

## deca Parva 145E

# Deca Parva 145E Welding Machine Instruction Manual

Model: 0400193 / 322006

## 1. INTRODUCTION

Thank you for choosing the Deca Parva 145E Welding Machine. This manual provides essential information for the safe and efficient operation, setup, maintenance, and troubleshooting of your new welding equipment. Please read this manual thoroughly before using the machine and keep it for future reference.

The Deca Parva 145E is designed for various welding tasks, offering reliable performance for both hobbyists and professionals. Proper understanding and adherence to these instructions will ensure optimal results and prolong the life of your machine.

## 2. SAFETY INSTRUCTIONS

**WARNING: Welding can be dangerous. Always follow safety precautions to prevent serious injury or death.**

- **Electric Shock:** Welding current can cause fatal electric shock. Ensure proper grounding. Do not touch live electrical parts. Wear dry, insulated gloves.
- **Fumes and Gases:** Welding fumes and gases can be hazardous to your health. Work in a well-ventilated area. Use a fume extractor if necessary.
- **Arc Rays:** Arc rays can burn eyes and skin. Wear a welding helmet with appropriate shade filter and protective clothing.
- **Fire and Explosion:** Welding sparks and hot metal can cause fire or explosions. Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Burns:** Hot metal and slag can cause severe burns. Wear protective gloves and clothing.
- **Pace Makers:** Persons with pacemakers should consult their doctor before operating this equipment.
- Always disconnect power before performing any maintenance or service.

## 3. PACKAGE CONTENTS

Carefully unpack the box and ensure all items are present and undamaged. If any items are missing or damaged, contact your retailer immediately.

- Deca Parva 145E Welding Machine
- Electrode Holder with Cable
- Ground Clamp with Cable
- Welding Mask (Handheld)
- Chipping Hammer / Wire Brush
- Instruction Manual

## 4. PRODUCT OVERVIEW

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The Deca Parva 145E is a compact and robust welding machine designed for various arc welding applications. Below is an image illustrating the main unit and its included accessories.



**Figure 1:** Deca Parva 145E Welding Machine and included accessories. The image displays the yellow main welding unit, a black handheld welding mask, a black chipping hammer with a wire brush, an electrode holder, and a ground clamp.

### Key Components:

- **Main Unit:** Yellow casing with control panel.
- **Power Switch:** On/Off control.
- **Current Adjustment Knob:** For stepless welding current regulation.
- **Thermal Protection Indicator:** Illuminates when the machine overheats.
- **Output Terminals:** Connections for electrode holder and ground clamp.
- **Electrode Holder:** Secures the welding electrode.
- **Ground Clamp:** Connects to the workpiece to complete the electrical circuit.
- **Welding Mask:** Provides eye and face protection from arc rays and sparks.
- **Chipping Hammer/Wire Brush:** Used for removing slag and cleaning welds.

## 5. SETUP

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1. **Placement:** Place the welding machine on a stable, level surface in a well-ventilated area, away from

flammable materials. Ensure adequate space around the machine for air circulation.

2. **Power Connection:** Connect the machine's power cord to a suitable grounded electrical outlet. Ensure the power supply matches the machine's requirements (refer to specifications).
3. **Connect Ground Clamp:** Attach the ground clamp cable to the appropriate output terminal on the welding machine. Securely attach the ground clamp to the workpiece or welding table, ensuring good electrical contact.
4. **Connect Electrode Holder:** Attach the electrode holder cable to the other output terminal on the welding machine. Insert a suitable electrode into the electrode holder. The recommended electrode size for this machine is 1.6mm to 3.2mm.
5. **Personal Protective Equipment (PPE):** Before turning on the machine, ensure you are wearing all necessary PPE, including a welding helmet, welding gloves, and protective clothing.

## 6. OPERATING INSTRUCTIONS

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1. **Turn On:** Switch the main power switch to the "ON" position.
2. **Set Welding Current:** Adjust the current adjustment knob to the desired welding current. The appropriate current setting depends on the electrode diameter and the material thickness being welded. Start with a lower setting and increase as needed.
3. **Prepare Workpiece:** Ensure the workpiece is clean and free of rust, paint, or grease to ensure a good weld.
4. **Strike an Arc:** While wearing your welding helmet, gently tap or scratch the electrode against the workpiece to strike an arc. Once the arc is established, maintain a consistent arc length and travel speed.
5. **Welding:** Move the electrode along the joint, maintaining a steady hand and angle. Observe the weld pool and adjust your technique as necessary.
6. **Thermal Protection:** If the thermal protection indicator illuminates, the machine has overheated. Turn off the machine and allow it to cool down before resuming operation. Do not bypass this safety feature.
7. **Finish Welding:** When finished, lift the electrode from the workpiece to break the arc. Turn off the welding machine.
8. **Post-Weld Cleaning:** Use the chipping hammer to remove slag from the weld bead, then use the wire brush to clean the weld.

## 7. MAINTENANCE

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Regular maintenance ensures the longevity and safe operation of your welding machine.

- **Cleaning:** Periodically clean the machine's exterior with a dry cloth. Use compressed air to blow out dust and debris from the ventilation openings. Ensure the machine is unplugged before cleaning.
- **Cable Inspection:** Regularly inspect all cables (power, electrode, ground) for cuts, fraying, or damage. Replace damaged cables immediately.
- **Terminal Connections:** Ensure all terminal connections are tight and free of corrosion.
- **Storage:** Store the welding machine in a dry, clean environment, away from moisture and extreme temperatures.
- **Electrode Holder and Ground Clamp:** Keep these accessories clean and in good working condition.

Replace if damaged.

## 8. TROUBLESHOOTING

Problem	Possible Cause	Solution
No power to the machine.	Power cord unplugged, faulty outlet, tripped circuit breaker.	Check power connection, test outlet, reset circuit breaker.
Machine turns on but no arc.	Poor ground connection, incorrect current setting, faulty electrode holder/cable, wet electrode.	Ensure ground clamp is securely attached to clean metal. Adjust current. Inspect cables and holder. Use dry electrodes.
Thermal protection light is on.	Machine overheated due to prolonged use or insufficient ventilation.	Turn off the machine and allow it to cool down. Ensure proper ventilation. Reduce duty cycle.
Poor weld quality (e.g., porosity, lack of penetration).	Incorrect current, improper arc length, wrong electrode, dirty workpiece, incorrect travel speed.	Adjust current, maintain proper arc length, use correct electrode for material, clean workpiece, adjust travel speed.

If you encounter problems not listed here or if the suggested solutions do not resolve the issue, please contact customer support.

## 9. SPECIFICATIONS

Feature	Detail
Brand	Deca
Model Name	Parva 145E
Part Number	0400193
Item Model Number	322006
Welding Current	Stepless adjustment
Electrode Diameter Range	1.6 mm - 3.2 mm
Power Source Type	Electric (AC)
Product Dimensions	390 x 210 x 280 mm (from description) / 24.99 x 16.99 x 29.49 cm (from specifications)
Item Weight	14.5 kg (from description) / 14.3 kg (from specifications)
Manufacturer	DECA
Date First Available	17 Sept. 2015

Note: Specifications are subject to change without notice for product improvement.

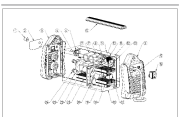

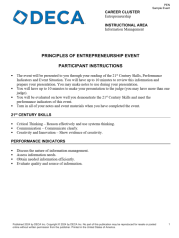
## 10. WARRANTY AND SUPPORT

For warranty information, please refer to the documentation provided at the time of purchase or contact your retailer. Deca products are manufactured to high-quality standards, and support is available for any operational issues or technical inquiries.

If you require technical assistance or have questions regarding your Deca Parva 145E Welding Machine, please contact the authorized Deca service center or your point of purchase. When contacting support, please have your model number (0400193 / 322006) and purchase date available.

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### Related Documents - Parva 145E

 <p>W. 417 1X230V-50/60HZ W/ACC.   Load: 1700W (230V/50/60HZ)</p> <p>DECA S.p.A. - Via Sesto, 10 - 20139 Milano (Italy) - Tel. +39 02 574911 - Fax +39 02 574912</p>	<p><a href="#">DECA SIL 417 1X230V-50/60HZ W/ACC. Parts List and Diagram</a></p> <p>Detailed parts list and electrical schematic for the DECA SIL 417 1X230V-50/60HZ W/ACC. electrical unit. Includes exploded view description, component references, and manufacturer information.</p>
 <p><b>CLASS Booster Series</b></p> <p>4500 5000</p>	<p><a href="#">DECA CLASS Booster Series Battery Chargers and Quick Starters</a></p> <p>Overview of DECA CLASS Booster Series battery chargers and quick starters, including models 4500 and 5000. Features and technical specifications for lead-acid batteries.</p>
 <p><b>DECA</b></p> <p>PRINCIPLES OF ENTREPRENEURSHIP EVENT PARTICIPANT INSTRUCTIONS</p>	<p><a href="#">DECA Principles of Entrepreneurship Event: Participant &amp; Judge Guide</a></p> <p>Official guide for the DECA Principles of Entrepreneurship Event, covering participant instructions, event situation, judge roles, and evaluation criteria for the Information Management instructional area.</p>

