

Stayer PLASMA MULTI 40

Stayer PLASMA MULTI 40 Inverter Industrial Plasma Cutter User Manual

Model: PLASMA MULTI 40

1. INTRODUCTION

The Stayer PLASMA MULTI 40 is an advanced electronic inverter equipment designed for electric arc welding and cutting. This versatile unit offers three primary functions: MMA (Shielded Metal Arc Welding), high-quality TIG welding, and plasma cutting for various metals. Engineered for both light and medium maintenance and construction tasks, it prioritizes maximum quality, ease of use, and reliability.

Key features include intelligent STAYER WELDING control with Hot Start, Arc Force, and Anti Stick for optimized arc ignition and stability, robust construction exceeding European specifications, and high-quality components like 600V IGBT switches. Weighing only 7kg, it is among the lightest in its category, offering maximum power density.



Figure 1: Front view of the Stayer PLASMA MULTI 40 unit.

2. SAFETY INFORMATION

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

- **Electric Shock:** Can kill. Do not touch live electrical parts. Wear dry, insulating gloves and protective clothing. Ensure the workpiece is properly grounded.
- **Fumes and Gases:** Can be hazardous to your health. Keep your head out of the fumes. Use ventilation or exhaust to remove fumes from the breathing zone.
- **Arc Rays:** Can burn eyes and skin. Wear a welding helmet with a proper shade filter. Wear appropriate eye protection with side shields. Wear protective clothing to cover exposed skin.
- **Fire and Explosion:** Welding and cutting can cause fire or explosion. Keep flammable materials away from the work area. Have a fire extinguisher readily available.
- **Hot Parts:** Can cause severe burns. Allow equipment to cool before touching.
- **Noise:** Excessive noise can damage hearing. Wear ear protection.
- **Pacemakers:** Persons with pacemakers should consult their doctor before operating this equipment.
- **Maintenance:** Disconnect power before servicing. Only qualified personnel should perform repairs.

3. PACKAGE CONTENTS

Upon unpacking, verify that all components are present and undamaged. The standard equipment includes:

- Stayer PLASMA MULTI 40 Inverter Unit
- Plasma Torch
- TIG Torch with consumables
- Electrode Holder Cable with Clamp (for MMA welding)
- Ground Cable with Clamp
- Power Cable (2m x 2.5mm²)



GAMA PLASMA 60%

PLASMA
MULTI 40 GE

VENTAJAS

- Equipo electrónico inverter para soldadura y corte por arco eléctrico.

- Tres funciones:

1. Soldadura de electrodo recubierto MMA con Arc Force externo y soldando incluso celulósico.

2. Soldadura TIG de máxima calidad con cebado de arco mediante alta frecuencia.

3. Corte de todo tipo de metales mediante Plasma con inicio sin contacto HF.

- Accesorios muy completos incluyendo antorcha plasma, antorcha TIG y cables para electrodo recubierto (MMA).

- Apto para todo tipo de trabajos ligeros y medianos de mantenimiento y construcción en los que se requiera máxima calidad de soldadura, corte y sencillez de uso.

- Prestaciones incomparables en su nivel de precio: 160A al 60%, voltaje en vacío=76Vdc.

- Fácil realización de soldadura, incluso para usuarios sin experiencia, gracias al control inteligente STAYER WELDING que incluye las ventajas Hot Start, Arc Force y Anti Stick para optimizar el cebado inicial del arco, mejorar su estabilidad durante el soldado y evitar que el electrodo se pegue por mal manejo.

- Equipo completamente preparado para uso seguro con generadores estabilizados, admitiendo sobretensiones de +17%.

- Sólida construcción superando ampliamente las especificaciones europeas 2011/65/EU, 2014/35/EU, 2014/30/EU y IEC 60974.

- Componentes de máxima calidad, incluyendo conmutadores IGBT de 600V y modulador PWM UC3846 de alta gama.

- Máxima densidad de potencia: el equipo más ligero en su categoría, solo 7kg de peso.



PLASMA MULTI 40

STAYER WELDING

STE

60%
DUTY CYCLE
EN 60974



Antorcha Plasma



Antorcha TIG

Modo

	MMA	TIG	PLASMA
Intensidad (A, X=60%)	160	160	40
Electrodo (mm)	4/5	3.2	-
Capacidad de corte (mm)	-	-	12

DATA SHEET

Corriente	ROD/TIG 160 - PLASMA 40	A
Electrodo	2.5 - 3.25	mm
Peso	7	kg
Alimentación	230 +/- 17%	V
Generador	6	KVA
Dimensiones	35 x 22 x 17	cm



2mx25mm²



2mx25mm²

DOTACIÓN STANDARD

- Cable de alimentación. 2m x 2.5mm²

- Cable porta-electrodos con pinza. 2m x 25mm²

- Cable de masa con pinzas. 2m x 25mm²

- Antorcha TIG y consumibles.

- Antorcha Plasma.



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www.stayer.es

Figure 2: Stayer PLASMA MULTI 40 unit with standard accessories.



Figure 3: Plasma Torch.



Figure 4: TIG Torch.



Figure 5: Electrode Holder Cable.



Figure 6: Ground Cable with Clamp.

4. PRODUCT OVERVIEW

The Stayer PLASMA MULTI 40 features a user-friendly control panel and robust connection points for various welding and cutting operations.

Front Panel Controls and Connections:

- **Power Switch:** Turns the unit ON/OFF.
- **Digital Display:** Shows current settings.

- **Mode Selector:** Allows selection between MMA, TIG, and Plasma modes.
- **Current Adjustment Knob:** Controls the welding/cutting amperage.
- **Accessory Connections:** Dedicated ports for plasma torch, TIG torch, electrode holder, and ground clamp.

5. SETUP

Before operating the PLASMA MULTI 40, ensure proper setup to guarantee safety and optimal performance.

1. **Placement:** Place the unit on a stable, level surface, ensuring adequate ventilation around the machine. Do not block air vents.
2. **Power Connection:** Connect the power cable to a suitable 230V power outlet. Ensure the power supply is stable and can handle the unit's requirements (8 KVA generator recommended if not directly from mains). The unit is designed to tolerate overvoltages of +17%.
3. **Ground Connection:** Securely attach the ground clamp to the workpiece or a clean, bare metal part of the work table. A good ground connection is crucial for safety and arc stability.
4. **Accessory Connection:** Connect the appropriate torch (MMA electrode holder, TIG torch, or Plasma torch) to its designated port on the front panel. Ensure all connections are tight and secure.
5. **Gas Connection (for TIG/Plasma):** For TIG welding and Plasma cutting, connect the appropriate gas supply (e.g., Argon for TIG, compressed air for Plasma) to the unit's gas inlet. Ensure the gas pressure is set according to the specific process requirements.

6. OPERATION

The Stayer PLASMA MULTI 40 offers three distinct operating modes: MMA, TIG, and Plasma Cutting.

6.1. General Operating Principles

- Turn on the unit using the power switch.
- Select the desired operating mode (MMA, TIG, or Plasma) using the mode selector.
- Adjust the current (amperage) using the adjustment knob according to the material thickness and process.
- Ensure proper personal protective equipment is worn at all times.

6.2. MMA Welding (Shielded Metal Arc Welding)

This mode is suitable for welding with coated electrodes, including cellulosic types. The intelligent STAYER WELDING control enhances performance:

- **Hot Start:** Provides an initial boost of current to ensure easy arc ignition.
- **Arc Force:** Automatically increases current when the arc length shortens, preventing the electrode from sticking and improving arc stability.
- **Anti Stick:** Reduces the current to a minimum if the electrode sticks to the workpiece, allowing for easy removal without damaging the electrode or workpiece.

Connect the electrode holder cable and ground clamp. Insert the appropriate electrode into the holder. Set the current based on electrode diameter and material. Initiate the arc by striking the electrode against the workpiece.

6.3. TIG Welding (Tungsten Inert Gas Welding)

The PLASMA MULTI 40 provides high-quality TIG welding with high-frequency (HF) arc ignition, eliminating the need for scratch starting and reducing tungsten contamination.

Connect the TIG torch and ground clamp. Ensure the inert gas (e.g., Argon) supply is connected and flowing. Install a suitable tungsten electrode in the torch. Select TIG mode and adjust the current. Use the torch trigger to initiate the HF arc and begin welding.

6.4. Plasma Cutting

This mode allows for cutting all types of metals with non-contact HF ignition, providing clean and precise cuts up to 12mm thickness.

Connect the plasma torch and ground clamp. Ensure the compressed air supply is connected and flowing at the correct pressure. Select Plasma mode and adjust the cutting current. Position the torch nozzle close to the workpiece without touching (non-contact HF ignition) and press the trigger to initiate the plasma arc and begin cutting.

7. MAINTENANCE

Regular maintenance ensures the longevity and optimal performance of your PLASMA MULTI 40 unit.

- **Cleaning:** Periodically clean the exterior of the unit with a dry, soft cloth. Use compressed air to blow out dust and debris from the ventilation openings. Ensure the unit is disconnected from power before cleaning.
- **Cable Inspection:** Regularly inspect all cables (power, welding, ground, torch) for cuts, cracks, or damaged insulation. Replace any damaged cables immediately.
- **Torch Consumables:** For plasma and TIG torches, regularly check and replace worn consumables (nozzles, electrodes, diffusers, collets) to maintain cutting/welding quality.
- **Connections:** Ensure all electrical and gas connections remain tight and free of corrosion.
- **Storage:** Store the unit in a clean, dry environment when not in use.

8. TROUBLESHOOTING

This section addresses common issues you might encounter with your PLASMA MULTI 40.

Problem	Possible Cause	Solution
Unit does not power on	No power supply; Faulty power cable; Internal fault	Check power outlet and circuit breaker; Inspect power cable; Contact service center.
No arc in MMA/TIG/Plasma	Poor ground connection; Incorrect current setting; Worn torch consumables; Gas supply issue (TIG/Plasma); Faulty torch.	Ensure good ground; Adjust current; Replace consumables; Check gas supply/pressure; Inspect torch.
Weak or unstable arc	Low input voltage; Long cables; Poor ground; Incorrect settings; Worn consumables.	Check power supply; Use shorter/thicker cables; Improve ground connection; Adjust settings; Replace consumables.
Overheating protection activated	Exceeded duty cycle; Blocked ventilation; High ambient temperature.	Allow unit to cool down; Clear ventilation openings; Operate in a cooler environment.

9. SPECIFICATIONS

Technical specifications for the Stayer PLASMA MULTI 40:

Feature	Specification
Manufacturer	STAYER
Model Number	0001.001732
Input Voltage	230V (+/- 17%)
Generator Compatibility	8 KVA
MMA Current (A, X=60%)	160A
TIG Current (A, X=60%)	160A
Plasma Current (A, X=60%)	40A
Open Circuit Voltage	76Vdc
MMA Electrode Diameter	2.5 - 3.25 mm (up to 4.0 mm)
Plasma Cutting Capacity	12 mm
Product Weight	7 kg
Dimensions (L x W x H)	35 x 22 x 17 cm
European Specifications	2011/65/EU, 2014/35/EU, 2014/30/EU, IEC 60974
ASIN	B0749RR356
First Available	July 27, 2017

10. WARRANTY AND SUPPORT

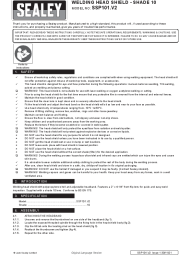
For warranty information, technical support, or service inquiries, please refer to the official Stayer website or contact your authorized Stayer dealer. Keep your purchase receipt as proof of purchase for any warranty claims.

For further assistance, you may visit the [Stayer Store on Amazon](#).



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	VEVOR CT-312/CT-520 Combo Plasma Cutter Welder User Manual Comprehensive user manual for the VEVOR CT-312/CT-520 Combo Plasma Cutter Welder, covering safety, installation, operation, technical specifications, and troubleshooting.
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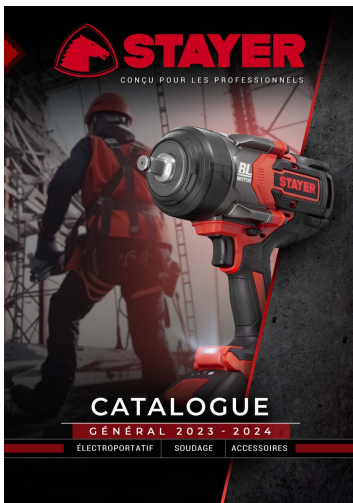
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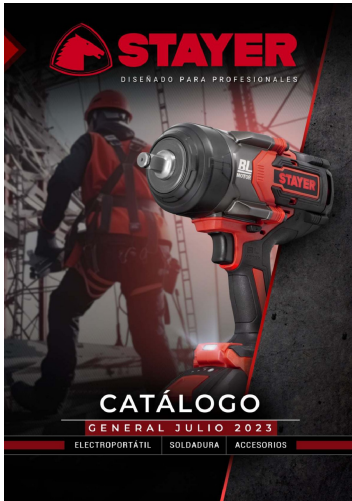
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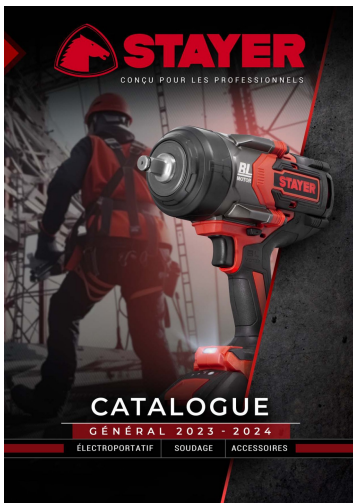


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