

MIG145

WELDCO™

Inverter MIG/MMA Welder

OPERATORS MANUAL



IMPORTANT: This manual contains important information regarding safety, operation, maintenance and storage of this product. Before use read carefully and understand all cautions, warnings, instructions and product labels. Failure to do so could result in serious personal injury and/or property damage.

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Thank you for your Purchase.

Weldco would like to thank you for purchasing the MIG145 Inverter Welder.

This manual is designed to guide you through using your new machine.

Your Weldco inverter welder utilizes the latest in welding technology to ensure you receive excellent results in a variety of applications.

UNPACKING YOUR WELDER



Contents:

- MIG inverter power source with 2.5m Direct connect MIG torch
- Earth clamp and lead.
- Electrode holder and lead.
- 0.6 / 0.8mm knurled roller = gasless (No shown)

Please check all contents are correct and damage free before first use, if any issues please contact your local dealer.

WELDING HAZARDS AND SAFETY



Welding poses a variety of hazards to health and safety. Please ensure you have correct safety equipment for yourself and those within the welding area. Your local distributor will be able to assist you with the correct Weldco protective helmet and gloves. Detailed documents can be located on the Worksafe website, www.worksafe.govt.nz, topic welding.

WORK AREA

- Ensure your work area is clear, dry, and free of trip hazards.
- That the area is well ventilated, and all flammable materials are removed to a safe distance.
- Never leave your welder powered up – unattended.

FIRE RISK

- Due to the welding process producing molten metal including sparks and fumes maximum fire safety must always be obeyed. Ensure you have direct access to the correct fire extinguisher for your environment.
- Never weld tanks or containers that have or have held flammable liquid, gas or where the contents are under pressure. This should only be carried out by trained specialists.
- Ensure that the area is checked for smoldering materials as material will remain hot well after welding.

ELECTRICITY CAN KILL

- Never weld or attempt to weld in a wet or raining environments. There is a serious risk of electrocution to the operator or those within the area.
- it is recommended that the welder be connected to an RCD.

FUMES AND GASES

- Welding produces fumes and gases that can be harmful to the operator and those within the surrounding areas. Always ensure that there is plenty of ventilation and fresh air.
- Do not weld material that has been coated or contaminated with paint, varnish, or rubber as they may give off harmful fumes or gas and increase the risk of fire and or explosion.

PERSONAL PROTECTIVE EQUIPMENT AND CLOTHING

The user must comply with occupational health and safety rules and wear appropriate protective equipment.

BURNS

- The welding process causes the work piece and surrounding items to become hot.
- It is always recommended that flame resistant clothing be worn.
- Welding gloves **must** be worn to help prevent burns to hands and arms when handling hot objects.
- Avoid skin exposure to the Ultraviolet rays produced by the arc. It is recommended that skin be protected from these harmful rays. Serious burns are possible when this recommendation is not followed.
- Approved welding helmets **must** be worn by the operator and any personnel within 10m of the work area. It is also recommended that welding safety screens are installed to protect.
- It is always recommended that enclosed footwear with rubber soles be worn to protect from sparks and molten metal and to reduce the risk of electrocution.
- As welding produces gases and fumes many of these can be harmful it is recommended that the operator and those in the direct area wear respirators with the relevant protection.
- Always wear safety glasses when chipping the slag, scraping, or preparing the work piece.

ELECTROMAGNETIC AND RADIO FREQUENCIES – “PACEMAKERS”

- Avoid contact with the energized work piece.
- Always ensure you have adequate protection from electrocution and burns.
- Since the welder emits strong electromagnetic and radio frequencies. Persons fitted with **“PACEMAKERS”** or similar devices **MUST** consult their doctor before turning on the welder. This relates to both the operator and those nearby.

PRE-CHECKS

The following items must be checked by the operator each time before powering up the power source.

- Ensure that the welder is damage free and no exposed wires.
- Check all welding cables, insulation and accessories are free of damage.
- The work area is checked and free of hazards
- All personal protective clothing and equipment is defect free.
- Access to Fire extinguisher and welding blanket.
- All flammable material has been removed.

WARNING!








- Disconnect the power source before servicing and ensure the device has powered down.
- Contact your dealer or reseller immediately should your welder require servicing.
- It is not recommended that you remove the covers to carry out your own servicing – doing so will void the warranty.

STORAGE, TRANSPORTATION AND MAINTENANCE

- Your welder contains sensitive electronics and needs to be stored in a dust and moisture free environment.
- Periodically your welder should be blown down using dry compressed air to remove any dust and metal fillings.
- Once your power source and welder have cooled down. Remove your accessories for storage – wipe both the welder and accessories down with a clean cloth to remove any contaminants.
- Store your welder in a dry safe environment.
- When transporting ensure that the power source, accessories, and wire are secure.
- Cylinders need to be stored and transported as per NZ regulations and safe operating procedures.

TECHNICAL DESCRIPTION

COMPLIANCE PLATE

WELDCO™		MODEL	MIG145	 E7783 E2020022232		
				CoC#: ESV200335		
AS/NZS 60974.1 AS/NZS 60974.6						
MIG/MAG 50A/16.5V~140A/21V				MMA 10A/16.5V~140A/25.6V		
X	25%	60%	100%	15%	60%	100%
I ₂	140A	90A	70A	140A	70A	54A
U ₂	21V	18.5V	17.5V	25.6V	22.8V	22.2V
 1~50/60Hz				Power factor: 0.76		
U ₁ = 230V				I ₁ max		I ₁ eff
50/60HZ				MIG/MAG	MMA	MIG/MAG
U ₀ = 51V				21A	26A	10A
Cooling way: FAN		Rank of protection: IP21S		Rank of insulation: H		

Duty Cycle

The welder's duty cycle is the number of minutes in a 10-minute period the power source can safely produce the set welding current (actual arc on). If this is exceeded the machine will enter thermal overload, turning the welding current off protecting the welder. This is indicated by the light on the front panel. The fan will continue to cool the power source during thermal overload.

For example:

- At 90 amps the welder will **MIG** continuously for **6 mins** and needs to rest for **4 mins**.
- At 70 amps the welder will **MIG** continuously or 100% of the time.

The duty cycle is tested at 40 degrees Celsius, if the welder is operating in lower temperature e.g., 20 degrees Celsius the duty cycle will be higher.

INPUT PLUG

The MIG145 is fitted with a **10amp plug**. This machine is designed to work with **10amp** domestic wall sockets. It is important that the machine is plugged directly into the mains plug. If an extension cord must be used a minimum 2.5mm wire thickness is required and no more than 10m in length.

Using unsuitable extension cords will reduce the input voltage (known as voltage drop) and this will void the warranty of your machine.

OPERATING ENVIRONMENT

- Operating temperature: -10°C~40°C.
- Transportation and storage: -25°C~55°C.
- Relative air humidity: 40°C ≤ 50%; 20°C ≤ 90%.
- The dust, acids, corrosive gases, and substance in the ambient air must be not higher than normal level.
- Altitude must be less than 1km.
- Good ventilation around the machine, at a distance of at least 50cm around.
- Power source must be kept on a level surface to reduce the risk of the machine falling.

MACHINE LAYOUT

1. Positive Terminal
2. Negative Terminal
3. Polarity Cable

INSIDE – WIRE FEED COMPARTMENT

4. Spool Retaining Nut
5. Tension Adjuster
6. Tensioner Arm
7. Roller Retainer Bolt
8. Drive Roller
9. Inlet Guide Tube
10. Spool Brake Tensioner Spring

REAR PANEL

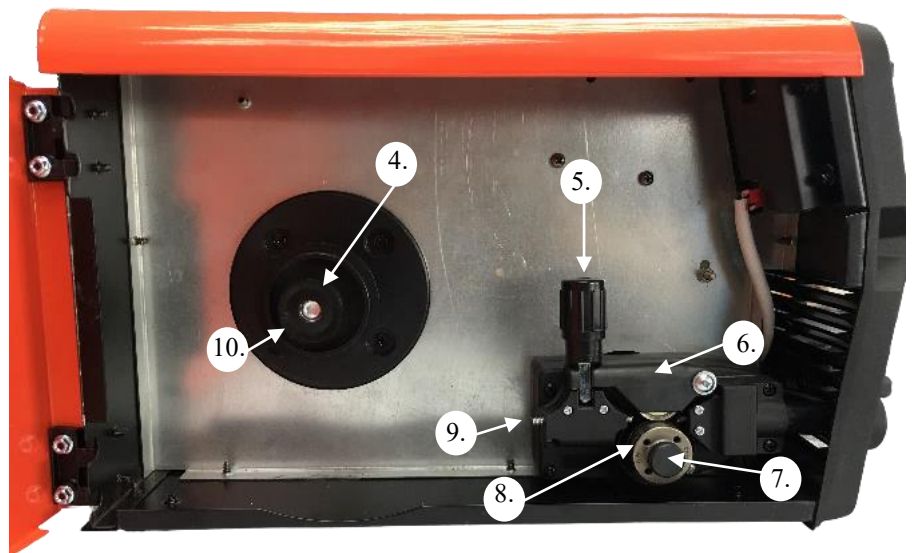
20. ON OFF Switch
21. 10amp 230-volt power cable
22. Shielding Gas Inlet.



REAR PANEL

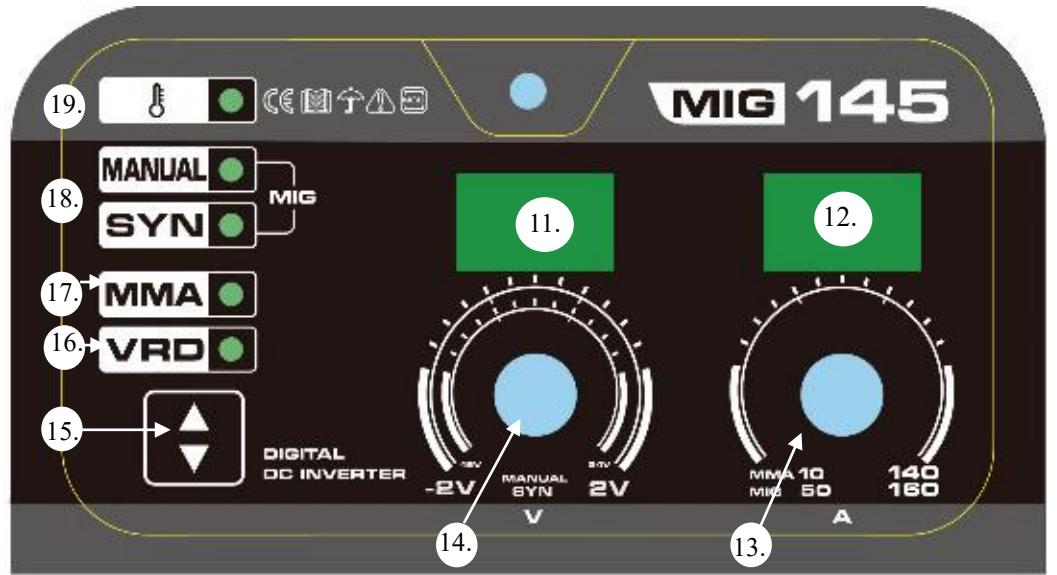


INSIDE – WIRE FEED COMPARTMENT



CONTROL PANEL LAYOUT

- 11. Voltage Display
- 12. Amperage Display
- 13. Amperage Control
- 14. Voltage Control
- 15. Welding Process selector
- 16. Voltage Reduction Device. (VRD)
- 17. MMA (Arc Welding).
- 18. MIG Synergic (SYN) or Manual
- 19. Thermal Overload Light



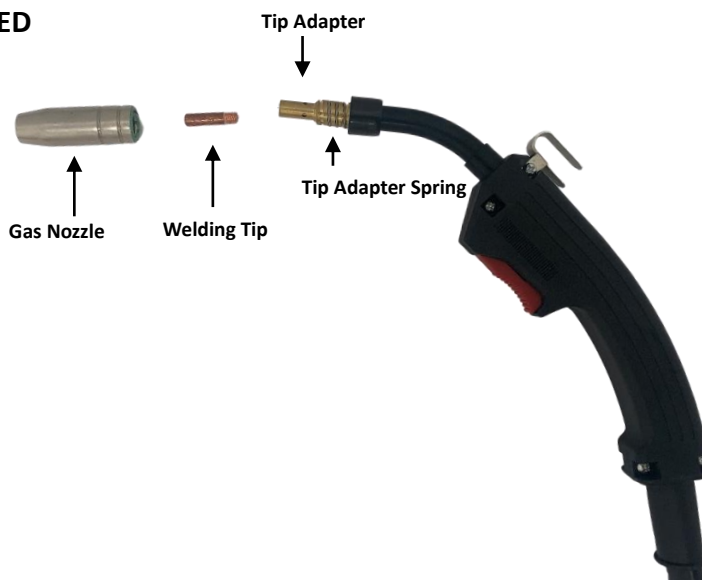
Earth Clamp and lead



Electrode Holder



MIG TORCH EXPLODED

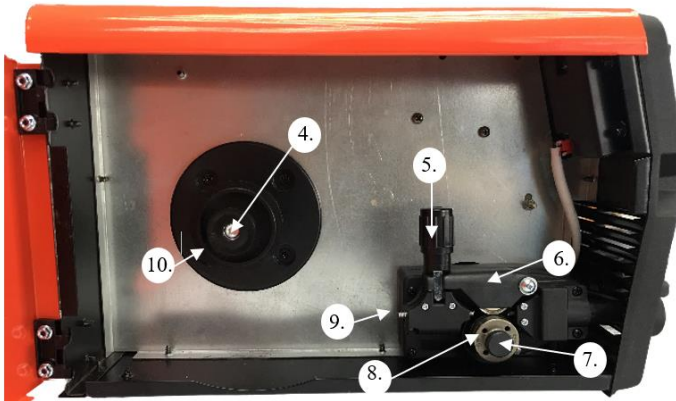


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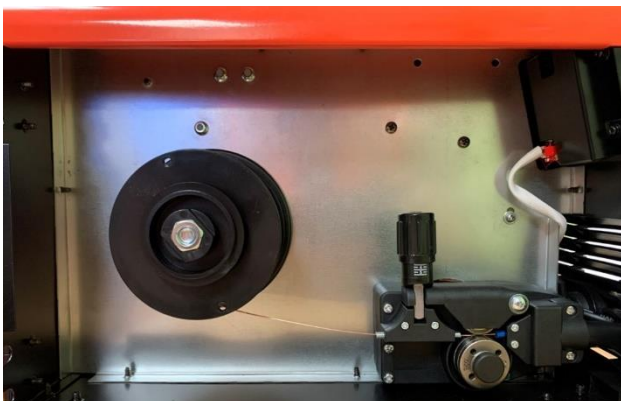
SETUP FOR GAS OR GASLESS MIG WELDING

Smooth consistent wire feed is critical to achieve professional results.

FITTING THE WIRE



- Open the side cover door for the wire feed compartment. Remove the wire spool retaining nut (4), tensioner spring and flange.

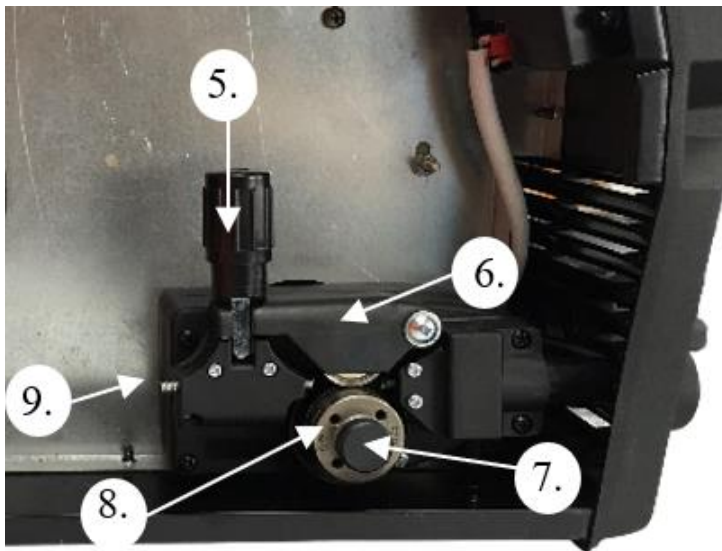


- Fit either the 5Kg/200mm or 1Kg/100mm diameter wire spool to the spool holder. Ensure the end of the wire feeds towards the drive rollers from the bottom of the spool.
- Align the wire spool flange, tensioner spring and tighten the retaining nut.

- Set the spool brake tensioner by tightening or loosening the wire spool retaining nut.
Set the spool brake tension so that the spool can rotate freely, without continuing to rotate once the wire feed stops.
Check performance from time to time to ensure that the wire is feeding correctly, especially as the wire spool empties.

WIRE FEEDER

- Release the wire feeder tensioner arm (6) by pulling forward the tension adjustment knob (5).
Check the drive roller matches the wire type and wire diameter (size is stamped on the side of the roller).
“V” groove roller for solid hard gas shield wires – Mild steel and Stainless Steel.
“Knurled” roller for gasless/flux core.
To change the roller, undo the roller retainer bolt (7), slide off the roller, replace with the correct roller making sure that the correct size groove lines up with the inlet guide tube (9). Tighten the retaining bolt anticlockwise, hand tight.
- Whilst holding the wire spool (this will prevent the spool uncoiling) carefully snip the wire and feed through the inlet guide tube (9), over the roller and into the torch liner, feeding the wire approximately 50mm into the torch liner as this will assist in feeding the wire through the torch.
- Align the wire into the groove of the roller and close the wire tensioner arm (6) and adjust the wire feed tensioner (5) making sure the wire remains in the groove.
- Adjust the wire feed tension (5) by turning clockwise to increase the tension and anti-clockwise to reduce. Do not over tighten the tension, the wire will be crushed – especially soft wires and flux cored wires.



SETUP FOR GASLESS MIG WELDING



Please ensure you have all relevant safety equipment and PPE ready.

- Check that the correct gasless (Flux cored) wire, drive roller (8) and welding tip are fitted.
- Connect Polarity cable (3) to the Negative Terminal (2).
- Connect Earth Lead to the Positive Welding Terminal (1).
- Connect Earth Clamp to the work piece. It is important the earth clamp makes strong contact with bare metal – remove paint, rust or other contaminants to ensure strong contact. Failure to do so will reduce your welding performance.



- Ensure the main power switch is in the **OFF** position. Plug the 10amp plug into the 10amp wall socket. Turn power to the **ON** position on both the wall socket and the power source. The front panel will illuminate, and the cooling fan will start.

MIG Synergic setup

- Select **MIG Synergic (18)** by pressing the welding process selector (**15**) the MIG SYN light will light up.
- Remove the welding nozzle from the torch in a clockwise twisting action (this ensures the tip adaptor spring remains tight) and then remove the welding tip, press and hold the trigger on the welding torch this will run the wire feed motor to push the wire through the torch. Once the wire comes out of the torch release the torch trigger stopping the wire feed motor.
- Reinstall the welding tip ensuring the correct tip is selected (same size as the wire or one size larger) and reinstall the nozzle again using a clockwise twisting action.
- Your MIG145 MIG synergic mode, removes the guess work out of selecting the right combination of VOLTAGE and WIRE SPEED. Once you have selected MIG Synergic increasing or decreasing dial (**13**) will adjust both the voltage (heat) and Amperage (wire speed m/min). The voltage will be displayed on voltage display screen (**11**) and your Amperage on the amperage display screen (**12**).
- Adjusting the synergic curve up or down will fine tune your welder's performance (finding the sweet spot). Turn the dial (**14**) clockwise this will increase **VOLTAGE only** (increasing heat to the weld pool but not wire speed), turning the dial anti-clockwise will reduce the **VOLTAGE only** cooling the weld pool (effectively increasing wire speed). Once you have found the sweet spot use dial (**13**) to adjust the welder for increased thickness on thinner plate.

MIG Manual setup

- To adjust your voltage and wire speed individually, select **MIG Manual** by pressing the Step selector (**15**).
- Remove the welding nozzle from the torch in a clockwise twisting action (this ensures the tip adaptor spring remains tight) and then remove the welding tip, press, and hold the trigger on the welding torch this will run the wire feed motor pushing the wire through the torch. Once the wire comes out of the torch release the torch trigger stopping the wire feed motor.
- Reinstall the welding tip ensuring the correct tip is selected (same size as the wire or one size larger) and reinstall the nozzle again using a clockwise twisting action.
- The voltage will be displayed on the voltage display screen (**11**) and your Amperage (wire speed) on the amperage display screen (**12**).

To increase or decrease voltage (heat), adjust the voltage adjustment dial (**14**) the higher the voltage the thicker the material and hotter the weld pool. To adjust the wire speed, turn the Amperage adjustment dial (**13**) to the required setting.

It is recommended that the welding voltage is first set and then slowly adjust the amperage (wire speed) until the arc is stable and smooth. Once this is achieved if the voltage is too high (hot – burning through) or too low (cold – lacking penetration) adjust the voltage again and repeat this process.

With your PPE on, you are ready to start welding. Ensure to adjust your settings to receive optimal results.

SETUP FOR GAS MIG WELDING



Please ensure you have all relevant safety equipment and PPE ready.

- Connect the optional **Weldco Argon Regulator (WDC0812)** to the argon cylinder or CO2 cylinder and connect the gas line to the regulator.
- Connect the gas line from the regulator to the gas inlet on the back panel of the welder.
- Open the valve on the cylinder and set your gas flow rate between 5-10L/min. It is good practice to test for leaks. Close the cylinder valve. If there are no leaks the regulator will maintain the set L/min and cylinder pressure values. Always turn off your cylinder valve when not in use.
- Check that the correct gas shield wire, drive roller (8) and welding tip are fitted.
- Connect Polarity cable (3) to the positive + welding output terminal (1).
- Connect Earth Lead to the negative - output welding terminal (2).
- Connect Earth Clamp to the work piece. It is important the earth clamp makes strong contact with bare metal – remove paint, rust or other contaminants to ensure strong contact. Failure to do so will reduce your welding performance.



- Ensure the main power switch is in the **OFF** position. Plug the 10amp plug into the 10amp wall socket. Turn power to the **ON** position on both the wall socket and the power source. The front panel will illuminate, and the cooling fan will start.

MIG Synergic setup

- Select **MIG Synergic (18)** by pressing the welding process selector (**15**) the MIG SYN light will light up.
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- Reinstall the welding tip ensuring the correct tip is selected (same size as the wire or one size larger) and reinstall the nozzle again using a clockwise twisting action.
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It is recommended that the welding voltage is first set and then slowly adjust the amperage (wire speed) until the arc is stable and smooth. Once this is achieved if the voltage is too high (hot – burning through) or too low (cold – lacking penetration) adjust the voltage again and repeat this process.

With your PPE on, you are ready to start welding. Ensure to adjust your settings to receive optimal results.



Warning!

Please check your argon cylinder valve is closed after every use.

Never leave your machine running unattended.

SETUP FOR MMA (STICK) WELDING



Please ensure you have all relevant safety equipment and PPE ready.

This setup is for the most common **electrode positive** setting for General purpose rods. Please check your electrode packaging to confirm.

- Connect the **earth clamp cable** into the – **NEGATIVE (3)** terminal on the front of the machine. Connect the Earth clamp to the work piece. It is important the earth clamp makes strong contact with bare metal – remove paint, rust or other contaminants to ensure strong contact. Failure to do so will reduce your welding performance.
- Connect the **electrode holder cable** into the + **POSITIVE (2)** terminal on the front of the machine.

Ensure that the plug is secure in the socket to reduce any chance of arcing from loose connection

- With the main power switch is in the **OFF** position. Plug the 10amp plug into the 10amp wall socket. Turn power to the **ON** position on both the wall socket and the power source. The front panel will illuminate, and the cooling fan will start.



- Once the machine has powered up press the welding process selector (11) to select MMA.
- Your Weldco Inverter welder is fitted with a “Voltage Reduction Device” (VRD) (16)
The VRD reduces the open circuit voltage to safer levels. The VRD default is **OFF**. To activate the VRD press the welding process selector (15) to select VRD.
- Adjust the welding current to the relevant level for the welding electrode type and size, as per the electrode manufacturer by adjusting the amperage adjustment dial (13).
- Insert the electrode into the electrode holder. Once the electrode contacts the work piece (also any metal connected to the work piece) the electrode will strike an arc, for this reason do not rest the fitted electrode on the work area.
- With your PPE on, strike the work piece with the electrode (like striking a match) hold the electrode slightly off the work piece to maintain a constant arc.
- To stop the weld, quickly lift the electrode from the work piece (stopping the electrical circuit).
- It is important to chip away the “SLAG” before continuing to weld and for weld inspection, Allowing the weld to cool slightly will make “SLAG” removal easier. It is important to wear eye protection whilst removing the “SLAG”.

MAINTENANCE

- The major difference between an inverter arc welder and traditional welder is the inverter welder has a lot of advanced electronic components. Repair of this product can only be carried out by **Approved Weldco Technicians**.
- As part of general use, the user must carry out all pre-checks and ensure that the welder is maintained. Where the machine is in contact with dust or contaminants, these must be cleaned off regularly. In dusty environments the power source will need to be blown down from time to time with dry compressed air at a suitable level. The machine must not be plugged in when this happens, all care and responsibility must always be maintained to those in the surrounding area.
- All accessories and leads must be inspected regularly by the user. Any repairs must be done by **Approved Weldco Technicians**.



Warning!

Due to high voltage in the main circuit of the welder, DO NOT remove the cover except for Approved Weldco Technicians. Failure to do so could result in electrocution leading to injury or death.

WARRANTY

Your Weldco power source is covered by Weldco's 24-month warranty covering faulty materials and manufacturing.

During this time should your Weldco power source fail please contact your authorized Weldco distributor.

This warranty does not cover freight or goods serviced by un-authorized personnel.

Weldco NZ will inspect your power source for faulty material or workmanship and will only be replaced if repair is not possible.

Note: The warranty is for the power source only. Leads and accessories are consumables and only replaced for failures due to materials and manufacture.

TROUBLESHOOTING

POWER SUPPLY

Part	Check	Remarks
Control panel	Operation, replacement, and installation of Switch.	If no power, see approved service agent.
	Switch on the power and check if the power indicator is on.	
Fan	Check if the fan is functioning and the sound generated is normal.	If the fan does not work or the sound is abnormal. See approved service agent.
Power supply	Switch on the power supply and check if abnormal vibration, heating of the case of this equipment, variation of colors of case or buzz presents.	
Other parts	Check if gas connection is available, case, and other joints are in good connection.	

WELDING TORCH

Part	Check	Remarks
Nozzle	Check if the nozzle is fixed firmly and no distortion of the tip exists.	Possible gas leakage occurs due to the unfixed nozzle.
	Check if there is spatter sticking on the nozzle.	Spatter possibly leads to the damage of torch. Use anti-spatter to eliminate the spatter.
Contact tip	Check if the contact tip is fixed firmly.	Unfixed contract tip can lead to unstable arc.
	Check contact tip is within working tolerances.	The physically incomplete contact tip can lead to unstable arc and arc automatically terminating.
Torch liner	Check torch liner can take selected diameter wire	Disagreement of the diameters of wire and wire feed tube possibly leads to the unstable arc. Replace it/them if necessary.
	Make sure that there is no bending or elongation of wire feed tube.	Bending and elongation of wire feed tube possibly leads to the unstable wire feed and arc. Replace it if necessary.
	Make sure that there is no dust or spatter accumulated inside the wire feed tube which makes the wire feed tub blocked.	If there is dust or spatter, remove it.
	Check if the wire feed tube is physically complete.	The Physically incomplete wire feed tube possibly leads to the excessive spatter. Replace the wire feed tube or O-shaped seal ring if necessary.

Diffuser	Make sure that the diffuser of required specification is installed and is unblocked.	Defection weld or even the damage of torch occurs due to the non-installation of diffuser or the unqualified diffuser.
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WIRE FEEDER

Part	Check	Remarks
Pressure adjusting handle	Check the tensioner adjustment dial is fixed and adjusted to the desired position.	The unfixed pressure-adjusting leads to the unstable welding output and can crush wire.
Wire-feeding hose	Check if there is dust or spatter inside the hose or beside wire-feeding wheel.	Remove the dust.
	Check if there is a diameter agreement of wire and wire-feeding hose.	Non-agreement of the diameter of wire and wire-feeding hose possibly leads to the excessive spatter and unstable arc.
	Check if rod and wire feeding groove are concentric.	Unstable arc possibly occurs.
Wire-feeding drive roller	Check if there is an agreement of wire diameter and wire-feeding wheel.	Non-agreement of wire diameter and wire-feeding wheel possibly leads to the excessive spatter and unstable arc.
	Check if the wire groove is blocked.	Replace it if necessary.
Pressure adjusting wheel	Check if the pressure adjusting wheel can rotate smoothly, and it is physically complete.	Unstable rotation or physically incompleteness of the wheel possibly leads to unstable wire feeding and arc.

CABLES

Part	Check	Remarks
Torch cable	Check if the cable of torch is twisted.	The twisted torch cable leads to unstable wire feeding and arc.
	Check if the coupling plug is in loose connection.	
Output cable	Check if the cable is physically complete.	Relevant measures should be taken to obtain stable weld and prevent the possible electric shock.
	Check if insulation damaged or loose connection exists.	
Input cable	Check if the cable is physically complete.	
	Check if insulation damage or loose connection exists.	
Earth cable	Check if the earth cables are well fixed and not short-circuited.	Relevant measures should be taken to prevent the possible electric shock.
	Check if this welding equipment is well grounded.	



Warning!

Protect the machine from rapid power switching. When the machines senses that the power is turned on and off rapidly the unit will turn off. The power indicator light will not turn on. Allow the machine to rest for a few minutes and normal operation should continue.

If this does not rectify the issue, please contact your approved WELDCO Technician.

NOTES

NOTES

NOTES

WELDCO NEW ZEALAND

Christchurch 8024

New Zealand

www.weldco.co.nz

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