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› ANDELI MIG-250ME LED Welder User Manual

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Model: MIG-250ME LED

1. INTRODUCTION

Thank you for choosing the ANDELI MIG-250ME LED Welder. This versatile 3-in-1 multiprocess welding machine is designed for Flux MIG, Lift TIG, and Stick (MMA) welding, offering powerful and reliable performance for various applications. Featuring advanced IGBT inverter technology and an intuitive LED display, this welder provides precise control and ease of use for both beginners and experienced welders. Please read this manual thoroughly before operation to ensure safe and efficient use of your new welding machine.



Figure 1.1: ANDELI MIG-250ME LED Welder in operation.

This image shows a welder using the ANDELI machine, highlighting its application in a professional setting. The welder is wearing a protective helmet and gloves, demonstrating the machine's capability for various welding tasks.

2. SAFETY INSTRUCTIONS

Always prioritize safety when operating welding equipment. Failure to follow these instructions may result in serious injury or death.

- **Eye and Face Protection:** Always wear a welding helmet with appropriate shade lenses to protect your eyes and face from arc rays and sparks.
- **Body Protection:** Wear flame-resistant clothing, heavy-duty gloves, and protective footwear. Avoid synthetic

materials.

- **Ventilation:** Ensure adequate ventilation to remove welding fumes and gases from the work area. Use local exhaust ventilation or respirators if necessary.
- **Fire Prevention:** Keep a fire extinguisher nearby. Remove all flammable materials from the welding area. Be aware of hot metal and sparks.
- **Electrical Safety:** Ensure the welding machine is properly grounded. Do not operate in wet conditions. Inspect cables and connections for damage before each use.
- **Work Area:** Keep the work area clean and free of clutter. Ensure stable footing.
- **First Aid:** Know basic first aid procedures for burns and electrical shock.

3. PRODUCT OVERVIEW

3.1 Components and Accessories

The ANDELI MIG-250ME LED Welder package includes the following items:

- 1 x MIG-250ME LED Welder Unit
- 1 x MIG Torch
- 1 x Ground Clamp
- 1 x Electrode Holder (for Stick welding)
- 2 x Nozzles
- 5 x Conductive Tips
- 5 x Welding Rods
- 1 x Hammer/Brush
- 1 x User Manual

Note: A Lift TIG torch and additional MMA holder are not included and must be purchased separately for TIG/Stick welding functionality.



Figure 3.1: Included Components and Accessories.

This image displays the main welding unit along with all the accessories provided in the package, such as the MIG torch, ground clamp, electrode holder, various nozzles, contact tips, welding rods, and a brush, illustrating the complete setup for immediate use.

3.2 Key Features

- **Multiprocess Capability:** Supports Flux MIG, Lift TIG, and Stick (MMA) welding modes.
- **Dual Voltage Input:** Operates on 220V, providing flexibility for various power sources.
- **IGBT Inverter Technology:** Ensures high efficiency, stable arc, and increased duty cycle.
- **Intuitive LED Display:** Provides real-time data and allows for easy adjustment of welding parameters.
- **Synergic Control:** Simplifies parameter setting, especially for beginners, by automatically adjusting wire feed speed based on current.
- **Compact and Portable:** Lightweight design for easy transport and storage.
- **Safety Protection:** Automatic protection against overheating, over-voltage, and over-current.

LARGER LED DISPLAY

DELIVERING REAL-TIME DATA WITH CRYSTAL
-CLEAR VISIBILITY



Figure 3.2: Larger LED Display.

This image focuses on the welder's large LED display, which shows clear digital readouts for welding parameters such as current (250A), wire diameter (2.0mm), and various mode indicators, emphasizing its user-friendly interface for real-time data monitoring.

4. SETUP

4.1 Power Connection

1. Ensure the welder's power switch is in the "OFF" position.
2. Connect the power cord to a suitable 220V power outlet. Ensure the outlet is properly grounded and can supply the required amperage.

4.2 Wire Feed Setup (for Flux MIG)

1. Open the wire spool compartment.
2. Place the flux core wire spool onto the spindle, ensuring it rotates freely.
3. Thread the wire through the wire feed mechanism, ensuring it passes through the drive rollers and into the MIG

torch liner.

4. Adjust the tension of the drive rollers to prevent slipping or crushing the wire.
5. Close the compartment.

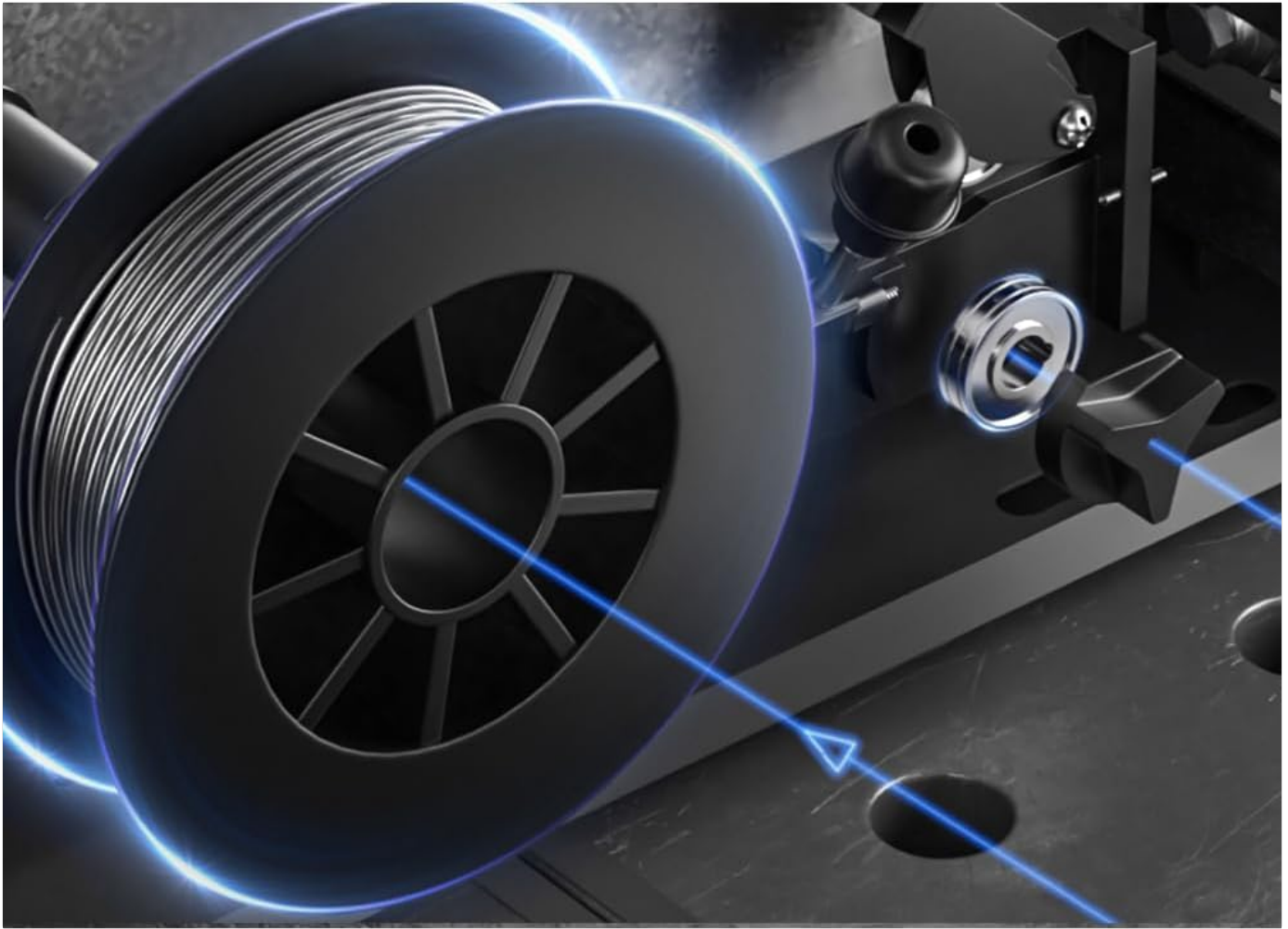


Figure 4.1: Wire Feed Mechanism.

This image provides a detailed view of the wire feed system within the welder, illustrating how the flux core wire is loaded onto the spool and guided through the rollers, which are crucial for consistent wire delivery during MIG welding.

4.3 Connecting Accessories

1. **MIG Torch:** Connect the MIG torch cable to the corresponding connector on the front panel of the welder. Ensure it is securely fastened.
2. **Ground Clamp:** Connect the ground clamp cable to the negative (-) terminal on the welder. Attach the ground clamp securely to the workpiece, ensuring good electrical contact.
3. **Electrode Holder (for Stick/MMA):** If performing Stick welding, connect the electrode holder cable to the positive (+) terminal on the welder.
4. **Lift TIG Torch (Optional):** If using a Lift TIG torch (purchased separately), connect it to the appropriate terminal as per the torch's instructions.

5. OPERATING INSTRUCTIONS

5.1 General Operation

1. Turn on the welder using the power switch.
2. Select the desired welding mode (MIG, Lift TIG, or Stick) using the mode selection button on the control panel.
3. Adjust the welding parameters (current, wire feed speed, voltage) using the control knobs and observing the LED display. For synergic MIG, the machine will assist in setting optimal parameters.
4. Perform a test weld on scrap material to verify settings before welding your actual workpiece.

5.2 Flux MIG Welding

This mode is ideal for welding without external shielding gas, using flux-cored wire.

1. Ensure flux core wire is correctly loaded and the MIG torch is connected.
2. Select "MIG" mode.
3. Set the appropriate current and wire feed speed based on the material thickness and wire diameter. Utilize the synergic control for easier setup.
4. Position the MIG torch at the start of the weld joint, maintaining a consistent stick-out.
5. Press the trigger on the MIG torch to initiate the arc and wire feed.
6. Move the torch steadily along the joint, maintaining a consistent travel speed and arc length.

5.3 Lift TIG Welding (Optional Accessory Required)

For precise welding of thinner materials, requiring a separate TIG torch and shielding gas.

1. Connect a Lift TIG torch (not included) and a gas cylinder with regulator if using shielding gas.
2. Select "Lift TIG" mode.
3. Set the desired welding current.
4. Touch the tungsten electrode to the workpiece to establish contact, then lift slightly to initiate the arc.
5. Maintain a short arc length and feed filler rod manually if required.

5.4 Stick (MMA) Welding (Optional Accessory Required)

For general-purpose welding with coated electrodes.

1. Connect the electrode holder to the positive (+) terminal and the ground clamp to the negative (-) terminal.
2. Insert the appropriate welding electrode into the electrode holder.
3. Select "Stick" mode.
4. Set the welding current according to the electrode diameter and material thickness.
5. Strike the electrode against the workpiece to initiate the arc, then maintain a consistent arc length and travel speed.

6. MAINTENANCE

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

- **Cleaning:** Regularly clean the internal components of the welder using compressed air to remove dust and debris. Ensure the power is disconnected before cleaning.
- **Torch and Cable Inspection:** Inspect the MIG torch, ground clamp, and all cables for signs of wear, cuts, or damage. Replace damaged components immediately.

- **Consumables:** Regularly check and replace MIG nozzles, contact tips, and drive rollers as they wear out. For Stick welding, ensure electrodes are stored in dry conditions.
- **Wire Feed Mechanism:** Keep the wire feed rollers clean and free of debris. Ensure proper tension.
- **Storage:** Store the welder in a clean, dry environment, away from moisture and extreme temperatures.

7. TROUBLESHOOTING

This section provides solutions to common issues you might encounter.

Problem	Possible Cause	Solution
Welder does not power on.	No power from outlet; power cord damaged; internal fuse blown.	Check power outlet and circuit breaker; inspect power cord; contact service if fuse is suspected.
No arc or weak arc.	Poor ground connection; incorrect settings; worn consumables; wire feed issue (MIG).	Ensure ground clamp is secure; adjust current/voltage; replace contact tip/electrode; check wire feed.
Wire not feeding (MIG).	Wire tangled; drive rollers loose/dirty; contact tip clogged; liner blocked.	Untangle wire; clean/adjust drive rollers; replace contact tip; clear liner.
Overheat protection activated.	Exceeded duty cycle; poor ventilation.	Allow welder to cool down; ensure adequate airflow around the machine.

If the problem persists after attempting these solutions, please contact ANDELI customer support.

8. SPECIFICATIONS

Feature	Detail
Model	MIG-250ME LED
Input Voltage	220V
Output Current	Real 120A (as per product description)
Welding Processes	Flux MIG, Lift TIG, Stick (MMA)
Technology	IGBT Inverter
Dimensions (Package)	46 x 35 x 30 cm
Weight (Package)	9 kilograms
Manufacturer	ANDELI

9. WARRANTY AND SUPPORT

ANDELI is committed to providing high-quality products and excellent customer service. While specific warranty details are not provided in this manual, ANDELI upholds a mission of "bringing customers a professional and reliable welding experience" and offers a "Quality Guarantee" and "Five star service."

For technical support, warranty claims, or inquiries about spare parts and accessories, please contact ANDELI customer service through their official channels or the retailer where you purchased the product. Please have your product model number (MIG-250ME LED) and purchase information ready when contacting support.



Figure 9.1: ANDELI Company Information.

These images provide background on the ANDELI company, highlighting its long history, extensive workforce, and commitment to quality and service in the electrical industry, reinforcing trust in their products and support.

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