VEVOR®

TOUGH TOOLS, HALF PRICE

Technical Support and E-Warranty Certificate
www.vevor.com/support

TIG Welder
Model:TIG/MMA-205

We continue to be committed to provide you tools with competitive price. "Save Half", "Half Price" or any other similar expressions used by us only represents an estimate of savings you might benefit from buying certain tools with us compared to the major top brands and does not necessarily mean to cover all categories of tools offered by us. You are kindly reminded to verify carefully when you are placing an order with us if you are actually saving half in comparison with the top major brands.

VEVOR®
TOUGH TOOLS, HALF PRICE

TIG Welder

Model:TIG/MMA-205

Note:The product picture is for reference, the actual details shall prevail

NEED HELP? CONTACT US!

Have product questions? Need technical support? Please feel free to contact us:

Technical Support and E-Warranty Certificate
www.vevor.com/support

This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.

	Warning-To reduce the risk of injury, user must read instructions manual carefully.
	**CORRECT DISPOSAL for Display** This product is subject to the provision of european Directive 2012/19/EU. The symbol showing a wheelie bin crossed through indicates that the product requires separate refuse collection in the European Union. This applies to the product and all accessories marked with this symbol. Products marked as such may not be discarded with normal domestic waste, but must be taken to acollection point for recycling electrical and electronic devices.
	Compliance is a EC security certification.

The **TIG/MMA-205** provides a convenient method of performing “stick” welding carbon steel. Inverter technology provides the capability of welding thin or heavy gauge steel with precision and ease. When adding the optional lift TIG torch **(not included)**, gas regulator, and a cylinder of shielding gas, the **TIG/MMA-205** becomes a TIG welder.

SPECIFICATIONS

Output Current Range:	Input Current	Input Voltage	Rated Duty Cycle	Rod Diameter	Rod Material
20~~205A	I1 max 45A (110V) I1 eff 34.8A (110V) I1 max 34A (220V) I1 eff 26.3A (220V)	110Vor220V	20%@ 205A	1/16~6/31 1.6~5.0mm	E6010 E6011 E6013 E7014 E7018S tainless Steel

DUTY CYCLE

The rated duty cycle refers to the amount of welding that can be done within an amount of time. The **TIG/MMA-205** has a duty cycle of 60% at 195A. It is easiest to look at your welding time in blocks of 10 minutes and the duty cycle being a percentage of that 10 minutes. If welding at 195A with a 60% duty cycle, within a 10 minute block of time you can weld for 6 minutes with 4 minutes of cooling for the welder. If the duty cycle is exceeded, the welder will automatically shut off, however the fan will continue running to cool the overheated components. When a safe temperature has been reached, the welder will automatically switch the welder output back on. To increase the duty cycle you can turn down the amperage output control.

READ AND UNDERSTAND ALL INSTRUCTIONS AND PRECAUTIONS BEFORE PROCEEDING.
This unit emits a powerful high voltage and extreme heat which can cause severe burns, dismemberment, electrical shock and death. **VEVOR** shall not be held liable for consequences due to deliberate or unintentional misuse of this product.

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER
DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING
WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION
CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE
NOTICE is used to address practices not related to personal injury.

⚠ READ INSTRUCTIONS

Thoroughly read and understand this manual before using the welder. Save for future reference.

⚠ DANGER ELECTRIC SHOCK CAN KILL!

- Improper use of an electric welder can cause electric shock, injury and death! Read all precautions described in the Welder Manual to reduce the possibility of electric shock.
- Disconnect welder from power supply before assembly, disassembly or maintenance of the torch, contact tip and when installing or removing nozzles.
- Always wear dry, protective clothing and leather welding gloves and insulated footwear. Use suitable clothing made from durableflame-resistant material to protect your skin.
- If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks.
- Always operate the welder in a clean, dry, well ventilated area. Do not operate the welder in humid, wet, rainy or poorly ventilatedareas.
- The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not allow these “hot” parts to come in contact with your bare skin or wet clothing.
- Separate yourself from the welding circuit by using insulating mats to prevent contact from the work surface.
- Be sure that the work piece is properly supported and grounded prior to beginning an electric welding operation.
- Always attach the ground clamp to the piece to be welded and as close to the weld area as possible. This will give the least resistance and best weld.

⚠ DANGER WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!

- Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials.
- Do not operate electric arc welder in areas where flammable or explosive vapors are present.
- Do not use near combustible surfaces. Remove all flammable items within 35 feet of the welding area.
- Always keep a fire extinguisher nearby while welding.
- Use welding blankets to protect painted and or flammable surfaces; rubber weather-stripping, dash boards, engines, etc.
- Ensure power supply has properly rated wiring to handle power usage.

⚠ WARNING ELECTROMAGNETIC FIELDS CAN BE A HEALTH HAZARD!

- The electromagnetic field that is generated during arc welding may interfere with various electrical and electronic devices such as cardiac pacemakers. Anyone using such devices should consult with their physician prior to performing any electric welding operations.
- Exposure to electromagnetic fields while welding may have other health effects which are not known.

⚠ WARNING ARC RAYS CAN BURN!

- Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).
- Use suitable clothing made from durable flame-resistant material to protect your skin.
- If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks and arc rays.

⚠ WARNING FUMES AND WELDING GASES CAN BE A HEALTH HAZARD!

- Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation. Wear an OSHA-approved respirator when welding.
- Always work in a properly ventilated area.
- Never weld coated materials including but not limited to: cadmium plated, galvanized, lead based paints.

⚠ CAUTION HOT METAL AND TOOLS WILL BURN!

- Electric welding heats metal and tools to temperatures that will cause severe burns!
- Use protective, heat resistant gloves and clothing when using Eastwood or any other welding equipment. Never touch welded work surface, torch tip or nozzle until they have completely cooled.

⚠ CAUTION FLYING METAL CHIPS CAN CAUSE INJURY!

- Grinding and sanding will eject metal chips, dust, debris and sparks at high velocity. To prevent eye injury wear approved safety glasses.
- Wear an OSHA-approved respirator when grinding or sanding.
- Read all manuals included with specific grinders, sanders or other power tools used before and after the welding process. Be aware of all power tool safety warnings.

REQUIRED ITEMS

Before you begin using the **TIG/MMA 205 STICK WELDER**, make sure you have the following:

- A properly grounded 1Phase 110/220 Volt AC, 50/60Hz, 50A circuit breaker.

NOTE: Unit must be grounded to work properly and safely!

- A clean, safe, well-lit, dry and well-ventilated work area.
- A non-flammable, long sleeve shirt or WELDING Jacket
- Heavy Duty Welding Gloves
- Auto-Darkening Welding Helmet to provide eye protection during welding operations. Note: MUST be a #11 lens or darker.
- Dedicated stainless steel wire welding brushes for each material to be welded.

CONTENTS

Remove all items from the box. Compare with list below to make sure unit is complete.

1.TIG/MMA-205
2.2m 25mm² Ground cable pliers 1 set
3.1 set of 2m 25mm² welding holder
4.3m WP-17 13mm² tig welding gun 1 set
5.welding brush *1
6.the United States plug dual voltage converter plug (dual power machine)

CONTROL AND DISPLAY PANEL

A:2T/4T Select button B:DC/SPOT/PULSE Select button

C: Manual welding mode D: Welding mode button

E: LIFTIG argon arc welding F: High frequency argon arc welding

G: Current display H: Input voltage display

I: current adjusting knob J: Built-in parameter display

K: Built-in function select button

Click the button to select the function to be steady on
In-screen alarm such as thermal protection

Welding Mode	Current(A)		Welding Param		
	110V	220V	VRD	ARC Force	Hot Start
Stick	20~130A	20~180A	ON/OFF	0~10	0~10
Lift TIG	10~145A	10~205A	/	/	/

Thermal protection LED illuminates when the unit has reached the maximum internal component temperature. This occurs when the duty cycle has been exceeded.
The Welder will automatically shut off however the fan will continue running to cool the overheated components. When a safe temperature has been reached, the protective circuit will automatically switch the welder output back on.

A: positive output interface B: Gun switch interface

C: gas-electric interface E: Power cord

F: Power switch G:TIG gas interface

MANUAL WELDING DEBUGGING AND OPERATION

1. Connect the power plug and turn on the power switch.
2. Connect the welding pliers to thepositive output port, and connect the ground clamp to the negative output port.
3. Hold the workpiece with a ground clamp.
4. Press the welding mode button to switch to manual welding mode.
5. Adjust the current knob to adjust the current to the appropriate range.
6. Touch the electrode and the workpiece with the welding pliers, and start the arc welding.

ARGON ARC WELDING DEBUGGING AND OPERATION

1. Power on and turn on the power switch.
2. Connect the argon arc welding gun to the gas-electric interface of the welding machine and tighten it clockwise.
3. Insert the two-core plug of the torch into the switch port of the torch.
4. Connect the ground clamp quick connector to the positive output end of the welder and hold the workpiece with the ground clamp.
5. Press the welding mode button to switch to argon arc welding mode.
6. Connect the gas cylinder gas pipe to the argon arc welding gas port on the rear panel and tighten it with the throat band.
7. Turn the cylinder valve to reach the appropriate welding pressure.
8. According to the thickness of the plate, turn the current adjustment knob to achieve the appropriate welding current.
9. Touch the tungsten electrode of the welding torch to the workpiece, press the gun switch on the handle, and welding begins.

PREPARING TO “STICK” WELDING

1. Plug the power cord into a properly grounded, 1Phase 110/220 Volt AC, 50/60Hz, 50A circuit breaker.
2. Make sure the electrode or “Stick” is not making contact with the grounded workpiece.
3. Switch the Power Switch to “ON”.

⚠ DANGER

ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!

The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not allow these “hot” parts to come in contact with your bare skin or wet clothing. Always wear dry, protective clothing and leather welding gloves and insulated footwear.

⚠ WARNING

ARC RAYS CAN BURN!

Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).

⚠ DANGER

WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!

Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials. Remove all flammable items within 35 feet of the welding area. Always keep a fire extinguisher nearby while welding.

⚠ WARNING

FUMES AND WELDING GASES CAN BE A HEALTH HAZARD!

Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation. Wear an OSHAapproved respirator when welding. Always work in a properly ventilated area.

⚠ CAUTION

HOT METAL AND TOOLS WILL BURN!

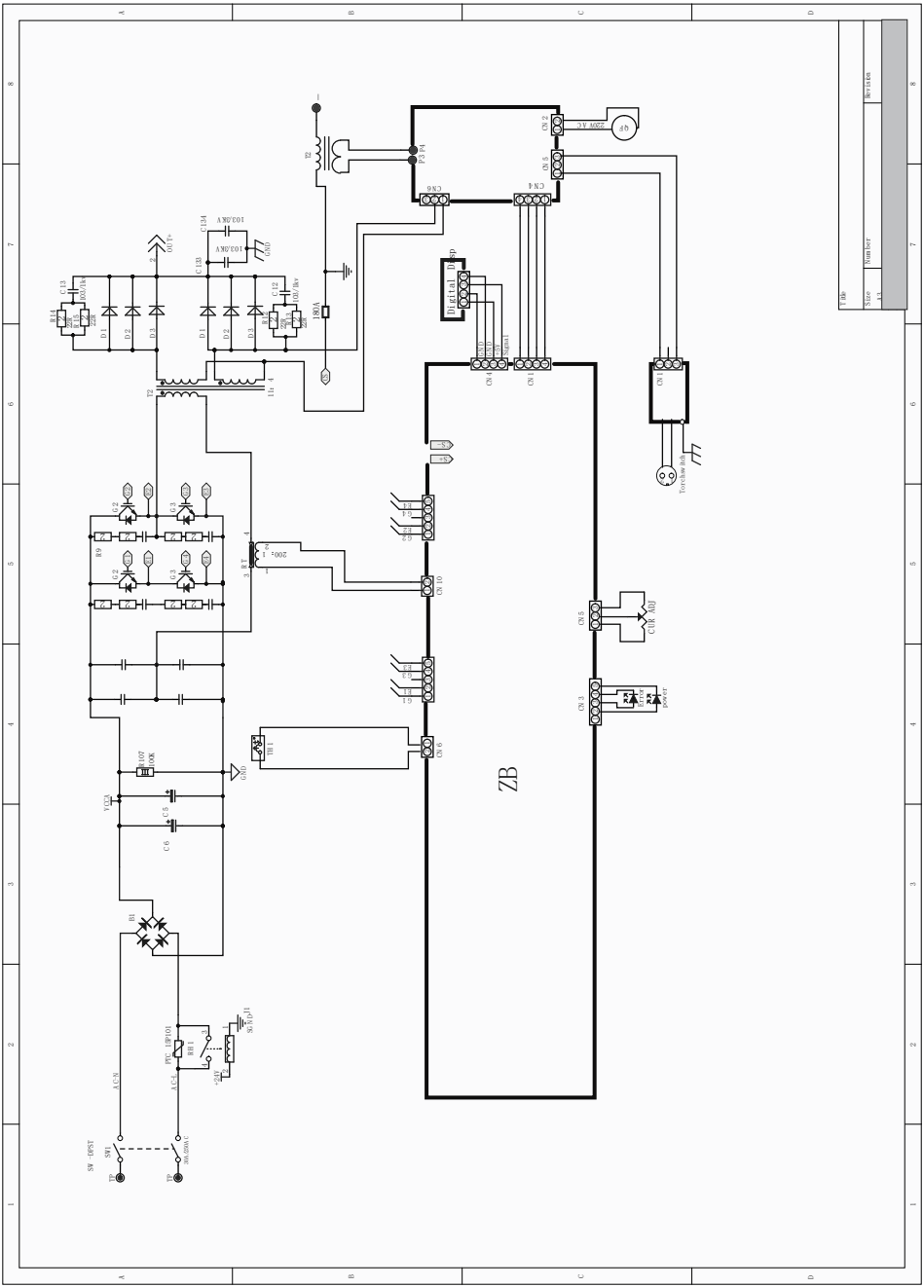
Electric welding heats metal and tools to temperatures that will cause severe burns! Use protective, heat resistant gloves and clothing.

1. While wearing a properly functioning Auto Darkening Welding Helmet, lightlydrag the tip of the Welding Rod along the workpiece surface to start an arc.
2. Feed the Welding Rod into the workpiece joint at a 15° angle.
3. Lift rod from workpiece when weld bead is completed.
4. Turn off Welder power switch.
5. Set the Electrode or “Stick” Holder on a safe, non-flammable, surface.

TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Contamination in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Poor Weld Appearance	Incorrect positioning	The angle of the electrode should be at 45° and drug away from the weld arc. Failing to do so may cause poor weld appearance.
Weld Bead is Cracking	Too much heat in material	Reduce heat & allow more time between passes.
	Base Metal is absorbing too much heat	Preheat base metal (consult welding codes for requirements)
	Incorrect Filler Wire	Use correct filler wire type & diameter for the joint being welded.
Material is Warping	Insufficient Clamping	Clamp work piece tightly & weld while clA are in place.
	Insufficient Tack Welds	Add more tack welds until rigidity and stiffness is developed.
	Too Much Heat in Material	To reduce heat it is best to spread the welding out around the area. This can be done by using stitch welding techniques, alternating sides, and/or taking your time and allowing the pieces to cool between passes.
Porosity in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated base metal	Clean base metal making sure to remove any oil, debris, coatings, or moisture.
Difficulty Starting Arc	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection
	Amperage Too Low	Based on the material welding & size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Arc Wander	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
Difficulty Holding Arc	Amperage Too Low	Based on the material welding and size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection.
	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture.

WIRING DIAGRAM



Manufacturer: Zhejiang Xingyi Ventilator Electrical Appliance Co., Ltd.
Address: Danya Industrial Park, Zeguo Town,WENLING Zhejiang 317523
Imported to AUS:SIHAO PTY LTD. 1 ROKEVA STREETEASTWOOD NSW 2122 Australia
Imported to USA: Sanven Technology Ltd. Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

UK	**REP**

YH CONSULTING LIMITED. C/O YH Consulting Limited Office 147, Centurion House, London Road, Staines-upon-Thames, Surrey, TW18 4AX

EC	**REP**

E-CrossStu GmbH
Mainzer Landstr.69,
60329 Frankfurt am Main.

VEVOR®

TOUGH TOOLS, HALF PRICE

Technical Support and E-Warranty Certificate

www.vevor.com/support

VEVOR®

TOUGH TOOLS, HALF PRICE

Assistance technique et certificat de garantie
électronique www.vevor.com/support

Soudeur TIG
Modèle : TIG/MMA-205

Nous continuons à nous engager à vous fournir des outils à des prix compétitifs. « Économisez la moitié », « Moitié prix » ou toute autre expression similaire utilisée par nous ne représente qu'une estimation des économies que vous pourriez réaliser en achetant certains outils chez nous par rapport aux grandes marques et ne couvre pas nécessairement toutes les catégories d'outils que nous proposons. Nous vous rappelons de bien vouloir vérifier soigneusement lorsque vous passez une commande chez nous si vous économisez réellement la moitié par rapport aux grandes marques.

VEVOR®
TOUGH TOOLS, HALF PRICE

Soudeur TIG

Modèle : TIG/MMA-205

Remarque : l'image du produit est à titre de référence, les détails réels prévalent

BESOIN D'AIDE? CONTACTEZ-NOUS!

Vous avez des questions sur les produits ? Vous avez besoin d'assistance technique ? N'hésitez pas à nous contacter :

Assistance technique et certificat de garantie électronique
www.vevor.com/support

Il s'agit de la notice d'origine. Veuillez lire attentivement toutes les instructions du manuel avant de l'utiliser. VEVOR se réserve le droit d'interpréter clairement notre manuel d'utilisation. L'apparence du produit dépend du produit que vous avez reçu. Veuillez nous excuser, nous ne vous informerons plus si des mises à jour technologiques ou logicielles sont disponibles sur notre produit.

	Avertissement - Pour réduire le risque de blessure, l'utilisateur doit lire attentivement le manuel d'instructions.
	ÉLIMINATION CORRECTE pour l'affichage Ce produit est soumis aux dispositions de la directive européenne 2012/19/UE. Le symbole représentant une poubelle à roulettes barrée indique que le produit doit être collecté séparément dans l'Union européenne. Cela s'applique au produit et à tous les accessoires marqués de ce symbole. Les produits marqués comme tels ne peuvent pas être jetés avec les ordures ménagères normales, mais doivent être apportés à un point de collecte pour le recyclage des appareils électriques et électroniques.
	La conformité est une certification de sécurité CE.

The TIG/MMA-205 provides a convenient method of performing “stick” welding carbon steel. Inverter technology provides the capability of welding thin or heavy gauge steel with precision and ease. When adding the optional lift TIG torch **(not included)**, gas regulator, and a cylinder of shielding gas, the TIG/MMA-205 becomes a TIG welder.

SPECIFICATIONS

Output Current Range:	Input Current	Input Voltage	Rated Duty Cycle	Rod Diameter	Rod Material
20~~205A	I1 max 45A (110V) I1 eff 34,8 A (110 V) I1 max 34A (220V) I1 eff 26,3 A (220 V)	110V ou 220V	20%@ 205A	16/01~31/06 1,6 à 5,0 mm	E6010 E6011 E6013 E7014 E7018S Acier inoxydable

DUTY CYCLE

The rated duty cycle refers to the amount of welding that can be done within an amount of time. The TIG/MMA-205 has a duty cycle of 60% at 195A. It is easiest to look at your welding time in blocks of 10 minutes and the duty cycle being a percentage of that 10 minutes. If welding at 195A with a 60% duty cycle, within a 10 minute block of time you can weld for 6 minutes with 4 minutes of cooling for the welder. If the duty cycle is exceeded, the welder will automatically shut off, however the fan will continue running to cool the overheated components. When a safe temperature has been reached, the welder will automatically switch the welder output back on. To increase the duty cycle you can turn down the amperage output control.

READ AND UNDERSTAND ALL INSTRUCTIONS AND PRECAUTIONS BEFORE PROCEEDING.
This unit emits a powerful high voltage and extreme heat which can cause severe burns, dismemberment, electrical shock and death. VEVOR shall not be held liable for consequences due to deliberate or unintentional misuse of this product.

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER
DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING
WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION
CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE
NOTICE is used to address practices not related to personal injury.

⚠ LISEZ LES INSTRUCTIONS

Lisez attentivement et comprenez ce manuel avant d'utiliser le soudeur. Conservez-le pour référence ultérieure.

⚠ DANGER LES CHOCS ÉLECTRIQUES PEUVENT TUER !

· Une utilisation incorrecte d'un poste à souder électrique peut provoquer un choc électrique, des blessures et la mort ! Lisez toutes les précautions décrites dans le manuel du poste à souder pour réduire le risque de choc électrique.

· Débranchez le soudeur de l'alimentation électrique avant le montage, le démontage ou l'entretien de l'appareil. torche , pointe de contact et lors de l'installation ou du retrait des buses.

· Portez toujours des vêtements de protection secs, des gants de soudage en cuir et des chaussures isolées. des vêtements adaptés fabriqués à partir d'un matériau résistant aux flammes pour protéger votre peau.

· Si d'autres personnes ou des animaux domestiques se trouvent dans la zone de soudage, utiliser des écrans de soudage pour protéger les personnes présentes évitez les étincelles.

· Utilisez toujours le poste à souder dans un endroit propre, sec et bien aéré. N'utilisez pas le poste à souder dans des zones milieu , mouillé , pluvieuses ou mal aérées.

· L'électrode et les circuits de travail (ou de terre) sont électriquement « chauds » lorsque le soudeur est allumé. Ne laissez pas ces pièces « chaudes » entrer en contact avec votre peau nue ou vos vêtements mouillés.

· éloignez-vous du circuit de soudage en utilisant des tapis isolants pour éviter tout contact avec le surface de travail.

· Assurez-vous que la pièce à travailler est correctement soutenue et mise à la terre avant de commencer une opération électrique. opération de soudage.

· Fixez toujours la pince de masse sur la pièce à souder et aussi près que possible de la zone de soudure. possible. Cela donnera la moindre résistance et la meilleure soudure.

⚠ DANGER LES ÉTINCELLES DE SOUDAGE PEUVENT PROVOQUER UN INCENDIE OU UNE EXPLOSION !

· Le soudage électrique produit des étincelles qui peuvent être projetées sur des distances considérables à grande vitesse, enflammant des vapeurs et des matériaux inflammables ou explosifs.

· N'utilisez pas le soudeur à arc électrique dans des zones où des vapeurs inflammables ou explosives sont présentes.

· Ne pas utiliser à proximité de surfaces combustibles. Retirer tous les objets inflammables à moins de 10 mètres de la zone de soudage. zone de travail.

· Gardez toujours un extincteur à proximité pendant le soudage. · Utilisez des couvertures de soudage pour protéger les surfaces peintes et/ou inflammables ; les joints en caoutchouc, les moteurs, etc. tableaux de bord ,

· Assurez-vous que l'alimentation électrique dispose d'un câblage correctement dimensionné pour gérer la consommation électrique.

⚠ WARNING LES CHAMPS ÉLECTROMAGNÉTIQUES PEUVENT CONSTITUER UN DANGER POUR LA SANTÉ !

· Le champ électromagnétique généré lors du soudage à l'arc peut interférer avec divers appareils électriques et électroniques tels que les stimulateurs cardiaques. Toute personne utilisant de tels appareils doit consulter leur médecin avant d'effectuer toute opération de soudage électrique.

L'exposition aux champs électromagnétiques pendant le soudage peut avoir d'autres effets sur la santé qui ne sont pas connu.

⚠ WARNING LES RAYONS D'ARC PEUVENT BRÛLER !

· Les rayons de l'arc produisent un rayonnement ultraviolet intense qui peut brûler la peau exposée et provoquer des lésions oculaires. dommages. utilisez un écran avec le filtre approprié (au moins #1 1) pour protéger vos yeux des les étincelles et les rayons de l'arc lors du soudage ou lors de l'observation du soudage à l'arc ouvert (voir ANsl Z49 . 1 et Z87 . 1 pour les normes de sécurité) .

· utilisez des vêtements appropriés fabriqués à partir de matériaux durables et ignifuges pour protéger votre peau.

· Si d'autres personnes ou animaux domestiques se trouvent dans la zone de soudage, utilisez des écrans de soudage pour protéger les personnes présentes. des étincelles et des rayons d'arc.

⚠ WARNING LES FUMÉES ET LES GAZ DE SOUDAGE PEUVENT CONSTITUER UN DANGER POUR LA SANTÉ !

· Les fumées et les gaz dégagés pendant le soudage sont dangereux. Ne respirez pas les fumées produites par l'opération de soudage. Portez un masque respiratoire homologué OSHA lors du soudage.

· Travaillez toujours dans un endroit correctement ventilé.

· Ne jamais souder des matériaux revêtus, y compris, mais sans s'y limiter : cadmiés, galvanisés, plomb

⚠ CAUTION [illegible] d'alcool. LE MÉTAL CHAUD ET LES OUTILS BRÛLERONT !

· Le soudage électrique chauffe le métal et les outils à des températures qui provoquent de graves brûlures !

· utiliser un équipement gants et vêtements résistants à la chaleur lors de l'utilisation d'Eastwood ou de tout autre outil de soudage de protection. Ne jamais toucher une surface soudée refroidie. , pointe de la torche ou la buse jusqu'à ce qu'elles soient complètement

⚠ CAUTION LES COPEAUX MÉTALLIQUES VOLANTS PEUVENT CAUSER DES BLESSURES !

· Le meulage et le ponçage projettent des copeaux de métal, de la poussière, des débris et des étincelles à grande vitesse. Pour éviter les blessures aux yeux, portez des lunettes de sécurité homologuées. ·

Portez un respirateur homologué OSHA lors du meulage ou du ponçage.

· Lisez tous les manuels fournis avec les meuleuses, ponceuses ou autres outils électriques spécifiques utilisés avant et après le processus de soudage. Tenez compte de tous les avertissements de sécurité relatifs aux outils électriques.

ÉLÉMENTS REQUIS

Avant de commencer à utiliser le soudeur TIG/MMA 205 ST CK , assurez-vous d'avoir les éléments suivants :

· Un disjoncteur monophasé 1 10/220 volts CA, 50/60 Hz, 50 A correctement mis à la terre.

REMARQUE : l'appareil doit être mis à la terre pour fonctionner correctement et en toute sécurité !

· Un nettoyage , sûr , bien éclairé , zone de travail sèche et bien aérée.

· Une chemise à manches longues ou une veste de SOUDAGE non inflammable

· Des gants de soudage très résistants

· Casque de soudage à obscurcissement automatique pour assurer la protection des yeux pendant les opérations de soudage. Remarque : DOIT être un #1 1 Identique ou plus foncé.

· Brosses de soudage en fil d'acier inoxydable dédiées à chaque matériau à souder.

CONTENU

Retirez tous les éléments de la boîte. Comparez avec la liste ci-dessous pour vous assurer que l'unité est complète.

1.TIG/MMA-205

Pince pour câble de terre 2,2 m 25 mm² 1 jeu

3.1 jeu de support de soudage 2m 25mm²

4.3mWP-17 13mm² pistolet de soudage TIG 1 jeu

5. brosse de soudage * 1

6.la prise américaine à double convertisseur de tension (machine à double alimentation)

PANNEAU DE CONTRÔLE ET D'AFFICHAGE

A : Bouton de sélection 2T/4T B : Bouton de sélection DC/SPOT/PULSE

C : Mode de soudage manuel D : Bouton du mode de soudage

E : Soudage à l'arc sous argon LIFTIG F : Soudage à l'arc sous argon à haute fréquence

G : Affichage du courant H : Affichage de la tension d'entrée

I : bouton de réglage du courant J : affichage des paramètres intégré

K : Bouton de sélection de fonction intégré

Cliquez sur le bouton pour sélectionner la fonction à maintenir en position fixe

Alarme à l'écran telle que la protection thermique

Mode de soudage	courant (A)		paramètres de soudage		
	1 1 0 V	220V	COMPARER	Force ARC	Démarrage à chaud
bâton	20 à 130 A	20 à 180 A	MARCHE/ARRÊT	0~10	0~10
Ascenseur TIG	10 ~ 145A	10 à 205 A	/	/	/

La LED de protection thermique s'allume lorsque l'appareil a atteint la température maximale des composants internes. Cela se produit lorsque le cycle de service a été dépassé.

Le soudeur s'éteindra automatiquement, mais le ventilateur continuera de fonctionner pour refroidir les composants surchauffés. Lorsqu'une température sûre sera atteinte, le circuit de protection réactivera automatiquement la sortie du soudeur.

A : interface de sortie positive B : interface de commutation du pistolet

C : interface gaz-électrique E : cordon d'alimentation

F : Interrupteur d'alimentation G : Interface de gaz TIG

SOUDURE MANUELLE
DÉBOGAGE ET FONCTIONNEMENT

1. Branchez la fiche d'alimentation et allumez l'
interrupteur d'alimentation.
2. Connectez la pince à souder au port de sortie positif et connectez la terre
pince sur le port de sortie négatif.
3. Maintenez la pièce à travailler avec un sol serrer.
4. Appuyez sur le bouton du mode de soudage pour changer au mode de soudage manuel.
5. Réglez le bouton actuel pour régler le courantà la plage appropriée.
6. Touchez l'électrode et la pièce à usiner avec la pince à souder et démarrez l'arc soudage.

SOUDAGE À L'ARC SOUS ARGON
DÉBOGAGE ET FONCTIONNEMENT

1. Allumez l'appareil et allumez l'interrupteur d'alimentation.
2. Connectez le pistolet de soudage à l'arc sous argon à l' interface gaz-électrique de la machine à souder et
serrez-le dans le sens des aiguilles d'une montre.
3. Insérez la fiche à deux conducteurs de la torche dans la changer le port de la torche.
4. Connectez le connecteur rapide de la pince de terre à l'extrémité de sortie positive du soudeur et maintenez la pièce avec la pince de masse.
5. Appuyez sur le bouton du mode de soudage pour passer à mode de soudage à l'arc sous argon.
6. Raccordez le tuyau de gaz de la bouteille de gaz à l'argon port de gaz de soudage à l'arc sur le panneau arrière et serrez il avec la bande de gorge.
7. Tournez la vanne du cylindre pour atteindre la pression de soudage appropriée.
8. Selon l'épaisseur de la plaque, tournez la bouton de réglage du courant pour obtenir le courant de soudage approprié.
9. Touchez l'électrode en tungstène de la soudure torche sur la pièce à travailler, appuyez sur l'interrupteur du pistolet la poignée et la soudure commence.

PREPARING TO “STICK” WELDING

1. Plug the power cord into a properly grounded, 1Phase 110/220 Volt AC, 50/60Hz, 50A circuit breaker.
2. Make sure the electrode or “Stick” is not making contact with the grounded workpiece.
3. Switch the Power Switch to “ON”.

⚠ DANGER

ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!

The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not allow these “hot” parts to come in contact with your bare skin or wet clothing. Always wear dry, protective clothing and leather welding gloves and insulated footwear.

⚠ WARNING

ARC RAYS CAN BURN!

Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).

⚠ DANGER

WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!

Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials. Remove all flammable items within 35 feet of the welding area. Always keep a fire extinguisher nearby while welding.

⚠ WARNING

FUMES AND WELDING GASES CAN BE A HEALTH HAZARD!

Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation. Wear an OSHAapproved respirator when welding. Always work in a properly ventilated area.

⚠ CAUTION

HOT METAL AND TOOLS WILL BURN!

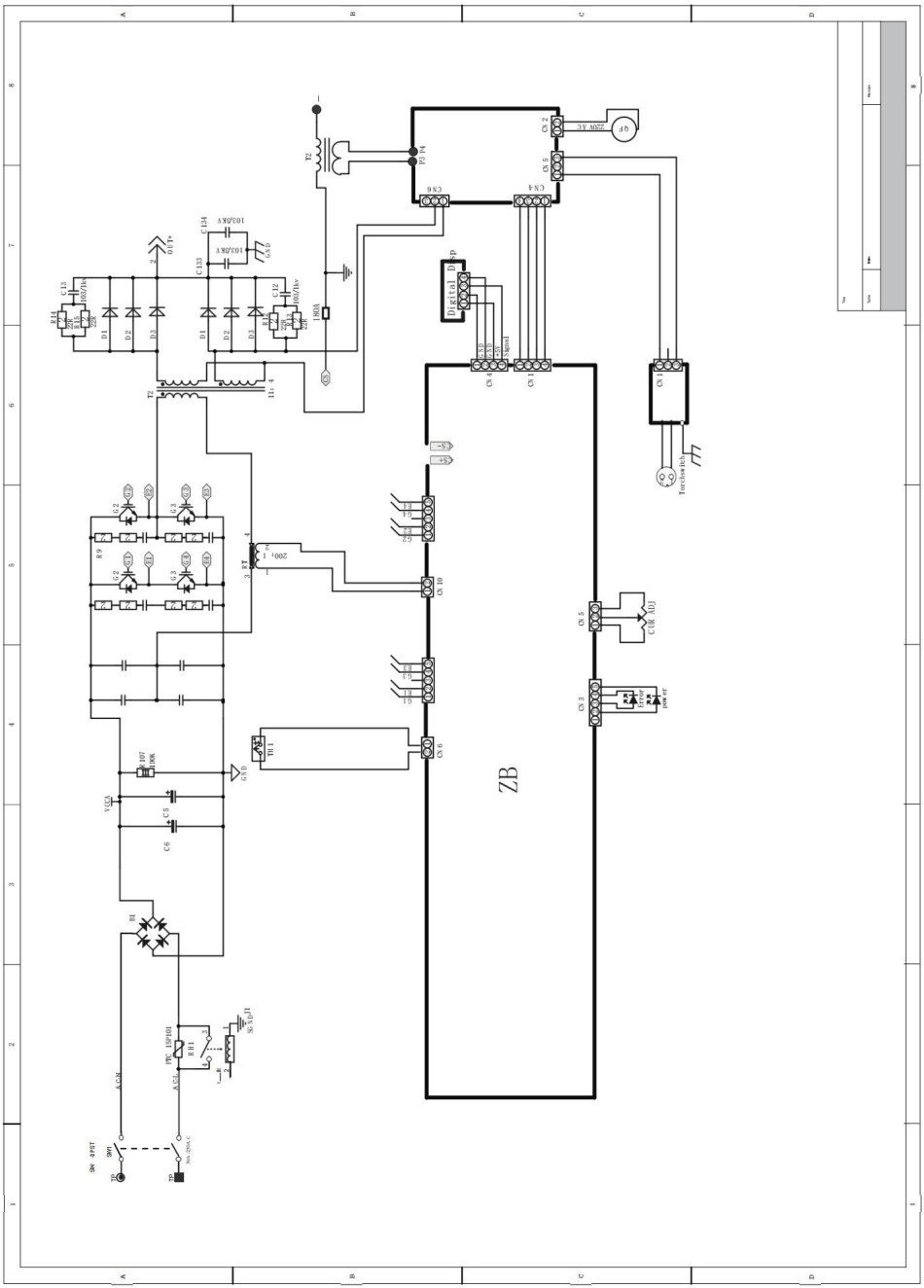
Electric welding heats metal and tools to temperatures that will cause severe burns! Use protective, heat resistant gloves and clothing.

1. While wearing a properly functioning Auto Darkening Welding Helmet, lightlydrag the tip of the Welding Rod along the workpiece surface to start an arc.
2. Feed the Welding Rod into the workpiece joint at a 15° angle.
3. Lift rod from workpiece when weld bead is completed.
4. Turn off Welder power switch.
5. Set the Electrode or “Stick” Holder on a safe, non-flammable, surface.

TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Contamination in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Poor Weld Appearance	Incorrect positioning	The angle of the electrode should be at 45° and drug away from the weld arc. Failing to do so may cause poor weld appearance.
Weld Bead is Cracking	Too much heat in material	Reduce heat & allow more time between passes.
	Base Metal is absorbing too much heat	Preheat base metal (consult welding codes for requirements)
	Incorrect Filler Wire	Use correct filler wire type & diameter for the joint being welded.
Material is Warping	Insufficient Clamping	Clamp work piece tightly & weld while clA are in place.
	Insufficient Tack Welds	Add more tack welds until rigidity and stiffness is developed.
	Too Much Heat in Material	To reduce heat it is best to spread the welding out around the area. This can be done by using stitch welding techniques, alternating sides, and/or taking your time and allowing the pieces to cool between passes.
Porosity in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated base metal	Clean base metal making sure to remove any oil, debris, coatings, or moisture.
Difficulty Starting Arc	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection
	Amperage Too Low	Based on the material welding & size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Arc Wander	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
Difficulty Holding Arc	Amperage Too Low	Based on the material welding and size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection.
	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture.

WIRING DIAGRAM



Fabricant : Zhejiang Xingyi Ventilator Electrical Appliance Co., Ltd.

Adresse : Parc industriel de Danya, ville de Zeguo, WENLING Zhejiang 317523 Importé en Australie : SIHAO PTY LTD. 1 ROKEVA STREET, ASTWOOD NSW2122, Australie Importé aux États-Unis : Sanven

Technology Ltd. Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

REPRÉSENTANT DU ROYAUME-UNI	YH CONSULTING LIMITED. C/OYH Consulting Limited Office 147, Centurion House, London Road, Staines-upon-Thames, Surrey, TW18 4AX
REPRÉSENTANT DE LA CE	E-CrossStu GmbH Mainzer Landstr.69, 60329 Francfort-sur-le-Main.

VEVOR®

TOUGH TOOLS, HALF PRICE

Assistance technique et certificat de garantie

électronique www.vevor.com/support

VEVOR®

TOUGH TOOLS, HALF PRICE

Technischer Support und E-Garantie-Zertifikat
www.vevor.com/support

WIG-Schweißer

Modell: WIG/MMA-205

Wir sind weiterhin bestrebt, Ihnen Werkzeuge zu wettbewerbsfähigen Preisen anzubieten. „Sparen Sie die Hälfte“, „Halber Preis“ oder andere ähnliche Ausdrücke, die wir verwenden, stellen nur eine Schätzung der Ersparnis dar, die Sie beim Kauf bestimmter Werkzeuge bei uns im Vergleich zu den großen Topmarken erzielen können, und decken nicht unbedingt alle von uns angebotenen Werkzeugkategorien ab. Wir möchten Sie freundlich daran erinnern, bei Ihrer Bestellung bei uns sorgfältig zu prüfen, ob Sie im Vergleich zu den großen Topmarken tatsächlich die Hälfte sparen.

VEVOR®
TOUGH TOOLS, HALF PRICE

WIG-Schweißer

Modell: WIG/MMA-205

Hinweis: Das Produktbild dient als Referenz, die tatsächlichen Details sind maßgebend

Brauchen Sie Hilfe? Kontaktieren Sie uns!

Haben Sie Fragen zu den Produkten? Benötigen Sie technischen Support? Kontaktieren Sie uns gerne:

Technischer Support und E-Garantie-Zertifikat
www.vevor.com/support

Dies ist die Originalanleitung. Bitte lesen Sie alle Anweisungen sorgfältig durch, bevor Sie das Gerät in Betrieb nehmen. VEVOR behält sich eine klare Auslegung unseres Benutzerhandbuchs vor. Das Erscheinungsbild des Produkts entspricht dem Produkt, das Sie erhalten haben. Bitte verzeihen Sie uns, dass wir Sie nicht erneut informieren, wenn es Technologie- oder Software-Updates für unser Produkt gibt.

	Warnung: Um das Verletzungsrisiko zu verringern, muss der Benutzer die Bedienungsanleitung sorgfältig lesen.
	**KORREKTE ENTSORGUNG für Display** Dieses Produkt unterliegt den Bestimmungen der europäischen Richtlinie 2012/19/EU. Das Symbol einer durchgestrichenen Mülltonne weist darauf hin, dass das Produkt in der Europäischen Union einer getrennten Müllentsorgung bedarf. Dies gilt für das Produkt und alle mit diesem Symbol gekennzeichneten Zubehörteile. Produkte, die so gekennzeichnet sind, dürfen nicht nicht mit dem normalen Hausmüll entsorgt werden, sondern müssen bei einer Sammelstelle für das Recycling von elektrischen und elektronischen Geräten abgegeben werden.
	Bei der Konformität handelt es sich um ein EG-Sicherheitszertifikat.

The WIG/MMA-205 provides a convenient method of performing “stick” welding carbon steel. Inverter technology provides the capability of welding thin or heavy gauge steel with precision and ease. When adding the optional lift TIG torch **(not included)**, gas regulator, and a cylinder of shielding gas, the WIG/MMA-205 becomes a TIG welder.

SPECIFICATIONS

Output Current Range:	Input Current	Input Voltage	Rated Duty Cycle	Rod Diameter	Rod Material
20 bis 205yA	I1 max. 45 A (110 V) I1 eff 34,8 A (110 V) I1 max. 34 A (220 V) I1 eff 26,3A (220V)	110VVor220V	20 %@ 205A	16.1. bis 31.6. 1,6 bis 5,0 mm	E6010 E6011 E6013 E7014 E7018S Edelstahl

DUTY CYCLE

The rated duty cycle refers to the amount of welding that can be done within an amount of time. The WIG/MMA-205 has a duty cycle of 60% at 195A. It is easiest to look at your welding time in blocks of 10 minutes and the duty cycle being a percentage of that 10 minutes. If welding at 195A with a 60% duty cycle, within a 10 minute block of time you can weld for 6 minutes with 4 minutes of cooling for the welder. If the duty cycle is exceeded, the welder will automatically shut off, however the fan will continue running to cool the overheated components. When a safe temperature has been reached, the welder will automatically switch the welder output back on. To increase the duty cycle you can turn down the amperage output control.

READ AND UNDERSTAND ALL INSTRUCTIONS AND PRECAUTIONS BEFORE PROCEEDING.

This unit emits a powerful high voltage and extreme heat which can cause severe burns, dismemberment, electrical shock and death. VEVOR shall not be held liable for consequences due to deliberate or unintentional misuse of this product.

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING

WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION

CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE

NOTICE is used to address practices not related to personal injury.

⚠ ANLEITUNG LESEN

Lesen Sie dieses Handbuch vor der Inbetriebnahme des Schweißgeräts gründlich durch und bewahren Sie es für die spätere Verwendung auf.

⚠ DANGER STROMSCHLAG KANN TÖDLICH SEIN!

· Unsachgemäßer Gebrauch eines Elektroschweißgeräts kann zu Stromschlägen, Verletzungen und zum Tod führen! Lesen Sie alle im Schweißerhandbuch beschriebenen Vorsichtsmaßnahmen, um die Möglichkeit eines Stromschlags zu verringern.

· Trennen Sie das Schweißgerät von der Stromversorgung, bevor Sie es montieren, demontieren oder warten. Fackel , Kontaktspitze und beim Einsetzen oder Entfernen von Düsen.

· Tragen Sie stets trockene Schutzkleidung, Lederschweißhandschuhe und isoliertes Schuhwerk. geeignete Kleidung aus strapazierfähigem, flammhemmendem Material zum Schutz Ihrer Haut.

· Befinden sich weitere Personen oder Haustiere im Schweißbereich, besteht Verwenden Sie Schweißschirme, um umstehende Personen zu schützen Funkengefahr.

· Betreiben Sie das Schweißgerät immer in einem sauberen, trockenen und gut belüfteten Bereich. Betreiben Sie das Schweißgerät nicht in feuchten Mitte , nass , oder schlecht belüfteten Bereichen.

· Die Elektroden- und Arbeits- (oder Erdungs-)Schaltkreise sind bei eingeschaltetem Schweißgerät elektrisch „heiß“. Lassen Sie diese „heißen“ Teile nicht mit Ihrer bloßen Haut oder nasser Kleidung in Berührung kommen.

· Trennen Sie sich vom Schweißstromkreis durch Verwendung von Isoliermatten, um den Kontakt mit dem Arbeitsfläche.

· Stellen Sie sicher, dass das Werkstück ordnungsgemäß abgestützt und geerdet ist, bevor Sie mit einer elektrischen Schweißvorgang.

· Befestigen Sie die Masseklemme immer am zu schweißenden Teil und so nah wie möglich an der Schweißstelle. möglich. Dadurch wird der geringste Widerstand und die beste Schweißnaht erreicht.

⚠ DANGER SCHWEISSFUNKEN KÖNNEN BRAND ODER EXPLOSION VERURSACHEN!

· Beim Elektroschweißen entstehen Funken, die mit hoher Geschwindigkeit über weite Distanzen entladen werden können und entzündbare oder explodierende Dämpfe und Materialien entzünden.

· Betreiben Sie das Lichtbogenschweißgerät nicht in Bereichen, in denen brennbare oder explosive Dämpfe vorhanden sind.
· Nicht in der Nähe von brennbaren Oberflächen verwenden. Entfernen Sie alle brennbaren Gegenstände im Umkreis von 35 Fuß um die Schweißnaht. ing-Bereich.

· Halten Sie beim Schweißen immer einen Feuerlöscher bereit. · Verwenden Sie Schweißdecken zum Schutz von lackierten und/oder brennbaren Oberflächen, Gummidichtungen, Motoren usw. Armaturenbretter ,

· Stellen Sie sicher, dass die Verkabelung des Netzteils für den Stromverbrauch ausreichend dimensioniert ist.

⚠ WARNING ELEKTROMAGNETISCHE FELDER KÖNNEN GESUNDHEITSSCHÄDEN DARSTELLEN!

· Das beim Lichtbogenschweißen erzeugte elektromagnetische Feld kann verschiedene elektrische und elektronische Geräte wie Herzschrittmacher stören. Jeder, der solche Geräte verwendet, sollte konsultieren Sie Ihren Arzt, bevor Sie Elektroschweißarbeiten durchführen.

, Die Einwirkung elektromagnetischer Felder beim Schweißen kann andere gesundheitliche Auswirkungen haben, die nicht bekannt.

⚠ WARNING LICHTBOGENSTRAHLEN KÖNNEN VERBRENNUNGEN VERURSACHEN!

· Lichtbogenstrahlen erzeugen intensive ultraviolette Strahlung, die die Haut verbrennen und Augenschäden verursachen kann.
Schäden. Verwenden Sie einen Schutzschild mit dem richtigen Filter (mindestens #1 1), um Ihre Augen vor
Funken und Strahlen des Lichtbogens beim Schweißen oder beim Beobachten des offenen Lichtbogenschweißens (siehe ANsl
Z49 . 1 und Z87 . 1 für Sicherheitsnormen) .

· Tragen Sie zum Schutz Ihrer Haut geeignete Kleidung aus strapazierfähigem, flammhemmendem Material.

· Wenn sich andere Personen oder Haustiere im Schweißbereich befinden, verwenden Sie Schweißschirme, um umstehende Personen zu schützen.
vor Funken und Lichtbogenstrahlen.

⚠ WARNING RAUCH UND SCHWEISSGASE KÖNNEN EIN GESUNDHEITSRISIKO DARSTELLEN!

· Beim Schweißen freigesetzte Dämpfe und Gase sind gefährlich. Atmen Sie die beim Schweißen entstehenden Dämpfe nicht ein. Tragen Sie beim
Schweißen eine von der OSHA zugelassene Atemschutzmaske.

· Arbeiten Sie immer in einem gut belüfteten Bereich.

· Schweißen Sie niemals beschichtete Materialien, einschließlich aber nicht beschränkt auf: kadmierte, verzinkte, führen

⚠ CAUTION d Werkzeuge können brennen!

· Beim Elektroschweißen werden Metall und Werkzeuge auf Temperaturen erhitzt, die schwere Verbrennungen verursachen können!

· Schutzausrüstung hitzebeständige Handschuhe und Kleidung bei der Verwendung von Eastwood oder anderen
verwenden. Niemals gekühlte Schweiß- und Arbeitsflächen , Brennerspitze oder Düse, bis sie vollständig
berühren.

⚠ CAUTION UMHERFLIEGENDE METALLSPÄNE KÖNNEN VERLETZUNGEN VERURSACHEN!

· Beim Schleifen und Schmirgeln werden Metallspäne, Staub, Schmutz und Funken mit hoher Geschwindigkeit herausgeschleudert. Tragen Sie zur
Vermeidung von Augenverletzungen eine zugelassene Schutzbrille. ·

Tragen Sie beim Schleifen und Schmirgeln eine von der OSHA zugelassene Atemschutzmaske.

· Lesen Sie alle Handbücher, die den jeweiligen Schleifmaschinen, Schleifgeräten oder anderen Elektrowerkzeugen beiliegen, bevor Sie sie verwenden.
und nach dem Schweißvorgang. Beachten Sie alle Sicherheitshinweise für Elektrowerkzeuge.

ERFORDERLICHE ARTIKEL

Bevor Sie den TIG/MMA 205 ST CK WELDER in Betrieb nehmen , Stellen Sie sicher, dass Sie über Folgendes verfügen:

· Ein ordnungsgemäß geerdeter 1-Phasen-Leistungsschalter mit 10/220 Volt Wechselstrom, 50/60 Hz und 50 A.
HINWEIS: Das Gerät muss geerdet sein, um ordnungsgemäß und sicher zu funktionieren!

· Eine saubere , sicher , gut beleuchtet , trockener und gut belüfteter Arbeitsbereich.

· Ein nicht brennbares, langärmeliges Hemd oder eine SCHWEISSERJACKE

· Hochleistungs-Schweißerhandschuhe

· Automatisch abdunkelnder Schweißhelm zum Schutz der Augen während Schweißarbeiten. Hinweis: MUSS ein
#1 1 Gleich oder dunkler.

· Spezielle Schweißbürsten aus Edelstahldraht für jedes zu schweißende Material.

INHALT

Nehmen Sie alle Artikel aus der Verpackung. Vergleichen Sie sie mit der Liste unten, um sicherzustellen, dass die Einheit vollständig ist.

1.WIG/MMA-205
2,2m 25mm² Massekabelzange 1 Satz
3.1 Satz Schweißhalter 2 m 25 mm² 4.3
mWP-17 13 mm² WIG-Schweißpistole 1 Satz
5. Schweißbürste * 1
6. Der US-Stecker mit Doppelspannungswandler (Dual-Power-Maschine)

BEDIEN- UND ANZEIGEFELD

A: 2T/4T-Auswahltaste B: DC/SPOT/PULSE-Auswahltaste

C: Manueller Schweißmodus D: Schweißmodus-Taste

E: LIFTIG-Argonlichtbogenschweißen F: Hochfrequenz-Argonlichtbogenschweißen

G: Stromanzeige H: Eingangsspannungsanzeige

I: Stromeinstellknopf J: Eingebaute Parameteranzeige

K: Integrierte Funktionsauswahltaste

Klicken Sie auf die Schaltfläche, um die Funktion auszuwählen, die dauerhaft eingeschaltet sein soll

Im Bildschirm integrierter Alarm, z. B. Wärmeschutz

Schweißmodus	Strom (A)		Schweißparameter		
	1 1 0 V	220 V	VERGLEICHEN	ARC-Kraft	Heißer Start
Stock	20 bis 130ýA	20 bis 180ýA	EIN/AUS	0~10	0~10
WIG anheben	10~145A	10 bis 205ýA	/	/	/

Die LED für den Thermoschutz leuchtet auf, wenn das Gerät die maximale interne Komponententemperatur erreicht hat. Dies tritt auf, wenn der Arbeitszyklus überschritten wurde.

Das Schweißgerät schaltet sich automatisch ab, der Lüfter läuft jedoch weiter, um die überhitzten Komponenten zu kühlen. Wenn eine sichere Temperatur erreicht ist, schaltet die Schutzschaltung den Schweißausgang automatisch wieder ein.

A: positive Ausgangsschnittstelle B: Pistolenschalterschnittstelle

C: Gas-Elektro-Schnittstelle E: Netzkabel

F: Netzschalter G: WIG-Gasschnittstelle

MANUELLES SCHWEISSEN
DEBUGGING UND BETRIEB

1. Schließen Sie den Netzstecker an und schalten Sie das Netzschalter.
2. Schließen Sie die Schweißzange an den positiven Ausgangsanschluss an und verbinden Sie die Masse Klemme an den negativen Ausgangsanschluss.
3. Halten Sie das Werkstück mit einem Erdungsstift Klemme.
4. Drücken Sie die Schweißmodus-Taste, um in den manuellen Schweißmodus.
5. Stellen Sie den Stromregler ein, um die Strom auf den entsprechenden Bereich.
6. Berühren Sie die Elektrode und das Werkstück mit der Schweißzange und starten Sie den Lichtbogen Schweißen.

Argon-Lichtbogenschweißen
DEBUGGING UND BETRIEB

1. Einschalten und den Netzschalter betätigen.
2. Verbinden Sie die Argon-Lichtbogenschweißpistole mit dem Gas-Elektro-Schnittstelle der Schweißmaschine und im Uhrzeigersinn festziehen.
3. Stecken Sie den zweiadrigen Stecker der Taschenlampe in die Schalteranschluss der Taschenlampe.
4. Verbinden Sie den Erdungsanschluss mit der das positive Ausgangsende des Schweißgeräts und halten Sie das Werkstück mit der Erdungsklemme.
5. Drücken Sie die Schweißmodus-Taste, um zu wechseln Argon-Lichtbogenschweißmodus.
6. Verbinden Sie die Gasleitung der Gasflasche mit dem Argon Lichtbogenschweißgasanschluss an der Rückseite und festziehen es mit dem Kehlband.
7. Drehen Sie das Flaschenventil, um den entsprechenden Schweißdruck zu erreichen.
8. Je nach Plattendicke drehen Sie den Stromeinstellknopf, um den entsprechenden Schweißstrom zu erreichen.
9. Berühren Sie die Wolframelektrode des Schweißgeräts Brenner auf das Werkstück, drücken Sie den Pistolenschalter auf der Griff, und das Schweißen beginnt.

PREPARING TO “STICK” WELDING

1. Plug the power cord into a properly grounded, 1Phase 110/220 Volt AC, 50/60Hz, 50A circuit breaker.
2. Make sure the electrode or “Stick” is not making contact with the grounded workpiece.
3. Switch the Power Switch to “ON”.

⚠ DANGER

ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!
The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not allow these “hot” parts to come in contact with your bare skin or wet clothing. Always wear dry, protective clothing and leather welding gloves and insulated footwear.

⚠ WARNING

ARC RAYS CAN BURN!
Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).

⚠ DANGER

WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!
Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials. Remove all flammable items within 35 feet of the welding area. Always keep a fire extinguisher nearby while welding.

⚠ WARNING

FUMES AND WELDING GASES CAN BE A HEALTH HAZARD!
Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation. Wear an OSHAapproved respirator when welding. Always work in a properly ventilated area.

⚠ CAUTION

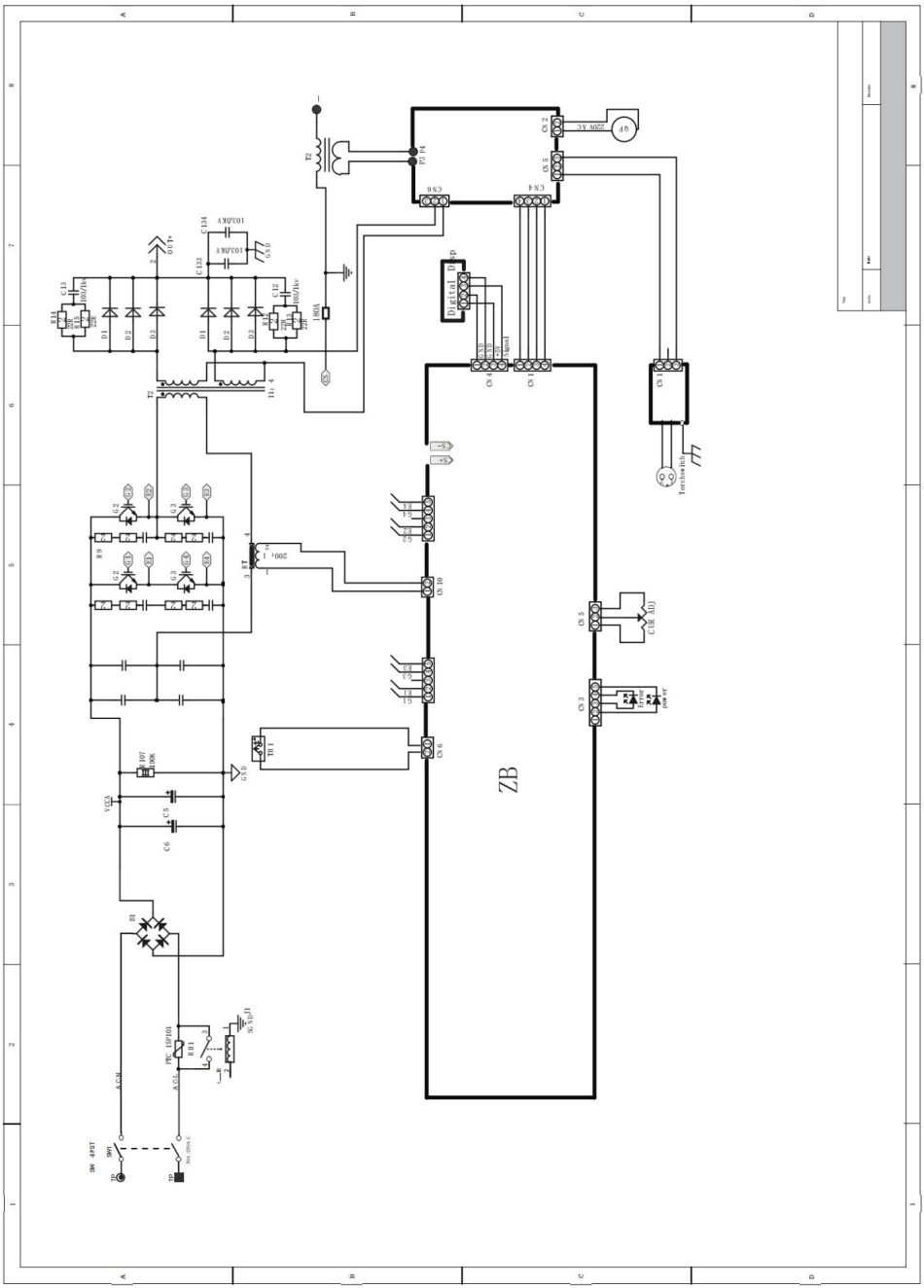
HOT METAL AND TOOLS WILL BURN!
Electric welding heats metal and tools to temperatures that will cause severe burns! Use protective, heat resistant gloves and clothing.

1. While wearing a properly functioning Auto Darkening Welding Helmet, lightlydrag the tip of the Welding Rod along the workpiece surface to start an arc.
2. Feed the Welding Rod into the workpiece joint at a 15° angle.
3. Lift rod from workpiece when weld bead is completed.
4. Turn off Welder power switch.
5. Set the Electrode or “Stick” Holder on a safe, non-flammable, surface.

TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Contamination in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Poor Weld Appearance	Incorrect positioning	The angle of the electrode should be at 45° and drug away from the weld arc. Failing to do so may cause poor weld appearance.
Weld Bead is Cracking	Too much heat in material	Reduce heat & allow more time between passes.
	Base Metal is absorbing too much heat	Preheat base metal (consult welding codes for requirements)
	Incorrect Filler Wire	Use correct filler wire type & diameter for the joint being welded.
Material is Warping	Insufficient Clamping	Clamp work piece tightly & weld while clA are in place.
	Insufficient Tack Welds	Add more tack welds until rigidity and stiffness is developed.
	Too Much Heat in Material	To reduce heat it is best to spread the welding out around the area. This can be done by using stitch welding techniques, alternating sides, and/or taking your time and allowing the pieces to cool between passes.
Porosity in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated base metal	Clean base metal making sure to remove any oil, debris, coatings, or moisture.
Difficulty Starting Arc	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection
	Amperage Too Low	Based on the material welding & size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Arc Wander	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
Difficulty Holding Arc	Amperage Too Low	Based on the material welding and size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection.
	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture.

WIRING DIAGRAM



Hersteller: Zhejiang Xingyi Ventilator Electrical Appliance Co., Ltd.
Adresse: Danya Industrial Park, Zeguo Town, WENLING Zhejiang 317523. Importiert nach Australien: SIHAO PTY LTD. 1 ROKEVA STREETEASTWOOD NSW2122Australien.

Importiert in die USA: Sanven Technology Ltd. Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730.

UK REP	YH CONSULTING LIMITED. C/OYH Consulting Limited Büro 147, Centurion House, London Road, Staines-upon-Thames, Surrey, TW18 4AX
Vertreter der EG	E-CrossStu GmbH Mainzer Landstr.69, 60329 Frankfurt am Main.

VEVOR®

TOUGH TOOLS, HALF PRICE

Technischer Support und E-Garantie-Zertifikat

www.vevor.com/support

VEVOR®

TOUGH TOOLS, HALF PRICE

Supporto tecnico e certificato di garanzia elettronica
www.vevor.com/support

Saldatore TIG

Modello: TIG/MMA-205

Continuiamo a impegnarci per fornirvi strumenti a prezzi competitivi. "Risparmia la metà", "Metà prezzo" o qualsiasi altra espressione simile da noi utilizzata rappresenta solo una stima del risparmio che potresti ottenere acquistando determinati utensili con noi rispetto ai principali marchi principali e non significa necessariamente coprire tutte le categorie di utensili da noi offerti. Ti ricordiamo cortesemente di verificare attentamente quando effettui un ordine con noi se stai effettivamente risparmiando la metà rispetto ai principali marchi principali.

VEVOR®
TOUGH TOOLS, HALF PRICE

Saldatore TIG

Modello: TIG/MMA-205

Nota: l'immagine del prodotto è di riferimento, i dettagli effettivi prevarranno

HAI BISOGNO DI AIUTO? CONTATTACI!

Hai domande sul prodotto? Hai bisogno di supporto tecnico? Non esitare a contattarci:

Supporto tecnico e certificato di garanzia elettronica
www.vevor.com/support

Questa è l'istruzione originale, si prega di leggere attentamente tutte le istruzioni del manuale prima di utilizzare. VEVOR si riserva una chiara interpretazione del nostro manuale utente. L'aspetto del prodotto sarà soggetto al prodotto ricevuto. Vi preghiamo di perdonarci se non vi informeremo di nuovo se ci sono aggiornamenti tecnologici o software sul nostro prodotto.

	Attenzione: per ridurre il rischio di lesioni, l'utente deve leggere attentamente il manuale di istruzioni.
	**CORRETTO SMALTIMENTO per l'esposizione** Questo prodotto è soggetto alle disposizioni della direttiva europea 2012/19/UE. simbolo raffigurante un bidone della spazzatura barrato indica che il prodotto richiede una raccolta differenziata dei rifiuti nell'Unione Europea. Ciò si applica al prodotto e a tutti gli accessori contrassegnati con questo simbolo. I prodotti contrassegnati come tali potrebbero non essere smaltire insieme ai normali rifiuti domestici, ma devono essere portati in un punto di raccolta per il riciclaggio di apparecchiature elettriche ed elettroniche.
	La conformità è una certificazione di sicurezza CE.

The TIG/MMA-205 provides a convenient method of performing “stick” welding carbon steel. Inverter technology provides the capability of welding thin or heavy gauge steel with precision and ease. When adding the optional lift TIG torch **(not included)**, gas regulator, and a cylinder of shielding gas, the TIG/MMA-205 becomes a TIG welder.

SPECIFICATIONS

Output Current Range:	Input Current	Input Voltage	Rated Duty Cycle	Rod Diameter	Rod Material
20~~205A	I1 massimo 45A (110V) I1 eff 34,8A (110V) I1 max 34A (220V) I1 eff 26,3A (220V)	110V o 220V	20%@ 205A	16/01~31/06 1,6~5,0mm	E6010 E6011 E6013 E7014 E7018S acciaio inossidabile

DUTY CYCLE

The rated duty cycle refers to the amount of welding that can be done within an amount of time. The TIG/MMA-205 has a duty cycle of 60% at 195A. It is easiest to look at your welding time in blocks of 10 minutes and the duty cycle being a percentage of that 10 minutes. If welding at 195A with a 60% duty cycle, within a 10 minute block of time you can weld for 6 minutes with 4 minutes of cooling for the welder. If the duty cycle is exceeded, the welder will automatically shut off, however the fan will continue running to cool the overheated components. When a safe temperature has been reached, the welder will automatically switch the welder output back on. To increase the duty cycle you can turn down the amperage output control.

READ AND UNDERSTAND ALL INSTRUCTIONS AND PRECAUTIONS BEFORE PROCEEDING.
This unit emits a powerful high voltage and extreme heat which can cause severe burns, dismemberment, electrical shock and death. VEVORE shall not be held liable for consequences due to deliberate or unintentional misuse of this product.

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER
DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING
WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION
CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE
NOTICE is used to address practices not related to personal injury.

⚠ LEGGI LE ISTRUZIONI

Leggere attentamente e comprendere il presente manuale prima di utilizzare la saldatrice. Conservarlo per riferimento futuro.

⚠ DANGER LA SCOSSA ELETTRICA PUÒ UCCIDERE!

· L'uso improprio di una saldatrice elettrica può causare scosse elettriche, lesioni e morte! Leggere tutte le precauzioni descritte nel manuale della saldatrice per ridurre la possibilità di scosse elettriche.

· Scollegare la saldatrice dall'alimentazione prima del montaggio, dello smontaggio o della manutenzione della stessa. torcia , punta di contatto e durante l'installazione o la rimozione degli ugelli.

· Indossare sempre indumenti protettivi asciutti e guanti da saldatura in pelle e calzature isolanti. indumenti adatti realizzati in materiale durevole e ignifugo per proteggere la pelle.

· Se altre persone o animali domestici si trovano nella zona di saldatura, potrebbero utilizzare schermi di saldatura per proteggere gli astanti verificarsi scintille.

· Utilizzare sempre la saldatrice in un'area pulita, asciuttae ben ventilata. Non utilizzare la saldatrice in aree piovose o scarsamente ventilate. metà , Bagnato ,

· L'elettrodo e i circuiti di lavoro (o di terra) sono elettricamente "caldi" quando la saldatrice è accesa. Non permettere a queste parti "calde" di entrare in contatto con la pelle nuda o con gli indumenti bagnati.

· separarsi dal circuito di saldatura utilizzando tappetini isolanti per evitare il contatto con il superficie di lavoro.

· Assicurarsi che il pezzo in lavorazione sia adeguatamente supportato e messo a terra prima di iniziare un'operazione elettrica operazione di saldatura.

· Fissare sempre il morsetto di terra al pezzo da saldare e il più vicino possibile alla zona di saldatura possibile. Ciò fornirà la minima resistenza e la migliore saldatura.

⚠ DANGER LE SCINTILLE DI SALDATURA POSSONO CAUSARE INCENDI O ESPLOSIONI!

· La saldatura elettrica produce scintille che possono essere scaricate ad alta velocità a distanze considerevoli, accendendo vapori e materiali infiammabili o esplosivi.

· Non utilizzare la saldatrice ad arco elettrico in aree in cui siano presenti vapori infiammabili o esplosivi.
· Non utilizzare vicino a superfici combustibili. Rimuovere tutti gli oggetti infiammabili entro 35 piedi dalla saldatura. zona di ingaggio.

· Tenere sempre un estintore a portata di mano durante la saldatura. · Utilizzare coperte per saldatura per proteggere superfici verniciate e/o infiammabili; guarnizioni in gomma, motori, ecc. cruscotti ,

· Assicurarsi che l'alimentatore sia dotato di cavi adeguatamente dimensionati per gestire il consumo energetico.

⚠ WARNING I CAMPI ELETTROMAGNETICI POSSONO ESSERE UN RISCHIO PER LA SALUTE!

· Il campo elettromagnetico generato durante la saldatura ad arco può interferire con vari dispositivi elettrici ed elettronici come i pacemaker cardiaci. Chiunque utilizzi tali dispositivi dovrebbe consultare il proprio medico prima di eseguire qualsiasi operazione di saldatura elettrica.

L'esposizione ai campi elettromagnetici durante la saldatura può avere altri effetti sulla salute che non sono conosciuto.

⚠ WARNING I RAGGI DELL'ARCO POSSONO BRUCIARE!

· I raggi dell'arco producono radiazioni ultraviolette intense che possono bruciare la pelle esposta e causare danni agli occhi. danni. utilizzare uno schermo con il filtro appropriato (almeno n. 1 1) per proteggere gli occhi da scintille e i raggi dell'arco durante la saldatura o quando si osserva la saldatura ad arco aperto (vedere ANsl Z49. 1 e Z87. 1 per gli standard di sicurezza).

· utilizzare indumenti adatti, realizzati in materiale resistente alle fiamme, per proteggere la pelle.

· Se altre persone o animali domestici si trovano nell'area di saldatura, utilizzare schermi di saldatura per proteggere gli astanti da scintille e raggi d'arco.

⚠ WARNING I FUMI E I GAS DI SALDATURA POSSONO ESSERE UN RISCHIO PER LA SALUTE!

· I fumi e i gas rilasciati durante la saldatura sono pericolosi. Non respirare i fumi prodotti dall'operazione di saldatura. Indossare un respiratore approvato OSHA durante la saldatura.

· Lavorare sempre in un'area adeguatamente ventilata.

· Non saldare mai materiali rivestiti, inclusi ma non limitati a: cadmiati, zincati, Guida

⚠ CAUTION di ammoniaca.IL METALLO E GLI UTENSILI CALDI BRUCERANNO!

· La saldatura elettrica riscalda il metallo e gli utensili a temperature che possono causare gravi ustioni!

· utilizzare dispositivi guanti e indumenti resistenti al calore quando si utilizza Eastwood o qualsiasi altro tipo di saldatura di protezione. Non toccare mai la superficie di lavoro saldata , punta o ugello della torcia fino a quando non sono completamente raffreddata.

⚠ CAUTION I trucioli metallici volanti possono causare lesioni!

· La molatura e la carteggiatura espelleranno trucioli di metallo, polvere, detriti e scintille ad alta velocità. Per prevenire lesioni agli occhi, indossare occhiali di sicurezza approvati.

· indossare un respiratore approvato OSHA durante la molatura o la carteggiatura.

· Leggere tutti i manuali forniti con le smerigliatrici, le levigatrici o altri utensili elettrici specifici utilizzati prima e dopo il processo di saldatura. Siate consapevoli di tutte le avvertenze di sicurezza per gli utensili elettrici.

ARTICOLI RICHIESTI

Prima di iniziare a utilizzare la SALDATURA TIG/MMA 205 ST CK , assicurati di avere quanto segue:

· Un interruttore automatico monofase 1 10/220 volt CA, 50/60 Hz, 50 A correttamente collegato a terra.

NOTA: per funzionare correttamente e in sicurezza, l'unità deve essere collegata a terra!

· Una pulita , sicuro , ben illuminato , area di lavoro asciutta e ben ventilata.

· Una camicia a maniche lunghe non infiammabile o una giacca da SALDATURA · Guanti da saldatura resistenti

· Casco da saldatura auto-oscurante per fornire protezione agli occhi durante le operazioni di saldatura. Nota: DEVE essere un #1 1 Uguale o più scuro.

· Spazzole per saldatura in filo di acciaio inossidabile dedicate per ogni materiale da saldare.

CONTENUTO

Rimuovere tutti gli articoli dalla scatola e confrontarli con l'elenco sottostante per accertarsi che l'unità sia completa.

1.TIG/MMA-205

Pinza per cavi di terra da 2,2 m 25 mm² 1 set

3.1 set di 2m 25mm² supporto per saldatura

4.3mWP-17 13mm² pistola per saldatura tig 1 set

5.Spazzola per saldatura *1

6. La spina degli Stati Uniti è un convertitore a doppia tensione (macchina a doppia alimentazione)

PANNELLO DI CONTROLLO E VISUALIZZAZIONE

A:Pulsante di selezione 2T/4T B:Pulsante di selezione DC/SPOT/PULSE

C: Modalità di saldatura manuale D: Pulsante modalità di saldatura

E: Saldatura ad arco di argon LIFTIG F: Saldatura ad arco di argon ad alta frequenza

G: Visualizzazione corrente H: Visualizzazione tensione di ingresso

I: manopola di regolazione della corrente J: display dei parametri integrato

K: Pulsante di selezione delle funzioni integrato

Fare clic sul pulsante per selezionare la funzione da mantenere fissa Allarme sullo schermo come protezione termica

Modalità di saldatura	corrente(A)		parametro di saldatura		
	1 1 0V	220V	COMPROVARE	Forza ARC	Avvio a caldo
bastone	20~130A	Da 20 a 180 A	ACCESO/SPENTO	0~10	0~10
Sollevamento TIG	10~145A	10~205A	/	/	/

Il LED di protezione termica si accende quando l'unità ha raggiunto la temperatura massima dei componenti interni. Ciò si verifica quando è stato superato il ciclo di lavoro.

La saldatrice si spegnerà automaticamente, ma la ventola continuerà a funzionare per raffreddare i componenti surriscaldati. Una volta raggiunta una temperatura sicura, il circuito di protezione riaccenderà automaticamente l'uscita della saldatrice.

A: interfaccia di uscita positiva B: interfaccia dell'interruttore della pistola

C: interfaccia gas-elettrico E: cavo di alimentazione

F: Interruttore di potenza G: Interfaccia gas TIG

SALDATURA MANUALE DEBUGGING E FUNZIONAMENTO

1. Collegare la spina di alimentazione e accendere il interruttore di alimentazione.
2. Collegare la pinza per saldatura alla porta di uscita positiva e collegare la terra morsetto alla porta di uscita negativa.
3. Tenere il pezzo in lavorazione con una massa MORSETTO.
4. Premere il pulsante della modalità di saldatura per cambiare alla modalità di saldatura manuale.
5. Regolare la manopola corrente per regolare correntenell'intervallo appropriato.
6. Toccare l'elettrodo e il pezzo in lavorazione con la pinza per saldare e accendere l'arco saldatura.

SALDATURA AD ARCO DI ARGON DEBUGGING E FUNZIONAMENTO

1. Accendere e accendere l'interruttore di alimentazione.
2. Collegare la pistola per saldatura ad arco di argon al interfaccia gas-elettrica della saldatrice e stringerlo in senso orario.
3. Inserire la spina bipolare della torcia nella commutare la porta della torcia.
4. Collegare il connettore rapido del morsetto di terra a l'estremità di uscita positiva della saldatrice e tenere premuto il pezzo in lavorazione con il morsetto di terra.
5. Premere il pulsante della modalità di saldatura per passare a modalità di saldatura ad arco di argon.
6. Collegare il tubo del gas della bombola del gas all'argon porta del gas di saldatura ad arco sul pannello posteriore e serrare con la fascia per la gola.
7. Ruotare la valvola della bombola per raggiungere la pressione di saldatura appropriata.
8. In base allo spessore della piastra, ruotare il manopola di regolazione della corrente per ottenere la corrente di saldatura appropriata.
9. Toccare l'elettrodo di tungsteno della saldatura torcia sul pezzo in lavorazione, premere l'interruttore della pistola su la maniglia e inizia la saldatura.

PREPARING TO “STICK” WELDING

1. Plug the power cord into a properly grounded, 1Phase 110/220 Volt AC, 50/60Hz, 50A circuit breaker.
2. Make sure the electrode or “Stick” is not making contact with the grounded workpiece.
3. Switch the Power Switch to “ON”.

⚠ DANGER

ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!
The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not allow these “hot” parts to come in contact with your bare skin or wet clothing. Always wear dry, protective clothing and leather welding gloves and insulated footwear.

⚠ WARNING

ARC RAYS CAN BURN!
Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).

⚠ DANGER

WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!
Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials. Remove all flammable items within 35 feet of the welding area. Always keep a fire extinguisher nearby while welding.

⚠ WARNING

FUMES AND WELDING GASES CAN BE A HEALTH HAZARD!
Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation. Wear an OSHAapproved respirator when welding. Always work in a properly ventilated area.

⚠ CAUTION

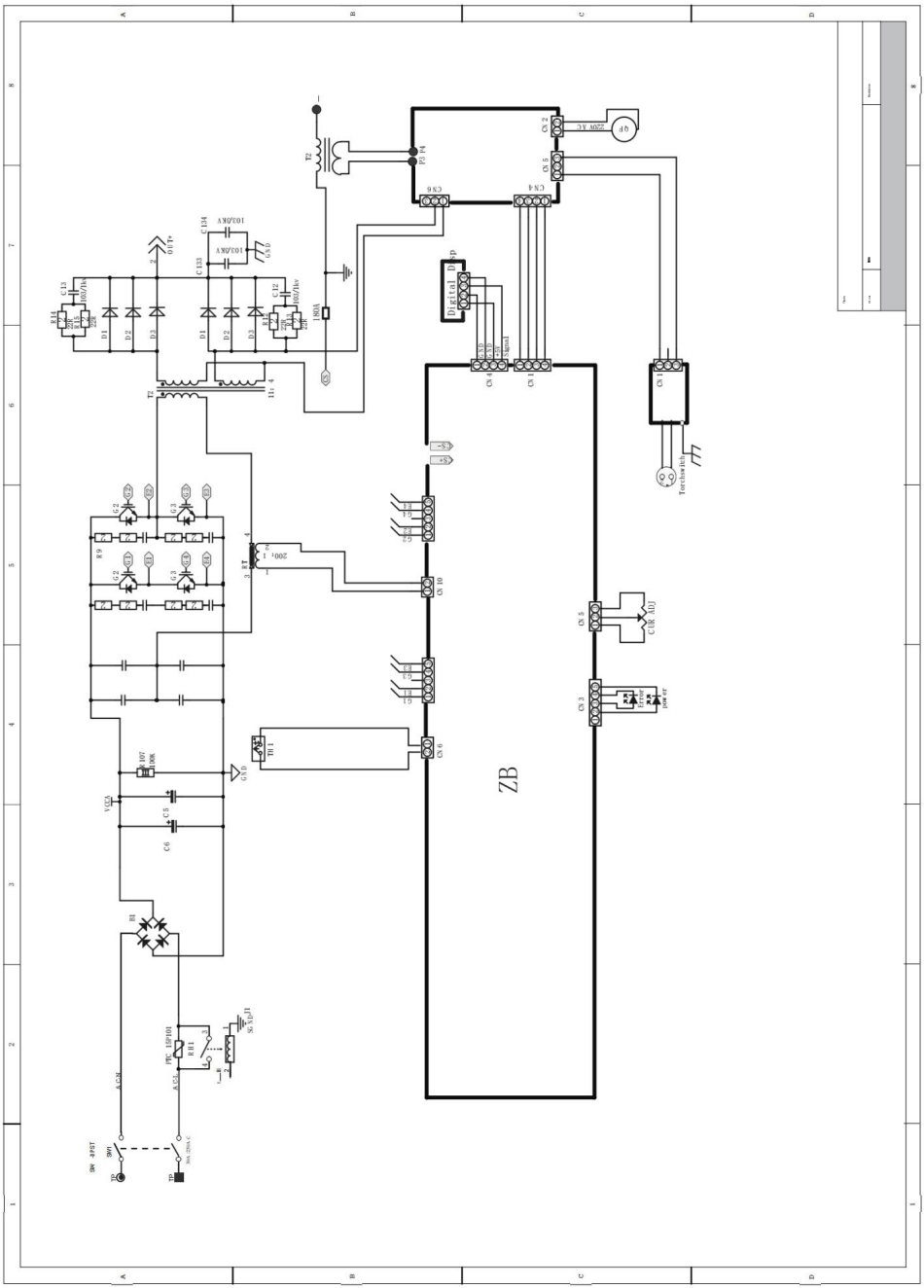
HOT METAL AND TOOLS WILL BURN!
Electric welding heats metal and tools to temperatures that will cause severe burns! Use protective, heat resistant gloves and clothing.

1. While wearing a properly functioning Auto Darkening Welding Helmet, lightlydrag the tip of the Welding Rod along the workpiece surface to start an arc.
2. Feed the Welding Rod into the workpiece joint at a 15° angle.
3. Lift rod from workpiece when weld bead is completed.
4. Turn off Welder power switch.
5. Set the Electrode or “Stick” Holder on a safe, non-flammable, surface.

TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Contamination in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Poor Weld Appearance	Incorrect positioning	The angle of the electrode should be at 45° and drug away from the weld arc. Failing to do so may cause poor weld appearance.
Weld Bead is Cracking	Too much heat in material	Reduce heat & allow more time between passes.
	Base Metal is absorbing too much heat	Preheat base metal (consult welding codes for requirements)
	Incorrect Filler Wire	Use correct filler wire type & diameter for the joint being welded.
Material is Warping	Insufficient Clamping	Clamp work piece tightly & weld while clA are in place.
	Insufficient Tack Welds	Add more tack welds until rigidity and stiffness is developed.
	Too Much Heat in Material	To reduce heat it is best to spread the welding out around the area. This can be done by using stitch welding techniques, alternating sides, and/or taking your time and allowing the pieces to cool between passes.
Porosity in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated base metal	Clean base metal making sure to remove any oil, debris, coatings, or moisture.
Difficulty Starting Arc	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection
	Amperage Too Low	Based on the material welding & size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Arc Wander	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
Difficulty Holding Arc	Amperage Too Low	Based on the material welding and size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection.
	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture.

WIRING DIAGRAM



Produttore: Zhejiang Xingyi Ventilator Electrical Appliance Co., Ltd.
Indirizzo: Danya Industrial Park, Zeguo Town, WENLING Zhejiang 317523 Importato in AUS: SIHAO PTY LTD. 1 ROKEVA STREETEASTWOOD NSW2122 Australia Importato

negli USA: Sanven Technology Ltd. Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

RAPPRESENTANZA DEL REGNO UNITO	YH CONSULTING LIMITED. C/OYH Consulting Limited Ufficio 147, Centurion House, London Road, Staines-upon-Thames, Surrey, TW18 4AX
Rappresentante della CE	E-CrossStu GmbH Mainzer Landstr.69, 60329 Francoforte sul Meno.

VEVOR®

TOUGH TOOLS, HALF PRICE

Supporto tecnico e certificato di garanzia
elettronica www.vevor.com/support

VEVOR®

TOUGH TOOLS, HALF PRICE

Soporte técnico y certificado de garantía electrónica
www.vevor.com/support

Soldador TIG
Modelo: TIG/MMA-205

Seguimos comprometidos a brindarle herramientas a precios competitivos. "Ahorre la mitad", "mitad de precio" o cualquier otra expresión similar que utilicemos solo representa una estimación del ahorro que podría obtener al comprar ciertas herramientas con nosotros en comparación con las principales marcas y no necesariamente significa que cubra todas las categorías de herramientas que ofrecemos. Le recordamos que, al realizar un pedido con nosotros, verifique cuidadosamente si realmente está ahorrando la mitad en comparación con las principales marcas.

VEVOR®
TOUGH TOOLS, HALF PRICE

Soldador TIG

Modelo: TIG/MMA-205

Nota: La imagen del producto es de referencia, prevalecerán los detalles reales.

¿NECESITA AYUDA? ¡CONTÁCTENOS!

¿Tiene preguntas sobre el producto? ¿Necesita asistencia técnica? No dude en ponerse en contacto con nosotros:

Soporte técnico y certificado de garantía electrónica
www.vevor.com/support

Estas son las instrucciones originales, lea atentamente todas las instrucciones del manual antes de utilizar el producto. VEVOR se reserva una interpretación clara de nuestro manual de usuario. La apariencia del producto estará sujeta al producto que recibió. Perdónenos por no informarle nuevamente si hay actualizaciones de tecnología o software en nuestro producto.

	Advertencia: Para reducir el riesgo de lesiones, el usuario debe leer atentamente el manual de instrucciones.
	ELIMINACIÓN CORRECTA de la pantalla Este producto está sujeto a las disposiciones de la Directiva europea 2012/19/UE. El símbolo que muestra un contenedor de basura tachado indica que el producto requiere una recogida selectiva de residuos en la Unión Europea. Esto se aplica al producto y a todos los accesorios marcados con este símbolo. Los productos marcados como tales no pueden desecharse con la basura doméstica normal, sino que deben llevarse a un punto de recogida para reciclar aparatos eléctricos y electrónicos.
	Compliance es una certificación de seguridad CE.

The TIG/MMA-205 provides a convenient method of performing “stick” welding carbon steel. Inverter technology provides the capability of welding thin or heavy gauge steel with precision and ease. When adding the optional lift TIG torch **(not included)**, gas regulator, and a cylinder of shielding gas, the TIG/MMA-205 becomes a TIG welder.

SPECIFICATIONS

Output Current Range:	Input Current	Input Voltage	Rated Duty Cycle	Rod Diameter	Rod Material
20~~205A	I1 máx. 45 A (110 V) I1 ef 34,8 A (110 V) I1 máx. 34 A (220 V) I1 ef 26,3 A (220 V)	110V o 220V	20%@ 205A	16/1 ~ 31/6 1,6 ~ 5,0 mm	E6010 E6011 E6013 E7014 E7018S acero inoxidable

DUTY CYCLE

The rated duty cycle refers to the amount of welding that can be done within an amount of time. The TIG/MMA-205 has a duty cycle of 60% at 195A. It is easiest to look at your welding time in blocks of 10 minutes and the duty cycle being a percentage of that 10 minutes. If welding at 195A with a 60% duty cycle, within a 10 minute block of time you can weld for 6 minutes with 4 minutes of cooling for the welder. If the duty cycle is exceeded, the welder will automatically shut off, however the fan will continue running to cool the overheated components. When a safe temperature has been reached, the welder will automatically switch the welder output back on. To increase the duty cycle you can turn down the amperage output control.

READ AND UNDERSTAND ALL INSTRUCTIONS AND PRECAUTIONS BEFORE PROCEEDING.
This unit emits a powerful high voltage and extreme heat which can cause severe burns, dismemberment, electrical shock and death. VEVOR shall not be held liable for consequences due to deliberate or unintentional misuse of this product.

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER
DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING
WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION
CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE
NOTICE is used to address practices not related to personal injury.

⚠ LEER INSTRUCCIONES

Lea y comprenda completamente este manual antes de utilizar la soldadora. Guárdelo para futuras referencias.

⚠ DANGER ¡LA DESCARGA ELÉCTRICA PUEDE MATAR!

· El uso inadecuado de una soldadora eléctrica puede provocar descargas eléctricas, lesiones y la muerte. Lea todas las precauciones descritas en el manual de la soldadora para reducir la posibilidad de descargas eléctricas.

· Desconecte la soldadora de la fuente de alimentación antes de realizar el montaje, desmontaje o mantenimiento de la misma. antorcha , punta de contacto y al instalar o quitar boquillas.

· Utilice siempre ropa protectora seca y guantes de cuero para soldar y calzado aislante. Ropa adecuada fabricada con material duradero y resistente al fuego para proteger tu piel.

· Si otras personas o mascotas se encuentran en el área de soldadura, evite Utilice pantallas de soldadura para proteger a los transeúntes las chispas.

· Utilice siempre la soldadora en un área limpia, seca y bien ventilada. No utilice la soldadora en áreas húmedas o mal ventiladas. medio , húmedo ,

· Los circuitos de electrodos y de trabajo (o de tierra) están eléctricamente "calientes" cuando la soldadora está encendida. No permita que estas partes "calientes" entren en contacto con su piel desnuda o con su ropa mojada.

· separarse del circuito de soldadura utilizando esteras aislantes para evitar el contacto con el superficie de trabajo.

· Asegúrese de que la pieza de trabajo esté correctamente apoyada y conectada a tierra antes de comenzar un trabajo eléctrico. operación de soldadura.

· Fije siempre la pinza de tierra a la pieza a soldar y lo más cerca posible del área de soldadura. posible. Esto dará la menor resistencia y la mejor soldadura.

⚠ DANGER ¡LAS CHISPAS DE SOLDADURA PUEDEN CAUSAR INCENDIO O EXPLOSIÓN!

· La soldadura eléctrica produce chispas que pueden descargarse a distancias considerables a alta velocidad y encender vapores y materiales inflamables o explosivos.

· No opere la soldadora de arco eléctrico en áreas donde haya vapores inflamables o explosivos.
· No lo use cerca de superficies combustibles. Retire todos los elementos inflamables que se encuentren a menos de 35 pies de la soldadura. Área de ing.

· Mantenga siempre un extintor de incendios cerca mientras suelda. · Utilice mantas de soldadura para proteger superficies pintadas y/o inflamables, burletes de goma, motores, etc. tableros de instrumentos ,

· Asegúrese de que la fuente de alimentación tenga un cableado con la clasificación adecuada para soportar el uso de energía.

⚠ WARNING ¡LOS CAMPOS ELECTROMAGNÉTICOS PUEDEN SER UN PELIGRO PARA LA SALUD!

· El campo electromagnético que se genera durante la soldadura por arco puede interferir con varios dispositivos eléctricos y electrónicos, como marcapasos cardíacos. Cualquier persona que utilice dichos dispositivos debe Consulte con su médico antes de realizar cualquier operación de soldadura eléctrica.

La exposición a campos electromagnéticos durante la soldadura puede tener otros efectos sobre la salud que no se describen a continuación. conocido.

⚠ WARNING ¡LOS RAYOS DEL ARCO PUEDEN QUEMAR!

· Los rayos del arco producen una intensa radiación ultravioleta que puede quemar la piel expuesta y causar quemaduras en los ojos. daño. use un protector con el filtro adecuado (un mínimo de #1 1) para proteger sus ojos de chispas y rayos del arco al soldar o al observar una soldadura por arco abierto (ver ANsl (Z49.1 y Z87.1 para normas de seguridad).

· Utilice ropa adecuada, fabricada con material duradero e ignífugo para proteger su piel.

· Si hay otras personas o mascotas en el área de soldadura, use pantallas de soldadura para proteger a los transeúntes. de chispas y rayos de arco.

⚠ WARNING ¡LOS HUMOS Y GASES DE SOLDADURA PUEDEN REPRESENTAR UN PELIGRO PARA LA SALUD!

· Los humos y gases que se liberan durante la soldadura son peligrosos. No respire los humos que se producen durante la operación de soldadura. Use un respirador aprobado por OSHA al soldar.

· Trabaje siempre en un área adecuadamente ventilada.

· Nunca suelde materiales revestidos, incluidos, entre otros: cadmiados, galvanizados, dirigir

⚠ CAUTION de metal. ¡ EL METAL CALIENTE Y LAS HERRAMIENTAS QUEMARAN!

· ¡La soldadura eléctrica calienta el metal y las herramientas a temperaturas que pueden provocar quemaduras graves!

· Utilice equipo de Guantes y ropa resistentes al calor cuando se utiliza Eastwood o cualquier otro equipo de soldadura. protección. Nunca toque la superficie de trabajo soldada que , punta o boquilla de la antorcha hasta que estén completamente esté fría.

⚠ CAUTION ¡LAS VIRUTAS METÁLICAS QUE VUELAN PUEDEN CAUSAR LESIONES!

· El pulido y el lijado expulsan virutas de metal, polvo, residuos y chispas a alta velocidad. Para evitar lesiones oculares, use anteojos de seguridad aprobados. · Use un respirador aprobado por OSHA al lijar o pulir.

· Lea todos los manuales incluidos con las amoladoras, lijadoras u otras herramientas eléctricas específicas utilizadas antes y después del proceso de soldadura. Tenga en cuenta todas las advertencias de seguridad para herramientas eléctricas.

ARTICULOS REQUERIDOS

Antes de comenzar a utilizar la soldadora TIG/MMA 205 ST CK , Asegúrese de tener lo siguiente:

· Un disyuntor monofásico de 1 fase de 10/220 voltios de CA, 50/60 Hz, 50 A, debidamente conectado a tierra.

NOTA: ¡La unidad debe estar conectada a tierra para funcionar de manera adecuada y segura!

· Una limpieza , seguro , bien iluminado , Área de trabajo seca y bien ventilada.

· Una camisa de manga larga no inflamable o una chaqueta de soldadura ·

Guantes de soldadura resistentes

· Casco de soldadura con oscurecimiento automático para brindar protección ocular durante las operaciones de soldadura. Nota: DEBE ser un #1 1 Igual o más oscuro.

· Cepillos de soldadura de alambre de acero inoxidable dedicados para cada material a soldar.

CONTENIDO

Retire todos los elementos de la caja. Compárelos con la lista a continuación para asegurarse de que la unidad esté completa.

1.TIG/MMA-205

Alicates para cable de tierra de 2,2 m y 25 mm², 1 juego

3,1 juego de soporte de soldadura de 2 m y 25 mm²

4,3 mWP-17 pistola de soldadura tig de 13 mm² 1 juego

5. Cepillo de soldadura * 1

6. El enchufe convertidor de voltaje dual del enchufe de los Estados Unidos (máquina de doble potencia)

PANEL DE CONTROL Y VISUALIZACIÓN

A: Botón de selección 2T/4T B: Botón de selección DC/SPOT/PULSE

C: Modo de soldadura manual D: Botón de modo de soldadura

E: Soldadura por arco de argón LIFTIG F: Soldadura por arco de argón de alta frecuencia

G: Visualización de corriente H: Visualización de voltaje de entrada

I: perilla de ajuste de corriente J: Pantalla de parámetros incorporada

K: Botón de selección de función incorporado

Haga clic en el botón para seleccionar la función que desea mantener activada

Alarma en pantalla como protección térmica

Modo de soldadura	corriente(A)		parámetro de soldadura		
	1 1 0 V	220 V	COMPARAR	Fuerza ARC	Arranque en caliente
palo	20 ~ 130 A	20 ~ 180 A	ENCENDIDO/APAGADO	0~10	0~10
Levante TIG	10~145A	10 ~ 205 A	/	/	/

El LED de protección térmica se ilumina cuando la unidad ha alcanzado la temperatura máxima del componente interno. Esto ocurre cuando se ha excedido el ciclo de trabajo.

La soldadora se apagará automáticamente, pero el ventilador continuará funcionando para enfriar los componentes sobrecalentados. Cuando se alcance una temperatura segura, el circuito de protección volverá a encender automáticamente la salida de la soldadora.

A: Interfaz de salida positiva B: Interfaz de interruptor de pistola

C: Interfaz gas-electricidad E: Cable de alimentación

F: Interruptor de encendido G: Interfaz de gas TIG

SOLDADURA MANUAL
DEPURACIÓN Y FUNCIONAMIENTO

1. Conecte el enchufe de alimentación y enciéndalo.
interruptor de encendido.
2. Conecte los alicates de soldadura al puerto de salida positivo y conecte la toma de tierra.
abrazadera al puerto de salida negativo.
3. Sujete la pieza de trabajo con un soporte.
abrazadera.
4. Pulse el botón de modo de soldadura para cambiar al modo de soldadura manual.
5. Ajuste la perilla actual para ajustar la actual al rango apropiado.
6. Toque el electrodo y la pieza de trabajo.
con las pinzas de soldar y encender el arco soldadura.

SOLDADURA POR ARCO DE ARGÓN
DEPURACIÓN Y FUNCIONAMIENTO

1. Encienda el dispositivo y gire el interruptor de encendido.
2. Conecte la pistola de soldadura por arco de argón a la Interfaz gas-eléctrica de la máquina de soldar y
Apriételo en el sentido de las agujas del reloj.
3. Inserte el enchufe de dos núcleos de la antorcha en el puerto de conmutación de la antorcha.
4. Conecte el conector rápido de la abrazadera de tierra a el extremo de salida positivo del soldador y manténgalo la pieza de trabajo con la abrazadera de tierra.
5. Pulse el botón de modo de soldadura para cambiar a modo de soldadura por arco de argón.
6. Conecte el tubo de gas del cilindro de gas al argón.
Puerto de gas para soldadura por arco en el panel trasero y apriete con la banda de la garganta.
7. Gire la válvula del cilindro para alcanzar la presión de soldadura adecuada.
8. Según el espesor de la placa, gire el
Perilla de ajuste de corriente para lograr la corriente de soldadura adecuada.
9. Toque el electrodo de tungsteno de la soldadura.
Coloque la antorcha sobre la pieza de trabajo y presione el interruptor de la pistola.
el mango y comienza la soldadura.

PREPARING TO “STICK” WELDING

1. Plug the power cord into a properly grounded, 1Phase 110/220 Volt AC, 50/60Hz, 50A circuit breaker.
2. Make sure the electrode or “Stick” is not making contact with the grounded workpiece.
3. Switch the Power Switch to “ON”.

⚠ DANGER

ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!

The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not allow these “hot” parts to come in contact with your bare skin or wet clothing. Always wear dry, protective clothing and leather welding gloves and insulated footwear.

⚠ WARNING

ARC RAYS CAN BURN!

Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).

⚠ DANGER

WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!

Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials. Remove all flammable items within 35 feet of the welding area. Always keep a fire extinguisher nearby while welding.

⚠ WARNING

FUMES AND WELDING GASES CAN BE A HEALTH HAZARD!

Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation. Wear an OSHAapproved respirator when welding. Always work in a properly ventilated area.

⚠ CAUTION

HOT METAL AND TOOLS WILL BURN!

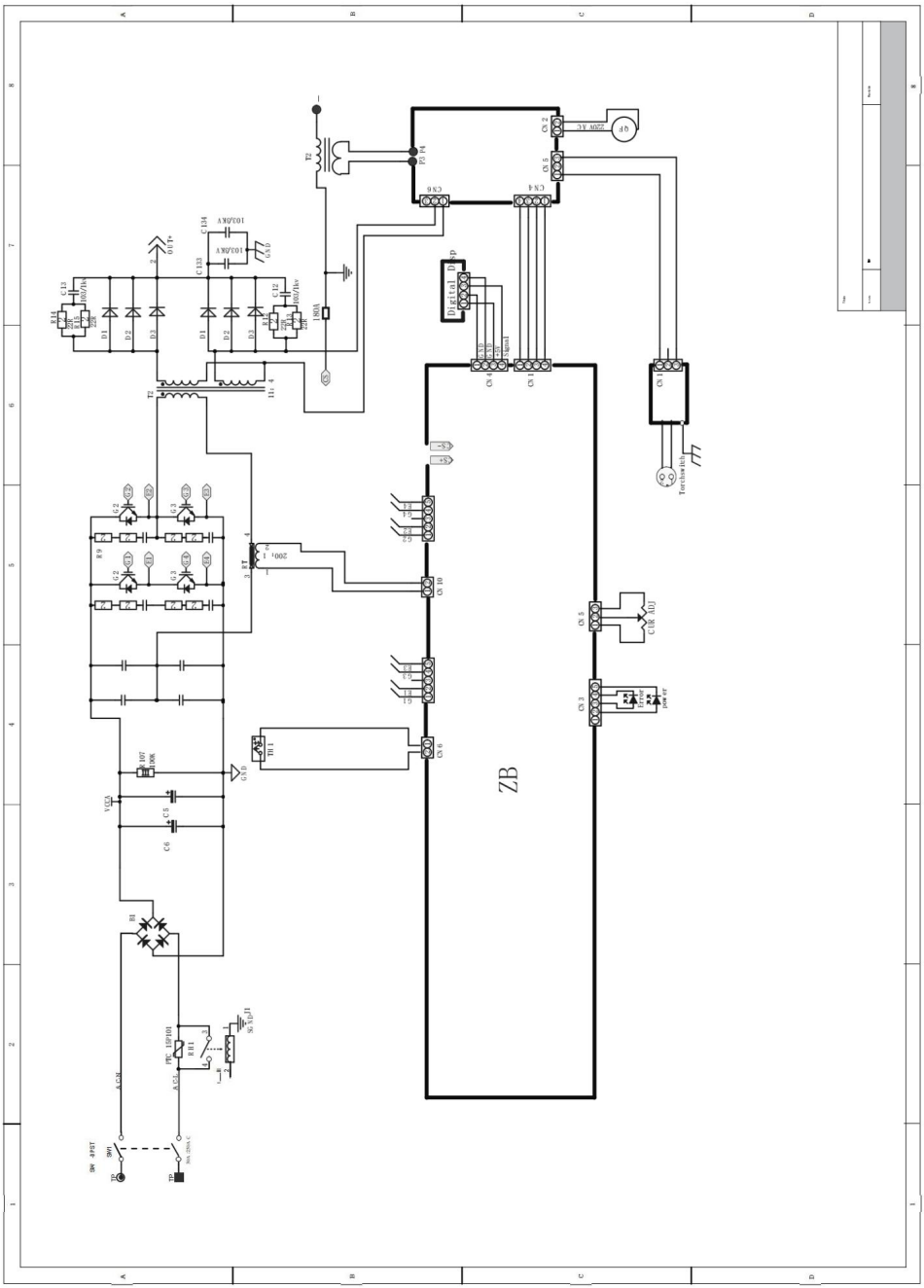
Electric welding heats metal and tools to temperatures that will cause severe burns! Use protective, heat resistant gloves and clothing.

1. While wearing a properly functioning Auto Darkening Welding Helmet, lightlydrag the tip of the Welding Rod along the workpiece surface to start an arc.
2. Feed the Welding Rod into the workpiece joint at a 15° angle.
3. Lift rod from workpiece when weld bead is completed.
4. Turn off Welder power switch.
5. Set the Electrode or “Stick” Holder on a safe, non-flammable, surface.

TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Contamination in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Poor Weld Appearance	Incorrect positioning	The angle of the electrode should be at 45° and drug away from the weld arc. Failing to do so may cause poor weld appearance.
Weld Bead is Cracking	Too much heat in material	Reduce heat & allow more time between passes.
	Base Metal is absorbing too much heat	Preheat base metal (consult welding codes for requirements)
	Incorrect Filler Wire	Use correct filler wire type & diameter for the joint being welded.
Material is Warping	Insufficient Clamping	Clamp work piece tightly & weld while clA are in place.
	Insufficient Tack Welds	Add more tack welds until rigidity and stiffness is developed.
	Too Much Heat in Material	To reduce heat it is best to spread the welding out around the area. This can be done by using stitch welding techniques, alternating sides, and/or taking your time and allowing the pieces to cool between passes.
Porosity in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated base metal	Clean base metal making sure to remove any oil, debris, coatings, or moisture.
Difficulty Starting Arc	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection
	Amperage Too Low	Based on the material welding & size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Arc Wander	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
Difficulty Holding Arc	Amperage Too Low	Based on the material welding and size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection.
	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture.

WIRING DIAGRAM



Fabricante: Zhejiang Xingyi Ventilator Electrical Appliance Co., Ltd.
Dirección: Danya Industrial Park, Zeguo Town, WENLING Zhejiang 317523 Importado a
Australia: SIHAO PTY LTD. 1 ROKEVA STREET EASTWOOD NSW2122
Australia Importado a

los EE. UU.: Sanven Technology Ltd. Suite 250, 9166 Anaheim Place, Rancho
Cucamonga, CA 91730

REPRESENTANTE DEL REINO UNIDO	YH CONSULTING LIMITED. C/OYH Consulting Limited Oficina 147, Centurion House, London Road, Staines-upon-Thames, Surrey, TW18 4AX
REPRESENTANTE CE	E-CrossStu GmbH Mainzer Landstr.69, 60329 Fráncfort del Meno.

VEVOR®

TOUGH TOOLS, HALF PRICE

Soporte técnico y certificado de garantía
electrónica www.vevor.com/support

VEVOR®

TOUGH TOOLS, HALF PRICE

Wsparcie techniczne i certyfikat gwarancji elektronicznej www.vevor.com/support

Spawacz TIG
Model: TIG/MMA-205

Nadal staramy się oferować Państwu narzędzia w konkurencyjnych cenach. „Oszczędź połowę", „Połowa ceny" lub inne podobne wyrażenia używane przez nas stanowią jedynie szacunkowe oszczędności, jakie możesz uzyskać, kupując u nas określone narzędzia w porównaniu z głównymi markami i niekoniecznie oznaczają one obejście wszystkich kategorii oferowanych przez nas narzędzi. Uprzejmie przypominamy, aby dokładnie sprawdzić, czy składając u nas zamówienie faktycznie oszczędzasz połowę w porównaniu z głównymi markami.

VEVOR®
TOUGH TOOLS, HALF PRICE

Spawacz TIG

Model: TIG/MMA-205

Uwaga: Zdję cie produktu ma charakter poglądowy, decydujące znaczenie mają rzeczywiste szczegóły

POTRZEBUJESZ POMOCY? SKONTAKTUJ SIĘ Z NAMI!

Masz pytania dotyczące produktu? Potrzebujesz wsparcia technicznego? Skontaktuj się z nami:

Certyfikat wsparcia technicznego i gwarancji elektronicznej
www.vevor.com/support

To jest oryginalna instrukcja, przed użyciem należy uważnie przeczytać wszystkie instrukcje. VEVOR zastrzega sobie jasną interpretację naszej instrukcji obsługi. Wygląd produktu bę dzie zależał od produktu, który otrzymałeś. Prosimy o wybaczenie, że nie poinformujemy Cię ponownie, jeśli w naszym produkcie pojawią się jakiekolwiek aktualizacje technologii lub oprogramowania.

	Ostrzeżenie: Aby zminimalizować ryzyko obrażeń, użytkownik powinien uważnie przeczytać instrukcję obsługi.
	PRAWIDŁOWA UTYLIZACJA dla Wyświetlacz Ten produkt podlega postanowieniom Dyrektywy Europejskiej 2012/19/UE. symbol przedstawiający przekreślony kosz na śmieci na kółkach oznacza, że produkt wymaga oddzielnej zbiórki odpadów w Unii Europejskiej. Dotyczy to produktu i wszystkich akcesoriów oznaczonych tym symbolem. Produkty oznaczone w ten sposób nie mogą być nie wolno ich wyrzucać razem z normalnymi odpadami domowymi, lecz należy je oddać do punktu zbiórki urządzeń elektrycznych i elektronicznych przeznaczonych do recyklingu.
	Zgodność oznacza certyfikat bezpieczeństwa WE.

The TIG/MMA-205 provides a convenient method of performing “stick” welding carbon steel. Inverter technology provides the capability of welding thin or heavy gauge steel with precision and ease. When adding the optional lift TIG torch **(not included)**, gas regulator, and a cylinder of shielding gas, the TIG/MMA-205 becomes a TIG welder.

SPECIFICATIONS

Output Current Range:	Input Current	Input Voltage	Rated Duty Cycle	Rod Diameter	Rod Material
20~~205A	I1 maks. 45A (110V) I1 skuteczność 34,8A (110V) I1 maks. 34A (220V) I1 skuteczne 26,3A (220V)	110V lub 220V	20%@ 205A	1/16~6/31 1,6~5,0 mm	E6010 E6011 E6013 E7014 E7018S Stal nierdzewna

DUTY CYCLE

The rated duty cycle refers to the amount of welding that can be done within an amount of time. The TIG/MMA-205 has a duty cycle of 60% at 195A. It is easiest to look at your welding time in blocks of 10 minutes and the duty cycle being a percentage of that 10 minutes. If welding at 195A with a 60% duty cycle, within a 10 minute block of time you can weld for 6 minutes with 4 minutes of cooling for the welder. If the duty cycle is exceeded, the welder will automatically shut off, however the fan will continue running to cool the overheated components. When a safe temperature has been reached, the welder will automatically switch the welder output back on. To increase the duty cycle you can turn down the amperage output control.

READ AND UNDERSTAND ALL INSTRUCTIONS AND PRECAUTIONS BEFORE PROCEEDING.

This unit emits a powerful high voltage and extreme heat which can cause severe burns, dismemberment, electrical shock and death. VEVOR shall not be held liable for consequences due to deliberate or unintentional misuse of this product.

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING

WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION

CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE

NOTICE is used to address practices not related to personal injury.

⚠ PRZECZYTAJ INSTRUKCJĘ

Przed użyciem spawarki należy dokładnie przeczytać i zrozumieć niniejszą instrukcję . Zachowaj ją do wykorzystania w przyszłości.

⚠ DANGER PORAŻENIE PRĄDEM MOŻE ZABIĆ!

· Niewłaściwe użycie spawarki elektrycznej może spowodować porażenie prądem, obrażenia i śmierć! Przeczytaj wszystkie środki ostrożności opisane w instrukcji spawarki, aby zmniejszyć ryzyko porażenia prądem.

· Przed montażem, demontażem lub konserwacją spawarki należy odłączyć ją od zasilania. latarka , końcówki stykowej oraz podczas montażu i demontażu dysz.

· Zawsze noś suchą, ochronną odzież, skórzane rę kawice spawalnicze i izolowane obuwie. odpowiednia odzież wykonana z trwałego i ognioodpornego materiału, chroniąca skórę .

· Jeżeli w obszarze spawania znajdują się inne osoby lub zwierzę ta, istnieje stosuj ekrany spawalnicze, aby chronić osoby postronne niebezpieczeństwo iskrzenia.

· Zawsze używaj spawarki w czystym, suchym i dobrze wentylowanym pomieszczeniu. Nie używaj spawarki w miejscach o niskiej lub niskiej średni , mokry , wentylacji.

· Obwody elektrody i robocze (lub uziemienia) są elektrycznie „gorące", gdy spawarka jest włączona. Nie dopuść, aby te „gorące" czę ści zetknę ły się z Twoją gołą skórą lub mokrym ubraniem.

· odizoluj się od obwodu spawalniczego, używając mat izolacyjnych, aby zapobiec kontaktowi z powierzchnia robocza.

· Przed rozpoczę ciem prac elektrycznych należy upewnić się , że obrabiany przedmiot jest prawidłowo podparty i uziemiony. operacja spawania.

· Zawsze mocuj zacisk uziemiający do spawanego elementu i jak najbliżej miejsca spawania. możliwe. To da najmniejszy opór i najlepsze spawanie.

⚠ DANGER ISKRY SPAWALNICZE MOGĄ SPOWODOWAĆ POŻAR LUB WYBUCH!

· Spawanie elektryczne wytwarza iskry, które mogą być wyładowywane na znaczną odległość z dużą prę dkością, zapalając łatwopalne lub wybuchające opary i materiały.

· Nie należy używać spawarki łukowej w miejscach, w których wystę pują opary łatwopalne lub wybuchowe.
· Nie używać w pobliżu powierzchni palnych. Usuń wszystkie przedmioty łatwopalne w odległości 35 stóp od miejsca spawania.

Obszar objęty zakazem.

· Podczas spawania zawsze trzymaj w pobliżu gaśnicę . · Używaj koców

spawalniczych do ochrony malowanych lub łatwopalnych powierzchni, uszczelek gumowych, silników itp. deski rozdzielcze ,

· Upewnij się , że zasilacz ma odpowiednio dobrane okablowanie, aby poradzić sobie ze zużyciem energii.

⚠ WARNING POLA ELEKTROMAGNETYCZNE MOGĄ BYĆ ZAGROŻONE DLA ZDROWIA!

· Pole elektromagnetyczne generowane podczas spawania łukiem elektrycznym może zakłócać działanie różnych urządzeń elektrycznych i elektronicznych, takich jak rozruszniki serca. Każda osoba korzystająca z takich urządzeń powinna Przed przystąpieniem do jakichkolwiek prac spawalniczych należy skonsultować się z lekarzem.

Narażenie na działanie pól elektromagnetycznych podczas spawania może mieć inne, nieuniknione skutki dla zdrowia. znany.

⚠ WARNING PROMIENIE ŁUKU MOGĄ PALIĆ!

· Promienie łuku elektrycznego wytwarzają intensywne promieniowanie ultrafioletowe, które może poparzyć odsłonię tą skórę i spowodować uszkodzenie oczu. uszkodzenia. Używaj osłony z odpowiednim filtrem (minimum #1 1), aby chronić oczy przed iskier i promieni łuku podczas spawania lub obserwacji spawania łukiem otwartym (patrz ANsl Z49.1 i Z87.1 dotyczące norm bezpieczeństwa).

· należy używać odpowiedniej odzieży wykonanej z trwałego, ognioodpornego materiału, aby chronić skórę .

· Jeżeli w obszarze spawania znajdują się inne osoby lub zwierzę ta, należy stosować osłony spawalnicze w celu ochrony osób postronnych. przed iskrami i łukami elektrycznymi.

⚠ WARNING OPARY I GAZY SPAWALNICZE MOGĄ BYĆ ZAGROŻONE DLA ZDROWIA!

· Dymy i gazy uwalniane podczas spawania są niebezpieczne. Nie wdychaj dymów wytwarzanych podczas spawania. Podczas spawania noś respirator zatwierdzony przez OSHA.

· Zawsze pracuj w odpowiednio wentylowanym pomieszczeniu.

· Nigdy nie spawaj materiałów powlekanych, w tym mię dzy innymi: kadmowanych, ocynkowanych, Ołów

⚠ CAUTION ORĄCY METAL I NARZĘDZIA MOGĄ SIĘ PALIĆ

· Spawanie elektryczne nagrzewa metal i narzę dzia do temperatur, które mogą spowodować poważne oparzenia!

· stosować sprzę t podczas pracy z Eastwood lub innymi urządzeniami spawalniczymi należy używać rę kawic i odzieży odpornej na ciepło ochronny. Nigdy nie dotykać schłodzonej powierzchni roboczej , końcówkę palnika lub dyszę , aż do całkowitego spawanej.

⚠ CAUTION LATAJĄCE WIÓRY METALOWE MOGĄ SPOWODOWAĆ OBRAŻENIA!

· Szlifowanie i polerowanie powoduje wyrzucanie wiórów metalowych, pyłu, zanieczyszczeń i iskier z dużą prę dkością. Aby zapobiec urazom oczu, należy nosić zatwierdzone okulary ochronne. · Podczas szlifowania lub polerowania należy nosić respirator zatwierdzony przez OSHA.

· Przed użyciem należy przeczytać wszystkie instrukcje dołączone do konkretnych szlifierek, polerek lub innych elektronarzę dzi. i po procesie spawania. Należy zapoznać się ze wszystkimi ostrzeżeniami dotyczącymi bezpieczeństwa elektronarzę dzi.

WYMAGANE ELEMENTY

Przed rozpoczę ciem korzystania ze spawarki TIG/MMA 205 ST CK , upewnij się , że posiadasz nastę pujące rzeczy:

· Prawidłowo uziemiony wyłącznik automatyczny 1-fazowy 1 10/220 V AC, 50/60 Hz, 50 A.
UWAGA: Aby urządzenie działało prawidłowo i bezpiecznie, musi być uziemione!

· Czystość , bezpieczna , dobrze oświetlony , suche i dobrze wentylowane miejsce pracy.

· Niepalna koszula z długim rę kawem lub kurtka SPAWALNICZA · Wytrzymałe rę kawice spawalnicze

· Automatycznie przyciemniający się hełm spawalniczy zapewniający ochronę oczu podczas prac spawalniczych. Uwaga: MUSI być #1 1 Taki sam lub ciemniejszy.

· Dedykowane szczotki spawalnicze ze stali nierdzewnej do każdego spawanego materiału.

ZAWARTOŚĆ

Wyjmij wszystkie elementy z pudełka. Porównaj z listą poniżej, aby upewnić się , że jednostka jest kompletna.

1.TIG/MMA-205

Szczypce do kabli uziemiających 2,2 m 25 mm² 1 zestaw

3.1 zestaw 2m 25mm² uchwyt spawalniczy 4.3mWP-17

13mm² pistolet spawalniczy TIG 1 zestaw

5.szczotka spawalnicza *1

6.Stany Zjednoczone wtyczka konwertera podwójnego napię cia (maszyna o podwójnym zasilaniu)

PANEL STEROWANIA I WYŚWIETLANIA

A: Przycisk wyboru 2T/4T B: Przycisk wyboru DC/SPOT/PULSE

C: Tryb spawania ręcznego D: Przycisk trybu spawania

E: Spawanie łukiem argonowym LIFTIG F: Spawanie łukiem argonowym o wysokiej czę stotliwości

G: Wyświetlacz prądu H: Wyświetlacz napięcia wejściowego

I: pokrętło regulacji prądu J: wbudowany wyświetlacz parametrów

K: Wbudowany przycisk wyboru funkcji

Kliknij przycisk, aby wybrać funkcję , która ma być stabilna
Alarm na ekranie, np. zabezpieczenie termiczne

Tryb spawania	prąd(A)		parametry spawania		
	1 1 0V	220 V	[illegible]	Siła łuku	Gorący start
stick	20~130A	20~180A	WŁ./WYŁ.	0~10	0~10
Podnieś TIG	10~145A	10~205A	/	/	/

Dioda LED ochrony termicznej zapala się , gdy jednostka osiągnie maksymalną temperaturę wewnę trznych podzespołów. Dzieje się tak, gdy przekroczony zostanie cykl pracy.

Spawarka wyłączy się automatycznie, jednak wentylator bę dzie nadal pracował w celu schłodzenia przegrzanych podzespołów. Po osiągnię ciu bezpiecznej temperatury obwód ochronny automatycznie włączy ponownie wyjście spawarki.

A: interfejs wyjściowy dodatni B: interfejs przełącznika pistoletu

C: Interfejs gazowo-elektryczny E: Przewód zasilający

F: Wyłącznik zasilania G: Interfejs gazowy TIG

SPAWANIE RĘCZNE DEBUGOWANIE I DZIAŁANIE

1. Podłącz wtyczkę zasilającą i włącz urządzenie. wyłącznik zasilania.
2. Podłącz szczypce spawalnicze do portu wyjściowego dodatniego i podłącz uziemienie zacisk do ujemnego portu wyjściowego.
3. Trzymaj przedmiot obrabiany za pomocą szlifierki. zacisk.
4. Naciśnij przycisk trybu spawania, aby przełączyć do trybu spawania rę cznego.
5. Dostosuj bieżące pokrę tło, aby dostosować prąd do odpowiedniego zakresu.
6. Dotknij elektrody i przedmiotu obrabianego za pomocą szczypiec spawalniczych i rozpocznij łuk spawalniczy.

SPAWANIE ŁUKIEM ARGONOWYM DEBUGOWANIE I DZIAŁANIE

1. Włącz zasilanie i włącz przełącznik zasilania.
2. Podłącz pistolet spawalniczy łukiem argonowym do interfejs gazowo-elektryczny spawarki i dokrę ć zgodnie z ruchem wskazówek zegara.
3. Włóż dwużyłową wtyczkę palnika do przełącznik portu latarki.
4. Podłącz szybkozłączkę zacisku uziemiającego do dodatni koniec wyjściowy spawarki i przytrzymaj przedmiot obrabiany za pomocą zacisku uziemiającego.
5. Naciśnij przycisk trybu spawania, aby przełączyć na tryb spawania łukiem argonowym.
6. Podłącz rurę gazową butli z gazem do argonu port gazowy do spawania łukiem elektrycznym na tylnym panelu i dokrę ć z opaską gardłową.
7. Obrócić zawór butli tak, aby uzyskać odpowiednie ciśnienie spawania.
8. W zależności od grubości płyty, obróć pokrę tło regulacji prądu, aby uzyskać odpowiedni prąd spawania.
9. Dotknij elektrody wolframowej spawarki przyłóż palnik do obrabianego przedmiotu i naciśnij przełącznik pistoletu uchwyt i rozpoczyna się spawanie.

PREPARING TO “STICK” WELDING

1. Plug the power cord into a properly grounded, 1Phase 110/220 Volt AC, 50/60Hz, 50A circuit breaker.
2. Make sure the electrode or “Stick” is not making contact with the grounded workpiece.
3. Switch the Power Switch to “ON”.

⚠ DANGER

ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!
The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not allow these “hot” parts to come in contact with your bare skin or wet clothing. Always wear dry, protective clothing and leather welding gloves and insulated footwear.

⚠ WARNING

ARC RAYS CAN BURN!
Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).

⚠ DANGER

WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!
Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials. Remove all flammable items within 35 feet of the welding area. Always keep a fire extinguisher nearby while welding.

⚠ WARNING

FUMES AND WELDING GASES CAN BE A HEALTH HAZARD!
Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation. Wear an OSHAapproved respirator when welding. Always work in a properly ventilated area.

⚠ CAUTION

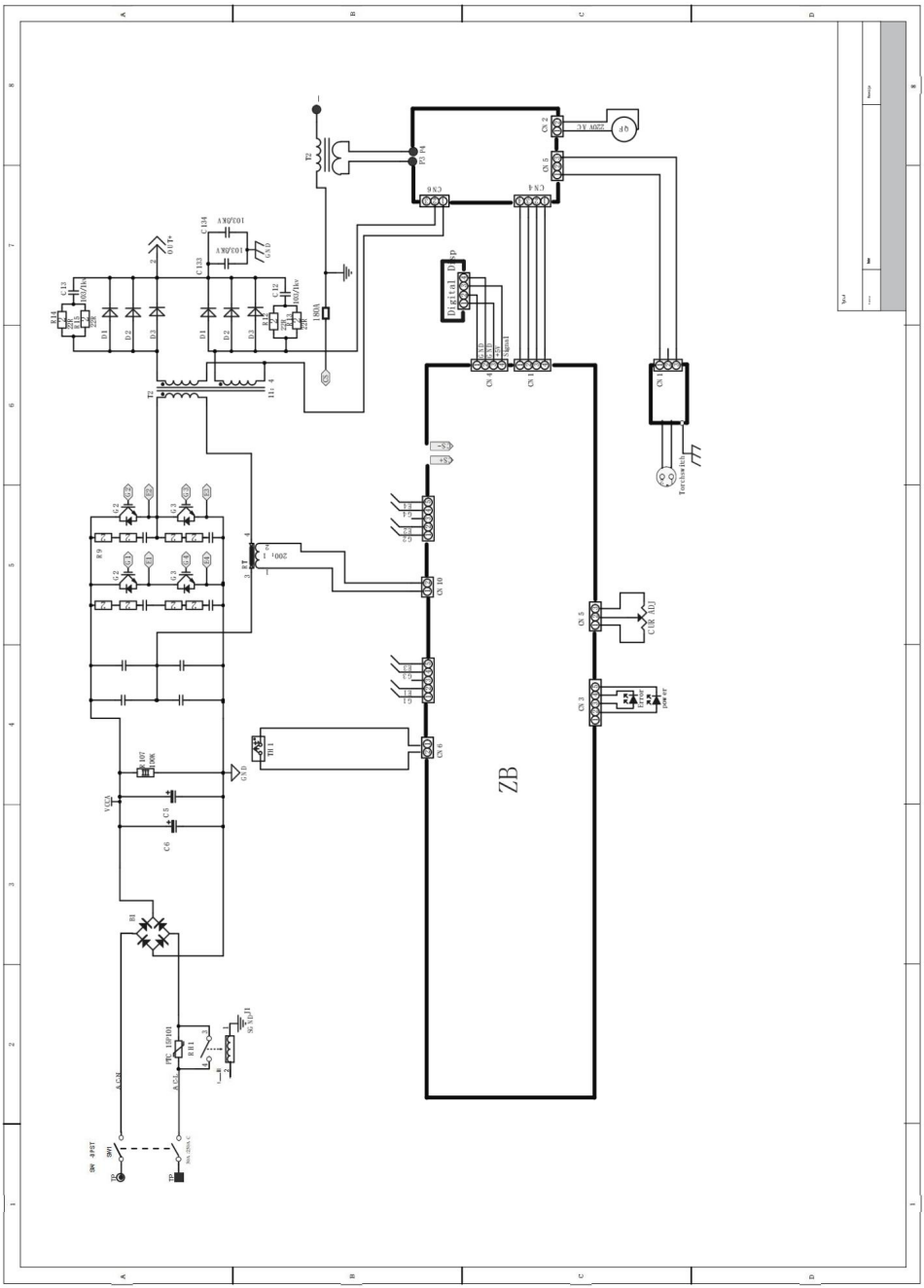
HOT METAL AND TOOLS WILL BURN!
Electric welding heats metal and tools to temperatures that will cause severe burns! Use protective, heat resistant gloves and clothing.

1. While wearing a properly functioning Auto Darkening Welding Helmet, lightlydrag the tip of the Welding Rod along the workpiece surface to start an arc.
2. Feed the Welding Rod into the workpiece joint at a 15° angle.
3. Lift rod from workpiece when weld bead is completed.
4. Turn off Welder power switch.
5. Set the Electrode or “Stick” Holder on a safe, non-flammable, surface.

TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Contamination in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Poor Weld Appearance	Incorrect positioning	The angle of the electrode should be at 45° and drug away from the weld arc. Failing to do so may cause poor weld appearance.
Weld Bead is Cracking	Too much heat in material	Reduce heat & allow more time between passes.
	Base Metal is absorbing too much heat	Preheat base metal (consult welding codes for requirements)
	Incorrect Filler Wire	Use correct filler wire type & diameter for the joint being welded.
Material is Warping	Insufficient Clamping	Clamp work piece tightly & weld while clA are in place.
	Insufficient Tack Welds	Add more tack welds until rigidity and stiffness is developed.
	Too Much Heat in Material	To reduce heat it is best to spread the welding out around the area. This can be done by using stitch welding techniques, alternating sides, and/or taking your time and allowing the pieces to cool between passes.
Porosity in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated base metal	Clean base metal making sure to remove any oil, debris, coatings, or moisture.
Difficulty Starting Arc	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection
	Amperage Too Low	Based on the material welding & size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Arc Wander	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
Difficulty Holding Arc	Amperage Too Low	Based on the material welding and size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection.
	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture.

WIRING DIAGRAM



Producent: Zhejiang Xingyi Ventilator Electrical Appliance Co., Ltd.
Adres: Danya Industrial Park, Zeguo Town, WENLING Zhejiang 317523 Importowane doAUS: SIHAO PTY LTD. 1 ROKEVA STREETEASTWOOD NSW2122Australia
Importowane do USA:

Sanven Technology Ltd. Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

REP WIELKIEJ BRYTANII	YH CONSULTING LIMITED. Biuro C/OYH Consulting Limited 147, Centurion House, London Road, Staines-upon-Thames, Surrey, TW18 4AX
Przedstawiciel UE	E-CrossStu GmbH Mainzer Landstr.69, 60329 Frankfurt nad Menem.

VEVOR®

TOUGH TOOLS, HALF PRICE

Wsparcie techniczne i certyfikat gwarancji elektronicznej www.vevor.com/support

VEVOR®

TOUGH TOOLS, HALF PRICE

Technische ondersteuning en e-garantiecertificaat
www.vevor.com/support

TIG Welder

Model: TIG/MMA-205

Wij streven er voortdurend naar om u gereedschappen tegen concurrerende prijzen te leveren. "Save Half", "Half Price" of andere soortgelijke uitdrukkingen die wij gebruiken, geven alleen een schatting van de besparingen die u kunt behalen door bepaalde gereedschappen bij ons te kopen in vergelijking met de grote topmerken en betekent niet noodzakelijkerwijs dat alle categorieën gereedschappen die wij aanbieden, worden gedekt. Wij herinneren u eraan om zorgvuldig te controleren of u daadwerkelijk de helft bespaart in vergelijking met de grote topmerken wanneer u een bestelling bij ons plaatst.

VEVOR®
TOUGH TOOLS, HALF PRICE

TIG Welder

Model: TIG/MMA-205

Let op: De productfoto is ter referentie, de werkelijke details zijn doorslaggevend.

HULP NODIG? NEEM CONTACT MET ONS OP!

Heeft u vragen over het product? Heeft u technische ondersteuning nodig? Neem dan gerust contact met ons op:

Technische ondersteuning en e-garantiecertificaat
www.vevor.com/support

Dit is de originele instructie, lees alle handleidingen zorgvuldig door voordat u het product gebruikt. VEVOR behoudt zich een duidelijke interpretatie van onze gebruikershandleiding voor. Het uiterlijk van het product is afhankelijk van het product dat u hebt ontvangen. Vergeef ons dat we u niet opnieuw zullen informeren als er technologische of software-updates voor ons product zijn.

	Waarschuwing: om het risico op letsel te verkleinen, moet de gebruiker de gebruiksaanwijzing zorgvuldig lezen.
	**CORRECTE VERWIJDERING voor Display** Dit product is onderworpen aan de bepalingen van de Europese richtlijn 2012/19/EU. De symbool met een doorgestreepte afvalbak geeft aan dat het product gescheiden afvalinzameling vereist in de Europese Unie. Dit geldt voor het product en alle accessoires die met dit symbool zijn gemarkeerd. Producten die als zodanig zijn gemarkeerd, mogen niet mogen met het normale huisvuil worden weggegooid, maar moeten naar een inzamelpunt voor recycling van elektrische en elektronische apparaten worden gebracht.
	Compliance is een EG-veiligheidscertificering.

The TIG/MMA-205 provides a convenient method of performing “stick” welding carbon steel. Inverter technology provides the capability of welding thin or heavy gauge steel with precision and ease. When adding the optional lift TIG torch **(not included)**, gas regulator, and a cylinder of shielding gas, the TIG/MMA-205 becomes a TIG welder.

SPECIFICATIONS

Output Current Range:	Input Current	Input Voltage	Rated Duty Cycle	Rod Diameter	Rod Material
20-–205A	I1 maximaal 45A (110V) I1 effectief 34,8A (110V) I1 maximaal 34A (220V) I1 effectief 26,3A (220V)	110V of 220V	20%@ 205A	1/16-6/31 1,6-5,0 mm	E6010 E6011 E6013 E7014 E7018S roestvrij staal

DUTY CYCLE

The rated duty cycle refers to the amount of welding that can be done within an amount of time. The TIG/MMA-205 has a duty cycle of 60% at 195A. It is easiest to look at your welding time in blocks of 10 minutes and the duty cycle being a percentage of that 10 minutes. If welding at 195A with a 60% duty cycle, within a 10 minute block of time you can weld for 6 minutes with 4 minutes of cooling for the welder. If the duty cycle is exceeded, the welder will automatically shut off, however the fan will continue running to cool the overheated components. When a safe temperature has been reached, the welder will automatically switch the welder output back on. To increase the duty cycle you can turn down the amperage output control.

READ AND UNDERSTAND ALL INSTRUCTIONS AND PRECAUTIONS BEFORE PROCEEDING.
This unit emits a powerful high voltage and extreme heat which can cause severe burns, dismemberment, electrical shock and death. VEVOR shall not be held liable for consequences due to deliberate or unintentional misuse of this product.

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER
DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING
WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION
CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE
NOTICE is used to address practices not related to personal injury.

⚠ LEES INSTRUCTIE$

Lees deze handleiding zorgvuldig door en zorg dat u deze begrijpt voordat u het lasapparaat gebruikt. Bewaar de handleiding voor toekomstig gebruik.

⚠ DANGER ELEKTRISCHE SCHOK KAN DODELIJK ZIJN!

· Onjuist gebruik van een elektrisch lasapparaat kan leiden tot elektrische schokken, letsel en de dood! Lees alle voorzorgsmaatregelen die in de handleiding van het lasapparaat staan beschreven om de kans op elektrische schokken te verkleinen.

· Koppel het lasapparaat los van de stroomvoorziening voordat u het monteert, demonteert of onderhoudt. fakkel , contacttip en bij het installeren of verwijderen van sproeiers.

· Draag altijd droge, beschermende kleding en leren lashandschoenen en geïsoleerd schoeisel. Geschikte kleding van duurzaam, vlamvertragend materiaal om uw huid te beschermen.

· Als er andere personen of huisdieren in de buurt zijn van de lasruimte, kunnen Gebruik lasschermen om omstanders te beschermen er vonken ontstaan.

· Gebruik de lasser altijd in een schone, droge, goed geventileerde ruimte. Gebruik de lasser niet in regenachtige of slecht midden , nat , geventileerde ruimtes.

· De elektrode en werk- (of aardings-) circuits zijn elektrisch "heet" wanneer de lasser aan staat. Laat deze "hete" onderdelen niet in contact komen met uw blote huid of natte kleding.

· Scheid uzelf van het lascircuit door isolatiematten te gebruiken om contact met de lasstroom te voorkomen. werkoppervlak.

· Zorg ervoor dat het werkstuk goed wordt ondersteund en geaard voordat u met een elektrische installatie begint. lasbewerking.

· Bevestig de aardklem altijd aan het te lassen stuk en zo dicht mogelijk bij het lasgebied. mogelijk. Dit geeft de minste weerstand en de beste las.

⚠ DANGER LASVONKEN KUNNEN BRAND OF EXPLOSIE VEROORZAKEN!

· Bij elektrisch lassen ontstaan vonken die met hoge snelheid over grote afstanden kunnen worden afgevoerd, waardoor ontvlambare of exploderende dampen en materialen kunnen ontbranden.

· Gebruik het elektrische booglasapparaat niet in ruimtes waar ontvlambare of explosieve dampen aanwezig zijn.
· Niet gebruiken in de buurt van brandbare oppervlakken. Verwijder alle brandbare items binnen 35 voet van de las-

gebied.

· Zorg dat u altijd een brandblusser bij de hand hebt tijdens het lassen. · Gebruik

lasdekens om geverfde en/of brandbare oppervlakken te beschermen, zoals rubberen tochtstrips, motoren, enz. dashboards ,

· Zorg ervoor dat de voeding de juiste bedrading heeft om het stroomverbruik aan te kunnen.

⚠ WARNING ELEKTROMAGNETISCHE VELDEN KUNNEN EEN GEVAAR VOOR DE GEZONDHEID VORMEN!

· Het elektromagnetische veld dat wordt gegenereerd tijdens booglassen kan interfereren met verschillende elektrische en elektronische apparaten, zoals pacemakers. Iedereen die dergelijke apparaten gebruikt, moet Raadpleeg uw arts voordat u elektrisch gaat lassen.

Blootstelling aan elektromagnetische velden tijdens het lassen kan andere gezondheidseffecten hebben die niet bekend zijn bekend.

⚠ WARNING BOOGSTRALEN KUNNEN BRANDEN!

· Boogstralen produceren intense ultraviolette straling die de blootgestelde huid kan verbranden en oogletsel kan veroorzaken. schade. Gebruik een schild met het juiste filter (minimaal #1 1) om uw ogen te beschermen tegen vonken en de stralen van de boog bij het lassen of bij het observeren van open booglassen (zie ANsl Z49.1 en Z87.1 voor veiligheidsnormen).

· Draag geschikte kleding van duurzaam, vlamvertragend materiaal om uw huid te beschermen.

· Als er andere personen of huisdieren in de buurt van het laswerk aanwezig zijn, gebruik dan lasschermen om omstanders te beschermen. van vonken en boogstralen.

⚠ WARNING DAMPEN EN LASGASSEN KUNNEN EEN GEVAAR VOOR DE GEZONDHEID VORMEN!

· Dampen en gassen die vrijkomen tijdens het lassen zijn gevaarlijk. Adem geen dampen in die vrijkomen tijdens het lassen. Draag een door OSHA goedgekeurd ademhalingstoestel tijdens het lassen.

· Werk altijd in een goed geventileerde ruimte.

· Las nooit gecoate materialen, waaronder maar niet beperkt tot: gecadmeerd, gegalvaniseerd, leiding

⚠ CAUTION (o basis van verf.HEET METAAL EN GEREEDSCHAP ZULLEN BRANDEN!

· Bij elektrisch lassen worden metaal en gereedschappen verhit tot temperaturen die ernstige brandwonden kunnen veroorzaken!

· Gebruik beschermende Hittebestendige handschoenen en kleding bij het lassen met Eastwood of een ander type lasapparaat uitrusting. Raak nooit een afgekoeld gelast werkoppervlak aan. , branderpunt of mondstuk totdat ze volledig zijn

⚠ CAUTION VLIEGENDE METAALSPANNERS KUNNEN LETSEL VEROORZAKEN!

· Slijpen en schuren zal metaalspanen, stof, puin en vonken met hoge snelheid uitstoten. Draag een goedgekeurde veiligheidsbril om oogletsel te voorkomen. · Draag een door OSHA goedgekeurde ademhalingsbescherming tijdens het slijpen of schuren.

· Lees alle handleidingen die bij de specifieke slijpmachines, schuurmachines of andere elektrische gereedschappen zijn geleverd voordat u ze gebruikt. en na het lasproces. Wees op de hoogte van alle veiligheidswaarschuwingen voor elektrisch gereedschap.

VEREISTE ITEMS

Voordat u de TIG/MMA 205 ST CK WELDER gaat gebruiken , Zorg ervoor dat u het volgende heeft:

· Een goed geaarde 1-fase 1 10/220 volt AC, 50/60 Hz, 50 A stroomonderbreker.
LET OP: het apparaat moet geaard zijn om goed en veilig te kunnen werken!

· Een schone , veilig , goed verlicht , droge en goed geventileerde werkruimte.
· Een niet-ontvlambaar shirt met lange mouwen of een lasjas · Robuuste lashandschoenen

· Automatisch verduisterende lashelm voor oogbescherming tijdens laswerkzaamheden. Let op: MOET een #1 1 Hetzelfde of donkerder.

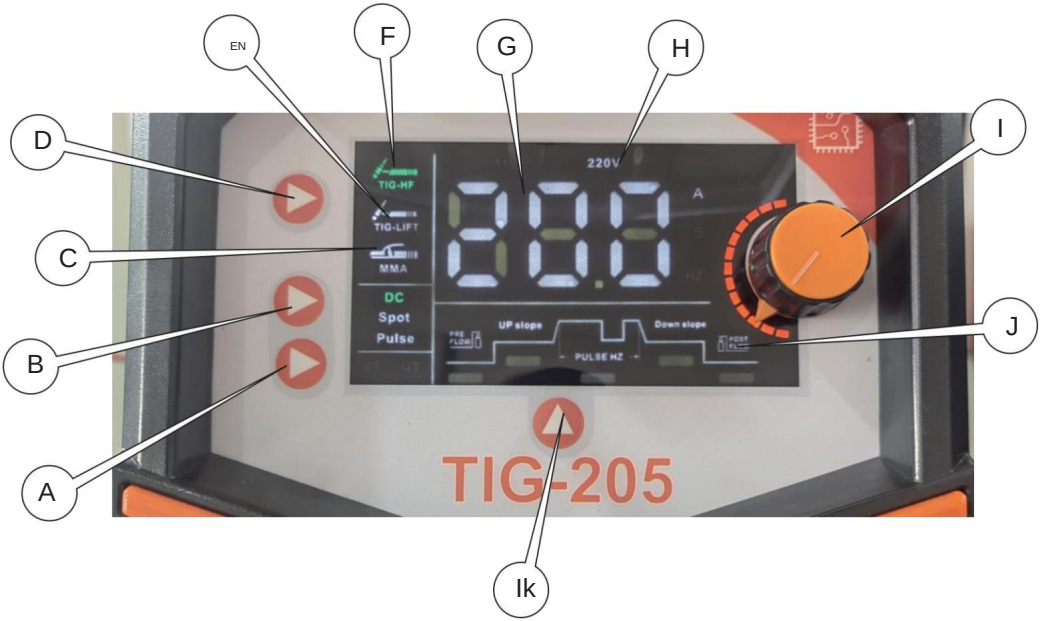
· Speciale lasborstels van roestvrij staal voor elk te lassen materiaal.

INHOUD

Haal alle onderdelen uit de doos. Vergelijk ze met de onderstaande lijst om er zeker van te zijn dat de unit compleet is.

1.TIG/MMA-205
2,2 m 25 mm² Grondkabeltang 1 set
3.1 set van 2m 25mm² lashouder
4.3mWP-17 13mm² tig laspistool 1 set
5.lasborstel *1
6.De Verenigde Staten plug dual voltage converter plug (dual power machine)

BEDIENINGSPANEEL EN WEERGAVEPANEEL



A:2T/4T selectieknop B:DC/SPOT/PULSE selectieknop

C: Handmatige lasmodus D: Lasmodusknop

E: LIFTIG argonbooglassen F: Hoogfrequent argonbooglassen

G: Stroomweergave H: Ingangsspanningsweergave

I: huidige instelknop J: ingebouwde parameterweergave

K: Ingebouwde functieselectieknop

Klik op de knop om de functie te selecteren die u stabiel wilt houden
Alarm op het scherm, zoals thermische beveiliging

Lasmodus	stroom(A)		lasparameter		
	1 1 0V	220V	VERGELIJKEN	ARC-kracht	Warme start
stok	20~130A	20~180A	AAN/UIT	0~10	0~10
Lift TIG	10~145A	10~205A	/	/	/

Thermische bescherming LED licht op wanneer de unit de maximale interne componenttemperatuur heeft bereikt. Dit gebeurt wanneer de duty cycle is overschreden.

Het lasapparaat schakelt automatisch uit, maar de ventilator blijft draaien om de oververhitte onderdelen af te koelen. Zodra een veilige temperatuur is bereikt, schakelt het beveiligingscircuit de lasuitgang automatisch weer in.

A: positieve uitgangsinterface B: interface voor pistoolschakelaar

C: gas-elektrische interface E: Stroomkabel

F: Aan/uit-schakelaar G: TIG-gasinterface

HANDMATIG LASSEN DEBUGGEN EN BEDIENING

1. Sluit de stekker aan en zet het apparaat aan. aan/uit schakelaar.
2. Sluit de las-tang aan op de positieve uitgangspoort en sluit de aarding aan klem op de negatieve uitgangspoort.
3. Houd het werkstuk vast met een grondpen klem.
4. Druk op de lasmodusknop om te schakelen naar de handmatige lasmodus.
5. Pas de huidige knop aan om de stroom binnen het juiste bereik.
6. Raak de elektrode en het werkstuk aan met de las tang, en start de boog lassen.

ARGON BOOGLASSEN DEBUGGEN EN BEDIENING

1. Schakel het apparaat in en zet de aan/uit-schakelaar aan.
2. Sluit het argonbooglaspistool aan op de gas-elektrische interface van de lasmachine en Draai het met de klok mee vast.
3. Steek de tweeaderige stekker van de toorts in de schakelpoort van de toorts.
4. Sluit de snelkoppeling van de aardklem aan op het positieve uitgangseinde van de lasser en houd het werkstuk met de aardklem.
5. Druk op de lasmodusknop om over te schakelen naar Argonbooglasmodus.
6. Sluit de gasleiding van de gascilinder aan op de argon booglasgaspoort op het achterpaneel en draai vast het met de keelband.
7. Draai de cilinderklep tot de gewenste lasdruk is bereikt.
8. Draai de plaat volgens de dikte van de plaat stroomregelknop om de juiste lasstroom te verkrijgen.
9. Raak de wolfraamelektrode van de las aan brander op het werkstuk, druk op de pistoolschakelaar de hendel, en het lassen begint.

PREPARING TO “STICK” WELDING

1. Plug the power cord into a properly grounded, 1Phase 110/220 Volt AC, 50/60Hz, 50A circuit breaker.
2. Make sure the electrode or “Stick” is not making contact with the grounded workpiece.
3. Switch the Power Switch to “ON”.

⚠ DANGER

ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!
The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not allow these “hot” parts to come in contact with your bare skin or wet clothing. Always wear dry, protective clothing and leather welding gloves and insulated footwear.

⚠ WARNING

ARC RAYS CAN BURN!
Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).

⚠ DANGER

WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!
Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials. Remove all flammable items within 35 feet of the welding area. Always keep a fire extinguisher nearby while welding.

⚠ WARNING

FUMES AND WELDING GASES CAN BE A HEALTH HAZARD!
Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation. Wear an OSHAapproved respirator when welding. Always work in a properly ventilated area.

⚠ CAUTION

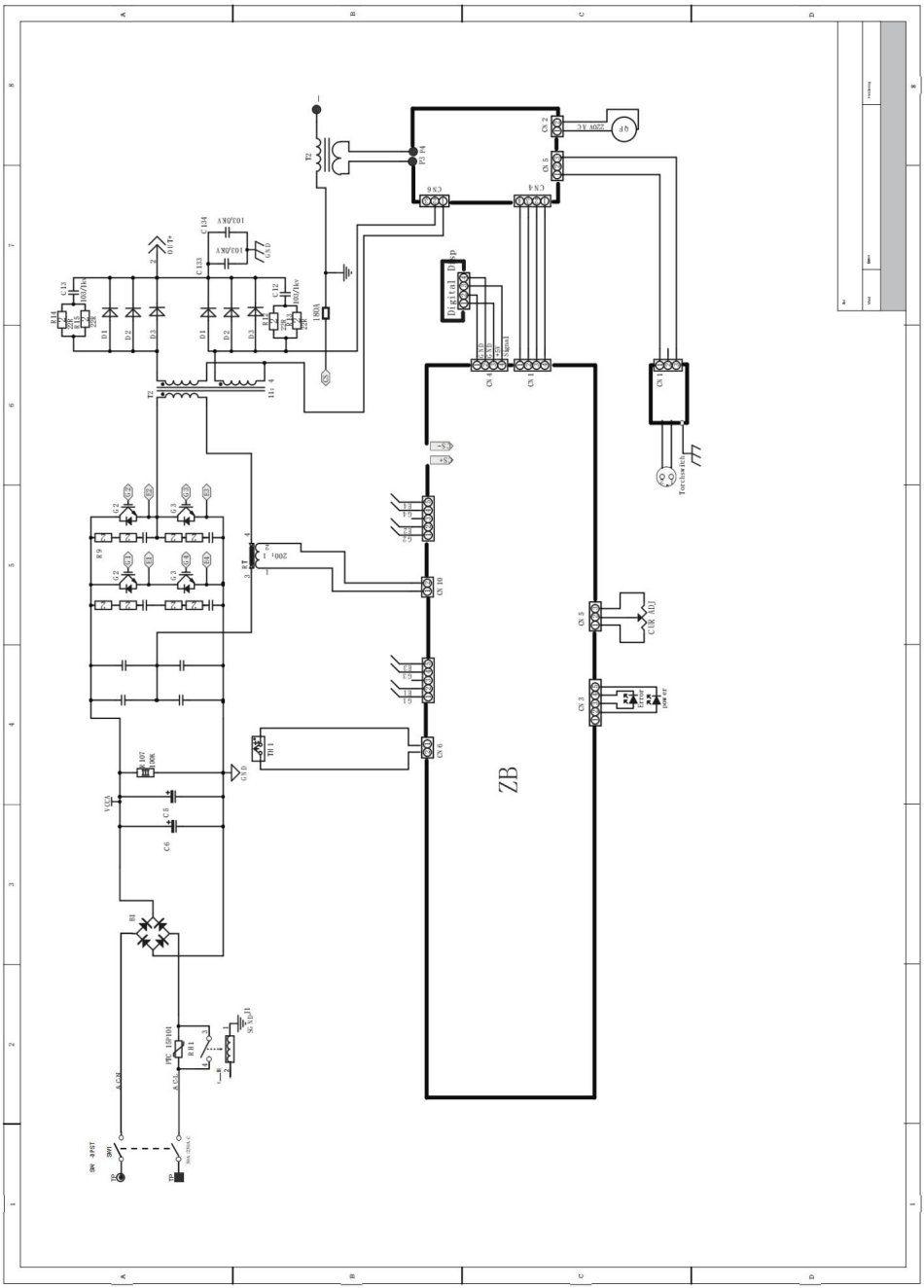
HOT METAL AND TOOLS WILL BURN!
Electric welding heats metal and tools to temperatures that will cause severe burns! Use protective, heat resistant gloves and clothing.

1. While wearing a properly functioning Auto Darkening Welding Helmet, lightlydrag the tip of the Welding Rod along the workpiece surface to start an arc.
2. Feed the Welding Rod into the workpiece joint at a 15° angle.
3. Lift rod from workpiece when weld bead is completed.
4. Turn off Welder power switch.
5. Set the Electrode or “Stick” Holder on a safe, non-flammable, surface.

TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Contamination in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Poor Weld Appearance	Incorrect positioning	The angle of the electrode should be at 45° and drug away from the weld arc. Failing to do so may cause poor weld appearance.
Weld Bead is Cracking	Too much heat in material	Reduce heat & allow more time between passes.
	Base Metal is absorbing too much heat	Preheat base metal (consult welding codes for requirements)
	Incorrect Filler Wire	Use correct filler wire type & diameter for the joint being welded.
Material is Warping	Insufficient Clamping	Clamp work piece tightly & weld while clA are in place.
	Insufficient Tack Welds	Add more tack welds until rigidity and stiffness is developed.
	Too Much Heat in Material	To reduce heat it is best to spread the welding out around the area. This can be done by using stitch welding techniques, alternating sides, and/or taking your time and allowing the pieces to cool between passes.
Porosity in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated base metal	Clean base metal making sure to remove any oil, debris, coatings, or moisture.
Difficulty Starting Arc	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection
	Amperage Too Low	Based on the material welding & size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Arc Wander	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
Difficulty Holding Arc	Amperage Too Low	Based on the material welding and size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection.
	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture.

WIRING DIAGRAM



Fabrikant: Zhejiang Xingyi Ventilator Electrical Appliance Co., Ltd.
Adres: Danya Industrial Park, Zeguo Town, WENLING Zhejiang 317523 Geïmporteerd naar AU: SIHAO PTY LTD. 1 ROKEVA STREETEASTWOOD NSW2122 Australië Geïmporteerd

naar de VS: Sanven Technology Ltd. Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

VK REP	YH CONSULTING LIMITED. C/OYH Consulting Limited Kantoor 147, Centurion House, London Road, Staines-upon-Thames, Surrey, TW18 4AX
EC-REP	E-CrossStu GmbH Mainzer Landstr.69, 60329 Frankfurt am Main.

VEVOR®

TOUGH TOOLS, HALF PRICE

Technische ondersteuning en e-garantiecertificaat

www.vevor.com/support

VEVOR®

TOUGH TOOLS, HALF PRICE

Teknisk support och e-garanticertifikat
www.vevor.com/support

TIG svetsare

Modell: TIG/MMA-205

Vi fortsätter att vara engagerade i att ge dig verktyg till konkurrenskraftiga priser. "Spara halva", "halva priset" eller andra liknande uttryck som används av oss representerar endast en uppskattning av besparingar du kan dra nytta av att köpa vissa verktyg hos oss jämfört med de stora toppmärkena och betyder inte nödvändigtvis att täcka alla kategorier av verktyg som erbjuds av oss. Du påminns vänligen om att noggrant kontrollera när du gör en beställning hos oss om du faktiskt sparar hälften i jämförelse med de främsta stora varumärkena.

VEVOR®
TOUGH TOOLS, HALF PRICE

TIG svetsare

Modell: TIG/MMA-205

Obs: Produktbilden är för referens, de faktiska detaljerna ska råda

BEHÖVER HJÄLP? KONTAKTA OSS!

Har du produktfrågor? Behöver du teknisk support? Kontakta oss gärna:

Teknisk support och e-garanticertifikat www.vevor.com/support

Detta är originalinstruktionen, vänligen läs alla bruksanvisningar noggrant innan du använder den. VEVOR förbehåller sig en tydlig tolkning av vår användarmanual. Produktens utseende är beroende av den produkt du mottagit. Ursäkta oss att vi inte kommer att informera dig igen om det finns någon teknik eller mjukvaruuppdateringar på vår produkt.

	Varning - För att minska risken för skada måste användaren läsa instruktionerna noggrant.
	**KORREKT AVFALLSHANTERING för** **display** Denna produkt omfattas av bestämmelserna i det europeiska direktivet 2012/19/EU. De symbol som visar en soptunna korsad anger att produkten kräver separat sophämtning i EU. Detta gäller för produkten och alla tillbehör märkta med denna symbol. Produkter märkta som sådana kanske inte är det kasseras tillsammans med vanligt hushållsavfall, men måste lämnas till en insamlingsplats för återvinning av elektriska och elektroniska enheter.
	Överensstämmelse är en EG-säkerhetscertifiering.

The TIG/MMA-205 provides a convenient method of performing “stick” welding carbon steel. Inverter technology provides the capability of welding thin or heavy gauge steel with precision and ease. When adding the optional lift TIG torch **(not included)**, gas regulator, and a cylinder of shielding gas, the TIG/MMA-205 becomes a TIG welder.

SPECIFICATIONS

Output Current Range:	Input Current	Input Voltage	Rated Duty Cycle	Rod Diameter	Rod Material
20~~205A	I1 max 45A (110V) I1 eff 34,8A (110V) I1 max 34A (220V) I1 eff 26,3A (220V)	110V eller 220V	20 %@ 205A	1/16~6/31 1,6~5,0 mm	E6010 E6011 E6013 E7014 E7018S rostfritt stål

DUTY CYCLE

The rated duty cycle refers to the amount of welding that can be done within an amount of time. The TIG/MMA-205 has a duty cycle of 60% at 195A. It is easiest to look at your welding time in blocks of 10 minutes and the duty cycle being a percentage of that 10 minutes. If welding at 195A with a 60% duty cycle, within a 10 minute block of time you can weld for 6 minutes with 4 minutes of cooling for the welder. If the duty cycle is exceeded, the welder will automatically shut off, however the fan will continue running to cool the overheated components. When a safe temperature has been reached, the welder will automatically switch the welder output back on. To increase the duty cycle you can turn down the amperage output control.

READ AND UNDERSTAND ALL INSTRUCTIONS AND PRECAUTIONS BEFORE PROCEEDING.

This unit emits a powerful high voltage and extreme heat which can cause severe burns, dismemberment, electrical shock and death. VEVOR shall not be held liable for consequences due to deliberate or unintentional misuse of this product.

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING

WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION

CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE

NOTICE is used to address practices not related to personal injury.

⚠ LÄS INSTRUKTIONER

Läs och förstå denna bruksanvisning noggrant innan du använder svetsaren. spara för framtida referens.

⚠ DANGER ELEKTRISK STÖT KAN DÖDA!

· Felaktig användning av en elektrisk svetsare kan orsaka elektriska stötar, skador och dödsfall! Läs alla försiktighetsåtgärder som beskrivs i svetsmanualen för att minska risken för elektriska stötar.

· Koppla bort svetsaren från strömförsörjningen före montering, demontering eller underhåll av fackla , kontaktspets och vid montering eller borttagning av munstycken.

· Bär alltid torra skyddskläder och lädersvetshandskar och isolerade skor. använda lämpliga kläder tillverkade av slitstarkt flambeständigt material för att skydda din hud.

· Om andra personer eller husdjur är i området för svetsning, från gnistor. använd svetsskärmar för att skydda åskådare

· Använd alltid svetsaren i ett rent, torrt och välventilerat utrymme. Använd inte svetsaren i regniga eller dåligt ventilerade utrymmen. mitt- , våt ,

· Elektroden och arbets- (eller jord-)kretsarna är elektriskt "heta" när svetsaren är på . Låt inte dessa "heta" delar komma i kontakt med din bara hud eller våta kläder.

· separera dig från svetskretsen genom att använda isoleringsmattor för att förhindra kontakt från arbetsyta.

· Se till att arbetsstycket är ordentligt stött och jordat innan du påbörjar en elektrisk svetsoperation.

· Fäst alltid markklämman på det stycke som ska svetsas och så nära svetsområdet som möjlig. Detta ger minst motstånd och bästa svetsning.

⚠ DANGER SVETSGNISTOR KAN ORSAKA BRAND ELLER EXPLOSION!

· Elektrisk svetsning producerar gnistor som kan släppas ut på avsevärda avstånd vid hög hastighet vilket antänder brandfarliga eller exploderande ångor och material.

· Använd inte en elektrisk ljusbågsvetsare i områden där det finns brandfarliga eller explosiva ångor.
· Använd inte nära brännbara ytor. Ta bort alla brännbara föremål inom 35 fot från svetsen- ing område.

· Ha alltid en brandsläckare i närheten när du svetsar. · använd svetsfiltar för att skydda målade och/eller brännbara ytor; gummiskydd, motorer etc. instrumentbrädor ,

· Se till att strömförsörjningen har rätt klassade ledningar för att hantera strömförbrukningen.

⚠ WARNING ELEKTROMAGNETISKA FÄLT KAN VARA EN HÄLSOFARA!

· Det elektromagnetiska fältet som alstras under bågsvetsning kan störa olika elektriska och elektroniska enheter såsom pacemakers. Alla som använder sådana enheter borde rådfråga sin läkare innan du utför några elektriska svetsoperationer.

, Exponering för elektromagnetiska fält under svetsning kan ha andra hälsoeffekter som inte är det känd.

⚠ WARNING BÅGSTRÅLAR KAN BRÄNNA!

· Bågstrålar producerar intensiv ultraviolett strålning som kan bränna exponerad hud och orsaka ögon skada. använd en sköld med rätt filter (minst #1 1) för att skydda dina ögon från gnistor och ljusbågens strålar vid svetsning eller vid observation av öppen bågsvetsning (se ANsl Z49. 1 och Z87. 1 för säkerhetsstandarder).

· använd lämpliga kläder gjorda av slitstarkt flambeständigt material för att skydda din hud.

· Om andra personer eller husdjur befinner sig i svetsområdet, använd svetsskärmar för att skydda åskådare från gnistor och ljusbågsstrålar.

⚠ WARNING RÖKOR OCH SVETSGAS KAN VARA EN HÄLSOFARA!

· Rök och gaser som frigörs vid svetsning är farliga. Andas inte in rök som produceras vid svetsningen. bär ett OSHA-godkänt andningsskydd vid svetsning.

· Arbeta alltid i ett väl ventilerat utrymme.

· Svetsa aldrig belagda material inklusive men inte begränsat till: kadmiumpläterade, galvaniserade, leda

⚠ CAUTION ger.HET METALL OCH VERKTYG KOMMER ATT BRÄNNA!

· Elektrisk svetsning värmer metall och verktyg till temperaturer som kan orsaka allvarliga brännskador!

· använd värmebeständiga handskar och kläder när du använder Eastwood eller någon annan svetsning skyddsutrustning. Rör aldrig svetsad arbetsyta kyld. , brännarens spets eller munstycke tills de är helt

⚠ CAUTION FLY NG METALL CHIPS KAN ORSAKA SKADA!

· Slipning och slipning kommer att spruta ut metallspån, damm, skräp och gnistor med hög hastighet. Använd godkända skyddsglasögon för att förhindra ögonskador. · använd ett OSHA-godkänt andningsskydd vid slipning eller slipning.

· Läs alla manualer som medföljer specifika slipmaskiner, slipmaskiner eller andra elverktyg som använts tidigare och efter svetsprocessen. Var medveten om alla säkerhetsvarningar för elverktyg.

OBLIGATORISKA ARTIKLAR

Innan du börjar använda TIG/MMA 205 ST CK WELDER , se till att du har följande:

· En korrekt jordad 1-fas 1 10/220 volt AC, 50/60Hz, 50A Strömbrytare.
OBS: enheten måste vara jordad för att fungera korrekt och säkert!

· En ren , säker , väl upplysta , torrt och välventilerat arbetsområde.

· En icke brandfarlig långärmad skjorta eller WELDING Jacka · Heavy Duty svetshandskar

· Automatisk mörkare svetshjälm för att ge ögonskydd vid svetsning. Obs: MÅSTE vara en #1 1 Samma eller mörkare.

· Dedikerade borstar för ståltrådssvetsning för varje material som ska svetsas.

INNEHÅLL

Ta bort alla föremål från lådan. jämför med listan nedan för att säkerställa att enheten är komplett.

1.TIG/MMA-205
2,2m 25mm² Jordkabeltång 1 set
3,1 set 2m 25mm² svetshållare
4,3mWP-17 13mm² tig-svetspistol 1 set
5.svetsborste *1
6. USA-kontakt med dubbelspänningsomvandlare (dual power-maskin)

KONTROLL- OCH DISPLAYPANEL

A:2T/4T Välj knapp B:DC/SPOT/PULSE Välj knapp

C: Manuellt svetsläge D: Svetslägesknapp

E: LIFTIG argonbågsvetsning F: Högfrekvent argonbågsvetsning

G: Strömdisplay H: Ingångsspänningsdisplay

I: strömjusteringsratt J: Inbyggd parametervisning

K: Inbyggd funktionsvalsknapp

Klicka på knappen för att välja den funktion som ska vara fast på In-screen larm såsom termiskt skydd

svetsläge	ström(A)		svetsparam		
	1 1 0V	220V	JÄMFÖRA	ARC Force	Varmstart
stick	20~130A	20~180A	PÅ/AV	0~10	0~10
Lyft TIG	10~145A	10~205A	/	/	/

Termiskt skyddslysdiod tänds när enheten har nått den maximala interna komponenttemperaturen. Detta inträffar när arbetscykeln har överskridits.

Svetsaren stängs automatiskt av men fläkten fortsätter att gå för att kyla de överhettade komponenterna. när en säker temperatur har uppnåtts kommer skyddskretsen automatiskt att slå på svetsutgången igen.

A: gränssnitt för positiv utgång B: Gränssnitt för pistolbrytare

C: gas-elektriskt gränssnitt E: Nätsladd

F: Strömbrytare G:TIG gasgränssnitt

MANUELL SVETSNING FELSÖKNING OCH DRIFT

1. Anslut nätkontakten och slå på strömbrytare.
2. Anslut svetstången till den positiva utgångsporten och anslut jord klämma fast den negativa utgångsporten.
3. Håll arbetsstycket med ett underlag klämma.
4. Tryck på svetslägesknappen för att växla till manuellt svetsläge.
5. Justera den aktuella ratten för att justera ström till lämpligt område.
6. Rör vid elektroden och arbetsstycket med svetstången och starta bågen svetsning.

ARGON BÅGSVETSNING FELSÖKNING OCH DRIFT

1. Slå på och slå på strömbrytaren.
2. Anslut argonbågssvetspistolen till den gas-elektriskt gränssnitt för svetsmaskinen och dra åt den medurs.
3. Sätt in den tvåkärniga kontakten på brännaren i den byt port på ficklampan.
4. Anslut jordklämmans snabbkoppling till svetsarens positiva utgångsände och håll kvar arbetsstycket med markklämman.
5. Tryck på svetslägesknappen för att växla till argonbågsvetsningsläge.
6. Anslut gasflaskans gasrör till argon bågsvetsgasport på bakpanelen och dra åt det med halsbandet.
7. Vrid cylinderventilen för att uppnå lämpligt svetstryck.
8. Beroende på plattans tjocklek, vrid på strömjusteringsratten för att uppnå lämplig svetsström.

9. Rör vid svetsningens volframelektrode brännaren till arbetsstycket, tryck på pistolbrytaren handtaget och svetsningen börjar.

PREPARING TO “STICK” WELDING

1. Plug the power cord into a properly grounded, 1Phase 110/220 Volt AC, 50/60Hz, 50A circuit breaker.
2. Make sure the electrode or “Stick” is not making contact with the grounded workpiece.
3. Switch the Power Switch to “ON”.

⚠ DANGER

ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!
The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not allow these “hot” parts to come in contact with your bare skin or wet clothing. Always wear dry, protective clothing and leather welding gloves and insulated footwear.

⚠ WARNING

ARC RAYS CAN BURN!
Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).

⚠ DANGER

WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!
Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials. Remove all flammable items within 35 feet of the welding area. Always keep a fire extinguisher nearby while welding.

⚠ WARNING

FUMES AND WELDING GASES CAN BE A HEALTH HAZARD!
Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation. Wear an OSHAapproved respirator when welding. Always work in a properly ventilated area.

⚠ CAUTION

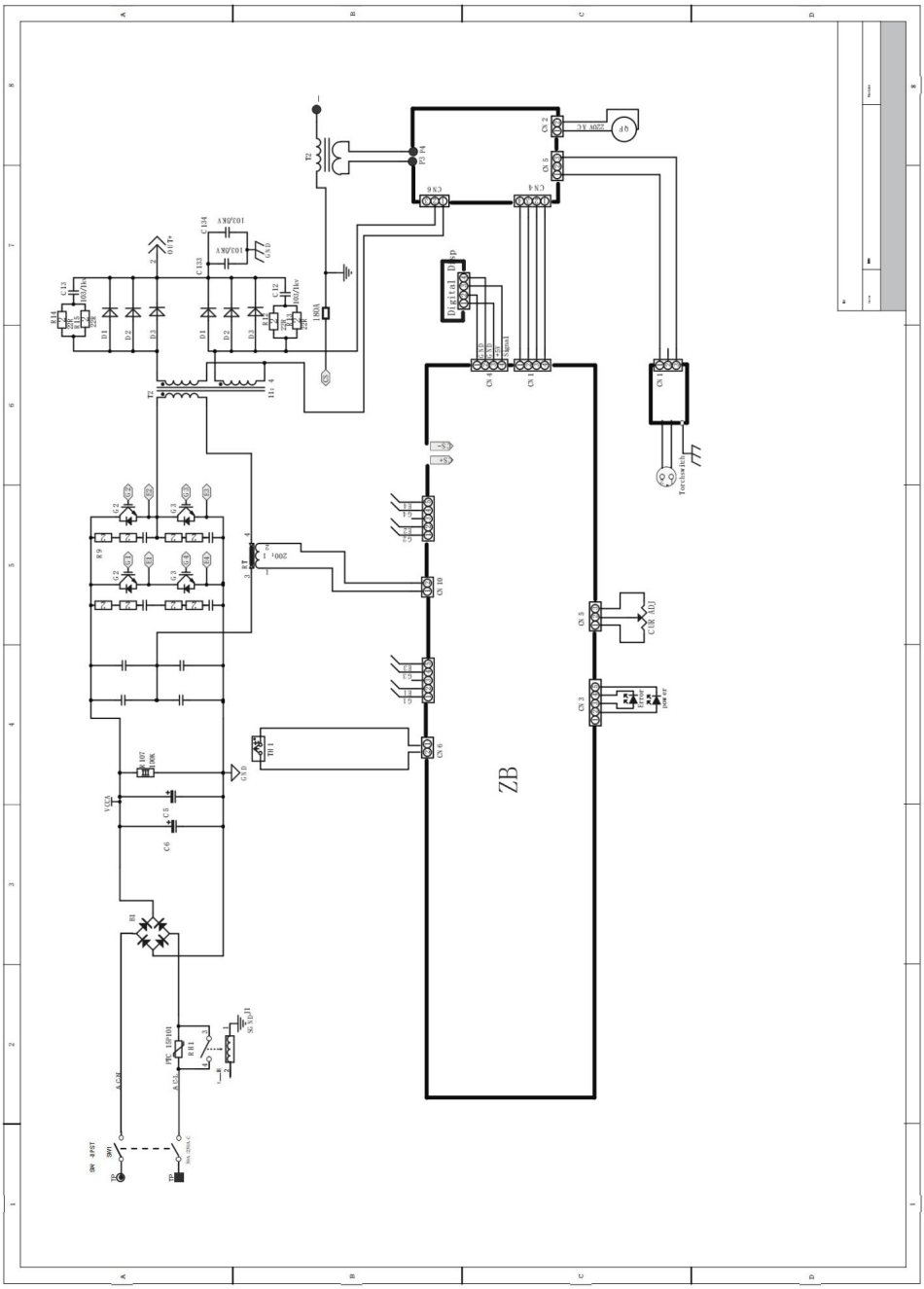
HOT METAL AND TOOLS WILL BURN!
Electric welding heats metal and tools to temperatures that will cause severe burns! Use protective, heat resistant gloves and clothing.

1. While wearing a properly functioning Auto Darkening Welding Helmet, lightlydrag the tip of the Welding Rod along the workpiece surface to start an arc.
2. Feed the Welding Rod into the workpiece joint at a 15° angle.
3. Lift rod from workpiece when weld bead is completed.
4. Turn off Welder power switch.
5. Set the Electrode or “Stick” Holder on a safe, non-flammable, surface.

TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Contamination in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Poor Weld Appearance	Incorrect positioning	The angle of the electrode should be at 45° and drug away from the weld arc. Failing to do so may cause poor weld appearance.
Weld Bead is Cracking	Too much heat in material	Reduce heat & allow more time between passes.
	Base Metal is absorbing too much heat	Preheat base metal (consult welding codes for requirements)
	Incorrect Filler Wire	Use correct filler wire type & diameter for the joint being welded.
Material is Warping	Insufficient Clamping	Clamp work piece tightly & weld while clA are in place.
	Insufficient Tack Welds	Add more tack welds until rigidity and stiffness is developed.
	Too Much Heat in Material	To reduce heat it is best to spread the welding out around the area. This can be done by using stitch welding techniques, alternating sides, and/or taking your time and allowing the pieces to cool between passes.
Porosity in weld bead	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated base metal	Clean base metal making sure to remove any oil, debris, coatings, or moisture.
Difficulty Starting Arc	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection
	Amperage Too Low	Based on the material welding & size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Arc Wander	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
Difficulty Holding Arc	Amperage Too Low	Based on the material welding and size/material of the electrode, pick an appropriate amperage to perform the desired weld.
	Electrode too far from welding surface	Move electrode so that it is contacting the weld puddle and feed rod into the puddle as needed.
	Incomplete Circuit	Check Ground connection. Make sure that the ground is on a freshly cleaned surface and close to the welding area. It is suggested to weld toward the ground connection.
	Contaminated Electrode Rod	Make sure that Electrodes are clean and dry before use.
	Contaminated Base Metal	Clean base metal of any oil, debris, coatings, or moisture.

WIRING DIAGRAM



Tillverkare: Zhejiang Xingyi Ventilator Electrical Appliance Co., Ltd.
Adress: Danya Industrial Park, Zeguo Town, WENLING Zhejiang 317523 Importerad till AUS:SIHAO PTY LTD. 1 ROKEVA STREETEASTWOOD NSW2122Australien
Importerad till USA:

Sanven Technology Ltd. Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

UK REP	YH CONSULTING LIMITED. C/OYH Consulting Limited Office 147, Centurion House, London Road, Staines-upon-Thames, Surrey, TW18 4AX
EC REP	E-CrossStu GmbH Mainzer Landstr.69, 60329 Frankfurt am Main.

VEVOR®

TOUGH TOOLS, HALF PRICE

Teknisk support och e-garanticertifikat
www.vevor.com/support