

AWT®

MIG-200

**IGBT Inverter Welding Machine(GAS MIG, FLUX-CORED,
SPOOL GUN COMPATIBLE MIG, STICK, LIFT TIG)**



OPERATOR'S MANUAL

**READ AND UNDERSTAND ALL INSTRUCTIONS AND PRECAUTIONS BEFORE
PROCEEDING.**



The AWT MIG-200 WELDER is designed for hobbyist or the busy professional with the versatility to MIG, Stick or Lift TIG weld all from a single compact, space-saving and lightweight unit combined with self-sensing, dual-voltage capability for go anywhere convenience. The latest IGBT inverter technology produces the most stable arc possible and provides the capability of welding thin or heavy gauge steel with precision and ease. A powerful, 200 amp maximum welding output allows welding up to 15/64" thick steel.

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. AWT shall not be held liable for consequences due to deliberate or unintentional misuse of this product.

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1.PACKING



P14



P13



P12



P8

- 1.MIG-200 Welder
- 2.110V~220V Adapter Cord
- 3.Hose Band*2
- 4.Ground Clamp With 10'(3m) Cable
- 5.MIG Torch With 10'(3m) Cable (.030\"/>

2.SAFETY PRECAUTIONS - READ BEFORE USING



Protect yourself and others from injury — read, follow, and save these important safety precautions and operating instructions.

2.1 Symbol Usage



DANGER! Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.



Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

NOTICE – Indicates statements not related to personal injury.

2.2 Arc Welding Hazards



Welding can be dangerous to you and other persons in the work area. Read and understand this instruction manual before using your AWT welding machine. Injury or death can occur if safe welding practices are not followed. The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard.

Safety information is set forth below and throughout this manual.

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



ELECTRIC SHOCK CAN KILL

- The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not touch these “hot” parts with your bare skin or wet clothing.
- Always wear dry, protective clothing and leather welding gloves and insulated footwear. Use suitable clothing made from durable flame-resistant material to protect your skin.
- Always operate the Welder in a clean, dry, well ventilated area. Do not operate the Welder in humid, wet, rainy or poorly ventilated areas.
- Do not touch live electrical parts.
- Disconnect Welder from power supply before assembly, disassembly or maintenance of the torch, contact tip and when installing or removing nozzles.
- Frequently inspect input power cord and ground conductor for damage or bare wiring – replace immediately if damaged – bare wiring can kill.
- 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.



⚠ Fumes And Gases Can Be Hazardous

- Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health. Keep your head out of the fumes. Do not breathe the fumes.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator.
- Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
- Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel.



⚠ Arc Rays Can Burn Eyes And Skin

- Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.
- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes from arc rays and sparks when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.
- Wear body protection made from durable, flame-resistant material (leather, heavy cotton, wool). Body protection includes oil-free clothing such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.



⚠ Welding And Cutting 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 from the work area where welding sparks can reach (min. of 35 feet).
- Always keep a fire extinguisher nearby while welding.
- Use welding blankets to protect painted and or flammable surfaces; rubber weatherstripping, dash boards, engines, etc.
- Ensure power supply has properly rated wiring to handle power usage.



⚠ 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.



⚠ FLYING METAL or DIRT can injure eyes.

- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.



⚠ Hot Parts Can Burn

- Do not touch hot parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.



⚠ Buildup Of Gas Can Injure Or Kill.

- Shut off compressed gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.

⚠ CAUTION INADEQUATE WIRING CAN CAUSE FIRE AND INJURY!

- Verify that the facility power source has properly rated wiring to handle power requirements of this Welder.

2.3 Principal Safety Standards

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, is available as a free download from the American Welding Society at <http://www.aws.org>, or purchased from Global Engineering Documents(website: www.global.ihs.com).

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B, from National Fire Protection Association, Quincy, MA 02269 (website: www.nfpa.org).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, (website: www.osha.gov).

3.PRODUCT DESCRIPTION

3.1 FUNCTION OVERVIEW

Versatility

- Synergic MIG: Automatic matching of the voltage & wire feeding speed by adjusting wire diameter, material and gas.
- 6 in 1 Multi-functions: Gas MIG/Flux Cored/MMA /LIFT TIG/Spot welding/Spool Gun are available.
- 2T/4T: Realize wide application, easy welding and continuous long-term welding.
- Inductance Adjustment: Improve welding performance.
- Wire Feed Speed Adjustment: Meet your welding requirement.
- VRD: Reduce the risk of electric shock to ensure operator's safety.
- Dual Voltage: 110V/220V.
- Hot Start: Make the arc ignition in MMA welding easier and more reliable.
- Arc Force: Obviously improve the performance of the machine contribute to long-distance welding.
- Anti-stick: Improve welding performance to prevent stickiness.
- Post flow time at MIG mode.

3.2 PREMIUM FEATURE

Advanced IGBT Inverter Technology

- Inverting frequency of 42KHz greatly reduces the volume and weight of the welder.
- Great reduction in copper and iron loss obviously enhances the welding efficiency and energy saving effect.
- Switching frequency is beyond audiorange, which almost eliminates noise pollution.

Leading Control Mode

- Advanced digital control meets requirement of welding process and greatly improves the welding performance.
- It is applicable to welding wire with diameter of 0.6-1.2mm and different grades, and electrode of acid or basic.
- Easy arc ignition, less spatter, stable current, nice shape, etc.
- Cooling fan on demand prolongs its service life by stopping working during no load.

Nice Shape and Structure Design

- Front and rear panels in shape of streamline make the whole shape nicer.
- Large LED digital display: Read data Easily.
- Panel made of strong engineering plastics ensures high efficiency of the machine in severe conditions such as high impact, drop down and so on.
- With complete and closed air passage, welding machine can pass metal dust test with dust of 25 kg in 1 hour during normal operation.
- With complete and reliable structure, welding machine can pass HF vibration test from three directions in the condition of 6G acceleration and 2 mm displacement.

3.3 TECHNICAL SPECIFICATIONS

TECHNICAL PARAMETER	Units	Model	
		MIG-200	
Rated Input Voltage	V	AC 110V ±15% 50/60 HZ	AC 220V ±15% 50/60 HZ
Rated Input Power	KVA	4.2KVA	8KVA
Rated Input Current	A	38A	40A
MMA Welding Current Range	A	25A-108A	25A-180A
TIG Welding Current Range	A	15A-120A	15A-200A
MIG Welding Current Range	A	30A-120A	30A-200A
Wire Feed Speed Range	m/min	2.5-15	2.5-15
No-Load Voltage	V	60V	60V
Rated Duty Cycle	%	40%	40%
Overall efficiency	%	85%	85%
Enclosure Protection	IP	IP21S	IP21S
Power Factor	cosΦ	0.73	0.73
Insulation Class		F	F
Standard		UL 60974	UL 60974
Cooling Type		Wind Cooling	Wind Cooling
Dimension	mm/inch	544×350×395 / 21.4"×13.7"×15.5"	
Weight	kg/lb	10KG / 22LB	

MIG WELDING WIRE

	CO ₂ Fe	MIX Fe	FLUX	MIX SS	AL Ar	Cu Ar
MATERIAL	STEEL	STEEL	FLUX CORED	Stainless Steel	ALUMINUM	Copper
Wire Type	Solid ER70S-6/E50-6	Solid ER70S-6/E50-6	E71T-GS	304	AlMg ER5356	Cu-Si S211
Wire Diameter	.023"/.030" .035"/.04" (0.6/0.8 0.9/1.0mm)	.023"/.030" .035"/.040" (0.6/0.8/ 0.9/1.0mm)	.030"/.035" .040" (0.8/0.9/1.0mm)	.030"/.035" .040" (0.8/0.9/1.0mm)	.035"/.040" 0.45" 0.9/1.0/1.2mm	.035"/.040" 0.9/1.0
DRIVE ROLLER	V GROOVE	V GROOVE	KNURLED	V GROOVE	U GROOVE	V GROOVE
POLARITY	DCEP	DCEP	DCEN	DCEP	DCEP	DCEP
GAS TYPE	100% CO ₂	Ar 75% CO ₂ 25%	NO GAS	Ar 75% CO ₂ 25%	100% Ar	100% Ar

ARC WELDING RODS

Type	E6013
Diameter	1/16"-6/32" 1.6mm~5.0mm
Polarity	DCEP

3.4 SYSTEM CHARACTERISTICS

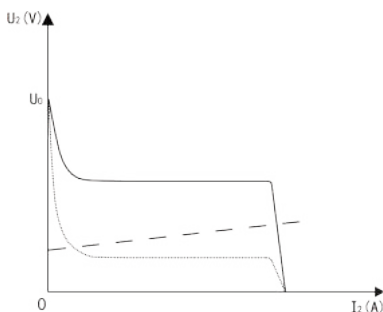
1)Duty cycle

Rated duty cycle is percentage of the ratio of operating time at rated Max output current to a 10-minute period.

The rated Duty cycle refers to the amount of welding that can be done within an amount of time. The AWT MIG-200 has a duty cycle of 40% at 200 Amps for 220 Volts. 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 200 Amps with a 40% Duty Cycle, within a 10 Minute block of time you can weld for 4 Minutes with 6 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 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 Voltage Output control.

2)Output characteristics

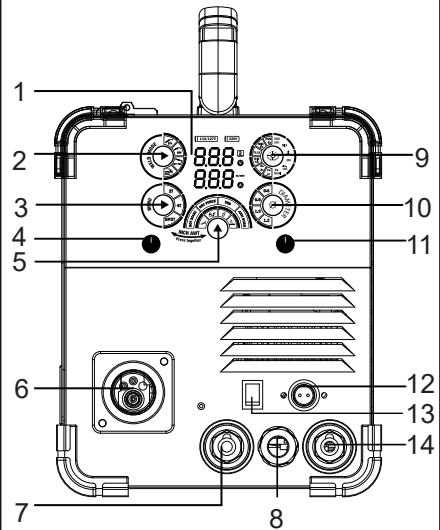


——	External characteristic curve of max output
.....	External characteristic curve of mini output
----	Rated load relationship

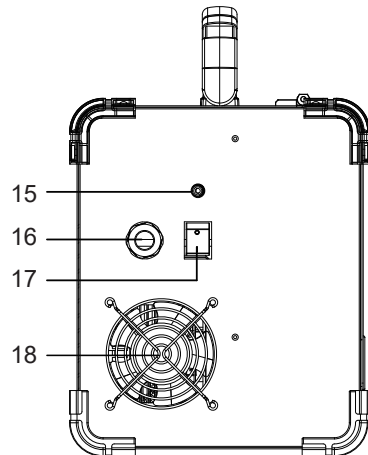
Graph of output characteristic

4. OPERATION CONTROL AND DESCRIPTION

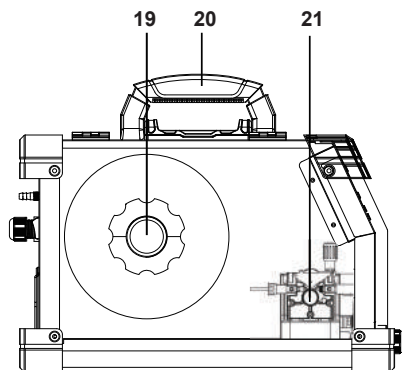
1. Digital screen display area
2. Weld mode and display area for Manual MIG /Synergic MIG/MMA/LIFT TIG button
3. MIG operation Mode selection area
4. Voltage knob
5. MIG/ MMA function adjustment
6. Euro connector for MIG torch
7. "+" output terminal
8. Polarity changeover plug
9. Material and gas selection button
10. MIG welding Wire diameter selection
11. Current and wire feed speed adjustment
12. Socket for Spool gun
13. Switch for Spool gun mode or Standard mode
14. "-" output terminal



15. Gas inlet
16. Input power cable
17. Power switch
18. Cooling Fan



19. Spool holder
20. Handle
21. Wire feeding unit



12. Socket for Spool gun

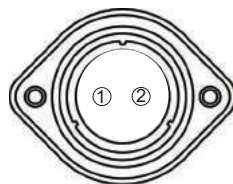
Hole 1: Spool gun power source "-"

Hole 2: Spool gun power source "+"

Note:

Please follow this connection.

If the connection is incorrect it will cause the wire feeder to reverse



CONNECTING THE WELDER TO A POWER SOURCE

The MIG-200 Welder requires a dedicated AC single phase 110V/220V,50/60HZ grounded outlet protected by a (50Amp @ 110V/ 50 Amp @ 220V) circuit breaker.

CONTROL AND DISPLAY PANEL

The MIG-200 Front Panel is equipped with Five Function Controls, One Digital Display and Two Value Knob (FIG 1). They are as follows:

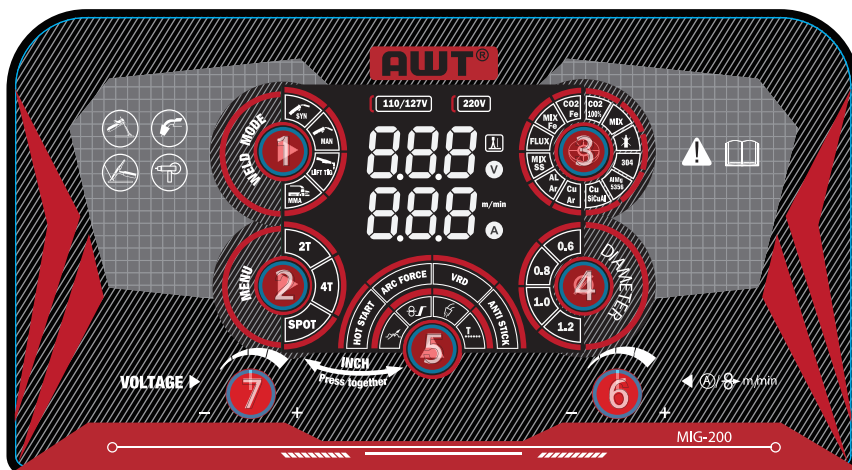


FIG1

Button Function On Panel

Button[1]: Manual MIG/Synergic MIG/MMA/LIFT TIG: Press the button switching welding modes, selecting between MIG Manual, MIG Synergy, Stick (MMA) or Lift TIG welding functionality.

Note: In Synergic MIG welding, the wire feed speed and Voltage will be auto fitted by adjusting wire diameter, material and gas.

Button[2]: Press the button switching 2T/4T(2 steps or 4 steps of welding) and Spot welding (spot welding time adjustment).

Button[3]: Press the button switching welding data, CO₂ Fe(100% CO₂)/MIX Fe(75%Ar+25%-CO₂)/ FLUX(no gas)/ MIX SS(75%Ar+25%CO₂)/ AL Ar(100% Ar)/ Cu Ar(100% Ar).

Button[4]: Press the button switching welding wire diameter.023"(0.6mm)/.030"(0.8mm)/.040"(1.0mm)/ .045"(1.2mm)

Note: Synergic MIG and Manual MIG allow the operation of different wire sizes. Please read carefully.

MIG		
WELDING WIRE	Synergy(SYN) mode	Manual (MAN) mode
SOLID	.023"/.030"/.035"/.040"	.023"/.030"/.035"/.040"
FLUX CORE	.030"/.035"/.040"	.030"/.035"/.040"
STAINLESS STEEL	.030"/.035"/.040"	.030"/.035"/.040"
Aluminum	.040"/.045"	.035"/.040"/.045"
COPPER	.040"	.040"
.035"(0.9mm) welding wire pls choose 0.40"(1.0mm).		

Wire Diameter					
Metric	0.6mm	0.8mm	0.9mm	1.0mm	1.2mm
Decimal	.023"	.030"	.035"	.040"	.045"

Button[5]: In MMA Mode, press button switching HOT START, ARC FORCE, VRD, and ANTI STICK (4 functions adjusted by knob(6)).

In MIG Mode, press button switching Inductance, Slow speed wire feeding control, Post flow Control), spot welding time (4 functions adjusted by knob(6)).

MMA Mode

Function	Description	Setting Range	Unit
Hot Start	Delivers a peak of current when striking the arc for increasing the ease of starting electrodes, especially in difficult conditions.	0 to 10. "0" for 0 amps, "10" for 180 amps	A
Arc Force	When the welding machine senses a short circuit it will deliver a peak of current.	0 to 10. "0" for 0 amps, "10" for 180 amps	A
VRD	Reduces the open-circuit voltage of a welding machine, usually around 16V.	ON/OFF	/
Anti Stick	Allows the stick welding electrode to be easily detached, if it does begin to stick to the job.	ON/OFF	/

MIG Mode

Function		Description	Setting Range
Inductance		Adjust soft to hard arc sparking.	-10% to +10%
Preset speed before arc start		Slows the wire feed speed to a pre-set speed prior to arc initiation, improving arc starts.	0-10 m/min
Pre-flow control		Control sets time gas flow before welding.	0 to 2 seconds
Spot Welding Time		Adjustable only in spot welding mode.	0 to 3 seconds

Knob[6]: Adjust the wire feed speed / current

- Manual MIG: wire feed speed can be adjust from 2.5-15m/min.
- Synergic MIG: welding current can be adjust from 30-200A.
- MMA: welding current can be adjust from 25-180A.
- TIG: welding current can be adjust from 15-200A.

Knob[7]: Adjust the voltage

- Manual MIG: welding voltage can be adjust from 10-27.5V
- Synergic MIG: welding voltage will be auto fitted after welding ampere is input, can micro adjust from $\pm 3V$ (each value=0.1V)

Button [2]+Button [5]=INCH

Only available in MIG mode. Inching can be achieved by Pressing button[2] and [5] at the same time . Press and hold INCH button, machine goes into quick feed mode for loading wire.

Note: Welding Parameter Table(For Reference Only)

MIG FLUX			
Welding Wire Diameter	Plant Thickness	Adjust Current	Adjust Voltage
0.8mm	1.0-2.0mm	40-80A	16-18V
	2.0-3.0mm	80-120A	18-20V
	3.0-4.0mm	120-150A	20-21.5V
1.0mm	1.2-2.0mm	60-80A	17-18V
	2.0-3.0mm	80-120A	18-20V
	3.0-4.0mm	120-150A	20-21.5V
	4.0-8.0mm	150-200A	21.5-23V
MIG CO₂ Fe/ MIG MIX Fe			
Welding Wire Diamete	Plant Thickness	Adjust Current	Adjust Voltage
0.6mm	0.6mm	30-80A	15.5-18V
0.8mm	1.0-2.0mm	40-80A	16-18V
	2.0-3.0mm	80-120A	18-20V
	3.0-4.0mm	120-150A	20-21.5V
1.0mm	1.2-2.0mm	60-80A	17-18V
	2.0-3.0mm	80-120A	18-20V
	3.0-4.0mm	120-150A	20-21.5V
	4.0-8.0mm	150-200A	21.5-23V
MIG MIX SS			
Welding Wire Diamete	Plant Thickness	Adjust Current	Adjust Voltage
0.8mm	1.0-2.0mm	40-80A	16-18V
	2.0-3.0mm	80-120A	18-20V
	3.0-4.0mm	120-150A	20-21.5V
1.0mm	1.2-2.0mm	60-80A	17-18V
	2.0-3.0mm	80-120A	18-20V
	3.0-4.0mm	120-150A	20-21.5V
	4.0-8.0mm	150-200A	21.5-23V
MIG Ar AL			
Welding Wire Diamete	Plant Thickness	Adjust Current	Adjust Voltage
1.0mm	1.2-2.0mm	60-80A	17-18V
	2.0-3.0mm	80-120A	18-20V
	3.0-4.0mm	120-150A	20-21.5V
	4.0-7.0mm	150-180A	21.5-23V
1.2mm	2.0-3.0mm	80-120A	18-20V
	3.0-4.0mm	120-150A	20-21.5V
	4.0-8.0mm	150-200A	21.5-23V

MIG Ar Cu			
Welding Wire Diamete	Plant Thickness	Adjust Current	Adjust Voltage
1.0mm	1.2-2.0mm	60-80A	17-18V
	2.0-3.0mm	80-120A	18-20V
	3.0-4.0mm	120-150A	20-21.5V
	4.0-8.0mm	150-200A	21.5-23V
MMA			
Electrode Diameter	Plant Thickness	Adjust Current	Adjust Voltage
1.0mm	1.0-2.0mm	25-50A	21-22V
1.6mm	1.5-2.5mm	40-70A	21.6-22.8V
2.0mm	2.0-3.5mm	50-80A	22-23.2V
2.5mm	2.5-4.0mm	60-120A	22.4-24.8V
3.2mm	2.5-5.0mm	80-140A	24.8-25.6V
4.0mm	3.0-7.0mm	120-180A	24.8-27.2V
5.0mm	4.0-8.0mm	160-200A	26.4-28V
LIFT TIG Ar			
Tungsten Electrode Diameter	Plant Thickness	Adjust Current	Adjust Voltage
1.6mm	1.0-2.0mm	15-60A	10.6-12.4V
2.0mm	1.5-4.0mm	30-120A	11.2-14.8V
2.4mm	2.0-8.0mm	50-200A	12-17.2V

Welding Mode	Welding Data	Welding Wire Diameter(mm)	Adjust Voltage Range(V)	Adjust Current Range (A)	Adjust Arc Length Range(V)
Synergic MIG	CO ₂ Fe	0.6	14-26.5	30-120	±3
		0.8	14.5-27.5	30-200	
		1.0	15.5-25	60-200	
	MIX Fe	0.6	13.5-22.5	30-120	
		0.8	14-24.3	40-200	
		1.0	14-22.3	60-200	
	FLUX	0.8	12.5-27.5	35-200	
		1.0	14-21	58-200	
	MIX SS	0.8	14.5-27.5	30-200	
		1.0	15.5-25	60-200	
	AL	1.0	11.5-19.5	50-200	
		1.2	11.5-19.5	50-200	
	Cu	1.0	11.5-19.5	50-200	

Manual MIG

- Choose spool gun mode or standard mode(MIG torch), set rocker switch that is inner of the machine. **(FIG2)**.
- Set the button **[1]** to **Manual MIG**.
- Set the button **[2]** to **2T/4T/spot**.
- Set button **[3]** to choose the **welding data**(CO₂ Fe/MIX Fe/FLUX/MIX SS/AL Ar/Cu Ar).
- Set the button **[4]** to choose the welding **wire diameter**(.023"/.030"/.040"/.045"), (Can handle Flux core wire and Stainless steel .030"/.035"/.040", Solid wire 0.23"/.030"/.035"/.040", And Aluminum 5356 .035"/.040"/.045", copper .040"



Note:.035" welding wire please select .040"

- Check the "V" type drive roll for solid welding wire, the "W" type drive roll for flux welding wire, the "U" type roll for aluminum welding wire, make sure the drive roll is matched current welding wire.

Tips: using aluminum welding wire, the torch need to install the Teflon tube.(FIG 7-1). Or using EURO STYLE spool gun(not included)

- Set the button **[5]** to inductance, Slow Speed Wire Feeding Control, Post flow Control, spot welding time(spot welding time is only in the spot mode).
- Turn the knob **[7]** to adjust voltage(10-27.5V), and knob **[6]** to adjust the wire speed (5-15m/min), depending on user needs.(recommend for professional welder only).
- Remove the torch tip and nozzle, press torch trigger, start to feed the wire outer of torch neck. Or press and hold button[2]and button[5] start to INCH function, get into quick feed mode.
- Set up the torch tip and nozzle according to correct wire diameter.

Synergic MIG

- Choose spool gun mode or standard mode(MIG torch), set rocker switch that is inner of the machine. **(FIG2)**
- Set the button **[1]** to **Synergic MIG**.
- Set the button **[2]** to **2T/4T/spot**.
- Set button **[3]** to choose the welding data(CO₂ Fe/MIX Fe/FLUX/MIX SS/AL Ar/Cu Ar).
Set the button **[4]** to choose the welding wire diameter(.023"/.030"/.040"/.045"), (can handle Flux core wire and Stainless steel .030"/.035"/.040", Solid wire 0.23"/.030"/.035"/.040", And Aluminum 5356 .040"/.045", copper .040"

Note:.035" flux core and solid wire please select .040" diameter. SYN mode can't handle .035" aluminum.

- Check the "V" type drive roll for solid welding wire, the "W" type drive roll for flux welding wire, the "U" type roll for aluminum welding wire, make sure the drive roll is matched current welding wire.

Tips: using aluminum welding wire, the torch need to install the Teflon tube.(FIG 7-1). Or using spool gun(not included)

- Set the button **[5]** to inductance, Slow Speed Wire Feeding Control, Post flow Control, spot welding time (spot welding time is only in the spot mode)
- Adjust the current knob **[6]** according to welding chart, the wire feed speed and voltage will be auto fitted by weld data program. can micro adjust from $\pm 3V$ (each value = 0.1V)
- Remove the torch tip and nozzle, press torch trigger, start to feed the wire out of torch neck. Or press and hold button **[2]** and button **[5]** start to INCH function, get into quick feed mode.
- Set up the torch tip and nozzle according to correct wire diameter.

Note:

- The 0.9mm(.035") aluminum wire is not shown in the panel. However, this machine is able to weld it in MIG manual mode. please choose 1.0mm(.040") when selecting diameter, or use with EURO STYLE spool gun(not include, but can be purchased at store). It cannot be welded well in synergy mode.
- The 0.9mm(.035") flux core and solid wire is not shown in the panel. However, this machine is able to weld them in both MIG manual mode and MIG synergic mode. please choose 1.0mm(.040") when selecting diameter.

MMA/STICK welding

- Set the button **[1]** to MMA
- Adjust knob **[6]**, set the welding ampere according to welding chart.
- Set the button **[5]** to arc force, hot start, VRD, ANTI STICK.

Lift TIG welding

- Set the button **[1]** to TIG,
- Set up the lift TIG torch (Not included)

5 INSTALLATION SET UP AND OPERATION

5.1 MIG WELDING SET-UP AND OPERATION

SET UP FOR MIG WELDING

Installing the MIG Welding Gun

- Open the side door of the Welder and loosen the Torch Tensioner Wing Screw located on the side of the brass, hex shaped member of the Drive Motor Assembly (**FIG 3**).
- Plug the Brass Body End of the Welding Gun line into the designated socket (**FIG 4**).
- **IMPORTANT NOTE:** The Brass Body End must be fully seated against the base of the drive assembly socket or gas may either leak or not be able to pass through the connections to the end of the Welding Gun (**FIG 5**).
- Tighten the Torch Tensioner Wing Screw finger tight (**FIG 4**).
- Connect the Male Metal Plug to the Female Cannon Plug connection on the front of the Welder (**FIG 6**).

FLUX(DCEN)

CO₂Fe(DCEP)

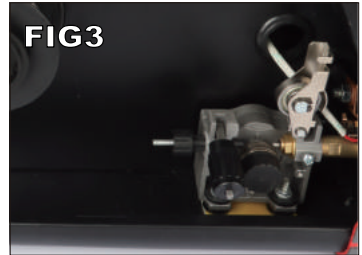
Mix Fe(DCEP)

Mix SS(DCEP)

Al Ar (DCEP)

Cu Ar (DCEP)

- Set the button(1)to the SYN MIG or MAN MIG



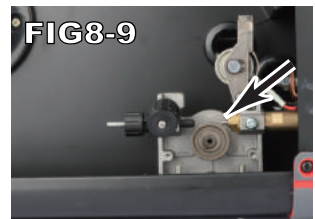
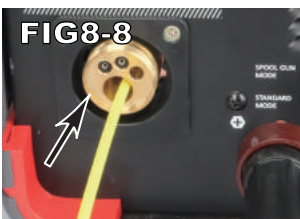
Install A Spool Gun for Aluminum Welding

- Remove the regular MIG torch and connect the EURO STYLE spool gun to the () , the other wire of the spool gun to the air socket(). Locate the Ground Clamp with (-) on the Welder.(DCEP) Check the wire size on the torch and install the aluminum wire. Switch the button to spool gun mode.(FIG 2).



Install Torch and Liner for Aluminum Welding

- Remove the spring on the plastic parts of wire feeder (**FIG.8-1**), keep it in safe place, need to install it back when we use ss or carbon steel weld. Remove the holding ring on steel liner of wire feeder.press steel liner (**FIG.8-2**) and let it move out of the torch sockets on front panel, keep it in safe place, need install it back when we weld with ss and carbon steel. use torch kid remove the tip(**FIG.8-4**) on the torch, remove the screw (**FIG.8-5**) on torch liner back.
- Pull the steel liner (**FIG.8-6**) out of the torch, keep it in safe place, need install it back when we weld with ss or carbon steel. Install the Teflon tube (**FIG.8-7**) into torch(make sure the liner into torch with correct direction, keep the steel part toward the torch head), insert the Teflon tube to the torch socket on front panel (**FIG.8-8**), come cross liner hole of torch till to the edge of roller (**FIG.8-9**). (aluminum material wire is soft, so we need keep using Teflon tube used in weld and change U type roller for aluminum welding)



INSTALLING THE GROUND CABLE AND CLAMP

- **DCEP:** Locate the Ground Clamp with Cable and connect the cable coupler end to the Negative Connector(-) on the Welder. DCEP@CO₂ 100%, Ar/CO₂ Mix, Ar100%
- **DCEN:** Locate the Ground Clamp with Cable and connect the cable coupler end to the Positive Connector(+) on the Welder. (DCEN @Flux)

Align the key of the brass ferrule with the notch of the receptacle at the 12:00 position (**FIG 9**), insert the plug and twist Clockwise 1/2 turn until it is tight. (**FIG 10**)



INSTALLING DING GAS SUPPLY

⚠ WARNING! BUILDUP OF GAS CAN INJURE OR KILL!

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air -supplied respirator.
- Always turn your face away from valve outlet when opening cylinder valve.



⚠ WARNING! CYLINDERS CAN EXPLODE IF DAMAGED!

- **Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. As gas cylinders are a normal component of the welding process, use extra care to handle them carefully.**
- Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks and arcs. Keep away from any welding or other electrical circuits.
- Install cylinders in an upright position by securing to a specifically designed rack, cart or stationary support to prevent falling or tipping over.
- Never weld on a pressurized cylinder or explosion will occur.
- Use only correct shielding gas cylinders, regulators, hoses and fittings designed for the specific application; maintain them and all related components in good condition.
- Keep protective cap in place over valve except when cylinder is in use.
- Use proper equipment, procedures and have adequate help when moving or lifting cylinders.

A Shielding Gas Bottle is **NOT INCLUDED** with your AWT MIG-200 but is necessary to weld using Solid Wire. It can be bought at most local Welding Supply Stores. AWT MIG-200 recommends the use of 80% Argon / 20% CO₂ or 75% Argon / 25% CO₂ for shielding gas when MIG welding Steel.

- Place the AWT MIG-200 in its dedicated area or on a welding cart.
- Secure your Shielding Gas Bottle to a stationary object or mount to your welding cart if it is equipped to hold one so that the cylinder cannot fall over.
- Remove the cap from the Shielding Gas Bottle.
- Install the Regulator Knob on the Shielding Gas Regulator (**FIG11**).
- Insert the large brass male fitting on the Shielding Gas Regulator into the female fitting on the Shielding Gas Bottle (**FIG12**).

⚠ NOTICE

Do not use White Thread Sealing Tape on this connection as it is an inert gas fitting and does not require it. If you have a leak, check for burrs or dirt in the threads.

- Tighten the fitting with a wrench until snug, do not over tighten.
- Connect either end of the Gas Line included with your AWT MIG-200 to the fitting on the regulator and wrench tighten until snug (**FIG12**).
- Connect the other end of the gas line to the fitting on the rear of the AWT MIG-200 and wrench tighten until snug (**FIG13**).
- Check the gas line for leaks by slowly opening the valve on the gas bottle. When welding the valve on the bottle should always be fully open.

FIG11

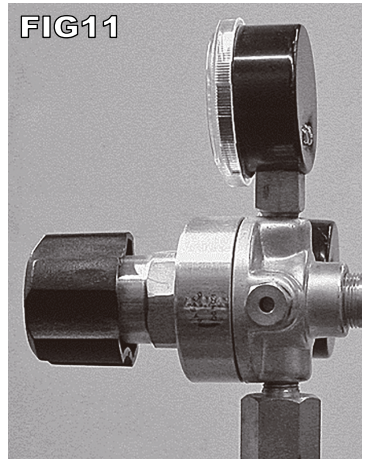


FIG12



FIG13



POSITIONING THE DRIVE ROLLER

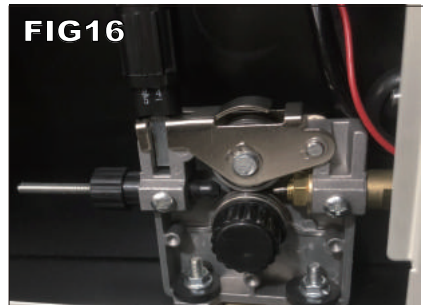
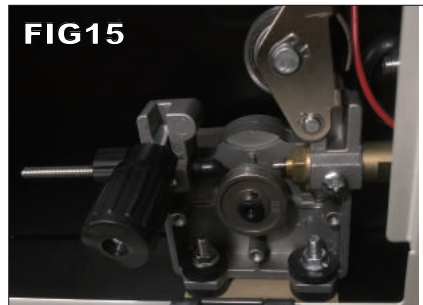
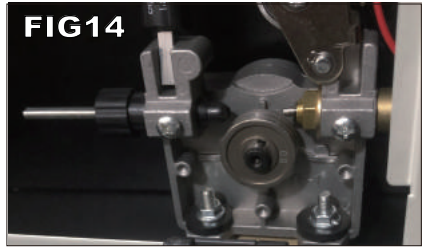
The AWT MIG-200 Wire Drive Roller has twin grooves to accommodate both .030"/.035" [0.8mm/0.9mm] wire.

The MIG-200 Drive Roller is factory set and up ready to use .030"/.035" [0.8mm/0.9mm] wire.

IMPORTANT NOTE: In this position, the wider, .030"/.035" [0.8mm/0.9mm] groove is inboard, under the wire while the 0.8/0.9 marking is visible on the outward face of the Drive Roller (**FIG 14**).

.030" [0.8mm] or .035" [0.9mm] wire can be used with the Drive Roller in this position.

- Open the side door of the Welder to access the drive motor compartment (**FIG 15**).
- Push the Pressure Adjuster rearward, pivot it down and out of the way then pivot the Tension Arm up away from the Drive Roller (**FIG 16**).
- Loosen and remove the Drive Roller Retaining Knob (**FIG 14**).
- Remove the Drive Roller and view the wire sizes stamped on each side of the Roller.
- Install the Drive Roller in the orientation so that the chosen wire size stamping is facing outward making sure shaft key aligns with the Drive Roller keyway. (**FIG 14**).
- Reinstall the Drive Roller Retaining Knob on the shaft.
- Replace the Tension Arm and re-latch the Pressure Adjuster.



INSTALLING THE WIRE SPOOL

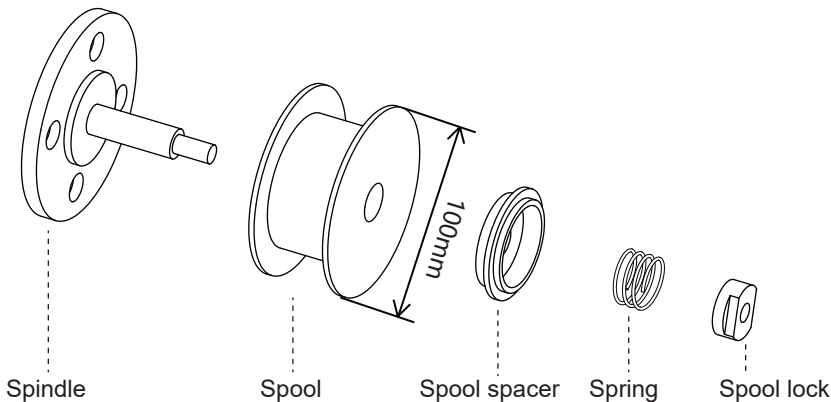
The AWT MIG-200 can be used with either a 4" or an 8" wire spool.

Using spool gun(not included) need to set the rocker switch that is inner of the machine. (**FIG 2**)

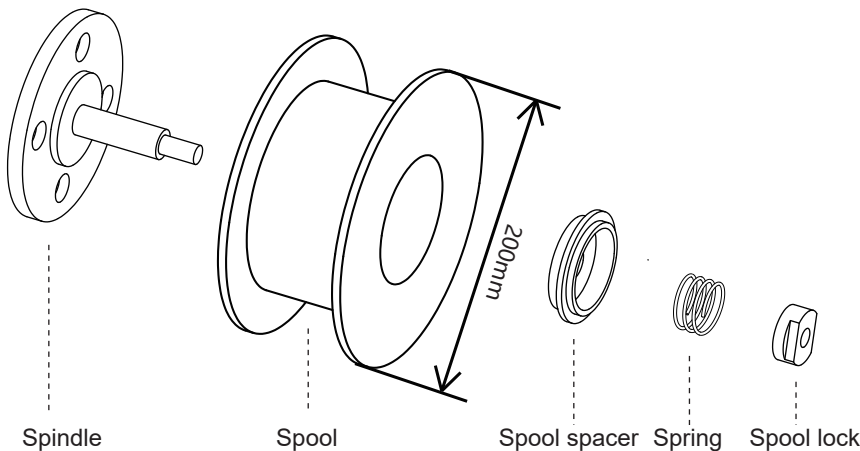
SETTING THE WIRE PRESSURE ADJUSTER

- To set the tension on the wire, incrementally tighten the Spool Retaining Wingnut until there is a slight resistance to spinning the wire spool on the spindle. If the tension is set too loose the wire spool will freely spin on the shaft and unspool all the wire. If the tension is too tight, the Drive Roller will have difficulty pulling the wire off the spool and some slipping may occur.

Installation of 4"(100mm) wire spool



Installation of 8"(200mm) wire spool



THREADING WELDING WIRE THROUGH THE DRIVE MOTOR TO THE WELDING GUN



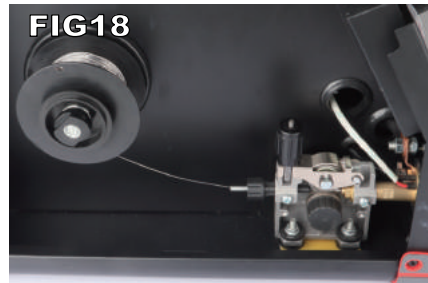
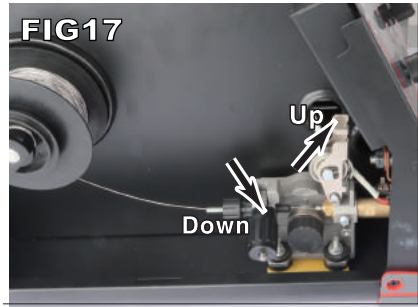
WARNING **ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!**
Disconnect Welder from power supply before beginning.

This Welder uses wire sizes ranging from .023" to .045" (0.6mm to 1.2mm). To safely and correctly install the welding wire, follow the procedure in the sequence outlined below:

1. Turn the power switch on the Upper back Panel to the "OFF" position and unplug the Welder from the power supply.
2. Set the Process Selector Button [1] on the Front Panel to 'Manual MIG or Synergic MIG'.
3. Remove the contact tip and nozzle from the end of the torch.
4. Ensure that the drive roller is installed in the proper "face-out position" in accordance with the wire size being used (FIG 14).
5. Push the Pressure Adjuster rearward, pivot it down and out of the way then pivot the Tension Arm up away from the Drive Roller (FIG 16).
6. Pull out the welding wire from the wire spool carefully;
IMPORTANT NOTE: Do not let go of the wire or the entire spool could unravel.
7. Cut off the small piece of the curved segment at the front of welding wire and straighten the welding wire approximately 3.0" long.
8. Thread the welding wire through the Guide Pipe and over the wire Drive Roller and into the Torch Hole (FIG 17).
9. Replace the Tension Arm and re-latch the Pressure Adjuster (FIG 18).
10. Connect the Welder to a power supply and Upper Back Panel to the "ON" position. Set the Ampere/Wire Speed Knob [6] According to Welding Chart
11. With the gun pointed away from you and others, depress the trigger to begin feeding wire.

NOTE: The Pressure Adjuster may need to be set. To do so:

- Watch the drive roller to see if any slipping is occurring between the roller and the wire- if so turn the machine off, unplug it and tighten the Pressure Adjuster 1/4 turn and test again.
 - Repeat the above step until wire is feeding smoothly with no binding or slippage.
12. Once the wire exits the end of the torch, reinstall the contact tip and nozzle. Cut the wire about 1/4" from the end of the contact tip.



MIG WELDING OPERATION

Your AWT MIG-200 can be used to form many different joints and welds all of which will require practice and testing before using on an actual project piece. This following welding process is just a baseline to get you started.

Refer to the 'Suggested Settings' chart which is located inside the side door of your AWT MIG Welder. From the chart select your baseline starting point for the recommended settings described in the chart.

- Connect your ground clamp to the work pieces that are to be welded. Make sure the ground clamp contacts are placed on a clean piece of metal free of paint, grease, rust, oils, etc. It is recommended to place your ground clamp as close to the weld area as possible.
- Assess your weld area and make sure the welding area is also cleaned of any paint, grease, rust, oils, etc.
- Plug in the Welder and move the Power Switch at the Upper Back Panel to the "ON" position. Depress the Welding Gun trigger pointing the welding gun away from your body and then let go of the trigger and cut the wire back to 1/4" stick out length.
- Wearing your welding helmet, gloves, and long sleeve shirt and pants, put the end of the wire sticking out of the gun into the joint to be welded.
- Position the MIG Gun so that it is perpendicular to the base metal with -20° tilt back.
- Depress the trigger to start the wire feed which starts the arc.
NOTE: A push, perpendicular, or drag technique can be used to weld the pieces together; the type used depends on the type of joint as well as other influential conditions.
- Once you depress the trigger and the arc has started, you will notice a molten puddle will form; this puddle is the weld bead and will follow the motion of the MIG Gun. Watching the size of the puddle dictates how fast you should be moving with the torch. If you burn through the material you are either moving too slow or you need to make some setting adjustments to the Welder settings. If you're not penetrating the base metal you're either moving too fast or you need to make adjustments to the Welder settings.
- Release the trigger on the MIG Gun to stop the weld.
- After welding is complete, turn off the Welder and disconnect from power source.

SHEET METAL WELDING TECHNIQUES

When welding sheet metal a different approach is usually taken to account for how thin the metal is and it's susceptible to warping it is. The technique most often used is called Stitch Welding and this process is described below:

- Clean the metal to be welded of any paint, rust, oil, grease, dirt or any other contaminants that may be on the surface of the piece.
- Secure the pieces to be welded in place using clamps. Be sure to leave a small gap between the two pieces of sheet metal for the weld to flow into, this will result in a lower bead height which will require minimal finishing.
- Consult the Suggested Settings Chart and set the Voltage and Wire Speed knobs appropriately. Get some pieces of scrap metal of the same thickness and verify that the settings will work for the specific weld you will be making.
- Once the settings have been fine tuned tack weld your final pieces in places and remove the clamps if they are in the way of the weld.
- The Stitch Welding technique can now be utilized which is basically a series of tacks connecting together. To perform the technique, trigger the gun to form a tack weld and then continue to trigger on and off the gun making a series of connected tack welds following along the path of the weld joint. Continue the series of tacks for an inch or so and then move to a different section of the weld and perform the process there. It is essential to keep moving around to spread out the heat making sure not to get one section too hot and warp the metal.
- Once the entire weld has been completed allow the metal to cool. If necessary follow up with a flap disc to grind the weld bead flush.

HEAVY GAUGE METAL WELDING TECHNIQUES

When welding heavy gauge metal, a continuous bead is formed using a 'push' method. This process is described below:

- Clean the metal to be welded of any paint, rust, oil, grease, dirt or any other contaminants that may be on the surface of the piece.
- Secure the pieces to be welded in place using clamps. Be sure to leave a small gap between the two pieces of metal for the weld to flow into, this will result in a lower bead height which will require minimal finishing. Any material thicker than 1/8" should be beveled using an angle grinder.
- Consult the Suggested Settings Chart and set the Voltage and Wire Speed knobs appropriately.
- Get some pieces of scrap metal of the same thickness and verify that the settings will work for the specific weld you will be making.
- Once the settings have been fine-tuned tack weld your final pieces in places and remove the clamps if they are in the way of the weld.
- When welding heavy gauge metal there are two basic approaches to creating the weld. The first is a continuous bead with steady gun movement along the length of the joint. The second type of weld is a Stringer or Weave bead. This is accomplished by moving the torch in a circular or zig zag pattern. Either of these techniques will create strong welds but in some cases the Stringer or Weave type will create a more aesthetically pleasing weld bead.
- Once the entire weld has been completed, allow the metal to cool. If necessary, follow up with a flap disc to grind the weld bead flush.

5.2 STICK WELDING SET-UP AND OPERATION

SET UP

⚠ DANGER ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!

- **Disconnect Welder from power supply before beginning.**

Set the Welder on a flat surface in the general area where the Welder will be used. A dedicated cart is best.

- Set the Process Selector Button(1) on the Front Panel to MMA.
- Locate the Ground Clamp with Cable and connect the plug on the cable end into the Negative (–) receptacle on the Lower Right Front Panel of the Welder. To connect the plug; align the key of the brass ferrule with the notch of the receptacle at the 12:00 position then rotate 1/2 turn Clockwise to lock.
- Locate the Electrode Holder with Cable and connect the plug on the cable end into the Positive (+) Connection Receptacle on the Lower Front Panel of the Welder. To connect the plug; align the key of the brass ferrule with the notch of the receptacle at the 12:00 position then rotate 1/2 turn Clockwise to lock.
- Connect the Welder to a power source. This Welder requires a minimum (50 Amp @ 110/220V), 50/60 Hz protected circuit.
- Insert the electrode to be used into the Electrode Holder.
- Connect the Ground Clamp to a clean bare metal surface of the part to be welded.
- Turn on the Power Switch at the Back Panel of the Welder.
- The Welder is now ready to use.

STICK WELDING OPERATION

Electrode Selection

Before beginning welding with your AWT MIG-200 , you will need to purchase electrodes as these are a consumable item in the ARC welding process. There are a variety of different types of rods available and should be selected depending on the project on hand. The chart below is an overview of some of the most popular electrodes.

E6013	DCEP	This electrode is best for use with clean, bare steel and is suitable for moderate penetration.

POLARITY SELECTION

The AWT MIG-200 can weld in both Direct Current Electrode Positive (DCEP) and Direct Current Electrode Negative (DCEN). The electrode, or rod, when welding in DCEP is positive and the grounded surface is negative. This polarity is used with electrodes that specify it and is usually the most commonly used polarity when ARC welding for general purpose use. The electrode when welding in DCEN is negative and the grounded surface is positive. This polarity is used with electrodes that require using this polarity and is usually used for building up heavy deposits of material with less penetration.

To use the AWT MIG-200 in DCEP:

- Locate the Ground Clamp with Cable and connect the plug on the cable end to the Ground Cable Connector (–) on the Welder. To connect the plug line up the key on the plug with the keyway on the socket of the Welder, insert the plug and twist until it is tight.
- Locate the Electrode Holder with Cable and connect the plug on the cable end to the Electrode Holder Connector (+) on the Welder. To connect the plug line up the key on the plug with the keyway of the socket on the Welder, insert the plug and twist until it is tight.

To use the AWT MIG-200 in DCEN:

- Locate the Ground Clamp with Cable and connect the plug on the cable end to the Positive Connector (+) on the Welder. To connect the plug line up the key on the plug with the keyway on the socket of the Welder, insert the plug and twist until it is tight.
- Locate the Electrode Holder with Cable and connect the plug on the cable end to the Negative Connector (–) on the Welder. To connect the plug line up the key on the plug with the keyway on the socket of the Welder, insert the plug and twist until it is tight.

STICK WELDING PROCEDURE

- Set up a clean well lit work area.
- Prepare the parts to be welded by cleaning the weld joint area of any rust, dirt, grease, or paint.
- Select the proper electrode for the weld joint.
- Turn on the Welder and select the appropriate amperage. To determine proper amperage it is best to practice on some similar metals to set up the machine before welding on an actual part of value.
- Attach the ground clamp to a clean bare metal section on the work piece.
- Insert the electrode into the electrode holder being careful not to allow the electrode to contact the grounded area.
- To start welding an arc must be struck, to do this a motion similar to striking a match will have to be performed with the electrode. Slowly bring the electrode closer to the weld joint and then contact and drag the electrode across the piece to strike the arc. Once the arc has been struck you can continue feeding the electrode into the weld joint.
- While moving along the weld joint the electrode will burn down, while it is burning you will need to continue moving the electrode closer to the joint trying to keep a 1/8" gap between the end of the electrode and the weld joint. The electrode holder must be held so that the electrode is in a downward angle moving in the direction of the weld joint.
- To stop welding simply lift the electrode away from the work piece. When finished welding remove the electrode from the holder and turn off the Welder.

5.3 Lift TIG WELDING SET-UP AND OPERATION

SHIELDING GAS CONNECTION FOR Lift TIG TORCH

⚠ WARNING BUILDUP OF GAS CAN INJURE OR KILL!

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.
- Always turn your face away from valve outlet when opening cylinder valve.

⚠ WARNING CYLINDERS CAN EXPLODE IF DAMAGED!

- Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. As gas cylinders are a normal component of the welding process, use extra care to handle them carefully.
- Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks and arcs. Keep away from any welding or other electrical circuits.
- Install cylinders in an upright position by securing to a specifically designed rack, cart or stationary support to prevent falling or tipping over.
- Never weld on a pressurized cylinder or explosion will occur.
- Use only correct shielding gas cylinders, regulators, hoses and fittings designed for the specific application; maintain them and all related components in good condition.
- Keep protective cap in place over valve except when cylinder is in use.
- Use proper equipment, procedures and have adequate help when moving or lifting cylinders.

A Shielding Gas Bottle is NOT INCLUDED with your AWT MIG-200 but is necessary for Lift TIG welding. A Shielding Gas Bottle can be bought at most local Welding Supply Stores. MIG-200 recommends the use of 100% Argon shielding gas when Lift TIG welding Steel and Stainless Steel.

After connecting your Shielding Gas Regulator, the gas flow rate needs to be adjusted so that the proper amount of Shielding Gas is flowing over your weld. If there is too little gas flow there will be porosity in your welds as well as excessive spatter, if there is too much gas flow you will be wasting gas and may affect the weld quality.

- Place the AWT MIG-200 in its dedicated area or on a welding cart.
- Secure your Shielding Gas Bottle to a stationary object or mount to your welding cart if it is equipped to hold one so that the cylinder cannot fall over.
- Remove the cap from the Shielding Gas Bottle.
- Install the Regulator Knob on the Shielding Gas Regulator (**FIG 11**).
- Insert the large brass male fitting on the Shielding Gas Regulator into the female fitting on the Shielding Gas Bottle (**FIG 12**).

▲ NOTICE

- **Do not use White Thread Sealing Tape on this connection as it is an inert gas fitting and does not require it. If you have a leak check for burrs or dirt in the threads.**

- Tighten the fitting with a wrench until snug, do not over tighten.
- Connect Lift TIG Torch gas line to the fitting on the Regulator and wrench-tighten until snug (**FIG 12**).
- Check the gas line for leaks by slowly opening the valve on the gas bottle. When welding, the valve on the bottle should always be fully open.

TORCH ASSEMBLY/DISASSEMBLY

Disassembly:

- Make sure the welder is turned OFF and unplugged.
- Remove the Back Cap from the Torch.
- If there is a Tungsten installed in the Torch pull it out of the front of the Torch.
- Slide the Collet out of the Torch.
- Unscrew and remove the Gas Shielding Nozzle.
- Unscrew and remove the Collet body.
- Rotate the knob on the gun to adjust the gas.

Assembly:

- Select a Collet body that matches your Tungsten diameter size and thread it into the front of the Torch. (**FIG 19**).
- Select a Collet that matches your Tungsten diameter size. Insert the Tungsten into the Collet and put the Collet and Tungsten back into the Torch.
- The Gas Shielding Nozzle size should be changed according to shielding gas requirements for the material being welded. Thicker material requires a larger Nozzle. Select the correct Gas Shielding Nozzle and thread it onto the Collet body.

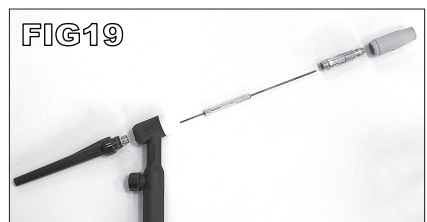


FIG20

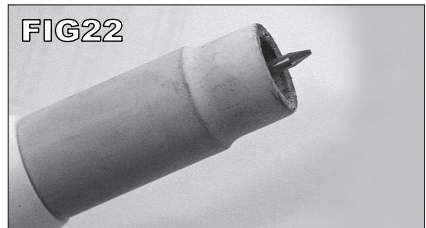
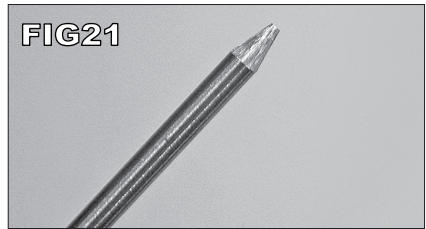


Install the back cap to lock the Tungsten in place. Always make sure the Tungsten protrudes 1/8" to 1/4" beyond the Gas Shielding Nozzle (FIG20).

SHARPENING THE TUNGSTEN

To avoid contamination of the Tungsten and ultimately the weld, it is imperative to have a dedicated grinding wheel used for Tungsten grinding only. A fine grit standard 6" synthetic stone grinding wheel on a bench top grinder is sufficient or our specifically designed MIG-200 Tungsten Grinders are available.

- Shut off the welder.
- Make sure the Tungsten and Torch are sufficiently cooled for handling then loosen and remove the
- Back Cap then the Collet and remove the Tungsten from the FRONT of the Torch only. (Removing from the rear will damage the Collet).
- If the Tungsten is used and the end is contaminated, use pliers or a suitable tool to grip the Tungsten above the contaminated section and snap off the end of the Tungsten.
- Holding the Tungsten tangent to the surface of the grinding wheel, rotate the Tungsten while exerting light pressure until a suitable point is formed. The ideal tip will have the length of the conical portion of the sharpened area at 2-1/2 times the Tungsten rod diameter(FIG21).
- Replace the Tungsten in the Collet with the tip extending 1/8"-1/4" beyond the Gas Shielding Nozzle, then re-tighten the Back Cap(FIG22).



Lift TIG WELDING SET-UP

⚠ DANGER ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!

- **Disconnect Welder from power supply before beginning.**

- Set the Welder on a flat surface in the general area where the Welder will be used. A dedicated cart is best.
- Set the Process Selector Button(1) on the Front Panel to "Lift TIG".
- Insert the Brass Connector of the Lift TIG Torch Cable into the Negative (-) on the Lower Left Front Panel of the Welder. To connect the plug line up the key on the plug with the keyway on the socket of the Welder, insert the plug and twist until it is tight.
- Insert the Brass Connector of the Ground Cable into the Positive (+) on the Lower Right Front Panel of the Welder. To connect the plug line up the key on the plug with the keyway on the socket of the Welder, insert the plug and twist ½ turn until it is tight.
- Connect the Welder to a power source. This Welder requires a minimum (20 Amp @ 110V/ 50 Amp @ 220V), 50/60 Hz Protected Circuit.
- Connect the Ground Clamp to a clean bare metal surface of the part to be welded.
- Turn on the Power Switch at the Upper Back Panel of the Welder.
- The Welder is now ready for use.

Lift TIG WELDING

IMPORTANT NOTE: These instructions are intended only to provide the user with some familiarity of the AWT MIG-200 . Lift TIG welding is a highly complex procedure with many variables. If you have no experience with Lift TIG welding; it is extremely important to seek the advice of someone experienced in Lift TIG welding for instruction, enroll in a local technical school welding course or study a comprehensive how-to DVD and obtain a good quality reference book on TIG welding as there is a moderate learning curve necessary before achieving proficiency in TIG Welding. Before attempting to use this unit on an actual project or object of value, practice on a similar material as there are many variables present and settings required when TIG welding different metals such as steel and stainless steel. It is also strongly recommended that the user adhere to the American Welding Society guidelines, codes and applications prior to producing welds where safety is affected.

- Turn the Power Switch at the Upper Back Panel to the "ON" position.
- Slowly open the gas cylinder valve.

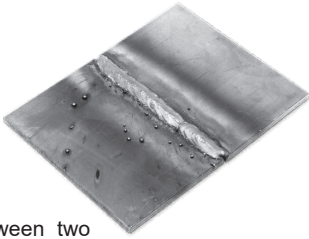
NOTE: Always open valve fully to avoid shielding gas leakage.

- Adjust the flow regulator built-in to the Torch Handle. Rotate Counter-clockwise to open, Clockwise to Close.
- Grounding is very important, place the Ground Cable Clamp on a clean, bare area of your work piece as close to the welding area as possible to minimize the chance of shock. Scrape, wire brush, file or grind a bare area to achieve a good ground to assure safety.
- Use a dedicated stainless steel brush or flap-disc to clean the areas to be welded. Do not use the brush or flap-disc for any other purpose.
- Making sure all your safety gear is in place (Welding Mask, Welding Gloves, non-flammable long sleeve apparel) and the area is completely free of flammable material.
- Although it is a matter of developing a personal style, a good starting point for best results is achieved by holding the tip at a 45° angle backward and approx. 20° to the right of the weld. Hold the Filler Metal Rod at a 60° angle to the Tungsten Tip. Never allow the Tungsten Tip to touch the welding surface or material rod. Doing so will quickly destroy the tip and contaminate the weld. If this happens, remove the Tungsten and regrind the tip. It is best to hold the Tungsten tip 1/8" from the surface.
- With your Welding Shield and all safety gear in place, practice "Forming a Puddle" with the Tungsten Tip. Once you become familiar with this step. Practice the "Dip and Pull" technique with the Filler Metal Rod and Torch. "Dip and Pull" is the practice of forming a puddle, moving the Torch while maintaining the puddle and adding filler rod metal to the puddle by "dipping and pulling" as you go; being careful not to allow the Tungsten to contact the puddle or rod.
- To stop welding, pull the Tip back over the weld approx. 1/2" [13mm] then lift to break the arc. Keep shielding gas flow in place for approx. 10 seconds.
- Keep in mind that you **MUST** let the shielding gas flow over the weld for approx. 10 seconds. Failure to do so will allow the welded area to oxidize as it cools, compromising the weld integrity.
- Constantly be aware that TIG welding quickly generates heat in the work piece and Torch. Severe burns can quickly occur by contacting hot metal pieces.
- When done, shut off the Power Switch, close the Regulator in the Torch Handle then close the Shielding Gas Tank valve completely.

5.4 OVERLOAD PROTECTION

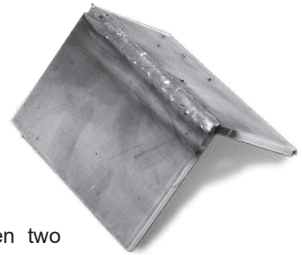
Our AWT MIG-200 Welder is equipped with over load protection system which will protect your Welder if the duty cycle is exceeded. If the output is exceeded, the system will trip and stop power supply to the drive motor although the fan will still run to cool the unit. Allow the Welder to cool for a minimum of 15 minutes before attempting to resume welding.

5.5 TYPES OF WELD JOINTS



BUTT WELD

is a joint between two pieces that are laying in the same direction.



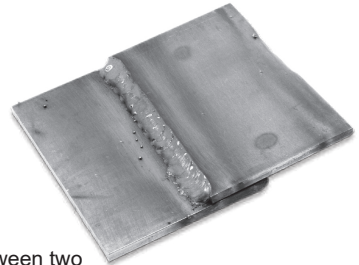
CORNER WELD

is a joint between two pieces that meet at or near perpendicular at their edges.



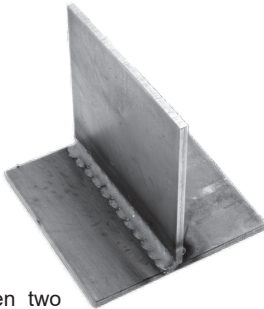
EDGE WELD

is a joint between two pieces where the edges are being joined.



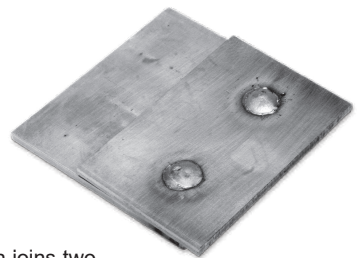
LAP WELD

is a joint between two overlapping pieces.



TEE WELD

is a joint between two pieces where one is perpendicular to the other.



PLUG WELD

is a joint which joins two overlapping pieces by filling in a hole punched in the top piece.

6.TROUBLESHOOTING

STICK WELD TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Electrode Sticking	Arc Too Short	While welding, keep the ignited end of the electrode further from the weld joint.
	Current Too Low	Adjust the current on the front of the Welder to a higher current setting.
Holes in Weld Bead (Porosity)	Arc Too Long	While welding, keep the ignited end of the electrode closer to the weld joint.
	Moisture in Electrode	Replace electrode with a new one.
Excessive Spatter	Arc Too Long	While welding, keep the ignited end of the electrode closer to the weld joint.
	Current Too High	Adjust the current on the front of the welder to a lower current setting.
Poor Penetration	Poor Joint Preparation	Clean the weld joint of any dirt, grease, paint or other possible contaminants. If the pieces being Welder are of a heavy gauge it may be necessary to bevel the edges of the pieces.
	Current Too Low	Adjust the current on the front of the welder to a higher current setting.
	Travel Speed Too Fast	Slow down the travel speed of the electrode while welding.
Overload Light On	Duty Cycle Exceeded	Allow the Welder to cool for a minimum of 15 minutes before attempting to use again.

MIG WELD TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Burn Through	High Voltage	Adjust voltage output to lower setting.
	Lack of Tack Welds	Adjust wire speed to slower setting.
	Slow Gun Travel	Increase your travel speed with the Welding Gun.
Lack of Penetration	Low Voltage	Adjust voltage output to higher setting.
	Slow Wire Speed	Adjust wire speed to faster setting.
	Fast Gun Travel	Slow your travel speed of the Welding Gun making sure to pull or drag the molten metal puddle.
	Excessive Wire Protruding	Move the Contact Tip on the Welding Gun closer to the work piece to shorten the length of exposed wire.
	Material Too Thick	The MIG-200 is rated for a maximum thickness of 3/8", exceeding this will result in poor penetration.

	Poor Material Prep	If welding heavy gauge metals, it may be necessary to increase the welding gap between the two pieces and also bevel the edges on the weld side of the pieces.
Excessive Penetration	High Voltage	Adjust voltage output to lower setting.
	Fast Wire Speed	Adjust wire speed to slower setting.
	Slow Gun Travel	Increase your travel speed with the Welding Gun.
Warping	Lack of Tack Welds	Tack weld the pieces in multiple areas to keep the pieces from pulling apart.
	No Clamping	Use welding clamps to secure the pieces in the proper shape.
	Poor Technique	To prevent warping, allow the workpiece to cool after welding small sections at a time. Move your welding areas around by not completing all the welding in one section all at once, rather, welding a small amount in one area and then move to another section area to spread out the heat in the piece.

TIG WELDING TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Arc is Triggered but Will Not Start	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 towards the ground connection.
	Incorrect Tungsten	Consult chart for proper Tungsten for the base metal being welded. In most cases Thoriated will be used for all steels.
	No Shielding Gas	Make sure the shielding gas cylinder is turned all the way open and set at the correct flow rate.
Arc wanders and it is Hard to Concentrate Heat in a Specific Area	Poorly Prepped Tungsten	Follow guidelines for prepping Tungsten.
	Poor Gas Flow	Adjust the flow rate of the shielding gas (refer to settings chart). Check for loose fittings where gas could be leaking.
	Contaminated Tungsten	Remove Tungsten from Torch, break off contaminated section, and resharpen.
	Incorrect Arc Length	Make sure the Tungsten is held 1/8 to 1/4 inch off the work piece.
	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 towards the ground connection.
	Contaminated Base Metal	Clean base metal making sure to remove any oil, debris, coatings, or moisture. If base metal is aluminum make sure all of the oxide is removed using either a dedicated stainless brush or flap wheel.

Porosity in Weld Bead	Poor Gas Flow	Adjust the flow rate of the shielding gas. Check for loose fittings where gas could be leaking.
	Contaminated Filler Metal	Clean filler metal making sure to remove any oil, debris, or moisture.
	Contaminated Filler Metal	Clean base metal making sure to remove any oil, debris, coatings, or moisture.
	Contaminated Base Metal	Make sure to be in an area with no wind and with any fans turned off. Wind or fans will blow the shielding gas away from the weld causing porosity.
	Poor Shielding	Adjust the Tungsten so that 1/8 to 1/4 inch protrudes from the Collet.
Contamination in Weld Bead	Contamination Tungsten	Remove Tungsten from Torch and break off contaminated section and resharpen.
	Contaminated Filler Metal	Clean filler metal making sure to remove any oil, debris, or moisture.
	Contaminated Base Metal	Clean base metal making sure to remove any oil, debris, coatings, or moisture. If base metal is cold rolled steel make sure to remove any mill scale.
Melting Tungsten	Poor Gas Flow	Adjust the flow rate of the shielding gas. Check for loose fittings where gas could be leaking.
	Wrong Size Tungsten	Increase Tungsten diameter. Refer to chart for proper sizing.
	Incorrect Shielding Gas	Only use 100% Argon when TIG Welding.
Poor Penetration	Low Voltage	Voltage setting is too low for material/thickness. Increase as needed.
Tungsten Contaminated	Contact of Tungsten with Base Metal	Keep Tungsten 1/8 to 1/4 inch from the base metal. If Tungsten comes in contact break off end and resharpen immediately.
Poor Weld Appearance	Incorrect Positioning	The angle between the filler metal and the Torch must be less than 90 degrees otherwise the filler metal will prematurely melt and glob off causing poor weld appearance.

TIG WELDING TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Crater in the End of the Weld Bead	Insufficient Shielding	Keep the Torch on the base metal while the post flow shielding gas flows to protect and cool the metal and Tungsten.
	Not Enough Filler Material	Reduce current and add more filler at end of weld. It may also be beneficial to back step to ensure no crater will form.
Weld Bead is Cracking	Too Much Heat in Material	Reduce heat and allow more time between passes.
	Base Metal is Absorbing Too Much Heat	Preheat base metal (consult welding codes for requirements)
	Incorrect Filler Wire	Use appropriate filler wire type and diameter for the joint being welded.
Material is Warping	Insufficient Clamping	Clamp work piece tightly and weld while clamps 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.

CODE OF OPERATION AND ERROR

CODE			CODE		
SPd	spd	FEEDER SPEED	4t	4t	4STEPS
AFC	AFC	ARC FORCE	VRd	VRD	VRD:Protection against electric shock
Ant	ant	ANTI STICK	on	ON	
ind	ind	INDUCTOR	oFF	OFF	
HS	HS	HOT START			
2t	2t	2STEPS			
Err 1		OVER CURRENT PROTECTION	Err 2		OVER HEAT PROTECTION

7.DIAGRAM

