

USER'S MANUAL



MIG-200ie

MIG / MMA / TIG WELDING MACHINE















Please read the User's Manual carefully before using the machine.

Safety

In the benefit of you and others, we recommend you to read and fully understand this manual before installation and operation

No prior notice will be given in case of any change.

 Notice	<p>Please install and use strictly according to the Manual!</p> <p>Electrical connection can be done only after the power supply is turned off. The operation process shall conform to relevant safety operation rules.</p>		
 Warning 	<p>An electric shock may hurt or cause severe injury to users.</p>	<p>Please turn off the power supply before wiring. Do not touch exposed conductive parts.</p>	 <p>Welding operation may cause fire or explosion!</p> <p>Welding spatter may ignite combustibles nearby.</p> <p>Combustibles shall be placed at least 10m from the welding site.</p> <p>Prevent the spatter from falling on clothes or body.</p>
	<p>The welding fume is harmful to health. Do not inhale the fume produced during welding. Clean up the greasy dirt on work piece. Keep the welding site sufficiently ventilated. Smoke and dust extracting facility shall be arranged at the welding station.</p>		<p>Strong arc light may hurt the eyes. The ultraviolet rays produced by the electric arc may hurt the skin and the eyes. Please wear protective clothes and gloves properly during welding.</p>
	<p>Inert gases are harmful to the human body and even cause suffocation. Please choose a well-ventilated environment for welding. If not, do close the gas cylinder valve.</p>		<p>High-frequency arc ignition may cause electromagnetic radiation. Radiation may interfere with other devices! Contact arc ignition can be used to avoid interference.</p>
	<p>The overheated part may burn the skin, and do not touch the overheated welding part.</p>		<p>High-speed moving objects may cause injury. Do not put your hands or a thin objects into the fanhood.</p>
	<p>The gas cylinder may explode. so do not heat it. It is preferred to keep the gas cylinder away from the welding site and store it well.</p>		<p>Personal protection. To prevent eye and skin injury, please comply with the safety and health rules and wear necessary protective clothing!</p>

INSTALLATION

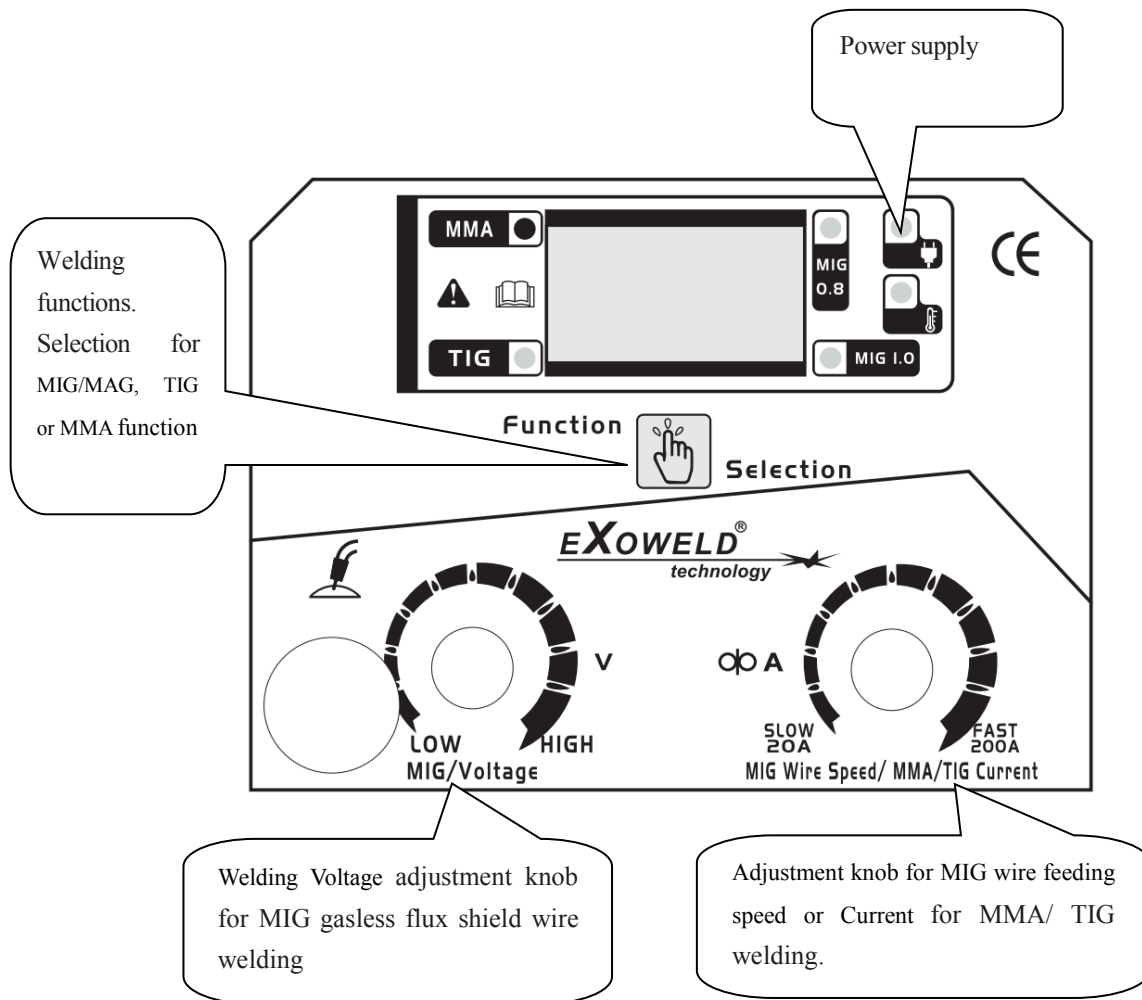


Figure 1: Control panel

INSTALLATION

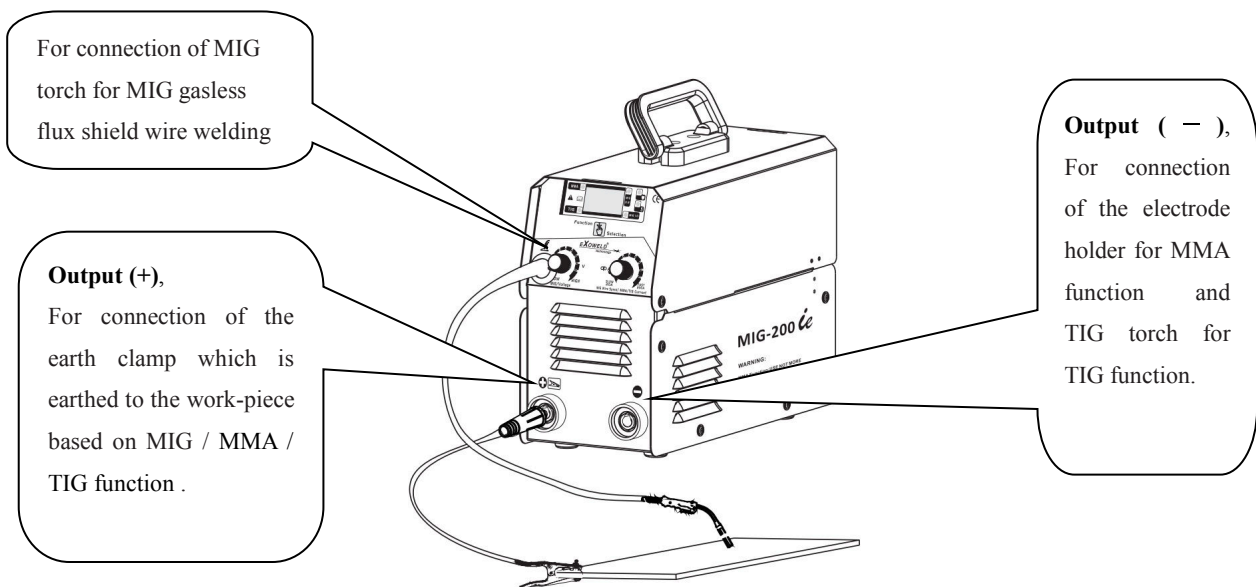


Figure 2: Connection of MIG , TIG torch or Electrode holder and Earth cable

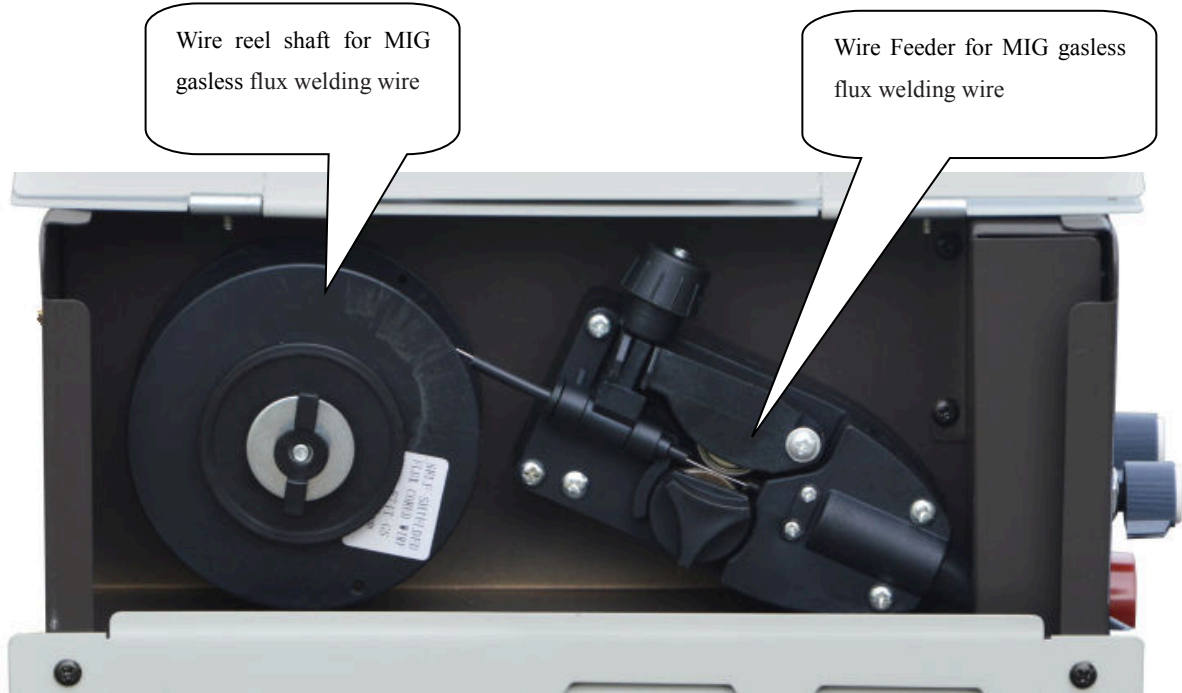


Figure 3: Internal wire feeder system

The weight of MIG Gasless Flux Shield Wire: 0.5~1Kg

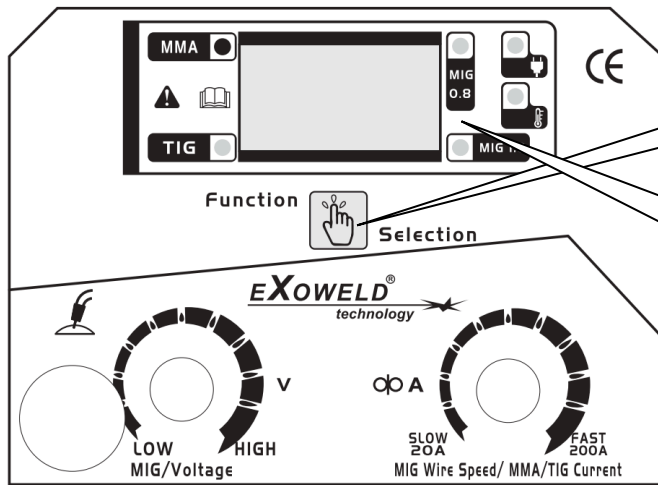
1. TECHNICAL INFORMATIONS

	MIG-200ie
Input voltage	1 Phase, 240VAC
Frequency	50/60Hz
Rated Output Current	200A (For MIG/MAG) ,200A (For MMA) , 200A (For TIG)
Rated Output Voltage	20.0V (For MIG/MAG) , 24.8V (For MMA) , 14.8V (For TIG)
Wire Diameter	0.8mm, 1.0mm
Machine Size	318×129×220mm
Weight	5.5Kg

2. CONNECTION FOR MIG GASLESS FLUX SHIELD WIRE WELDING

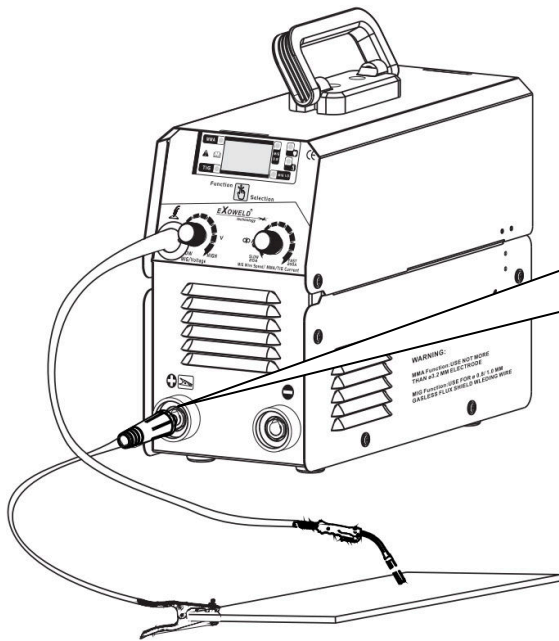
- 1). Press the function button (Function Selection),
- 2). Selected function to wire size 0.8 or 1.0, (also we called MIG 0.8 or MIG 1.0)
- 3). Output terminal (+), for Earth clamp which is to be connected to the work-piece. Connect MIG torch for MIG welding

- 4). Adjust the knob of MIG/ Voltage for welding.
- 5). Adjust the feeding speed of the welding wire feeding through the fixed MIG torch

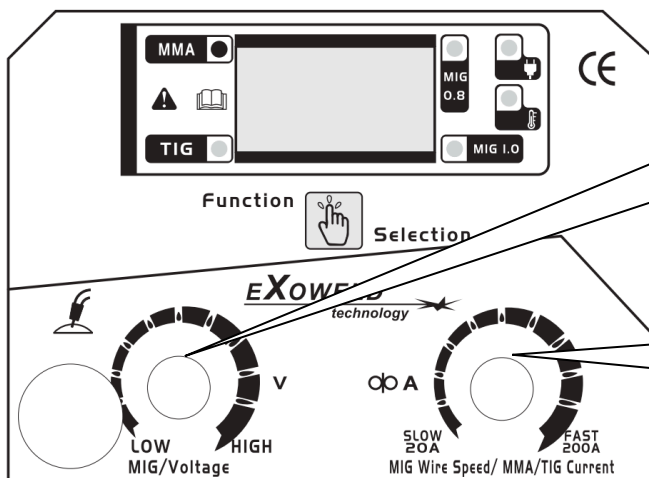


1). Press the function button.

2). Selected function to flux 0.8 or 1.0,(also we called MIG 0.8 or MIG 1.0)



3). **Output terminal (+)**, for Earth clamp which is to be connected to the work-piece as indicated on picture. Set up MIG torch for gasless flux shield wire welding

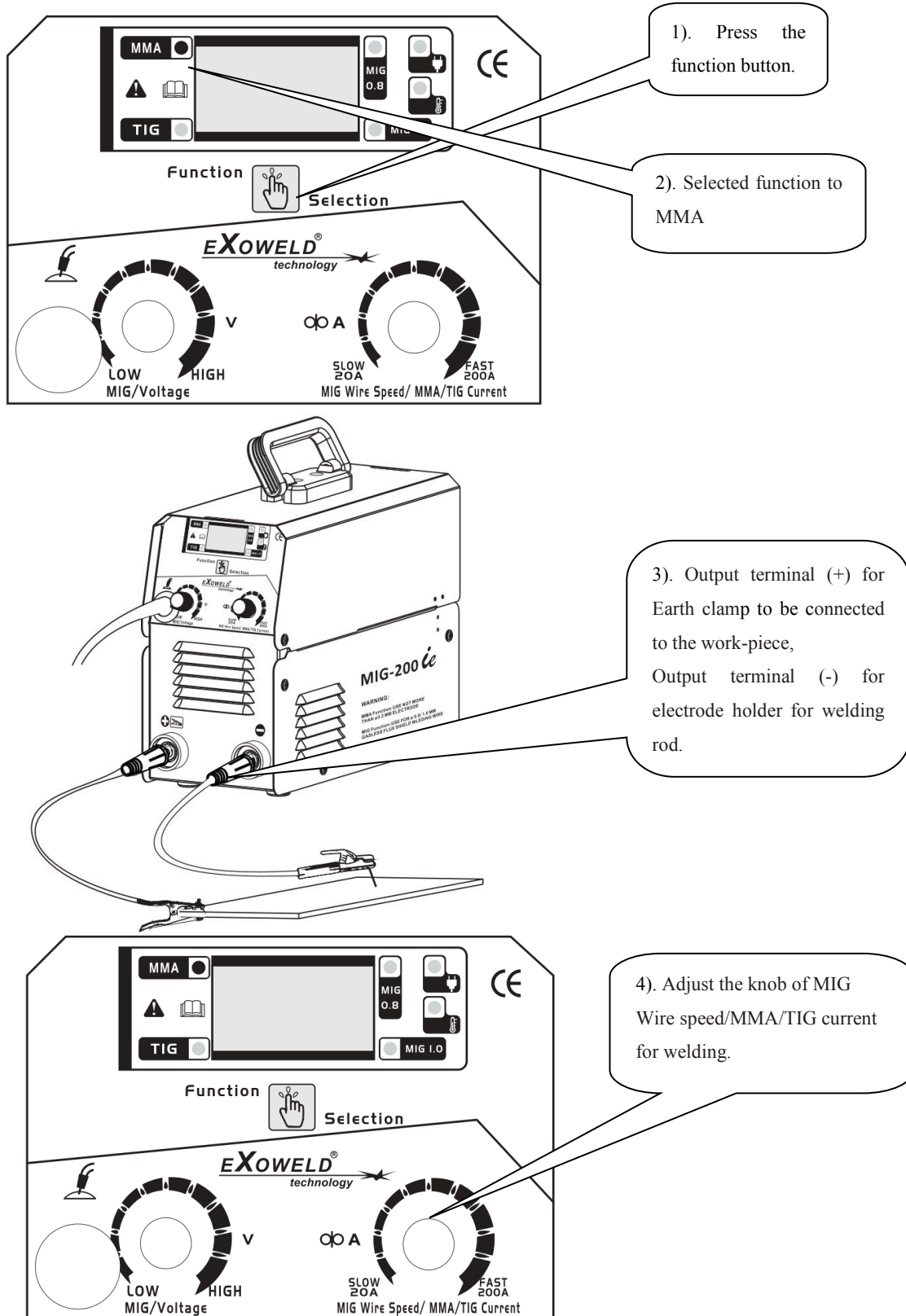


4). Adjust the knob of MIG/ Voltage for welding.

5). Adjust the feeding speed of the MIG gasless flux shield wire feeding through the torch

3. CONNECTION FOR MMA

- 1). Press the function button (Function Selection),
- 2). Selected function to MMA,
- 3). Output terminal (+) for Earth clamp to be connected to the work-piece,
Output terminal (-) for Electrode holder to be connected for welding rod.
- 4). Adjust the knob of MIG Wire Speed/MMA current for welding.



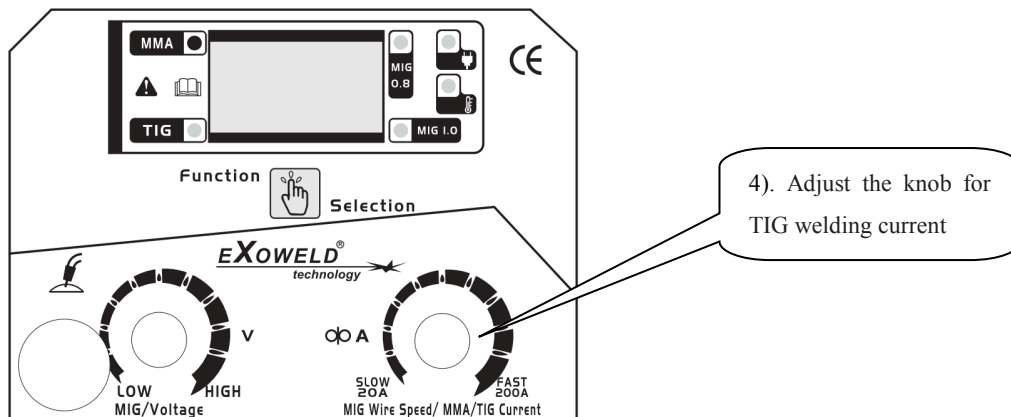
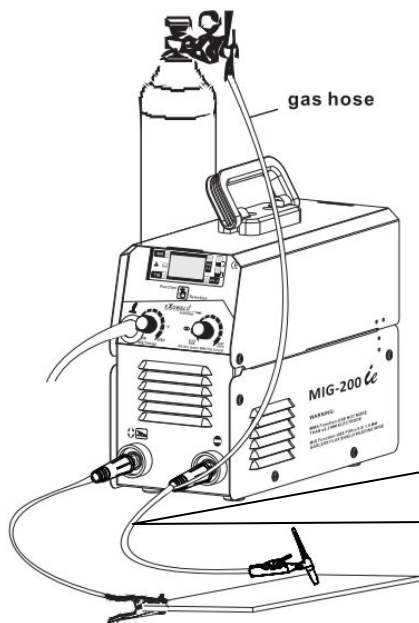
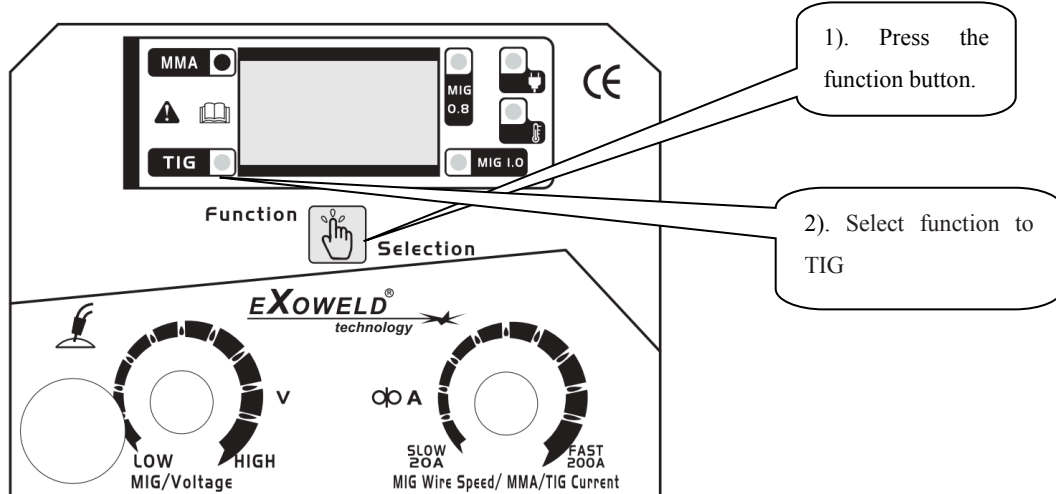
4. CONNECTION FOR TIG

- 1). Press the function button (Function Selection),
- 2). Selected function to TIG,
- 3). Output (-) terminal for TIG torch;

Output (+) terminal for earth clamp to be connected to work piece,

Connect the gas hose of the gas supply system (**external Argon gas supply system**) to TIG torch.

- 4). Adjust the knob (MIG Wire Speed/ MMA Current) for TIG welding current.



MAINTENANCE AND TROUBLE SHOOTING

5. BASIC TROUBLE SHOOTING

TROUBLE	REASON	REMEDY
1. Machine does not work.	Power source switch is out of order.	Change the switch.
	Fuse is blown out.	Change the fuse.
	PC board is out of order.	Contact your authorized technical service.
2. The welding machine is turned on, no output, the fan is not running.	Possible failure of power switch.	Check power supply
	Possible short circuit of input cable.	Check power supply
	Fan is out of order.	Change the Fan.
3. Wire feeder works but wire is not fed.	The drive roll is not appropriate for the wire diameter.	Select the appropriate drive roll.
	Pressure on the wire roller is not enough.	Adjust the pressure.
4. Trouble in welding operation.	Contact tip size is wrong or bad.	Change the contact tip.
	Pressure on the wire roller is not enough.	Adjust the pressure roll.
	CO ₂ heater fuse is blown out.	Check and Replace it if necessary.
	Protective gas pressure is not appropriate.	Check the gas and adjustment.
5. While this welding machine is in operation, LED is lighted up, no current output.	It is possible that the over-load protection is activated.	Wait till it is not flashing and the welding operation will be resumed.
	It is possible that the over-load protection is activated.	Wait till it is not flashing or switch off the power supply, restart ON/OFF switch of the welding machine.
6. Welding parameters cannot be adjusted. 7. Welding current or voltage isn't stabilized.	The main control PCB is out of order.	Change the control PCB
	Pressure on the wire roller is not enough.	Adjust the pressure roll.
	Gas flow rate is not enough.	Adjust the gas flow rate
	Circuits are possibly damaged.	Check and replace them if necessary.
	Capacitors are possibly damaged.	Replace them if necessary.
	No connection inside this welding machine.	Check and reconnect if necessary.
	No connection of the earth cable, or connection of the earth cable and work-piece.	Check and reconnect if necessary.
8. Heater is not working.	Fuse is blown out.	Change the fuse.
	Heater is out of order.	Change Heater