

Telwin DIGITAL MIG 330 (Model 820030)

Telwin DIGITAL MIG 330 Welding Machine User Manual

Model: 820030

INTRODUCTION

This manual provides essential information for the safe and efficient operation, maintenance, and troubleshooting of your Telwin DIGITAL MIG 330 welding machine. Please read this manual thoroughly before operating the machine and keep it for future reference.

The Telwin DIGITAL MIG 330 is a microprocessor-controlled MIG-MAG/Synergic welding machine with an integrated 4-roll wire feeder. It is particularly suitable for locksmith and bodywork applications, as well as welding galvanized sheets, high yield strength (HLE) steel, stainless steel, and aluminum.

SAFETY INSTRUCTIONS

Always prioritize safety when operating welding equipment. Failure to follow safety guidelines can result in serious injury or death.

- Ensure proper ventilation to avoid inhaling welding fumes.
- Wear appropriate personal protective equipment (PPE), including welding helmet, gloves, and protective clothing.
- Do not operate the machine in damp or wet conditions.
- Disconnect power before performing any maintenance or adjustments.
- Keep a fire extinguisher nearby.

PRODUCT OVERVIEW



Figure 1: Front view of the Telwin DIGITAL MIG 330 welding machine, showing its compact design with wheels for portability, the control



EMF SAFE



Weld



SYNERGIC



DIGI 188



ROLLS 4



Aluminium



STEEL STAINLESS STEELS

AUTOMOTIVE






PROFESSIONAL






Informations Techniques

Normes:		LVD: EN 60974-1		LVD: EN 50445		EMC: EN 60974-10	
CODE	V _{PH}	A _{MIN} A _{MAX}	A _{MAX} 40°C	A _{60%} 40°C	V ₀	P _{55%} MAX	 A
820030	V50/50Hz 230 / 400 3 ph	A 40 320	A EN60974-1 300 25 %	A EN60974-1 215	V 41	kW 7,5 11	A 16 / 10
						IP	 W _H
cosphi	nr	mm	mm	mm	mm	mm	cm(L,W,H)
0,9	12	0,6 1,2	0,8 1,2	0,8 1,2	0,8 1,2	IP22	87 45,3 80
	BAR CODE						
kg		pc/palette					
81	800489764557 5	3					

SETUP

1. Carefully remove the welding machine and all accessories from the packaging.
2. Inspect the machine for any signs of damage during transit. Report any damage to your supplier immediately.
3. Verify that all components listed in the packing list are present.

The Telwin DIGITAL MIG 330 operates on 230-400V. Ensure your power supply matches the machine's requirements. Connect the power cable to a suitable grounded outlet.

1. Securely attach the gas regulator to the appropriate shielding gas cylinder (e.g., Argon, CO2, or mixed gas, depending on the material).
2. Connect the gas hose from the regulator to the gas inlet on the welding machine.
3. Ensure all connections are tight to prevent gas leaks.

1. Open the wire feeder compartment.
2. Place the wire spool onto the spindle, ensuring it rotates freely.
3. Thread the welding wire through the wire feeder mechanism, ensuring it passes through the correct groove for the wire diameter.
4. Close the wire feeder compartment.

Torch and Ground Clamp Connection

1. Connect the MIG-MAG welding torch to the designated connector on the front panel.
2. Connect the ground clamp cable to the appropriate terminal and attach the clamp securely to the workpiece or welding table.

OPERATING INSTRUCTIONS

Control Panel Overview

The DIGITAL MIG 330 features an intuitive control panel with SYNERGIC DIGIDESK technology for quick and easy program configuration.

- **Display:** Shows selected parameters and welding programs.
- **Parameter Adjustment Knobs:** Used to fine-tune voltage, wire speed, and other settings.
- **Program Selection:** Allows selection of pre-set synergistic programs based on material, wire diameter, and gas type.
- **2/4-Stroke Selector:** Toggles between 2-stroke (press and hold for arc) and 4-stroke (press to start, press to stop) operation.
- **Spot Welding Function:** For timed spot welds.

Synergic Operation

The SYNERGIC DIGIDESK technology automatically programs the wire speed based on the characteristics of the welding material, shielding gas, and wire diameter. This ensures high arc control and welding quality.

1. Select the desired welding program corresponding to your material (e.g., steel, stainless steel, aluminum), wire diameter, and gas.
2. The machine will automatically set the optimal wire feed speed.
3. Adjust the voltage or other parameters as needed for fine-tuning the weld bead.

Manual Adjustments

While synergistic mode simplifies operation, manual adjustments are possible for specific applications:

- **Wire Speed Regulation:** Manually override the wire speed if required.
- **Post-Gas Time:** Adjust the duration of gas flow after the arc stops to protect the weld pool.
- **Burn-Back Time:** Control the time the wire burns back after the arc stops to prevent the wire from sticking in the puddle.

Spool Gun Usage

The machine supports the use of a Spool Gun torch, which is particularly useful for welding soft wires like aluminum, as it minimizes feeding issues.

MAINTENANCE

Regular maintenance ensures the longevity and optimal performance of your welding machine. Always disconnect the power supply before performing any maintenance.

Daily Maintenance

- Clean the welding torch nozzle and contact tip. Replace if worn.
- Check the condition of the ground clamp and cable.
- Inspect the power cable for any damage.

Weekly/Monthly Maintenance

- Clean the wire feeder rollers and guide tubes.
- Check the gas hose for leaks using a leak detection spray.
- Clean the machine's exterior and ventilation openings to prevent dust buildup.

Thermostat Protection

The machine is equipped with thermostat protection. If the machine overheats due to prolonged use or insufficient ventilation, it will automatically shut down. Allow it to cool down before resuming operation.

TROUBLESHOOTING

Problem	Possible Cause	Solution
No arc	No power, poor ground connection, gas flow issue, wrong settings.	Check power supply, ensure ground clamp is secure, verify gas flow, check welding parameters.
Wire feeding issues	Incorrect wire tension, clogged liner, worn contact tip, wrong drive roller size.	Adjust wire tension, clean/replace liner, replace contact tip, ensure correct drive rollers are installed.
Poor weld quality	Incorrect voltage/wire speed, insufficient gas shielding, dirty workpiece.	Adjust parameters, check gas flow and type, clean workpiece thoroughly.
Machine overheats (thermostat protection activated)	Prolonged use beyond duty cycle, blocked ventilation.	Allow machine to cool down, ensure adequate ventilation, reduce duty cycle.

SPECIFICATIONS

Feature	Detail
Model	DIGITAL MIG 330 (Model 820030)
Type	MIG-MAG / Synergic Welding Machine
Input Voltage	230-400V
Wire Feeder	Integrated 4-Roll Wire Feeder
Suitable Materials	Galvanized sheets, HLE steel, Stainless steel, Aluminum
Technology	SYNERGIC DIGIDESK
Features	Automatic wire speed programming, Supply voltage monitoring, 2/4-stroke operation, Spot function, Automatic torch recognition, Wire speed regulation, Post-gas time, Burn-back time, Spool Gun compatibility, Thermostat protection.
Weight	43 Kilograms

WARRANTY AND SUPPORT

The Telwin DIGITAL MIG 330 welding machine comes with a **1-year warranty** from the date of purchase. This warranty covers manufacturing defects and faulty materials under normal use conditions.

For technical support, service, or warranty claims, please contact your authorized Telwin dealer or the point of purchase. Ensure you have your proof of purchase and the machine's serial number available.

For more information, visit the official Telwin website: www.telwin.com

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