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**ANDELI MCT-520DPL**

# ANDELI MCT-520DPL 5-in-1 Multiprocess Welder Instruction Manual

Model: MCT-520DPL | Brand: ANDELI

## 1. Introduction

The ANDELI MCT-520DPL is a versatile 5-in-1 multiprocess inverter welding machine designed for a wide range of welding and cutting applications. This unit supports CUT (Plasma Cutting), MIG (CO2/MIX/FLUX), TIG (HF), COLD, PULSE, and MMA (Stick) welding functions. Its advanced IGBT technology ensures stable performance and efficient operation across various materials.




*Figure 1: ANDELI MCT-520DPL Multiprocess Welder with included accessories.*

## 2. Safety Information

Always prioritize safety when operating welding and cutting equipment. This machine features sheet metal shock-resistant construction, a durable transformer, and an automatic overload shutdown function. It incorporates Advanced IGBT Technology for reliable performance. Please adhere to all local and national safety regulations.

- Wear appropriate personal protective equipment (PPE), including welding helmet, gloves, and protective clothing.
- Ensure proper ventilation in your work area to avoid inhaling fumes.
- Always disconnect power before performing maintenance or changing accessories.
- Do not operate the machine in wet conditions.
- Keep children and unauthorized personnel away from the work area.




*Figure 2: Safety features of the ANDELI MCT-520DPL, including shock resistance and auto shutdown.*

## 3. Package Contents

The following items are included with your ANDELI MCT-520DPL Multiprocess Welder:

- ANDELI MCT-520DPL Multiprocess Welder Unit (with US plug)
- Ground Clamp
- MIG Torch (15AK)
- CUT Torch (PT-31)
- TIG Torch (WP-9F)
- MMA Holder
- Gas Pipe (3m)
- Air Pressure Regulator
- Hose Clamps (x2)
- Tungsten Electrodes (x10)

- Tips (x10)
- Electrodes (x10)
- Collets (x10)
- Nozzles (x20)
- Stainless Steel Wire
- Carbon Steel Wire (1kg)
- Welding Wire (3m)
- Welding Gloves
- Welding Rods (x5)
- Nozzle Shields (x2)




*Figure 3: Overview of all components and accessories included in the package.*

## 4. Setup

### 4.1 Power Connection

Connect the welder unit to a 220V AC power source using the provided US plug. Ensure the power source meets the machine's electrical requirements.

### 4.2 Connecting Welding Components

Connect the appropriate torch (MIG, TIG, or CUT) and the ground clamp/MMA holder to the designated ports on the front panel of the welder. Ensure all connections are secure.

### 4.3 Wire Installation (for MIG Welding)

Open the side panel of the welder. Install the appropriate wire spool (stainless steel or carbon steel) onto the spindle. Feed the wire through the drive roller mechanism and into the MIG torch liner. Adjust the wire tension as needed.

### 4.4 Gas Connection

For MIG (CO2/MIX), TIG (HF), and Cold welding, connect the gas pipe from your gas cylinder (e.g., pure argon for Cold welding) to the gas inlet on the rear panel of the welder via the air pressure regulator. Ensure all gas connections are leak-free.

## 5. Operating Modes

The MCT-520DPL offers multiple welding and cutting functions. Select the desired mode using the control panel and adjust parameters accordingly.




*Figure 4: Control panel illustrating the various functions: MIG, CUT, TIG, Cold, MMA, Pulse.*

### 5.1 MMA (Stick) Welding

Connect the MMA holder and ground clamp. Select MMA mode on the control panel. Adjust the current (amperage) based on the welding rod and material thickness. This mode is suitable for various steels.

### 5.2 MIG Welding (CO2/MIX/FLUX)

Connect the MIG torch and ground clamp. Select MIG mode. Choose between CO2, MIX gas, or FLUX-cored wire

settings. Adjust wire feed speed and voltage according to material and wire type. This mode is effective for thin steel, iron, and stainless steel.

### 5.3 TIG Welding (HF)

Connect the TIG torch and ground clamp. Select TIG (HF) mode. Ensure proper gas flow (e.g., argon). Adjust amperage for precise welding of thin materials like stainless steel and low-carbon steel.

### 5.4 CUT (Plasma Cutting)

Connect the CUT torch and ground clamp. Select CUT mode. Ensure compressed air is connected and flowing. Adjust cutting current based on material thickness for efficient plasma cutting.

### 5.5 COLD Welding

Connect the TIG torch and ground clamp. Select COLD mode. This mode is ideal for welding thin stainless steel, thin steel, and carbon steel with minimal heat input, preventing deformation and discoloration. Pure argon gas is required.

### 5.6 PULSE Welding

Select PULSE mode for enhanced control over heat input, particularly useful for thin materials or when precise bead control is required.




*Figure 5: Visual examples of welding and cutting results from different modes.*




*Figure 6: Thickness ranges for CUT, Cold, MIG, TIG, and MMA operations.*

## 6. Applicable Materials

The ANDELI MCT-520DPL is suitable for:

- Ordinary thin steel
- Iron
- Stainless steel
- Low-carbon steel
- Mold repair

**Note: This welding machine is NOT suitable for welding aluminum.**




*Figure 7: Examples of materials compatible with the welder.*

## 7. Maintenance

- Regularly clean the machine's exterior and ventilation openings to prevent dust buildup.
- Inspect all cables and connections for wear or damage before each use.
- Replace worn or damaged torch consumables (tips, nozzles, electrodes) as needed.
- Store the welder in a dry, clean environment away from direct sunlight and extreme temperatures.

## 8. Troubleshooting

If you encounter problems, please refer to the full user manual for detailed troubleshooting steps. Common issues may include:

- **No Arc/Poor Arc:** Check power supply, ground clamp connection, wire feed, gas flow, and consumable condition.
- **Overheat Protection:** Allow the machine to cool down. Ensure ventilation is not obstructed.
- **Wire Feeding Issues:** Check wire spool installation, drive roller tension, and liner condition.

## 9. Specifications

| Specification | Value |
|---|---|
| Manufacturer | ANDELI |
| Item Model Number | MCT-520DPL |
| Power Source | AC (220V) |
| Item Weight | 24.8 kg |
| Parcel Dimensions | 60.2 x 57.4 x 29.72 cm |
| Country of Origin | China |

## 10. Warranty and Support

The ANDELI MCT-520DPL Multiprocess Welder comes with a two-year warranty. Returns and exchanges are available within 30 days of receiving the goods. For any issues or guidance, please contact our efficient customer service team.


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