

Portable Spot Welder Manual



Please read this manual carefully before using the product and operate according to the instructions provided.

●Precautions and Safety Instructions

1. Minors are not allowed to use this product.
2. This product contains a lithium battery. Do not place it in damp, high-temperature, or other flammable and explosive environments to avoid accidents.
3. The temperature display of this product reflects the battery temperature. If the battery temperature exceeds 51°C , it is recommended to stop using the product. If the temperature exceeds 55°C , the product will automatically stop operating until the temperature drops below 55°C .
4. Protect the welding needles of the product from falling or

damage.

5. This product is intended for welding ordinary nickel-plated steel sheets, iron sheets, and nickel sheets; it should not be used for other purposes.

6. Dispose of or replace the battery of this product according to the relevant local laws and regulations.

7. Do not use this product while charging.

8. Do not use this product in flammable or explosive environments, as it may produce sparks that can ignite dust or fumes.

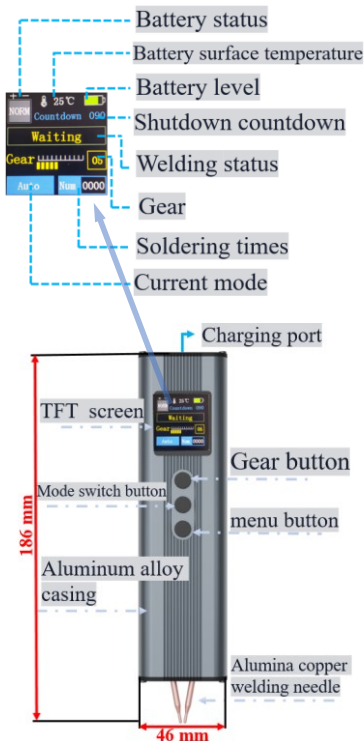
9. Sparks may occur at the tip during spot welding, please take protective measures.

10. Low battery voltage may

result in poor welding or even failure to weld. Please fully charge the battery before using it.

※Special Disclaimer: The company does not assume legal responsibility for any derivative results from using this product.

●General Overview



●Instructions for Use

1. Automatic Mode : The machine defaults to automatic mode. The main parameters displayed on the interface in automatic mode are as follows:

Battery Status : This function detects the surface temperature of the battery. Under normal usage, it will indicate "normal." If the temperature is too high, a red high-temperature warning will appear, and the spot welder should not be used during this state.

Battery Surface Temperature: Monitors the surface temperature of the battery in real-time. If the temperature exceeds 51°C, it is recommended to stop using the product. If the temperature exceeds 55°C, the product will not function properly. It can only resume operation once the temperature drops below 55°C.

Battery level: Indicates the remaining battery power. Use the product with sufficient battery power whenever possible. A red indicator

means the battery power is low.

Shutdown Countdown : When the sleep countdown reaches 0, the product will automatically shut down. It can be awakened by pressing any button.

Welding State: Displays three statuses: "Waiting" "Welding," and "Welding OK." Spot welding work can only be carried out when the machine prompts "Waiting".Note: When the product indicates " Welding OK" it will only switch to " Waiting " after the welding needles are lifted from the steel or nickel sheet for a while.

Gear Level: : Adjust the gear level using the gear level adjustment button.

Current Mode: Displays the current mode, which can be adjusted by long pressing the mode switch button, as shown in Figure 3.

Welding Times:Records the total number of spot welds since the current power cycle.

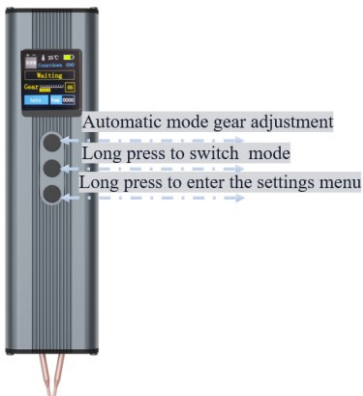
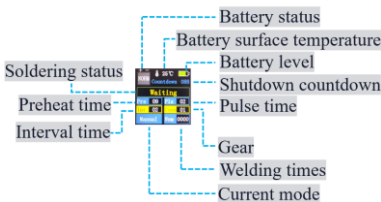


Figure 3

2. Manual Mode: Enter the manual mode through the mode selection, with the main parameters displayed as follows:



Most parameters in manual mode are

the same as those in automatic mode. The differences are preheat time, interval time, and pulse time. These three parameters need to be set in the menu. Automatic mode parameters are factory-set and correspond to the power level, with no need for customer adjustments.

Preheat Time: Also known as deoxidizing time, measured in ms. Usually, it should be set to a lower value than the pulse time.

Interval Time: The interval time from preheat to pulse, measured in ms.

Pulse Time: The interval time from preheat to pulse, measured in ms.

3. Menu Display: Long press the settings menu button to enter the menu. There are a total of 6 adjustable parameters. Each selected parameter has two states: pre-selected and selected. Switch between states by short-pressing the menu settings button, as shown in Figure 5.

When a parameter is in the **selected**

state: You can adjust the selected parameter's value using the power level adjustment and mode switch buttons.

When a parameter is in the **pre-selected state:** You can choose different parameters using the power level adjustment and mode switch buttons.

After setting the parameters, long press the menu settings button to save the current parameter settings.

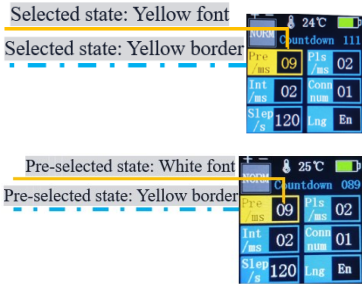


Fig 5

The meanings of parameter are as follows:

Preheat: Set the preheat time.

Pulse: Set the pulse time.

Interval: Set the interval time.

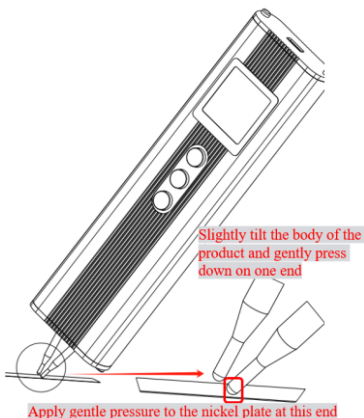
Continuous Welding Count: Set the continuous welding count. The default is 1.

Sleep: Set the shutdown time, with a default of 120 seconds.

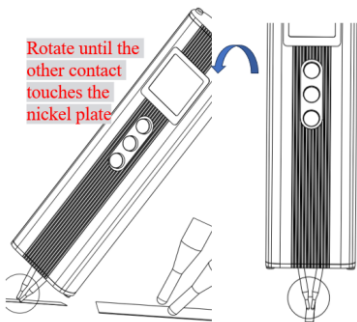
Language: Set the language.

●Spot Welding Techniques

1. When spot welding, if there is poor contact with the nickel strip, you can try the following methods:



First, as shown in the figure, tilt the welding machine slightly and gently press down on one end of the welding needle, allowing the other end to hang freely. Then, lightly rotate the welding machine until the other end of the welding needle also makes contact.



2. Clean the surface of the nickel sheet to be welded beforehand, ensuring the two contact points of the welding needles simultaneously make good contact with the nickel sheet. Wait about one second for the spot welding to complete, accompanied by an audible prompt. Note: Clean nickel sheets produce fewer

sparks.

3. The welding pen may develop black oxides after multiple uses. Use sandpaper to polish before further use.

4. Do not press down hard on the nickel strip while welding, as it may result in faulty welds with weak spots. The correct method is to lightly press the nickel sheet to ensure a good fit with the battery surface for optimal results.

●Product Warranty

1. Do not disassemble the instrument parts or modify the instrument without permission, as unprofessional handling can damage the instrument. If the instrument is damaged, please contact us.