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**MIGATRONIC 79337030**

# MIGATRONIC Rallymig 161i Multi-Process Welder User Manual

Model: 79337030 | Brand: MIGATRONIC

## 1. INTRODUCTION

This manual provides essential information for the safe and effective operation, setup, maintenance, and troubleshooting of your MIGATRONIC Rallymig 161i Multi-Process Welder. The Rallymig 161i is a versatile welding machine capable of performing MIG/MAG, TIG (with contact ignition), and MMA (Manual Metal Arc) welding processes. Please read this manual thoroughly before using the equipment to ensure proper handling and to prevent injury or damage.

## 2. SAFETY INSTRUCTIONS

Welding operations involve significant risks. Adhere to all safety precautions to prevent electric shock, fire, burns, and exposure to harmful fumes and radiation.

- **Personal Protective Equipment (PPE):** Always wear a welding helmet with appropriate shade, flame-resistant clothing, welding gloves, and safety shoes.
- **Electrical Safety:** Ensure the welder is properly grounded. Do not operate in wet conditions. Inspect cables for damage before each use.
- **Fume Ventilation:** Weld in a well-ventilated area or use local exhaust ventilation to remove welding fumes.
- **Fire Prevention:** Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Arc Rays:** Protect eyes and skin from arc rays, which can cause severe burns.
- **Cylinder Safety:** If using gas cylinders, secure them properly and handle with care.

## 3. PRODUCT OVERVIEW

The MIGATRONIC Rallymig 161i is a compact and robust multi-process welding machine designed for various welding tasks. Below is an image illustrating the unit.



Front view of the MIGATRONIC Rallymig 161i multi-process welder, showing the control panel, output terminals, and integrated handle. The machine features a grey and green casing with the MIGATRONIC logo prominently displayed.

## Key Components:

- **Control Panel:** Features dials and indicators for adjusting welding parameters and selecting welding modes.
- **Output Terminals:** Connections for welding cables (work clamp and electrode holder/MIG torch).
- **Wire Feed Unit (internal):** For MIG/MAG welding, manages the wire spool and feeding mechanism.
- **Gas Inlet:** Connection for shielding gas cylinder (for MIG/MAG and TIG).
- **Power Cord:** For connecting the welder to the main power supply.

## 4. SETUP

Proper setup is crucial for safe and effective welding.

1. **Unpacking and Inspection:** Carefully remove the welder from its packaging. Inspect for any visible damage that may have occurred during shipping. Report any damage to your supplier immediately.
2. **Power Connection:** Connect the power cord to a suitable power outlet. Ensure the power supply matches the welder's requirements (voltage and amperage).
3. **Gas Connection (MIG/MAG & TIG):**
  - Attach the gas hose from the welder to your shielding gas cylinder (e.g., Argon for TIG/Stainless MIG, CO2/Mixed Gas for Carbon Steel MIG).
  - Secure the gas cylinder to prevent tipping.
  - Install a gas regulator onto the cylinder and connect the gas hose.
  - Open the cylinder valve slowly.
4. **Welding Cable Connections:**
  - **Work Clamp (Ground Clamp):** Connect the work clamp cable to the appropriate terminal on the welder (usually the negative terminal for MIG/MAG and MMA, or positive for DC TIG). Attach the clamp securely to the workpiece or welding table, ensuring good electrical contact.
  - **MIG Torch:** Connect the MIG torch cable to the designated MIG connector on the front panel.
  - **MMA Electrode Holder:** For MMA, connect the electrode holder cable to the positive terminal and the work clamp to the negative terminal.

- **TIG Torch:** For TIG, connect the TIG torch to the appropriate connector. Ensure the gas line for the TIG torch is also connected if using a gas-cooled torch.

## 5. Wire Feed Setup (MIG/MAG):

- Open the wire spool compartment.
- Mount the correct size and type of welding wire spool onto the spindle.
- Thread the wire through the wire feed rollers and into the torch liner. Ensure the drive rollers match the wire size and type.
- Adjust the wire tension.

# 5. OPERATING

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This section outlines the basic steps for operating your Rallymig 161i welder in different modes.

## 5.1. Powering On/Off

- **To Power On:** Ensure all connections are secure, then flip the main power switch (usually located on the rear or front panel) to the 'ON' position.
- **To Power Off:** Flip the main power switch to the 'OFF' position. Disconnect from the power supply when not in use for extended periods.

## 5.2. Mode Selection and Parameter Adjustment

The Rallymig 161i allows selection between MIG/MAG, TIG, and MMA welding processes.

- **Select Welding Mode:** Use the mode selector switch or button on the control panel to choose MIG/MAG, TIG, or MMA.
- **Adjust Parameters:**
  - **MIG/MAG:** Adjust voltage and wire feed speed according to the material thickness and wire diameter. These are often linked for optimal settings.
  - **TIG:** Adjust welding current (amperage). The Rallymig 161i supports contact ignition TIG, meaning the arc is initiated by touching the tungsten electrode to the workpiece.
  - **MMA:** Adjust welding current (amperage) based on the electrode type and diameter.

## 5.3. Welding Procedures

Always perform test welds on scrap material before welding your actual workpiece.

- **MIG/MAG Welding:**
  - Ensure gas flow is set correctly.
  - Position the MIG torch at the correct angle and distance from the workpiece.
  - Press the torch trigger to initiate the arc and wire feed.
  - Maintain a consistent travel speed and arc length.
- **TIG Welding (Contact Ignition):**
  - Ensure gas flow is set correctly.
  - Prepare the tungsten electrode.
  - Touch the tungsten electrode to the workpiece to initiate the arc, then lift slightly to establish the arc.
  - Maintain a short arc length and feed filler rod manually if required.
- **MMA Welding:**

- Insert the appropriate electrode into the electrode holder.
- Strike the electrode against the workpiece to initiate the arc.
- Maintain a consistent arc length and travel speed, allowing the electrode to melt and deposit weld metal.

## 6. MAINTENANCE

Regular maintenance ensures the longevity and optimal performance of your welder.

- **Daily/Before Use:**

- Inspect all cables and connections for cuts, fraying, or loose fittings.
- Check the MIG torch nozzle and contact tip for spatter buildup and wear. Clean or replace as needed.
- Ensure the work clamp makes good contact.

- **Weekly/After Heavy Use:**

- Clean the exterior of the machine with a dry, clean cloth.
- Use compressed air to blow out dust and debris from the cooling vents. Ensure the power is disconnected before doing so.
- Check wire feed rollers for wear and cleanliness.

- **Consumable Replacement:**

- Replace MIG contact tips and nozzles as they wear out or become clogged with spatter.
- Replace MIG torch liners if wire feeding becomes inconsistent.
- Replace MMA electrodes as they are consumed.
- Sharpen or replace TIG tungsten electrodes as needed.

- **Storage:** Store the welder in a clean, dry environment, protected from dust and moisture.

## 7. TROUBLESHOOTING

This section provides solutions to common issues you might encounter.

Problem	Possible Cause	Solution
No power to welder	Power switch off, circuit breaker tripped, faulty power cord	Turn power switch on, reset circuit breaker, check power cord for damage
No arc (MIG/MMA)	Poor work clamp connection, incorrect settings, faulty torch/electrode holder, no wire feed (MIG)	Ensure good work clamp contact, verify settings, check torch/holder, check wire feed unit
Poor weld quality	Incorrect parameters, insufficient gas flow, contaminated material, worn consumables	Adjust settings, check gas cylinder/flow, clean workpiece, replace consumables
Wire feeding issues (MIG)	Incorrect wire tension, clogged liner, wrong drive rollers, tangled wire spool	Adjust tension, clean/replace liner, ensure correct rollers, untangle wire
Overheating protection activated	Exceeded duty cycle, blocked vents	Allow welder to cool down, ensure vents are clear

If problems persist after attempting these solutions, please contact MIGATRONIC customer support or a qualified

service technician.

## 8. SPECIFICATIONS

Key technical specifications for the MIGATRONIC Rallymig 161i Multi-Process Welder:

- **Brand:** MIGATRONIC
- **Model Number:** 79337030
- **ASIN:** B07HBNRY2D
- **Processes:** MIG/MAG, MMA (Manual Metal Arc), TIG (Contact Ignition)
- **Adjustability:** Fully adjustable parameters for precise control.
- **Power Source:** Single-phase (specific voltage/amperage details not provided in source data, refer to product label).
- **Included Items:** 1 unit (as per quantity of items).

*Note: Detailed electrical specifications (e.g., input voltage, output current range, duty cycle) should be verified on the product's rating plate or official manufacturer documentation.*

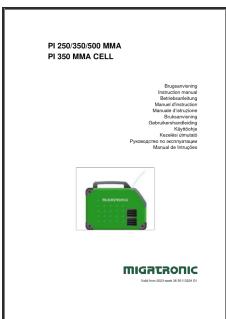
## 9. WARRANTY AND SUPPORT

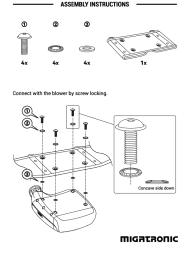
For information regarding the warranty period and terms for your MIGATRONIC Rallymig 161i welder, please refer to the warranty card included with your purchase or contact MIGATRONIC directly. Keep your proof of purchase for warranty claims.

For technical support, spare parts, or service inquiries, please contact your authorized MIGATRONIC dealer or visit the official MIGATRONIC website for contact information.

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### Related Documents - 79337030

	<p><a href="#"><u>Migatronic PI 250/350/500 MMA &amp; PI 350 MMA CELL User Manual</u></a></p> <p>Comprehensive user manual for Migatronic PI 250/350/500 MMA and PI 350 MMA CELL welding machines, covering machine programs, initial operation, control unit functions, technical data, and safety guidelines.</p>
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 <p>CentIG 200</p> <p>Groepsleiding Vaste leiding Geluidsaftsluiting Guide de l'attacheur Rohrleitung Guida per l'attaccatura Gelenkleitung Návod k upevnění Podpora upevnění Gelenkleitung Konečné směřování Manual de Instalación</p> <p><b>MIGATRONIC</b> Your Welding Partner</p>	<p><a href="#">CenTIG 200 User Guide</a></p> <p>Comprehensive user guide for the Migatronic CentIG 200 welding machine, covering connection, start-up, error handling, and technical specifications. Available in multiple languages.</p>
 <p>PI PLASMA</p> <p>QUICKGUIDE</p> <p><b>MIGATRONIC</b> Your Welding Partner</p>	<p><a href="#">Migatronic PI Plasma Hurtigguide: Betjening og Indstillinger</a></p> <p>Denne hurtigguide til Migatronic PI Plasma svejsemaskinen giver en oversigt over vigtige funktioner, betjeningspanelfunktioner, svejseparametre og programmulstilling for effektiv brug.</p>
 <p>ASSEMBLY INSTRUCTIONS</p> <p>Connect with the blower by screw locking</p> <p><b>MIGATRONIC</b> Your Welding Partner</p>	<p><a href="#">Migatronic Operator Belt Assembly Instructions</a></p> <p>Assembly instructions for the Migatronic operator belt, detailing the connection of the blower unit with screw locking.</p>
 <p>PI 350/500 AC/DC</p> <p>Reparationsdel Spare parts list Ersatzteile Lista de piezas de repuesto</p> <p><b>MIGATRONIC</b> Your Welding Partner</p>	<p><a href="#">Migatronic PI 350/500 AC/DC Spare Parts List</a></p> <p>Comprehensive spare parts list for Migatronic PI 350/500 AC/DC welding machines, detailing components, part numbers, and descriptions for maintenance and repair.</p>
 <p>INSTRUCTION MANUAL AUTOMIG X</p> <p><b>MIGATRONIC</b> Your Welding Partner</p>	<p><a href="#">Automig X MIG-MAG Welding Machine Instruction Manual</a></p> <p>Comprehensive instruction manual for the Migatronic Automig X series of MIG-MAG welding machines, covering general description, operation, technical data, maintenance, and troubleshooting.</p>



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**MIGATRONIC IN A BOX**  
- INTELLIGENT, PORTABLE  
MULTI FUNCTIONAL WELDING  
MACHINE WITH ALL THE BEST  
FROM MIGATRONIC

**MIG**   
**MMA**   
**TIG** 

**RALLYMIG 161i**  
ALL-IN-ONE – DIRECTLY FROM  
ANY POWER POINT

Anytime, anywhere. The RallyMIG 161i is a compact and portable multi-functional welding machine that means you have all processes at your fingertips – MIG, MMA and simple TIG. Anytime, anywhere. The machine is single-phase 120V and has IFC – Power Frequency Control – to allow you to weld with a long leads cable or a generator as your power source.

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