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> H HZXVOGEN MIG250 200A Multi-Process Welder Instruction Manual

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Model: MIG250 | Brand: H HZXVOGEN

1. SAFETY INSTRUCTIONS

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

- Wear appropriate personal protective equipment (PPE), including a welding helmet with proper shade, flame-resistant clothing, welding gloves, and safety shoes.
- Ensure adequate ventilation to avoid inhaling welding fumes.
- Keep a fire extinguisher nearby.
- Do not operate the welder in damp or wet conditions.
- Ensure the workpiece is properly grounded.
- Disconnect power before performing any maintenance or changing accessories.
- Avoid touching live electrical parts or hot metal.

2. PRODUCT OVERVIEW

The H HZXVOGEN MIG250 is a versatile 6-in-1 multi-process welding machine designed for various welding tasks. It supports Gas MIG, Gasless Flux Core MIG, MMA (Stick), Spot welding, and Lift TIG. It is compatible with both 110V and 220V power inputs and features synergic control for ease of use.



Figure 2.1: HZXVOGEN MIG250 200A Multi-Process Welder. This image displays the front panel and overall design of the welding machine.



Figure 2.2: The welder's 6-in-1 capabilities, including Gas MIG, Flux Core MIG, Stick, Lift TIG, Spool Gun, and Spot Welding. Note that the WP17V TIG torch and spool gun are sold separately.

3. PACKAGE CONTENTS

Verify that all items listed below are included in your package:

- MIG250 Welding Machine
- MIG Torch
- Ground Clamp
- Electrode Holder (for MMA)
- 0.8mm Welding Wire
- Wire Wheel

- Conductive Nozzle
- Graphene Tube
- Demolition Wrench
- Hose Clamp
- User Manual

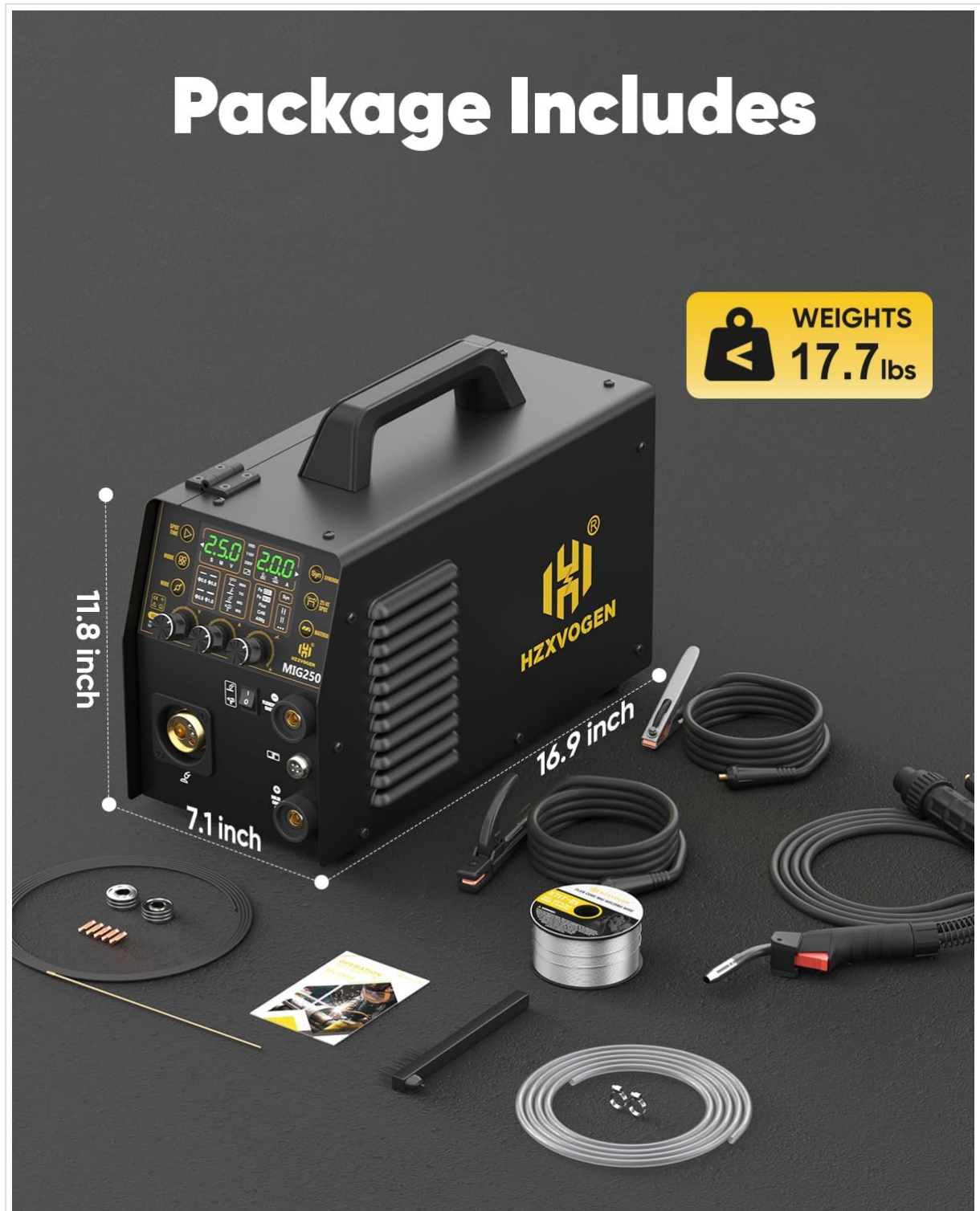


Figure 3.1: Visual representation of the items included in the MIG250 welder package. This image shows the main unit, MIG torch, ground clamp, electrode holder, welding wire, and various accessories.

4. SETUP

4.1 Power Connection

The MIG250 welder is designed for dual voltage input (110V/220V). The machine automatically detects the input voltage.

- Connect the power cord to a suitable power outlet. Ensure the outlet matches the welder's voltage requirements.
- Turn the power switch on the rear panel to the 'ON' position.

4.2 Welding Mode Connections

The welder supports multiple processes. Connect the accessories according to the desired welding mode.



Figure 4.1: Diagram illustrating the correct cable connections for Gas MIG, Flux Core MIG, Stick, Lift TIG, and Spool Gun welding modes. Pay attention to polarity and connection points for each process.

4.2.1 MMA (Stick) Welding Setup

- Connect the electrode holder cable to the positive (+) terminal.
- Connect the ground clamp cable to the negative (-) terminal.
- Securely attach the ground clamp to the workpiece.
- Insert the welding electrode into the electrode holder.

4.2.2 MIG Welding Setup (Gas/Flux Core)

- **Wire Spool Installation:** Open the side panel. Install the appropriate welding wire spool onto the spindle. Secure it with the knob.
- **Wire Feeding:** Guide the wire through the wire feeder mechanism. Close the wire feeder tension arm.
- **MIG Torch Connection:** Connect the MIG torch to the Euro connector on the front panel.
- **Ground Clamp:** For Gas MIG, connect the ground clamp to the negative (-) terminal. For Gasless Flux Core MIG, connect the ground clamp to the positive (+) terminal.
- **Gas Connection (for Gas MIG):** Connect the gas hose from your gas cylinder (e.g., CO₂, Argon, or mixed gas) to the gas inlet on the rear panel of the welder. Ensure all connections are tight to prevent gas leaks.

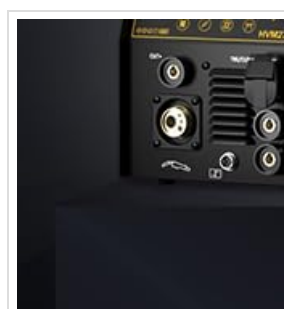


Figure 4.2: This diagram illustrates the compatibility of the welder with Aluminum Wire (1.0mm), Flux Core Wire (0.8/0.9/1.0mm), and Mild MIG Wire (0.6/0.8/0.9/1.0mm), along with the wire feeding path.

4.2.3 Lift TIG Welding Setup

- Connect the Lift TIG torch (WP17V TIG torch sold separately) to the negative (-) terminal.
- Connect the ground clamp cable to the positive (+) terminal.
- Connect the gas hose from your Argon gas cylinder to the gas inlet on the rear panel.

5. OPERATING INSTRUCTIONS

5.1 Control Panel Overview

The MIG250 features a large LED digital display and intuitive controls for easy operation.



Figure 5.1: Detailed view of the control panel, highlighting the LED display, mode selection buttons, wire diameter selection, synergic mode indicator, 2T/4T/Spot function, material selection, current/voltage displays, and adjustment knobs.

5.2 Mode Selection

Use the 'MODE' button to cycle through the available welding processes: Gas MIG, Gasless Flux Core MIG, MMA, Spot, and Lift TIG.

5.3 Parameter Adjustment

Adjust welding parameters using the dedicated knobs and buttons on the control panel.

- **Current Knob:** Adjusts the welding current (Amps).
- **Voltage Knob:** Adjusts the welding voltage (Volts).
- **Wire Button:** Selects the wire diameter (e.g., 0.6mm, 0.8mm, 0.9mm, 1.0mm).
- **Material Button:** Selects the material type (e.g., Fe+CO₂, Fe+MIX, Flux, CrNi, AlMg).
- **Burn Back Adjustment:** Adjusts the burn-back time to prevent wire sticking.
- **Pre-flow/Post-flow:** Adjusts gas pre-flow and post-flow times for TIG welding.

5.4 Synergic Mode

The synergic MIG technology simplifies welding by automatically adjusting recommended current and wire feed speed based on your wire diameter and material selection. This mode is ideal for beginners.



Figure 5.2: The synergic control interface, showing automatic matching of wire feed and voltage. Users can fine-tune settings with voltage compensation.

5.5 2T/4T Function

The 2T/4T function allows for different torch trigger operations:

- **2T (Two-Touch):** Press and hold the trigger to weld, release to stop.
- **4T (Four-Touch):** Press and release the trigger to start welding, press and release again to stop. This is useful for longer welds.

5.6 Spot Welding Function

The Spot welding function allows for precise, timed spot welds. Adjust the spot time (0-3s) by rotating the current button.

6. MAINTENANCE

6.1 General Cleaning

Regularly clean the welder to ensure optimal performance and longevity.

- Use compressed air to blow out dust and debris from the cooling vents.
- Wipe down the exterior with a clean, dry cloth.

6.2 Wire Feeder Maintenance

Inspect the wire feeder rollers and liner regularly for wear or damage. Replace as needed to ensure smooth wire feeding.

6.3 Consumables Replacement

Regularly check and replace worn MIG tips, nozzles, and TIG electrodes to maintain weld quality.

7. TROUBLESHOOTING

If you encounter issues, refer to the following common problems and solutions:

Problem	Possible Cause	Solution
No arc/Poor arc starting	Improper grounding, incorrect settings, worn consumables	Check ground clamp connection, verify settings, replace contact tip/electrode.
Wire feeding issues	Incorrect roller size, worn liner, wire tangle	Ensure correct drive roller, replace liner, untangle wire spool.
Overheating protection activated	Extended use, blocked vents	Allow machine to cool down, ensure clear airflow to vents.
Poor weld quality	Incorrect parameters, improper technique, contaminated material	Adjust current/voltage/wire feed speed, clean workpiece, improve technique.

8. SPECIFICATIONS

Below are the technical specifications for the H HZXVOGEN MIG250 welder:

Feature	Specification
Model	MIG250
Input Voltage	110/220V
Welding Processes	Gas MIG, Flux Core MIG, MMA, Spot, Lift TIG
Max Output Current	200A
Item Weight	12.7 kg
Dimensions	49.2 x 45.2 x 26.8 cm
Cooling	Energy-efficient cooling fan
Protection Features	VRD, Over Current, Over Voltage, Over-load, Overheating

8.1 MIG Welding Parameters



Figure 8.1: Table detailing recommended MIG welding parameters based on material, wire type, gas flow rate, gas type, wire diameter, and welding thickness/current.

8.2 Stick & Lift TIG Welding Parameters

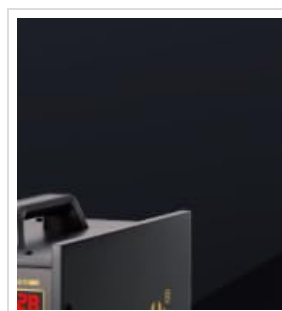


Figure 8.2: Table outlining recommended parameters for MMA (Stick) and Lift TIG welding, including material, electrode type/tungsten diameter, and welding current for various material thicknesses.

9. WARRANTY AND SUPPORT

The HZXVOGEN MIG250 welder comes with a **2-year quality support warranty**. For any technical assistance, warranty claims, or product inquiries, please contact H HZXVOGEN customer service. You can visit the official H HZXVOGEN store for more information and support: [H HZXVOGEN Store](#)

10. PRODUCT VIDEOS

10.1 HZXVOGEN Plasma Cutter Welder Combo Overview

Video 10.1: This video from H HZXVOGEN provides an overview of a Plasma Cutter Welder Combo unit, demonstrating various welding processes including HF TIG, MIG, and Stick. While it features a combo unit, the welding processes shown are relevant to the MIG250's capabilities.