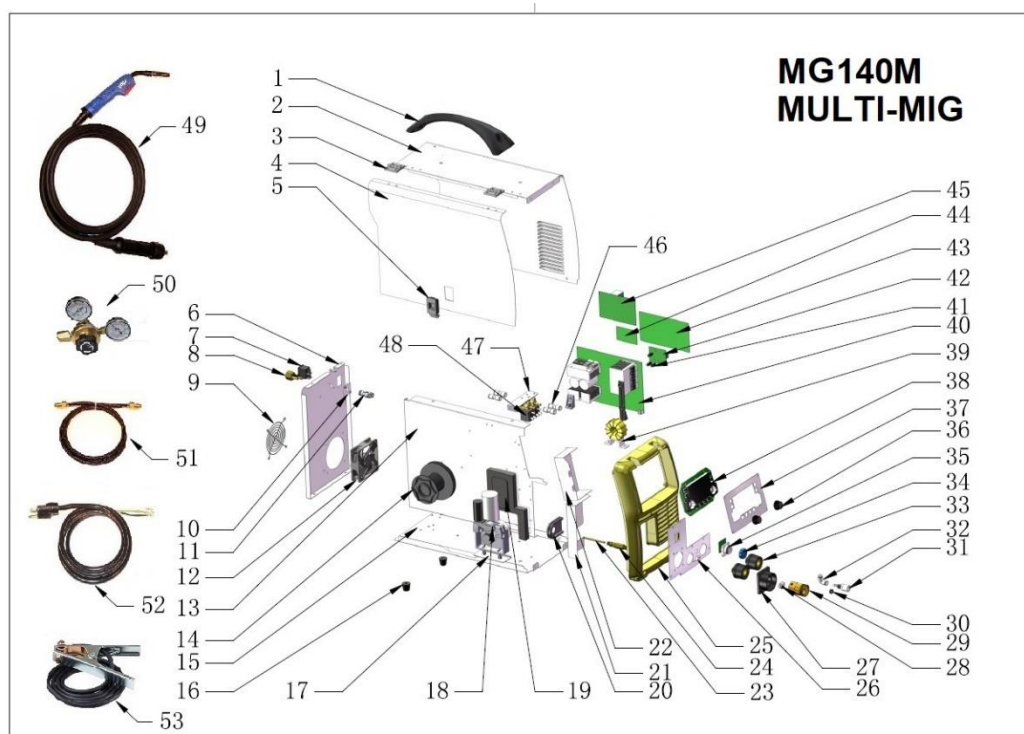
EH200: Arc electrode holder 200A with direct-connect cable assembly 12.5 ft.

Spool Gun: Spool gun 220A for 4" wire spool with direct-connect cable assembly 20 ft.

Flow Check: Gas flow checker, nozzle mounted with actual torch output flow rate.

Cylinder: Gas cylinder 80Cf capacity with CGA580 valve and steel cap AR/Co2/Mix

86.4 System Parts Lists



Item	Part no	Description	Item	Part no	Description
1	520.4010	F-Machine Handle	29	520.4023	Central Adaptor Socket
2	520.4050	Cabinet Cover 148/208M	30	520.3024	Socket Bushing
3	520.4019	Hinge	31	538.0015	Gas Connector 5/8-18RHT
4	520.4051	Cabinet Door 148/208M	32	707.0159	Quick-Connect Hose 90d
5	538.0017	Square Latch	33	511N0014	1/2" Dinse Socket
6	520.4050	Cabinet - Rear Panel	34	521.0012	Plug Protective Cover
7	530.0020	Rocker Type Switch	35	521.0011	9-Pin Receptacle
8	707.0165	Gas Out Connector	36	520.3027	Machine Knob
9	740.0122	Fan Cover Guard	37	520.4059	Display Mount Plate
10	520.4051	Gas Connector Installation Plate	38	520.4030	PCB - LCD Display Front
11	707.0152	3-Way Quick Connect	39-1	520.4038	Inductor Coil
12	740.0121	Cooling Fan	39-2	480.1023	Hall Current Sensor
13	520.4052	Median Septum	40	520.4034	IGBT Block (MIG140)
14	520.4016	Wire Spool Holder	41	000N0016	Hex Stand-off Spacer
15	520.4053	Cabinet - Bottom Board	42	521.2533	PCB - Push Pull Exchange
16	530.0025	Machine Leg	43	520.4036A	PCB- Control Board 148
17	520.4054	Wire Feeder Insulation Board	44	520.4037	PCB - D-Voltage 3846 Board
18	520.3019	Wire Feeder Motor	45	521.0205	PCB - Power Board
19	520.3020	Motor Shield Cap	46	707.0154	Quick-Connect Hose Straight
20	520.4055	Elliptical film Bushing	47	520.4060	Gas Valve Installation Plate
21	520.4056	Cover Shield - Socket	48	520.4048	Solenoid Valve 24VDC
22	520.4057	Cover Shield - PCB	49	SL15-10	SL15 MIG Gun Euro 10-Ft.
23	520.3021	Wire Guide Tube	50	721.0004	Gas Regulator CGA580
24	520.3022	Central Adaptor Rod	51	520.0009	Gas Hose 5/8-18RHT 3-Ft.
25	520.4057	Cabinet - Frame Front	52	707.0121	Power Cord NEMA5-15P
26	520.4058	Cabinet Front Panel	53	513N0013	200A Earth Clamp Cable 3550
27	521.2543	Central Adaptor Flange			
28	707.0159	Gas Hose Connector 90d			