

# INSTRUCTION MANUAL FOR MIG WELDING MACHINE

## IMPORTANT!!!

READ THIS MANUAL CAREFULLY BEFORE INSTALLING, USING, OR PERFORMING ANY MAINTENANCE ON THE MACHINE. PAY SPECIAL ATTENTION TO THE CHAPTER ON "SAFETY PRECAUTIONS". CONTACT YOUR DISTRIBUTOR IF YOU DO NOT FULLY UNDERSTAND THESE INSTRUCTIONS.

## 1 GENERAL DESCRIPTIONS

### 1.1 SPECIFICATIONS

This manual has been prepared for the purpose of educating personnel assigned to install, operate and service the welding machine.

This equipment is a constant-voltage generator, suitable for MIG/MAG and OPEN-ARC welding.

Upon receiving the machine, make sure there are no broken or damaged parts.

The purchaser should address any complaints for losses or damage to the vector. Please indicate the article and serial number whenever requesting information about the welding machine.

### 1.2 EXPLANATION OF TECHNICAL SPECIFICATIONS

EN50199 The welding machine is manufactured according to these international standards.  
EN50974.1 Serial number, which must be indicated on any type of request regarding the welding machine.

N<sup>3</sup> Three-phase transformer-rectifier.



Flat characteristic.



Downslope



Suitable for continuous electrode welding.



Suitable for TIG welding.



Suitable for MMA welding.

I<sub>2</sub> MAX Unconventional welding current. This value represents the maximum limit available during welding.

U<sub>0</sub> Secondary open-circuit voltage (peak value).  
X Duty cycle percentage  
The duty cycle expresses the percentage of 10 minutes during which the welding machine may run at a certain current without overheating.

I<sub>2</sub> Welding current.  
U<sub>2</sub> Secondary voltage with welding current I<sub>2</sub>.

U<sub>1</sub> Rated supply voltage.  
3- 50/60Hz 50- or 60-Hz three-phase power supply.

I<sub>1</sub> Absorbed current at the corresponding welding current I<sub>2</sub>.

IP21 Protection rating for the housing. Grade 1 as the second digit means that this equipment is suitable for use outdoors in the rain.

S Suitable for use in high-risk environments.

NOTES: The welding machine has also been designed for use in environments with a pollution rating of 3. (See IEC 664).

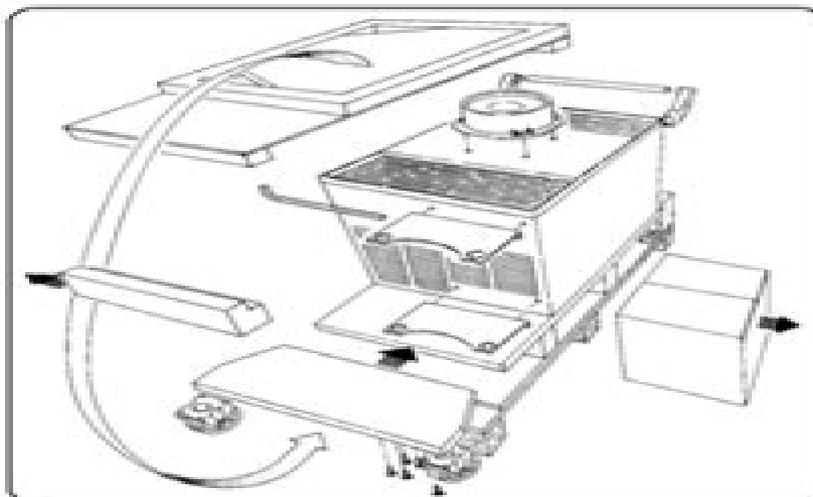
## 2 INSTALLATION

### 2.1 PLACEMENT

Dust, dirt, and any other foreign matter entering the welding machine can interfere with ventilation and thus with smooth operation.

Mount the handle, the 2 cylinder supports, the extension support and pivot support.

Mount the 2 fixed wheels on the wheel support located on top of the welder. Remove the Styrofoam buffer from under the bottom, at the back of the welding machine. Insert the wheel support on the bottom, fastening it in place with the screws provided.



### 2.2 START-UP

- Only qualified personnel should install this welding machine.
- Connect a plug suitable for the absorbed current to the power supply cable.
- Connect the yellow-green wire of the machine mains to an efficient grounding socket.
- Never use water pipes as a grounding conductor.

#### 2.2.1 Connecting the mass clip.

- Connect the power cable terminal to socket AA on the machine.
- Connect the mass cable clip to the workpiece.
- Make sure the cable is firmly attached to the mass terminal; check periodically to make sure these connections are tight. A loose coupling may cause drops in the welding current.

# Mig Welding Manual

**Christian G. Meyer**



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## **Table of Contents Mig Welding Manual**

1. Understanding the eBook Mig Welding Manual
  - The Rise of Digital Reading Mig Welding Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Mig Welding Manual
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Mig Welding Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Mig Welding Manual
  - Personalized Recommendations
  - Mig Welding Manual User Reviews and Ratings
  - Mig Welding Manual and Bestseller Lists
5. Accessing Mig Welding Manual Free and Paid eBooks

- Mig Welding Manual Public Domain eBooks
- Mig Welding Manual eBook Subscription Services
- Mig Welding Manual Budget-Friendly Options
- 6. Navigating Mig Welding Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - Mig Welding Manual Compatibility with Devices
  - Mig Welding Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Mig Welding Manual
  - Highlighting and Note-Taking Mig Welding Manual
  - Interactive Elements Mig Welding Manual
- 8. Staying Engaged with Mig Welding Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Mig Welding Manual
- 9. Balancing eBooks and Physical Books Mig Welding Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Mig Welding Manual
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine Mig Welding Manual
  - Setting Reading Goals Mig Welding Manual
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Mig Welding Manual
  - Fact-Checking eBook Content of Mig Welding Manual
  - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development

- Exploring Educational eBooks
- ### 14. Embracing eBook Trends
- Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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