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› [Telwin](#) /

› [Telwin Linear 340-819020 MMA DC Welding Machine User Manual](#)

Telwin 819020

Telwin Linear 340-819020 MMA DC Welding Machine User Manual

Model: 819020

1. INTRODUCTION

This manual provides essential information for the safe and effective operation, setup, maintenance, and troubleshooting of your Telwin Linear 340-819020 MMA DC Welding Machine. Please read this manual thoroughly before using the machine to ensure proper handling and to prevent injury or damage.



Figure 1: Telwin Linear 340-819020 Welding Machine. This image shows the overall view of the red and black welding machine with its control panel and wheels.

2. SAFETY INFORMATION

Welding operations involve significant risks. Always adhere to safety precautions to prevent electric shock, burns, fire, and exposure to fumes. This machine is designed for Manual Metal Arc (MMA) welding.

- **Electric Shock:** Ensure the machine is properly grounded. Do not touch live electrical parts. Wear dry welding gloves.
- **Fumes and Gases:** Work in a well-ventilated area. Use fume extraction if necessary.
- **Arc Rays:** Protect your eyes and skin from arc rays. Use a welding helmet with appropriate shade and protective clothing.
- **Fire and Explosions:** Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Burns:** Hot metal and equipment can cause severe burns. Wear protective clothing, gloves, and footwear.

3. SETUP

3.1 Unpacking and Inspection

Carefully remove the welding machine from its packaging. Inspect the machine for any signs of damage that may have occurred during transit. Ensure all components listed in the packing list are present. If any damage or missing parts are found, contact your supplier immediately.

3.2 Power Connection

The Telwin Linear 340-819020 operates on a 230-400V power supply. Ensure your power source matches these requirements. Connect the machine to a suitable power outlet using the provided cord. Verify that the power circuit is adequately protected by a fuse or circuit breaker.

3.3 Electrode Holder Connection

Connect the electrode holder cable to the appropriate terminal on the welding machine. For DC welding, the polarity depends on the electrode type and welding application. Consult your electrode manufacturer's recommendations for correct polarity.

3.4 Ground Clamp Connection

Attach the ground clamp cable to the workpiece. Ensure a clean, solid electrical connection to the base metal to facilitate a stable arc. A poor ground connection can lead to an unstable arc and poor weld quality.



Figure 2: Close-up of the Telwin Linear 340-819020 control panel. This image highlights the current adjustment knob and connection points.

4. OPERATING INSTRUCTIONS

4.1 Powering On/Off

To power on the machine, switch the main power switch to the 'ON' position. The indicator light will illuminate. To power off, switch the main power switch to the 'OFF' position.

4.2 Current Adjustment

The Telwin Linear 340-819020 features stepless regulation of the welding current. Use the adjustment knob on the front panel to set the desired welding current. Refer to the electrode manufacturer's recommendations for appropriate current settings based on electrode diameter and material thickness.

4.3 Electrode Selection

This machine is compatible with a wide range of electrodes, including rutile, basic, stainless steel, cast iron, and aluminum electrodes. Select the appropriate electrode type and diameter for your specific welding application and material.

4.4 Welding Process

1. Ensure all safety gear is worn.
2. Insert the chosen electrode into the electrode holder.
3. Strike an arc by lightly touching the electrode to the workpiece and quickly lifting it slightly to establish the arc.
4. Maintain a consistent arc length and travel speed for optimal weld quality.
5. After welding, allow the workpiece to cool before handling.

5. MAINTENANCE

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

- **Cleaning:** Periodically clean the machine's exterior with a dry cloth. Ensure ventilation openings are free from dust and debris. Use compressed air to clean internal components if necessary, ensuring the machine is unplugged.
- **Cable Inspection:** Regularly inspect all welding cables, electrode holder, and ground clamp for damage, cuts, or loose connections. Replace damaged cables immediately.
- **Storage:** Store the welding machine in a dry, clean environment, away from direct sunlight and extreme temperatures.

6. TROUBLESHOOTING

Problem	Possible Cause	Solution
No arc or weak arc	Poor ground connection, incorrect current setting, damp electrode, power supply issue.	Check ground clamp connection, adjust current, dry electrodes, verify power supply.
Machine overheats	Exceeding duty cycle, blocked ventilation.	Allow machine to cool, clear ventilation openings, reduce welding time.
Poor weld quality	Incorrect current, wrong electrode, improper technique, dirty workpiece.	Adjust current, select correct electrode, refine welding technique, clean workpiece.

7. SPECIFICATIONS

Feature	Detail
Manufacturer	Telwin
Model Number	819020
Item Weight	80 Kilograms
Product Dimensions	46 x 89 x 59 cm
Color	Red/Black
Power Source Type	Corded Electric
Voltage	240 Volts (Input 230-400V)
Wattage	11.5 Kilowatts (Max Power 7 kW)
Included Components	Device only
Batteries Included	No
Batteries Required	No

8. WARRANTY AND SUPPORT

For warranty information and technical support, please refer to the documentation provided with your purchase or contact Telwin customer service directly. Keep your proof of purchase for warranty claims.



Figure 3: Telwin brand logo. This image displays the official logo of the manufacturer, Telwin.