



# INSTRUCTIONS FOR: INVERTER MIG TIG & MMA WELDER 200A with LCD SCREEN

MODEL No: **INVMIG200LCD**

Thank you for purchasing a Sealey product. Manufactured to a high standard, this product will, if used according to these instructions and maintained properly, give you years of trouble free performance.

**IMPORTANT:** PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS & CAUTIONS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY. KEEP THESE INSTRUCTIONS SAFE FOR FUTURE USE.



Refer to Instruction  
Manual



Wear protective  
gloves



Warning:  
Fumes & Gases



Warning:  
Electric Shock



Warning:  
Fire Risk



Warning:  
Arc Rays



Warning:  
Magnetic Fields



Warning:  
Crushing of  
Hands

## 1. SAFETY

### 1.1. ELECTRICAL SAFETY

- WARNING!** It is the responsibility of the owner and the operator to read, understand and comply with the following:  
You must check all electrical products, before use, to ensure that they are safe. You must inspect power cables, plugs, sockets and any other connectors for wear or damage. You must ensure that the risk of electric shock is minimised by the installation of appropriate safety devices. A Residual Current Circuit Breaker (RCCB) should be incorporated in the main distribution board. We also recommend that a Residual Current Device (RCD) is used. It is particularly important to use an RCD with portable products that are plugged into a supply which is not protected by an RCCB. If in any doubt consult a qualified electrician. You must also read and understand the following instructions concerning electrical safety.
- 1.1.1. The **Electricity at Work Act 1989** requires that all portable electrical appliances, if used on business premises, are tested by a qualified electrician, using a Portable Appliance Tester (PAT), on a regular basis.
- 1.1.2. The **Health & Safety at Work Act 1974** makes owners of electrical appliances responsible for the safe condition of those appliances and the safety of the appliance operators. **If in any doubt about electrical safety, contact a qualified electrician.**
- 1.1.3. Ensure that the insulation on all cables and on the appliance is safe before connecting it to the power supply. See 1.1.1. and 1.1.2. and use a Portable Appliance Tester.
- 1.1.4. Ensure that cables are always protected against short circuit and overload.
- 1.1.5. Inspect power supply cables and plugs regularly for wear or damage and check all connections to ensure that none are loose.
- 1.1.6. Important: Ensure that the voltage marked on the appliance matches the power supply to be used and that the supply is correctly fused.
- 1.1.7. **DO NOT** pull or carry the appliance by the power cable.
- 1.1.8. **DO NOT** pull the plug from the socket by the cable.
- 1.1.9. **DO NOT** use worn or damaged cables, plugs or connectors. Have any faulty item repaired or replaced immediately by a qualified electrician.
- 1.1.10 **To achieve maximum output INVMIG200LCD will require a 32A fused supply. We recommend you discuss the installation of an industrial round pin plug and socket with a competent electrician.**

### 1.2. GENERAL SAFETY

- DANGER! Unplug the welder from the electric power supply before performing maintenance or service.**
- Keep the welder and cables in good condition. Take immediate action to repair or replace damaged parts.
- Use genuine parts and accessories only. Unapproved parts may be dangerous and will invalidate the warranty.
- Use an air hose to blow out any dirt from the liner regularly and keep the welder clean for best and safest performance.
- Check and spray the gas cup and contact tip regularly with anti-spatter spray, which is available from your Sealey dealer.
- Locate the welder in a suitable work area. Ensure that the area has adequate ventilation as welding fumes are harmful.
- Keep work area clean, tidy and free from unrelated materials. Also ensure that the work area has adequate lighting and that a fire extinguisher is to hand.
- WARNING! Use a welding head shield to protect eyes and avoid exposing skin to ultraviolet rays given off by electric arc. Wear safety welding gauntlets.**
- Remove ill fitting clothing, remove ties, watches, rings and other loose jewellery and contain long hair.
- Ensure that the workpiece is secured correctly before operating the welder.
- Avoid unintentional contact with workpiece. Accidental or uncontrolled use of the torch may be dangerous and will wear the nozzle.
- Keep unauthorised persons away from the work area. Any persons working within the area must wear protective head shield and gloves.
- Operators must receive adequate training before using the welder.
- Stand correctly, keeping a good footing and balance, and ensure that the floor is not slippery. Wear non-slip shoes.
- Turn machine OFF when not in use.
- DO NOT** operate the welder if it or its cables are damaged and **DO NOT** attempt to fit any unapproved torch or other parts to the welder unit.
- DO NOT** get welder wet or use in damp or wet locations or areas where there is condensation.
- DANGER! DO NOT weld near flammable materials, solids, liquids, or gases, and DO NOT weld containers or pipes which have held such products. Avoid operating on materials cleaned with chlorinated solvents or near such solvents.**
- DO NOT** stand welder on a metal workbench, car bodywork or similar object.
- DO NOT** touch any live metal parts of the torch or electrode while the machine is switched on.
- DO NOT** pull the welder by the cable or the torch and **DO NOT** bend or strain cables. Protect cables from sharp or abrasive items and **DO NOT** stand on them. Protect from heat. Long lengths of slack must be gathered and neatly coiled. **DO NOT** place cables where they could endanger other people.
- DO NOT** touch the torch or workpiece immediately after welding as they will be very hot. Allow to cool.
- DO NOT** operate welder while under the influence of drugs, alcohol or intoxicating medication, or if tired.
- When not in use store the welder in a safe, dry, childproof area.

**1.3. GAS SAFETY**

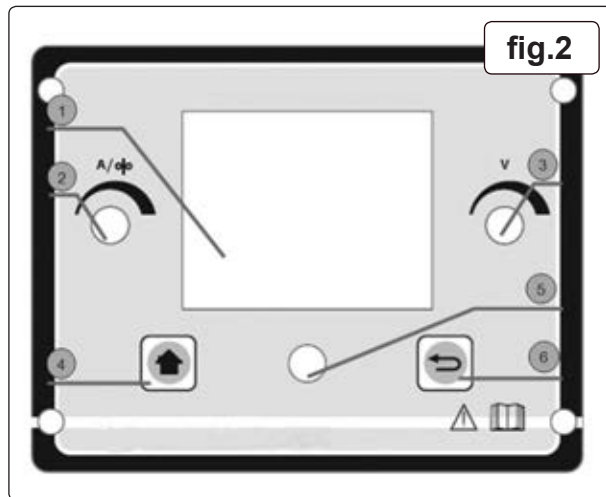
- ✓ Store gas cylinders in a vertical position only and ensure that the storage area is secured correctly.
- x **DO NOT** store gas cylinders in areas where temperature exceeds 50°C. **DO NOT** use direct heat on a cylinder. Always keep gas cylinders cool.
- x **DO NOT** attempt to repair or modify any part of a gas cylinder or valve and **DO NOT** puncture or damage a cylinder.
- x **DO NOT** obscure or remove any official cylinder labels. Always check the gas identity before use. Avoid getting gas cylinders oily
- x **DO NOT** lift a cylinder by the cap, guard or valve. Always keep caps and guards in place and close valve when not in use.

**2. INTRODUCTION**

Manufactured with a pressed steel outer casing, lighter than traditional models at 20kg. Fully functional LCD front panel with easy to follow assisted set up. Inverter technology offers many advantages over traditional transformer type welders, giving greater duty cycles and more power factor efficiency. 3-in-1 Welder uses state-of-the-art technology to achieve MIG/TIG/MMA (Arc). Suitable for arc welding a variety of rods including rutile, basic and stainless from Ø1.6 to Ø4mm. Fan cooled DC power supply for MIG and TIG, suitable to weld steel, stainless steel, copper, nickel, titanium and their alloys. Switchable between MIG, TIG\* or MMA\* welding modes (\*optional extra torches required). Thermal overload warning tells you to switch off when it exceeds maximum temperature. Wire feed control for adjusting speed of wire fed through the torch during welding. Polarity change terminals allow for MIG or flux-cored welding. Includes 3mtr MIG torch, 3mtr earth cable, gas hose, regulator and 0.6, 0.8, 0.9, 1mm contact tips.

**3. SPECIFICATION**

|                                     |                             |
|-------------------------------------|-----------------------------|
| Model No: .....                     | INVMIG200LCD                |
| Duty Cycle:MIG: .....               | 20% @200A, 100% @89A        |
| TIG: .....                          | 20% @180A, 100% @80A        |
| MMA (Arc): .....                    | 20% @180A, 100% @80A        |
| Wire Capacity: .....                | .5kg                        |
| Electrode Capacity: .....           | Ø1.6-4mm                    |
| Absorbed Power: .....               | 8.6kW                       |
| Supply: .....                       | 230V                        |
| Insulation: .....                   | IP21S                       |
| Protection: .....                   | H                           |
| Weight: .....                       | 20kg                        |
| MIG Torch: .....                    | Euro Non-Live BINZEL® MB15* |
| MMA Accessory Kit (Optional): ..... | MMA01                       |
| TIG Accessory Kit (Optional): ..... | TIG10S                      |
| Note: .....                         | *Included as standard       |



**KEY TO FUNCTION SELECTORS (fig.2)**

- 1) LCD: Displays function settings
- 2) Left adjustment control: Adjusts the current and wire feed speed accurately.
- 3) Right adjustment control: Adjusts the voltage accurately.
- 4) Home key: Press to return to home page.
- 5) Multi-function adjustment control: Selects functions; press to confirm.
- 6) Return: return to the previous step.

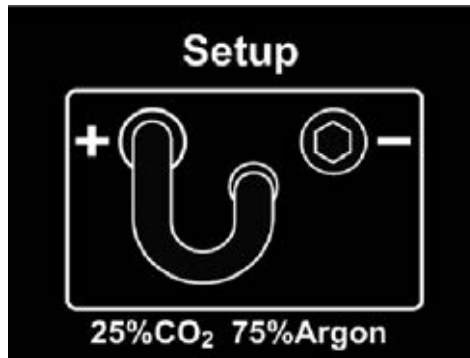
**3.1. Interface descriptions**

Switch machine on with the switch at the rear of the casing.

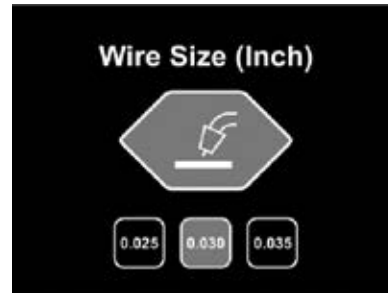
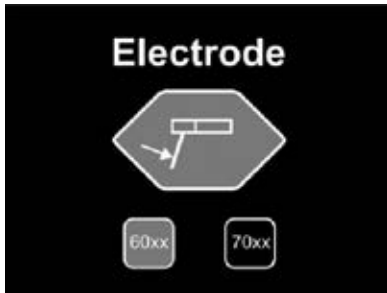
- 3.1.1. Multi-function selector: Total 9 functions, 8 welding functions and 1 setting. Turn multi-function control (fig.1.5) to select: press to confirm setting.



3.1.2. **Output setup:** Shows output connections and recommended gas mixture under different welding mode, press multi-function control to confirm.



3.1.3. **Electrode/ Wire diameter selection:** Adjust multi-function control to select different electrode/wire diameter, press to confirm.



3.1.4. **Material thickness:** Adjust multi-function control to select different material thickness, press to confirm



3.1.5. **Welding display:** Shows all selected parameters.

a) When MIG welding, wire speed and voltage can be set. Adjust Multi-function control to set electro-inductance, press the control to progress basic parameter setting.



**Note 1:** Basic parameter setting including: gas pre flow, wire speed, gas post flow, trigger settings, load and save function.

**Note2:** The green range of current and voltage shows recommended parameters.

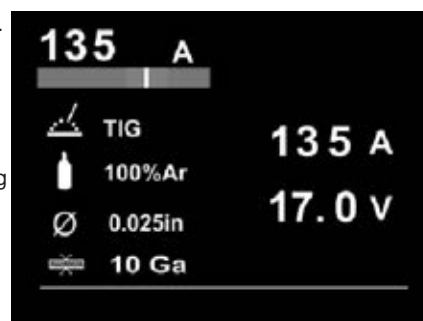
b) When TIG welding, user can set current parameter;

#### Trigger settings

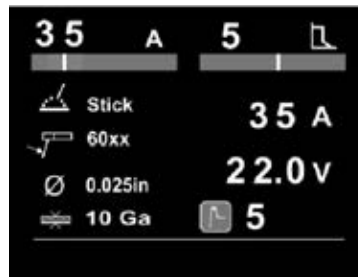
Spot: gives one pulse of current: may be set from 0.5sec to 9.9 sec.  
 2 touch: current flows as long as the trigger is pressed.  
 4 touch: click and release to turn on, click and release to turn off.

#### Load and save

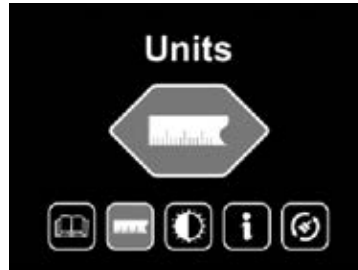
Up to four settings may be stored by entering the load and save page and selecting 'save'. The settings can be recalled by re-visiting the page.



c) When Stick welding, user can set current, arc force parameter and hot start.



3.1.6. **Setting interface:** shows language setting, units setting, light setting, information and recover setting.



3.1.7. **Alarm interface:** shows the machine is overloaded and the internal temperature is too high. Weld output will turn off automatically but the fan will still be working. When the internal temperature is decreased, the alarm interface will turn off and the machine will be ready to weld.



## 4. PREPARATION

### 4.1. GAS SUPPLY

4.1.1. **ATTACHING THE REGULATOR.** (fig.3) Whichever gas you are using it is advisable to 'crack' the cylinder valve before attaching the regulator. This means opening and closing the valve very quickly in order to blow away any dust and dirt that may have accumulated in the gas outlet. Stand to one side whilst doing this.

4.1.2. **CO<sub>2</sub> GAS.** Ensure that the threads on the gas bottle are undamaged and free of oil and grease before attaching the regulator. (Oil or grease in the presence of high pressure gases can be explosive.) Ensure that the regulator has an undamaged gasket fitted. The regulator will screw directly to the threads on the gas bottle. Tighten with a wrench.

4.1.3. **ARGON GAS OR ARGON MIXTURES.** Cylinders containing argon gas and argon mixtures have a female thread and will require the use of a Bull Nose Adaptor to attach the regulator to the cylinder as indicated in fig.3. Ensure that the threads on the gas bottle are undamaged and free of oil and grease before attaching the regulator. (Oil or grease in the presence of high pressure gases can be explosive.) Fit the Bull Nose Adaptor to the cylinder first and tighten with a wrench.

4.1.4. Slide a hose clip over each end of the gas hose supplied. Push one end of the hose onto the regulator outlet and the other end over the gas inlet spigot on the back of the welder. Tighten the clips to ensure a good seal.

4.1.5. Close the regulator valve by turning it anticlockwise before opening the cylinder valve. Stand to one side when opening.

4.1.6. Set the regulator flow rate to 5-8 litres/min depending on the material to be welded, and whether there are draughts which are strong enough to disturb the gas flow.

4.2. **CONNECTING THE TORCH CABLE TO THE WELDER.** Align the pins on the Euro connector with the socket on the welder front panel as shown in fig.4. Push the connector into the socket and rotate the locking ring (A) clockwise so that it draws the plug into the socket as shown in fig.5.

Note: damage to torches and cables is not covered by warranty.

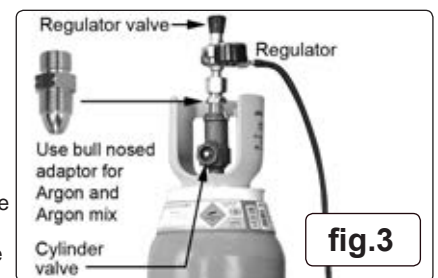


fig.3

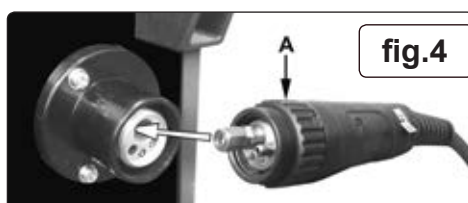


fig.4



fig.5

4.3. **FITTING A REEL OF WIRE (FIG.6).** INVMIG200LCD will accept up to a 5kg reel of wire. Ensure that the wire diameter used is matched by the correct groove size in the drive wheel and the correct tip size on the torch as well as the correct torch liner. Failure to do this could cause the wire to slip and/or bind.

4.3.1. Remove the retaining control (D) from the end of the spindle (A) by turning the control 90° anticlockwise and pulling it outwards. Remove the spring (C) and the retaining disc (B) from the end of the spindle also. Slide the reel of wire over the spindle and hold it against the back plate so that the hole in the reel rests on the flange (E). Ensure that the wire is coming off the top of the reel in the direction of the wire drive unit as shown in fig.7.

4.3.2. Retain hand pressure on the reel to keep it on the flange and slide the retaining disc (B) over the end of the spindle and into the hole in the reel. Note that the disc (B) has a hexagonal hole in it which fits onto the hexagonal portion of the spindle. Keep the disc under hand pressure to retain the reel. Place the spring (C) over the spigot of the retaining control (D). Match the indented end of the spigot to the hole in the end of the spindle. Push the control spigot into the end of the spindle, against spring pressure and turn it through 90° to lock it in place.

4.4. **FEEDING WIRE THROUGH TO TORCH.** Open the wire feed mechanism by pushing the locking/wire tension control (fig.8.1) down to the left allowing the pressure roller carrier (fig.8.2) to spring up revealing the feed roller. Ensure that the required feed groove (0.6 or 0.8) is in line with the wire path. See Section 4.6. on how to reverse or change the roller.

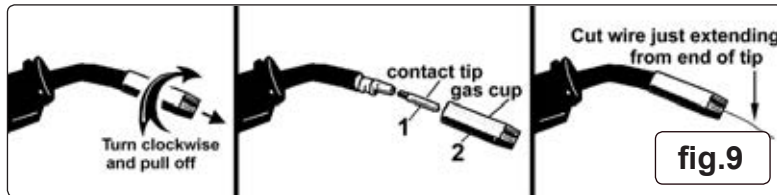
4.4.1. Release the wire from the reel and cut off any bent portion ensuring that there are no burrs left on the end of the wire. **Keep the wire under tension at all times to prevent it uncoiling.**

4.4.2. Straighten about 40-50mm of wire and push it gently through the flexible metal sheathed cable (fig.8.3) and through the 0.6mm or 0.8mm feed roller groove and on into the torch cable liner.

4.4.3. Push down the pressure roller carrier onto the wire feed roller and hold it down. Lift up the locking/wire tension control so that it enters the slot in the pressure roller carrier and snaps into the indent in its top surface (fig.8). Rotate the tension control to a medium setting i.e. between 2 and 3.

4.4.4. Remove gas cup (fig.9.2) and contact tip (fig.9.1) from end of torch as follows:

- Take torch in left hand with the torch tip facing to the right.
  - Grasp gas cup firmly in your right hand.
  - Turn gas cup clockwise only and pull it off end of torch tip.
- ⚠ **WARNING!** do not turn gas cup anti-clockwise, as this will damage the internal spring.
- Unscrew copper contact tip (right hand thread) to remove.



4.4.5. Check welder is switched off and that the earth clamp is away from the torch tip. Connect the welder to the mains power supply and select the MIG setting by means of the multi-function control.

4.4.6. Set the voltage control (fig.2.3) to minimum

4.4.7. Set the wire speed control (fig2.2.) to minimum. Keep the torch cable as straight as possible and press the torch switch. The wire will feed through the torch.

4.4.8. a) Take torch in left hand, slide the contact tip over the wire and screw back into place.  
b) Grasp gas cup in right hand, push onto torch head and turn clockwise only. Do not turn gas cup anti-clockwise, as this will damage the internal spring.  
c) Cut wire so that it is just protruding from the cup.

4.5. **SETTING WIRE TENSION.** Adjust the wire tension by rotating the wire tension control. Turn clockwise to increase the tension and anticlockwise to decrease the tension. See fig 10.1.

**IMPORTANT:** Too little or too much tension will cause wire feed problems and result in poor welding.

4.5.1. Tension between rollers is checked by slowing down the wire between gloved fingers. If top feed roller skids the tension is correct. Use as low a tension as possible; too high a tension could crush the wire and result in a blown fuse.

4.6. **TURNING/CHANGING THE DRIVE ROLLER.** (See figs.8 and 11.)

Ensure that the wire diameter (0.6/0.8mm) used is matched by the correct groove size in the drive wheel and the correct tip size on the torch as well as the correct torch liner. Failure to do so could cause the wire to slip and/or bind.

4.6.1. Referring to fig.8, open the wire feed mechanism by pushing the locking/wire tension control (1) down to the left allowing the pressure roller carrier (2) to spring up revealing the feed roller.

4.6.2. Referring to figure 11, move control (C) and put to one side.

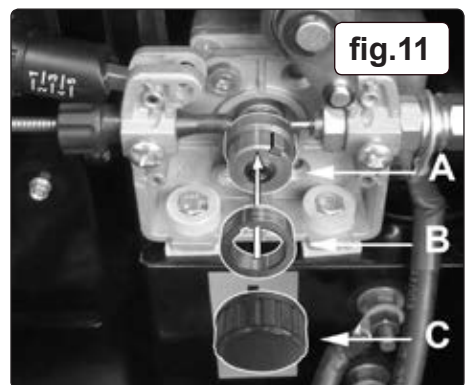
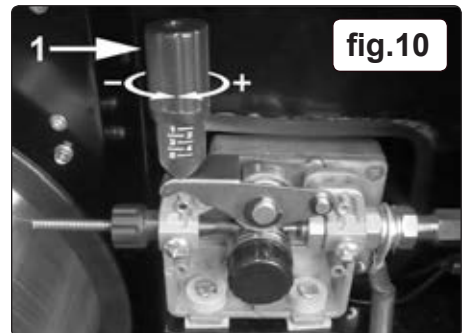
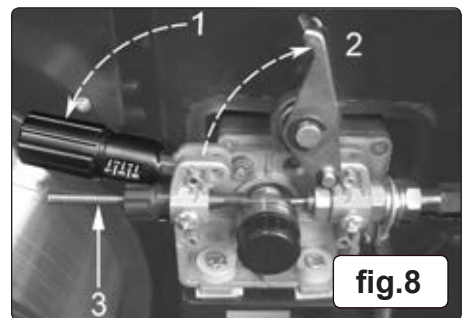
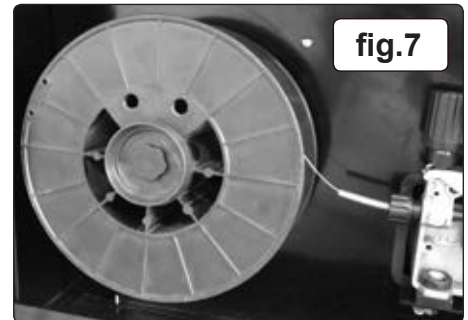
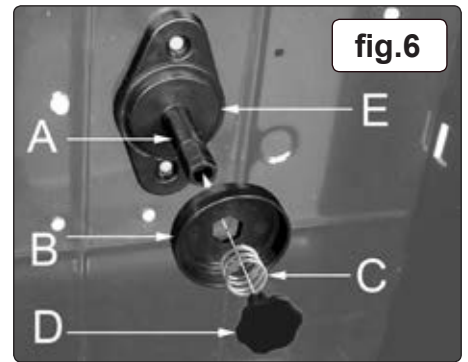
4.6.3. The roller carrier (A) is keyed to the main drive shaft and the drive roller (B) is keyed to the carrier, see below. Place a finger onto the end of the drive shaft to prevent the carrier moving and slide the drive roller off the carrier with your other hand.

4.6.4. The size of each wire feed groove is printed on the edge of the roller on the same side as the groove.

4.6.5. Turn the roller over to use the other groove or use a roller with different sized grooves as required. The groove to be used should be positioned furthest away from you to be in line with the drive path.

4.6.6. Check that the key in the carrier (A) is seated properly in its slot. Ensure that the slot on the inside face of the drive roller (B) is aligned with the key and slide the roller back onto the carrier.

4.6.7. Screw the black roller retaining control (C) back on to the end of the drive shaft and tighten.



#### 4.7. CONVERTING TO GASLESS WELDING.

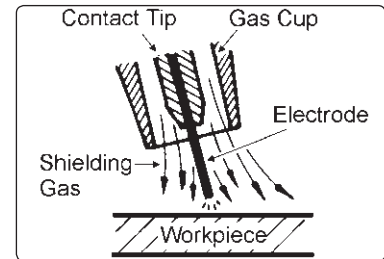
- 4.7.1.. To weld without gas (using flux cored wire) the power input lead (fig.1.9) must be connected to the negative (-) terminal and the earthing cable to the positive (+) terminal (fig.13).  
Ensure that the machine is switched off and unplugged from the mains supply before carrying out this task.
- 4.7.2. Disconnect the gas safely.
- 4.7.3. Fit a 1.0mm tip to the torch.
- 4.7.4. Mount the flux cored wire reel and feed it through to the torch.
- 4.7.5. Use the multi-function selection control to navigate to the flux cored wire setting. Press to confirm.



## 5. MIG/MAG WELDING

A spool of welding wire is positioned on the welder's spool holder and automatically fed through an insulated liner in the torch to the tip. The torch assembly consists of a switch, liner, gas hose, and control cable. The switch activates the wire feed roller and the gas flow. Conversely, releasing the switch stops the wire feed and gas flow. The weld current is transferred to the electrode (the wire) from the contact tip at the end of the torch. A gas cup fits over the contact tip to direct the gas flow towards the weld ensuring that the arc welding process is shielded from oxidising air contaminants. The shielding gas also assists heating of the weld materials. (The welder can also be used in gasless mode using flux cored wire). The torch is connected to the positive side of a DC rectifier, and the negative clamp is attached to the workpiece.

**IMPORTANT: Should you have no welding experience, we recommend you seek training from an expert source to ensure your personal health & safety. Good MIG welding may be achieved only with continued, supervised practice.**



### 5.1. PREPARATION FOR WELDING

**IMPORTANT: BEFORE YOU COMMENCE, MAKE SURE THE MACHINE IS DISCONNECTED FROM THE ELECTRIC SUPPLY. IF WELDING A MOTOR VEHICLE, DISCONNECT THE BATTERY OR FIT AN ELECTRONIC CIRCUIT PROTECTOR. WE RECOMMEND STRONGLY THE USE OF SEALEY "PROSAF/12V OR 24V" IN ORDER TO PROTECT SOPHISTICATED ELECTRONICS. ENSURE THAT YOU HAVE READ & UNDERSTOOD THE ELECTRICAL SAFETY INSTRUCTIONS IN SECTION 1.**

- 5.1.1. Clean the area to be welded: remove any oxidation, grease and paint, if necessary, grind the area to a bright finish.

- 5.1.2. **Mode:** Select required mode via the multi-function adjustment control (fig.2.5).

A second press will show the required earth and torch connections and the recommended gas ratio.

- 5.1.3. Subsequent presses will allow the electrode diameter and material thickness to be entered, using the multi-function control.

- 5.1.4. Having set the material thickness, a further press of the multi-function control will bring up the default welding settings.

The voltage and wire speed may be adjusted by use of the right and left adjustment controls (fig.2.2/2.3).

**NOTE:** The recommended settings are shown by the green sector of the display. Inappropriate settings are denoted by the voltage and wire feed numerals turning red.

### 5.2. Aluminium welding

- 5.2.1. To weld aluminium use:

- Argon gas,
- 0.8mm Contact Tip (MIG927),
- 0.8mm Aluminium Wire, (MIG/2KAL08).

A clean torch liner is essential, as any contamination of the aluminium wire will produce a poor weld.

- 5.2.2. Using the multi-function selection control, enter the aluminium welding pages, and follow the on-screen instructions as in 5.1.

**NOTE:** Arc welding cables are not supplied with this machine. Sealey part no: MMA01 is suitable.

- WARNING! Ensure that the inverter is not plugged into the mains power supply before connecting or disconnecting cables. For electrical installation, see Safety Instructions (Section 1).**

- 6.1. Using the multi-function selection control, enter the stick welder pages, and follow the on-screen instructions as in 5.1.

- 6.1.1. Observe the location of the torch and earth cables and connect accordingly.

- 6.2. Enter the electrode type (60xx or 70xx), diameter and material thickness when prompted.

- 6.3. The welding current and gas post flow may be adjusted from the default settings in this mode.

## 7. TIG WELDING

- WARNING! Ensure that the inverter is not plugged into the mains power supply before connecting or disconnecting cables. For electrical installation, see Safety Instructions (Section 1).**

- 7.1. Using the multi-function selection control, enter the TIG welder pages, and follow the on-screen instructions as in 5.1.

- 7.1.1. Observe the location of the torch and earth cables and connect accordingly.

- 7.2. Enter the tungsten electrode diameter and material thickness when prompted.

- 7.3. The welding current may be adjusted in this mode.

## 8. RATINGS PLATE

The ratings plate on the inverter gives the following data:

- 1 - Rating of internal protection provided by casing.
- 2 - Symbol for power supply line: 1= Single-phase AC.
- 3 - Symbol for internal structure of the welding machine.
- 4 - Manufacturers Details and Model No.
- 5 - Manufacturers Serial Number for welding machine identification.
- 6 - MIG Output.
- 7 - MMA Output
- 8 - TIG` Output
- 9 - Power Supply  
 $U_1$ : Alternating voltage and power supply frequency of welding machine. (allowed limit  $\pm 10\%$ )  
 $I_{1\max}$ : Maximum current absorbed by the line.  
 $I_{1\text{eff}}$ : Effective current supplied.
- 10 - Duty Cycle  
 $U_0$ : Maximum no load voltage.  
 $I_2, U_2$ : Current and corresponding normalised voltage that the welding machine can supply during welding.  
 X: Welding ratio based on a 10 minute duty cycle. 20% indicates 2 minutes welding and 8 minutes rest, 100% indicates continuous welding.
- 11 - The EUROPEAN standard relating to the safety and construction of arc welding machines.

|          |                   |                                |        |        |
|----------|-------------------|--------------------------------|--------|--------|
| MODEL: ④ |                   | NO: ⑤                          |        |        |
| ③        |                   | EN 60974-1 ⑪                   |        |        |
| ⑥        | MIG               | 40 A / 16 V - 200 A / 24 V     |        |        |
|          | MMA               | 10 A / 20.4 V - 180 A / 27.2V  |        |        |
|          | TIG               | 10 A / 10.4 V - 180 A / 17.2 V |        |        |
|          | X                 | 20 %                           | 100 %  |        |
| ⑧        | MODE              | MIG                            | MMA    | TIG    |
|          | $I_2$             | 200 A                          | 180 A  | 180 A  |
| ⑨        | $U_2$             | 24 V                           | 27.2 V | 17.2 V |
|          |                   | 18.5 V                         | 23.2 V | 13.2 V |
| ②        | $U_1$             | 230 V (220-240 V)              |        |        |
|          | $I_{1\max}$       | 36 A                           |        |        |
| ①        | $I_{1\text{eff}}$ | 16 A                           |        |        |
|          | ⑩                 | IP21S                          |        |        |

## 9. DUTY CYCLE

When the machine reaches the end of its duty cycle and overheats, the thermostatic switch opens to allow the internal components to cool. This is denoted by the error page illuminating. Allow the machine to cool and resume use when the error warning clears.

## 10. MAINTENANCE

- 10.1. **WIRE FEED UNIT** Check the wire feed unit at regular intervals. The feed roller wire guide plays an important part in obtaining consistent results. Poor wire feed affects welding. Clean the rollers weekly, especially the feed roller groove, removing all dust deposits.
- 10.2. **TORCH** Protect the torch cable assembly from mechanical wear. Clean the liner from the machine forwards by using compressed air. If the liner is clogged it must be replaced.
- 10.3. **CHANGING FEED ROLLER** (See Section 4.6.)
- 11.4. **CONTACT TIP** The contact tip is a consumable item and must be replaced when the hole becomes enlarged or oval. The contact tip **MUST** be kept free from spatter to ensure an unimpeded flow of gas. Refer to fig.9 and section 4.4.4 for removal and replacement.
- 10.5. **GAS CUP** The gas cup must also be kept clean and free from spatter. Build up of spatter inside the gas cup can cause a short circuit at the contact tip which will result in either the fuse blowing on the printed circuit card, or expensive machine repairs. To keep the contact tip free from spatter, we recommend the use of Sealey anti-spatter spray (MIG/722308) available from your Sealey Dealer.
- 10.6. **REPLACING THE LINER** Wind the wire back on to the spool and secure it. Unscrew the torch from the machine and undo the brass nut. The liner should now be visible. Pull it out and replace with a new one.
- 10.7. Remove the casing periodically and, with a low pressure air flow (max 1bar or 15psi), remove dust from inside the machine.
- 10.8. Do not direct compressed air onto the electronic circuit boards, these should be cleaned with a very soft brush.
- 10.9. Ensure that all electrical connections are tight and check the wiring for damage to the insulation.
- 10.10. Ensure that the casing is correctly replaced and secured before attempting to use the inverter.
- 10.11. Keep the outside of the machine clean by wiping with a soft, dry cloth.  
**For any other service or maintenance, contact your local Sealey service agent.**

### ENVIRONMENT PROTECTION



Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.

### WEEE REGULATIONS



Dispose of this product at the end of its working life in compliance with the EU Directive on Waste Electrical and Electronic Equipment (WEEE). When the product is no longer required, it must be disposed of in an environmentally protective way. Contact your local solid waste authority for recycling information.

**Note:** It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice.

**Important:** No Liability is accepted for incorrect use of this product.

**Warranty:** Guarantee is 12 months from purchase date, proof of which is required for any claim.

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