



Manuals.plus /

› AZZUNO /

› AZZUNO 135 Amp MIG Welder Instruction Manual

## AZZUNO

# AZZUNO 135 Amp MIG Welder Instruction Manual

Model: MIG-135A | Brand: AZZUNO

## 1. PRODUCT OVERVIEW

The AZZUNO 135 Amp MIG Welder is a compact and powerful 3-in-1 multiprocess welding machine, offering Flux MIG, Lift TIG, and Stick (MMA) welding capabilities. Designed with synergic control, it simplifies parameter settings, making it ideal for both beginners and experienced users. Its robust IGBT inverter technology ensures stable performance and efficient welding across various applications.



Figure 1: AZZUNO 135 Amp MIG Welder and its components.

### Key Features:

- **Synergic Control:** Automatically selects optimal voltage, amperage, and wire feeding speed based on welding data, simplifying operation.
- **Multi-process Capability:** Supports Flux MIG (Flux Cored Wire), Lift TIG (torch not included), and Stick (MMA) welding.
- **Portable Design:** Lightweight (10.8 pounds) and compact (15.35 x 12.6 x 11.02 inches) for easy transport and storage.
- **Safety Features:** Equipped with overload and overheating protection systems for safe operation.
- **Versatile Welding:** Capable of welding mild steel plates up to 3.0mm (0.12 inches) thick.



Figure 2: Visual representation of the welder's core technologies and safety features.

## 2. SAFETY INFORMATION

**WARNING: Welding can be dangerous. Always follow safety precautions to prevent injury or death.**

- Always wear appropriate personal protective equipment (PPE), including a welding helmet, gloves, and protective clothing.
- Ensure proper ventilation to avoid inhaling welding fumes.
- Protect eyes and skin from arc rays.
- Prevent fire hazards by keeping flammable materials away from the welding area.
- Ensure the welding machine is properly grounded.
- Do not operate the welder in wet conditions.
- Disconnect power before performing any maintenance or adjustments.



Figure 3: The welder features visible warning labels for user safety.

### 3. PRODUCT COMPONENTS

The AZZUNO 135 Amp MIG Welder comes with the following standard components:

- MIG Welder Unit
- Flux Cored Wire (0.8mm)
- MIG Gun
- Electrode Holder
- Earth Clamp
- Brush

# ACCESSORIES & SIZE



- 1 Ground clamp
- 2 Electrode holder
- 3 Mig torch
- 4 0.8mm flux cored wire
- 5 Brush



Figure 4: Included accessories and the compact size of the welder.

## 4. SETUP AND INSTALLATION

### 4.1 Connecting Components

1. **Connect the MIG Gun:** Insert the MIG gun connector into the designated torch output port on the front panel of the welder. Secure it by twisting the connector clockwise.
2. **Connect the Ground Clamp:** Attach the ground clamp cable to the negative terminal on the welder's front panel. Ensure a secure connection. The ground clamp should be attached to the workpiece or a clean, bare metal surface connected to the workpiece.
3. **Connect the Electrode Holder (for Stick/MMA welding):** If performing Stick welding, connect the electrode holder cable to the positive terminal on the welder's front panel.

Video 1: Demonstrates connecting the MIG gun and ground clamp to the welder.

## 4.2 Loading Flux Cored Wire

1. Open the side compartment of the welder to access the wire feed mechanism.
2. Place the spool of 0.8mm flux cored wire onto the spindle. Ensure the wire unwinds smoothly.
3. Thread the wire through the wire feed rollers and into the MIG gun liner. Adjust the tension on the wire feed rollers to prevent slipping or crushing the wire.

Video 2: Shows the process of opening the wire compartment and loading the wire spool.

## 4.3 Power Connection

Connect the welder to a standard 110V power outlet. Ensure the power source can handle the welder's current requirements to avoid tripping circuit breakers.



Figure 5: Front panel controls and connection points.

## 5. OPERATING INSTRUCTIONS

### 5.1 Selecting Welding Mode

The AZZUNO 135 Amp MIG Welder supports Flux MIG, Lift TIG, and Stick (MMA) welding. Use the 'CHOOSE' button on the control panel to cycle through the available welding modes.

- **Flux MIG:** For welding with flux cored wire, ideal for outdoor use or when gas shielding is not practical.
- **Lift TIG:** For precise welding of thinner materials (requires a separate Lift TIG torch).
- **Stick (MMA):** For welding with coated electrodes, suitable for various materials and conditions.



Figure 6: The welder supports multiple welding processes for diverse applications.

### 5.2 Adjusting Parameters (Synergic Control)

The welder features synergic control, which automatically sets optimal welding parameters. However, you can fine-tune settings using the dedicated knobs:

- **Voltage Adjustment:** Use the 'VOLTAGE' knob to increase or decrease the welding voltage.
- **Wire Feed Adjustment (for MIG):** Use the 'WIRE FEED' knob to control the speed at which the welding wire

is fed.

- **Current Adjustment (for MMA/TIG):** Use the 'CURRENT' knob to adjust the welding amperage.

Video 3: Demonstrates adjusting current and voltage settings on the control panel.

### 5.3 Welding Applications

This welder is suitable for various metals and applications:

- Weld up to 0.030" (0.8mm) and 0.035" (0.9mm) with flux core wire.
- Capable of welding mild steel plates up to 3.0mm (approximately 1/8 inch) thick.
- ARC mode fits rods: E6013.



Figure 7: Examples of suitable metals and weld quality achievable with the machine.

## 6. MAINTENANCE

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

- **Cleaning:** Periodically clean the exterior of the welder with a dry cloth. Ensure ventilation openings are free from dust and debris.
- **Wire Feed System:** Inspect the wire feed rollers and liner for wear or blockages. Clean or replace as necessary to ensure smooth wire feeding.
- **Connections:** Regularly check all cable connections (MIG gun, ground clamp, electrode holder) for tightness and signs of damage.
- **Cooling System:** The welder features a rapid heat dissipation system with a high-speed cooling fan. Ensure the fan intake and exhaust are not obstructed to maintain efficient cooling.

## RAPID HEAT DISSIPATION SYSTEM



High speed cooling fan



Quiet



Welding all day



Figure 8: The welder's efficient cooling system for prolonged use.

## 7. TROUBLESHOOTING

If you encounter issues with your AZZUNO welder, refer to the following common troubleshooting tips:

Problem	Possible Cause	Solution
No Power	Power cord not connected; Circuit breaker tripped; Welder switch off.	Check power connection; Reset breaker; Turn welder switch ON.
No Arc	Poor ground connection; Incorrect settings; Consumables worn.	Ensure good ground contact; Adjust voltage/current; Replace tip/nozzle.
Wire Feed Issues	Wire tangled; Rollers too loose/tight; Liner clogged.	Untangle wire; Adjust roller tension; Clean/replace liner.
Overheating Protection Activated	Prolonged use; Obstructed ventilation.	Allow welder to cool down; Clear ventilation openings.

For further assistance, please contact AZZUNO customer service.

## 8. SPECIFICATIONS

Attribute	Detail
Model	MIG-135A (MIG135R-US)
Manufacturer	AZZUNO
Item Weight	10.8 pounds
Product Dimensions	15.35 x 12.6 x 11.02 inches
Country of Origin	China
Power Source	DC
Voltage	100 Volts (110V compatible)
Included Components	MIG welder, flux cored wire, MIG Gun, Electrode holder, Earth clamp, Brush
Welding Capacity (Plate)	Up to 3.0mm (0.12 inches) mild steel
Wire Compatibility	0.030" (0.8mm) & 0.035" (0.9mm) flux core wire
ARC Rod Compatibility	E6013

## 9. WARRANTY AND SUPPORT

AZZUNO is committed to providing high-quality products and excellent customer service. For any questions, concerns, or technical support regarding your MIG welder, please do not hesitate to contact us.

Our customer service team is available to assist you with product inquiries, troubleshooting, and warranty claims. Please refer to your purchase documentation for specific warranty terms and contact information, or visit the official AZZUNO store on Amazon.

We value your satisfaction and are here to ensure you have a positive experience with your AZZUNO welding machine.