Welder Setting Chart

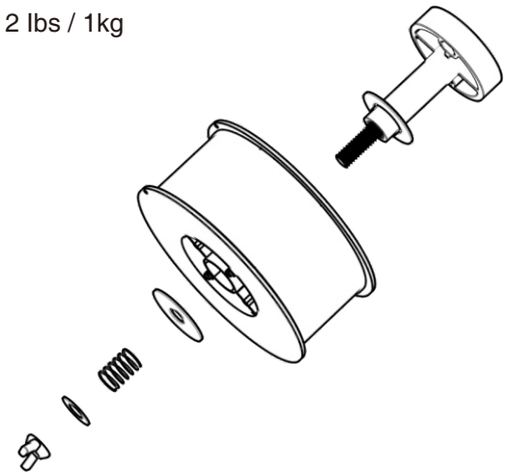
Welding parameters

FLUX MIG	.030" (0.8mm)	Workpiece Thickness mm	1.0mm (.040")	1.5mm (.059")	2.0mm (5/64")	2.5mm (3/32")
		Welding Voltage V	14.5	15.3	16.3	16.5
		Welding Current A	63	94	115	135
	.035" (0.9mm)	Workpiece Thickness mm	1.0mm (.040")	1.5mm (.059")	2.0mm (5/64")	2.5mm (3/32")
		Welding Voltage V	14	15.6	16.6	16.9
		Welding Current A	63	94	120	135

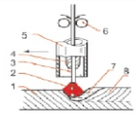
TIG	Tungsten Needle Ømm	1.0mm (.040")		1.6mm (1/16")		
	Workpiece Thickness mm	0.8mm (1/32")	1mm (.040")	1.5mm (.059")		
	Welding Current A	20~40	50~80	90~135		

MMA	Welding Rod Ømm	2.4mm (3/32")	3.2mm (1/8")			
	Workpiece Thickness mm	1.5mm (.059")	3.0mm (.118")			
	Welding Current A	60	100~135			

Wire Coil Installation

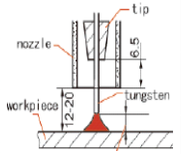


MIG Gun Consumables



Wire Diameter	Welding Current(A)	Nozzle Distance
.030" 0.8mm	50-100	5/16-3/8" (8.0-9.5mm)
	100-160	3/8-1/2" (9.5-12.7mm)
.035" 0.9mm	70-100	3/8-1/2" (9.5-12.7mm)
	100-250	1/2-5/8" (12.7-15.9mm)

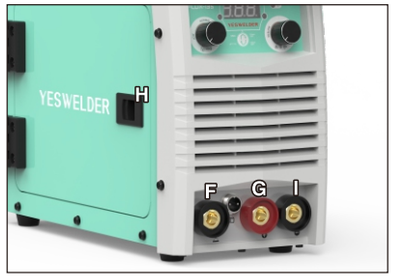
LIFT TIG Torch Consumables



Tungsten Diameter	Welding Current(A)	Gas Flow Rate(Ar)
.040" 1.0mm	20-40	6
	50-80	8
1/16" 1.6mm	10-50	12
	50-100	14
3/32" 2.4mm	30-80	12
	80-180	16
1/8" 3.2mm	30-100	14
	100-250	18

Welding Description

MIG Welding	For material thickness greater than 1/4", adopting a grooved weld is preferred. Use a multi-pass welding process will insure proper penetration. For solid wire use DCEP and shielding gas. For flux core welding, use DCEN. Shielding gas is not needed for flux core welding but can be used.
LIFT TIG Welding	For material thickness greater than 5/32", adopting a grooved weld is preferred. Use a multi-pass welding process will insure proper penetration. DC is suitable for welding carbon steel and stainless steel. AC is suitable for aluminum and aluminum alloy and other non-ferrous metals. (MIG machine not have AC TIG, so Aluminum is not available on Lift TIG Welding)
ARC Welding	For material thickness greater than 1/4", adopting a grooved weld is preferred. Use a multi-pass welding process will insure proper penetration. When using acidic electrodes, DCEP and DCEN can be used. Alkaline electrodes use DCEN and cellulose electrodes use DCEP.

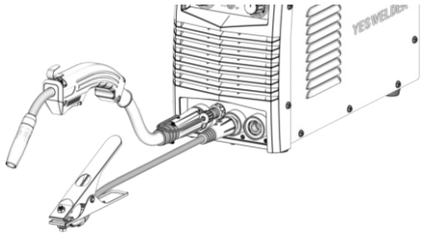


Front panel instruction

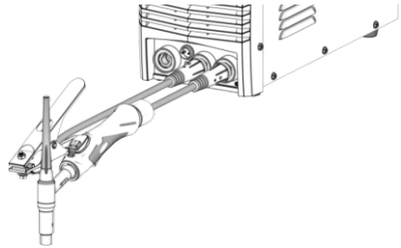
A	Selection button-switching between 0.8mm/.030" 0.9mm/.035", MMA(STICK) and Lift TIG
B	Voltage Knob-Micro adjust from -5V to 5V(Low to High)
C	Wire Feed Speed/Ampere Knob- adjusting welding current from 20A to 135A(MMA/Lift TIG) and 20A to 135A(0.8/0.9mm Flux MIG). Wire feed speed will be auto changing against welding current by welder data(Software controlled)
D	Thermal Protection LED
E	Power Indicator LED
F	MIG Torch Connector
G	Positive Connector(+)
H	Latch
I	Negative Connector(-)

Polarity

FLUX WIRE(DCEN)



LIFT TIG(DCEN)



MMA(DCEP)