

INSTRUCTION MANUAL

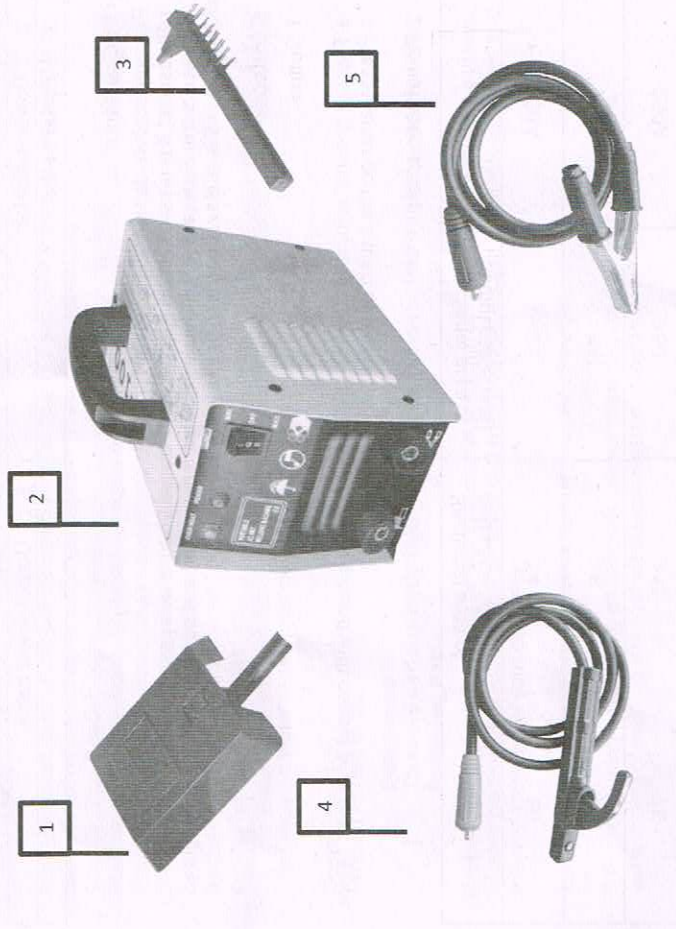
WELDING MACHINE



Read this manual entirely before getting down to work with your new machine

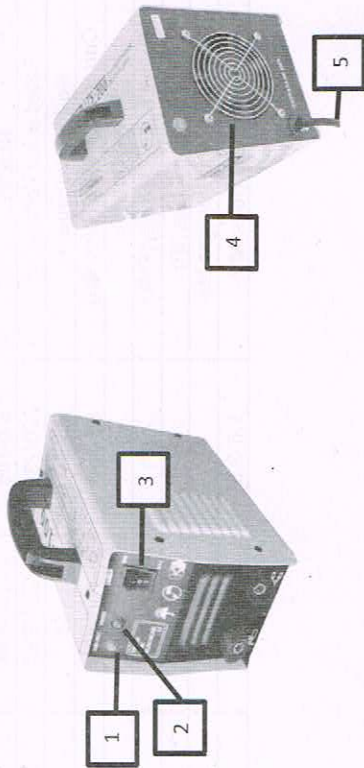
TECHNICAL SPECIFICATION

MODEL	BX-100	BX-130	BX-160
Rated input Voltage(v)	220/230	220/230	220/230
No-load Voltage(v)	48	48	48
Current Adjusting Range(A)	85-100	100-130	130-160
Rated Duty(%)	10	10	10
Rated Input Capacity(KVA)	5	6	8
Protection Class(IP)	21	21	21
Rank of Insulation(grade)	H	H	H
Usable Electrodes(MM)	1.6-2.5	2.5-3.2	3.2-4.0



COMPONENTS				
1	Mask	4	Electrode holder with cable	
2	Machine	5	Earth clamp with cable	
3	Brush			

Controls&Functions



LEGEND

1	Over-heat indicator	4	Fan
2	Power indicator	5	Output power cable
3	Power switch		

Notice items

Placement of welder

- 1.Please set it in less-cibration and flat place above 200mm away from the wall.
- 2.Please put in clean and dry place less of iron-power,dust and paint.
- 3.Place it in the site avoiding rain or sea-water erosion.

Connection

1. Ground

- a. There is ground terminal under the shell board.Please ground with copper wire over 14mm.
- b. Please arrange the expert or electrician to ground.

2. Power connection

Model	Sectional area of output cable(mm ²)	Sectional area of output cable(mm ²)	Air switch current(A)
130A	≥25	≥4	60
200A	≥35	≥6	60
250A	≥50	≥10	75

The above cable has copper coil

Each welder need be equipped with a distributor box switch and over-current protection device. Please lead the power the distributor box to input terminal of welder by cable. The capacity of distributor box and corss-sectional area of refer to below table.

- 3.Connection of welding end
One end adjoins the cable for welding torch through quick joint,and the other end adjoins the workpiece by cable with quick joint. The quick joint at the output end must be screwed colckwise firmly for safety. The workpiece must ground in operation.



Notice:

1. Switch off the power distributor box when adjoining the cable.
2. The cable must be connected with copper terminal. Please use insulating tape after fixing it with bolt and nut.

Operation instruction

Operate as follows

1. Switch on the distributor box and power.
2. Turn on the power switch of welder-turn the switch on MIN or MAX.
3. Operate welding-wear proper clothes and protective apparatus.
4. End operation.
5. Turn off the power of welder.
6. Switch off the distributor box.

Safety items

Read this manual carefully before using in order to avoid accident. Incorrect operation will cause three different degrees injuries. Signs in this manual indicate it.

Caution Sign Caution Term Content

Warning Wrong operation will lead to serious injuries or death.

Caution incorrect operation may cause middle-degree injury or destruction of matters.

The above serious injuries refer to those which need long-term treatment in hospital caused by sight dammification, wound(high-temperature or low temperature injury, Electric shock, fracture, poisoning and so on; and light injuries means burn or electric shock without long-term curing; destruction of machine.

The following signs show (must do)and (forbid to do)

Compei must do
Prohibit Forbid to do



Dangerous
To avoid serious body injury caused by accident,you ought to observe the following items.

1. The construction of inputing power source,the selection of the site for machine,the upkeep of work place after welding and the handing of waste should accord to the relecant rules and internal standard of your company.
2. Irrelevant personals are forbidden to enter the site of welding.
3. Persons using heartstroke pacemaker can not draw near to welder in use and the surrounding of welding site without the permission of the doctor.
4. Let professional or expert person install, maintain and repair welder.
5. Ler personnel who have the knowledge of safe use and technique operate the machine.
6. Do not use the machine except welding.

Upkeep & maintain

In order to prolong the service life of machine, please pay great attention to its upkeep and repair. Please maintain the welder once at least 6 month as below points. The power of distributor box and welder must be switched off.

1. Use resistance instrument to measure the resistance between ground and the primary winding, secondary, and each other winding. And the resistance should be more than 1M. Thus, you need use compressed to blow the dust in the winding and other parts away.
2. Dust may decrease the performance of insulation and make the winding over-heated. Thus, you need use compressed to blow the dust in the winding and other parts away.
3. Examine the contact state of power switch, if there is burnt on the surface, it should be changed.
4. Examine whether the bolt and nut is tight fixed. If they are loose, you need screw it tight.
5. Once the machine needs to be repaired, please inform the distributor the model and product number as soon as possible.

Notice

1. Please confirm the rated specifications and then make use of it.
2. Avoid over-load usage
 - a. Serious over-load can burn machine, at least shorten the service life.
 - b. Over-load may cause noise.
3. The connection of cable and terminal of machine should be steady. Or it will cause local running hot to burn the terminal and cable.
4. Too long output cable will lead to impeding current circulation and add electric power loss. If the surface insulation of cable is spoiled, the arc will be unstable, so we need change the old cable in time.
5. The power must be switched off after operation.
6. The internal movable iron-core sleek structure has been as adjusted well. Do not move it if no necessary.
7. Place the welder in the shade. Do not use the machine in the sun for a long time.
8. The temperature of shell will rise in operation. The insulation of winding belongs to F grade. Please use the machine at rated duty cycle.
9. Keep the voltage as stable as possible.

The voltage is lower than rated input voltage will lead to

- (1) The welding current is too low
- (2) The arc will break or be unstable

The voltage is higher than rated input voltage will lead to

- (1) The welding current is too high
- (2) Make noise
- (3) Shorten the service life of welder.

10. Please remember to wear suitable protective apparatus in case of accident.