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GZ GUOZHI MIG-160

GZ GUOZHI MIG-160 Multi-Process Welder Instruction Manual

Model: MIG-160

1. Introduction

This manual provides essential information for the safe and effective operation of your GZ GUOZHI MIG-160 Multi-Process Welder. Please read this manual thoroughly before operating the machine and keep it for future reference. The MIG-160 is a versatile 6-in-1 welding machine capable of Gas MIG, Gasless Flux Core MIG, Stick/MMA, Lift TIG, Spot Welding, and Spool Gun operations. It features dual voltage compatibility (110V/220V) and synergic control for ease of use.



Image: The GZ GUOZHI MIG-160 Multi-Process Welder, highlighting its six welding functions: Gas MIG, Flux Core MIG, Stick, Lift TIG, Spool Gun, and Spot Welding. The control panel shows 110V/220V input and MAX 160A output.

2. Safety Precautions

Always prioritize safety when operating welding equipment. Failure to follow safety guidelines can result in serious injury or death. Ensure you wear appropriate personal protective equipment (PPE) including a welding helmet, gloves, and protective clothing. Work in a well-ventilated area to avoid inhaling fumes. Keep a fire extinguisher nearby.

- **Electric Shock:** Welding current can cause electric shock. Do not touch live electrical parts. Ensure proper

grounding.

- **Fumes and Gases:** Welding produces fumes and gases that can be hazardous to health. Use adequate ventilation or a fume extractor.
- **Arc Rays:** Arc rays can injure eyes and burn skin. Wear a welding helmet with a proper shade filter and protective clothing.
- **Fire and Explosion:** Welding sparks and hot metal can cause fires. Keep flammable materials away from the welding area.
- **Burns:** Hot metal and slag can cause burns. Wear protective gloves and clothing.



Image: The GZ GUOZHI MIG-160 welder highlighting its safety features including over-heat, over-load, over-voltage, and over-current protection, along with an excellent heat dissipation system.

3. Setup and Connections

3.1 Unpacking and Inspection

Carefully unpack the welding machine and all accessories. Inspect for any damage that may have occurred during shipping. Ensure all components listed in the packing list are present.

- 1 x MIG-160 Welding Machine
- 1 x 500A Electrode Holder Assembly (10-feet)
- 1 x MIG Welding Gun Assembly (13-feet)
- 1 x 500A Work Clamp Assembly (10-feet)
- 1 x Gas Welding Hose
- 1 x MIG Welding Gun Accessories
- 1 x User Manual
- 1 x 220V-110V Adapter



Image: A visual representation of the items included in the GZ GUOZHI MIG-160 welding machine package.

3.2 Power Connection

The MIG-160 features a dual-voltage design (90V-260V wide-voltage, 115V/230V automatic conversion). Connect the machine to a suitable power outlet using the provided adapter if necessary. Ensure the power source matches the machine's requirements.



Image: Illustration of the dual voltage capability of the GZ GUOZHI MIG-160 welder, showing connections for both 110V and 220V power sources.

3.3 Wire Installation (Solid Wire)

1. Open the side panel of the welder.
2. Unscrew the retaining knob and place the 1.0 Pounds (0.8mm) solid wire spool onto the spindle.
3. Secure the spool with the retaining knob.
4. Feed the wire through the wire feeder mechanism, ensuring it passes through the correct groove for 0.030 inch (0.8mm) wire.
5. Close the side panel.

3.4 Wire Installation (Flux-Cored Wire)

1. Open the side panel of the welder.
2. Unscrew the retaining knob and place the 1.0 Pounds (0.8mm) flux-cored wire spool onto the spindle.
3. Secure the spool with the retaining knob.
4. Feed the wire through the wire feeder mechanism, ensuring it passes through the correct groove for 0.030 inch (0.8mm) wire.
5. Close the side panel.

3.5 Connection Methods for Welding Processes

Refer to the video below for detailed connection instructions for each welding mode.

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Video: GUOZHI MIG-160 Operation video demonstrating connection methods for MIG, Flux MIG, Spool Gun, Lift TIG, and MMA welding processes, along with wire loading and dual voltage operation.

- **Gas MIG:** Connect the MIG gun to the positive (+) terminal and the earth clamp to the negative (-) terminal. Connect the gas hose to the gas inlet on the rear panel.
- **Gasless Flux Core MIG:** Connect the MIG gun to the negative (-) terminal and the earth clamp to the positive (+) terminal. No gas connection is required.
- **Spool Gun:** Connect the spool gun to the designated spool gun connector. The spool gun is not included and must be purchased separately.
- **Lift TIG:** Connect the Lift TIG torch to the negative (-) terminal and the earth clamp to the positive (+) terminal. The Lift TIG torch (WP17V) is not included and must be purchased separately.
- **Stick/MMA:** Connect the electrode holder to the positive (+) terminal and the earth clamp to the negative (-) terminal for most electrodes. Consult electrode specifications for polarity.

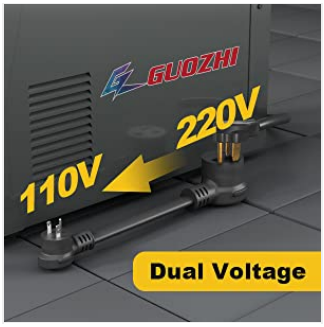


Image: A spool gun, which is an optional accessory for the GZ GUOZHI MIG-160 welder, used for welding aluminum.

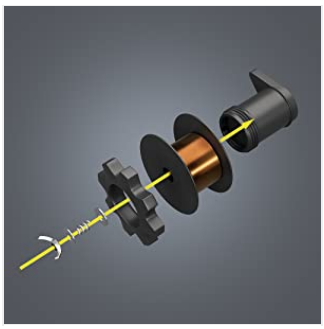


Image: A Lift TIG torch (WP17V), an optional accessory for the GZ GUOZHI MIG-160 welder, used for TIG welding.

4. Operating Instructions

4.1 Control Panel Overview

The MIG-160 features a user-friendly control panel with dual LED displays for current and voltage. Familiarize yourself with the controls before operation.



Image: Detailed view of the GZ GUOZHI MIG-160 control panel, indicating various functions such as Gas test, VRD, Current adjustment, Current meter, 2T/4T, Unitary/Part, O.C light, Pre-flow/Post-gas, Power light, Voltage/Time adjustment, Voltage meter, Wire test, and Welding mode selection.

4.2 Welding Modes and Settings

- **Synergic Control:** In this mode, adjusting the amperage automatically changes the voltage and wire feeding speed, simplifying setup for both beginners and experienced welders.
- **Manual Mode:** For advanced users, switch to manual mode to freely adjust machine parameters.
- **Current Adjustment:**
  - MIG: 40A-160A
  - MMA: 20A-140A

- TIG: 10A-140A

- **Preset Function:** Voltage and current settings can be preset for convenience, allowing for quick recall of preferred welding parameters.
- **2T/4T Function:** 2T is suitable for spot welding and simple tasks, while 4T is ideal for continuous, long-term welding.
- **Pre-flow/Post-gas:** This function protects accessories from oxidation. Pre-flow ensures gas flow before the arc starts, and Post-gas maintains flow after the arc stops.
- **Wire Test/Gas Test:** Use these functions to check wire feed and gas flow without striking an arc.



Image: A close-up of a welding operation, showcasing the sparks and arc produced by the machine during use.

4.3 Welding Performance

The MIG-160 is designed for low welding spatter and produces a beautiful weld appearance. Its wide voltage design ensures stable operation even with voltage fluctuations. The machine is also tested for low-temperature resistance, capable of working normally at temperatures as low as -20°C.

Image: Examples of various weld beads, demonstrating the smooth and clean welding performance of the GZ GUOZHI MIG-160 welder.

Image: The GZ GUOZHI MIG-160 welder shown operating in a cold environment, indicating its ability to function normally at temperatures as low as -20 degrees Celsius.

5. Maintenance

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

- **Cleaning:** Periodically clean the machine's exterior and internal components (if accessible) to prevent dust and debris buildup, which can affect cooling and performance.
- **Cable Inspection:** Regularly inspect all cables, including the power cord, welding cables, and torch leads, for

cuts, fraying, or damage. Replace damaged cables immediately.

- **Torch and Consumables:** Check the MIG gun nozzle, contact tip, and diffuser for wear. Replace consumables as needed to maintain weld quality. For Stick/MMA, ensure the electrode holder is clean and grips electrodes securely.
- **Wire Feeder:** Keep the wire feeder mechanism clean and free of debris. Ensure the drive rolls are correctly sized for your wire and are not worn.
- **Ventilation:** Ensure the ventilation openings on the machine are clear and unobstructed to allow for proper airflow and prevent overheating.

6. Troubleshooting

This section provides solutions to common issues you might encounter. For problems not listed here, contact customer support.

Problem	Possible Cause	Solution
No power to the machine	Power cord unplugged, circuit breaker tripped, faulty power switch.	Check power connections, reset circuit breaker, ensure power switch is ON.
No arc or weak arc	Improper grounding, incorrect settings, worn consumables, loose connections.	Ensure good ground connection, verify welding parameters, replace contact tip/nozzle, tighten all connections.
Wire feeding issues	Incorrect drive roll tension, wrong drive roll size, tangled wire, clogged liner.	Adjust drive roll tension, use correct drive rolls, untangle wire, clean or replace liner.
Overheat protection activated	Exceeded duty cycle, poor ventilation, high ambient temperature.	Allow machine to cool down, ensure proper ventilation, reduce welding time.

7. Specifications

Feature	Detail
Model Number	MIG-160
Input Voltage	90V-260V (115V/230V Dual-Voltage Automatic Conversion)
MIG Current Range	40A-160A
MMA Current Range	20A-140A
TIG Current Range	10A-140A
Welding Processes	Gas MIG, Gasless Flux Core MIG, Stick/MMA, Lift TIG, Spot Welding, Spool Gun
Flux Core Wire Compatibility	0.03" & 0.035"
Solid Wire Compatibility	0.023" & 0.03"
Item Weight	42 pounds
Package Dimensions	21.5 x 15 x 13.5 inches

Feature	Detail
Manufacturer	GZ GUOZHI

8. Warranty and Support

GZ GUOZHI provides a **12-month warranty** for machines purchased from the GZ GUOZHI store (excluding accessories). If the machine is damaged due to non-human factors within 12 months, please contact customer service through the Amazon channel or email for a replacement. The GZ GUOZHI after-sales team aims to resolve your problem as soon as possible.
For additional support or inquiries, please refer to the contact information provided with your purchase or visit the official GZ GUOZHI store on Amazon.

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