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› ANDELI MIG-270DLS Multiprocess Welder Instruction Manual

ANDELI MIG-270DLS

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Model: MIG-270DLS

1. INTRODUCTION

This manual provides detailed instructions for the safe and effective operation of your ANDELI MIG-270DLS Multiprocess Welder. This versatile machine supports MIG (CO₂/MIX/FLUX), Lift TIG, and MMA (Stick) welding processes, operating on both 110V and 220V power supplies. Please read this manual thoroughly before use to ensure proper setup, operation, and maintenance.



Figure 1: ANDELI MIG-270DLS Multiprocess Welder and included accessories.

2. SAFETY INFORMATION

Welding can be dangerous. Always follow safety precautions to prevent injury or death. Read and understand all safety warnings and instructions before operating this equipment.

- **Electric Shock Can Kill:** Ensure proper grounding. Do not touch live electrical parts. Wear dry welding gloves and protective clothing.
- **Fumes and Gases Can Be Dangerous:** Keep your head out of the fumes. Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- **Arc Rays Can Burn Eyes and Skin:** Wear a welding helmet with a proper shade filter. Wear safety glasses with side shields. Use protective screens or barriers to protect others.
- **Fire and Explosion Hazard:** Remove all flammables within 35 feet (10 meters) of the welding area. Have a fire extinguisher nearby.
- **Hot Parts Can Cause Severe Burns:** Allow equipment to cool before touching. Wear insulated gloves.

- **Always Disconnect Power:** Before servicing or making adjustments, disconnect the power supply.

3. PRODUCT FEATURES

- **Multiprocess Welding:** Supports MIG (CO2/MIX/FLUX), Lift TIG, and MMA (Stick) welding.
- **Dual Voltage:** Operates on 110V/220V power supplies, offering flexibility and portability.
- **200A Output:** Provides a real 200Amp output current for strong welding performance.
- **Aluminum Welding Capability:** Capable of welding aluminum, compatible with a spool gun or MIG torch with a graphite wire feed tube.
- **Synergic Control:** Features intuitive synergic design for automatic adjustment of voltage and wire feeding speed based on amperage or material thickness, simplifying operation for beginners.
- **IGBT Inverter Technology:** Utilizes efficient and reliable IGBT inverters for increased duty cycle and consistent performance.
- **Safety Features:** Includes automatic protection against overheating, over-voltage, and over-current.
- **CE Certified:** Ensures compliance with European safety standards.

4. SETUP AND INSTALLATION

4.1. Control Panel Overview

The control panel features dual digital displays for current and voltage, mode selection buttons, and adjustment knobs. Understanding these controls is essential for proper operation.

SYNERGETIC

Voltage/Current Double Knob Adjustment



Figure 2: Front view of the ANDELI MIG-270DLS control panel, showing digital displays and adjustment knobs.

3-IN-1 PULSE WELDER



Figure 3: Detailed view of the control panel, highlighting mode selections (MIG, Synergic MIG, MMA, TIG, AL), gas types (CO2, MIX, FLUX, Argon), and wire diameter options (1.0, 0.9, 0.8, 0.6).

4.2. Wire Reel Installation (MIG/Flux Core)

To install the welding wire reel:

1. Open the side panel of the welder.
2. Place the wire reel onto the spindle.
3. Ensure the correct drive wheel is selected for your wire diameter. For 0.8mm wire, ensure the side marked '0.8' on the drive

wheel is facing inward.

4. Feed the wire through the guide and into the drive roller mechanism.
5. Close the side panel.

Your browser does not support the video tag.

Video 1: Product Function Introduction and Operation Guide. This video demonstrates the installation of the wire reel starting at 1:20.

4.3. MIG Torch Installation

For MIG welding, connect the MIG torch to the front panel:

- Insert the MIG torch plug into the corresponding port on the front panel and twist to secure.
- If using gas, ensure the gas line is connected to the gas inlet on the rear of the machine and to your gas bottle.
- Connect the ground clamp to the negative (-) terminal and the MIG torch to the positive (+) terminal for gas MIG welding.
- For gasless (flux core) welding, connect the MIG torch to the negative (-) terminal and the ground clamp to the positive (+) terminal.

Video 1 (continued): This video demonstrates MIG torch installation starting at 2:00.

4.4. MMA (Stick) Holder Installation

For MMA (Stick) welding:

- Connect the MMA electrode holder to the positive (+) terminal.
- Connect the ground clamp to the negative (-) terminal.

Video 1 (continued): This video demonstrates MMA holder installation starting at 2:30.

4.5. Lift TIG Torch Installation

For Lift TIG welding:

- Connect the Lift TIG torch to the negative (-) terminal.
- Connect the ground clamp to the positive (+) terminal.
- Ensure the gas pipe is connected to the gas inlet on the rear of the machine and to your argon gas bottle.

Video 1 (continued): This video demonstrates Lift TIG torch installation starting at 3:15.

5. OPERATING INSTRUCTIONS

5.1. Mode Selection and Parameter Adjustment

The ANDELI MIG-270DLS offers various welding modes and adjustable parameters:

- Use the mode selection buttons on the control panel to choose between MIG, MMA, and Lift TIG.
- In MIG mode, select between CO₂, MIX, FLUX, or AL (Aluminum) gas options. Synergic MIG welding allows selection of different gases.
- Adjust current and voltage using the respective knobs. In synergic mode, adjusting the current will automatically change the voltage and wire feed speed.
- Select the appropriate wire diameter (1.0mm, 0.9mm, 0.8mm, 0.6mm) for MIG welding.
- For MIG welding under separate mode, 2T (Manual), 4T (Semi-automatic), and Spot welding options are available.

Video 1 (continued): This video demonstrates mode selection and parameter adjustment from 0:05 to 1:20.

5.2. Gas Check (MIG/TIG)

Before starting gas-shielded welding:

- Ensure the MIG mode is open.
- Long press the gas check button on the control panel.
- Release the button to stop the gas flow. This allows you to verify gas flow and adjust the regulator.

Video 1 (continued): This video demonstrates the gas check function from 1:07 to 1:20.

5.3. Welding Aluminum Technique

When welding aluminum, specific techniques can improve bead quality:

- Maintain a consistent stick-out of approximately one centimeter.
- For a clean, uniform bead, pause briefly to allow the molten puddle to form before moving the torch.
- If a specific bead appearance is not critical, maintain a steady travel speed.

Video 1 (continued): This video demonstrates aluminum welding technique from 3:49 to 4:28.

REAL WELDING EFFECT

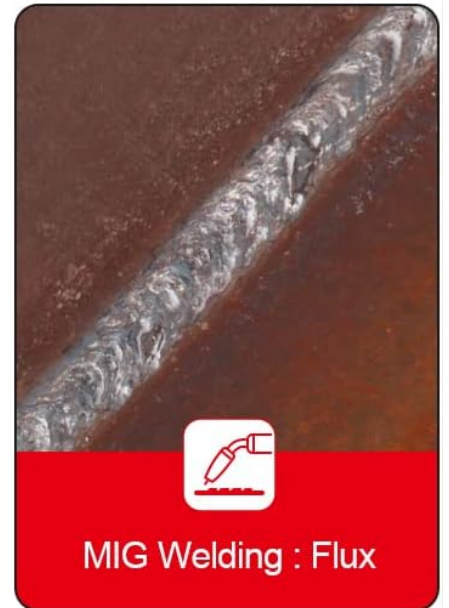
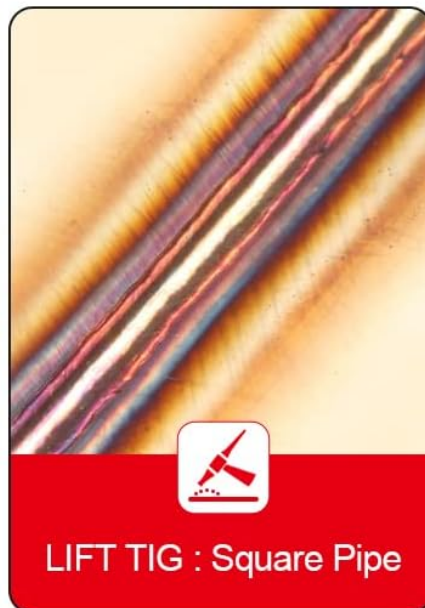


Figure 4: Examples of welding effects for MIG (CO₂, MIX, Flux), Lift TIG (Metal Plate, Square Pipe), and MMA (3.2 Electrode).

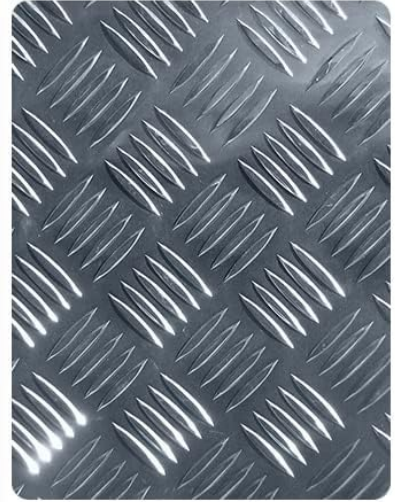
WIDE RANGE OF MATERIALS



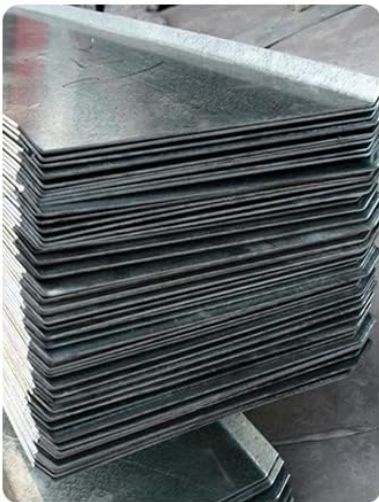
Aluminum



Carbon Steel



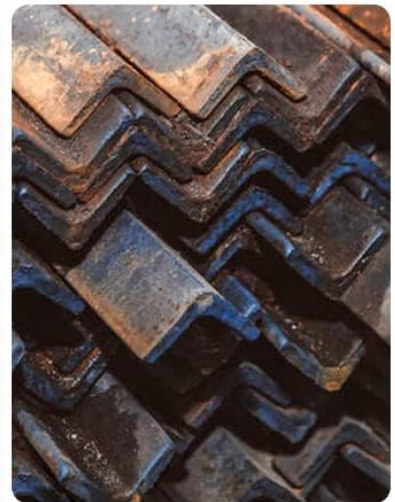
Stainless Steel



Galvanized Plate



Square Tube



Angle Steel

Figure 5: The ANDELI MIG-270DLS is suitable for welding various materials including Aluminum, Carbon Steel, Stainless Steel, Galvanized Plate, Square Tube, and Angle Steel.

6. MAINTENANCE

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

- **Cleaning:** Periodically clean the internal components and ventilation openings to prevent dust and debris buildup, which can cause overheating. Use dry, compressed air.
- **Cable Inspection:** Regularly inspect all welding cables, torches, and clamps for damage, fraying, or loose connections. Replace damaged parts immediately.
- **Drive Rollers:** Clean the wire feed drive rollers and guides to ensure smooth wire feeding. Check for wear and replace if necessary.
- **Consumables:** Replace MIG contact tips, nozzles, and TIG collets/collet bodies as they wear out to maintain weld quality.
- **Gas Lines:** Check gas lines and connections for leaks.

7. TROUBLESHOOTING

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

- **No Power:** Check power cord connection, circuit breaker, and ensure the power switch is on. Verify correct input voltage (110V/220V).
- **No Arc:** Ensure ground clamp is securely attached to the workpiece. Check electrode/wire connection. Verify correct welding mode and parameters are set.
- **Poor Wire Feed (MIG):** Check wire reel installation, tension on drive rollers, and ensure the correct drive wheel size is used. Inspect the MIG torch liner for blockages or kinks.
- **Overheat Protection:** If the welder stops and displays an overheat warning, allow it to cool down. Ensure ventilation is not obstructed. Reduce duty cycle or amperage if continuously overheating.
- **Inconsistent Weld:** Check for proper gas flow (if applicable), correct wire/electrode type and size, and clean workpiece. Adjust voltage and wire speed settings.

For further assistance, contact ANDELI customer service.

8. SPECIFICATIONS

MIG-270DLS						
Power Supply Voltage(V)	110V			220V		
Function	MIG	MMA	Lift TIG	MIG	MMA	Lift TIG
Rated Input Power(KW)	4.2	4.3	3.1	5.9	6	4.4
Rated Input Current(A)	38.1	38.6	28.3	26.8	27.7	20.1
Effective Input Current(A)	15.9	17.5	11.6	9.4	10.7	7
Welding Current Range(A)	30-140	20-120	15-140	30-180	20-160	15-180
Load Voltage(V)	21	24.8	15.6	23	26.4	17.2
Wire Diameter(MM)	0.8/1.0	/	/	0.8/1.0	/	/
Rated Duty Cycle (% 40℃ 10min)	25%			20%		
No-Load Voltage(V)	62			62		
Frequency(Hz)	60			50		
Efficiency(%)	85%					
Power Factor	0.93					
Protection Class	IP21S					
Insulation Class	H					
Cooling	Fan					
Dimension(MM)	490×200×320					
Net Weight(KG)	10					

Figure 6: Detailed technical specifications for the ANDELI MIG-270DLS welder.

9. WARRANTY AND SUPPORT

The ANDELI MIG-270DLS welder comes with a **two-year warranty**. For any issues or questions regarding your product, please contact ANDELI customer service. They provide free guidance and support, including returns and exchanges within 30 days of receipt, and free replacements under warranty. Visit the [ANDELI Store](#) for more information and support resources.

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