

# 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 vendor. 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.

EN60974-1 **N** Serial number, which must be indicated on any type of request regarding the welding machine, 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.



Secondary open-circuit voltage (peak value).



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.



Welding current.



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



Rated supply voltage.



3~ 50/60Hz: 50- or 60-Hz three-phase power supply.



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



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



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

**Robert Scharff,Ltd Staff Scharff  
Associates**

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