

Pretul 29959

Pretul SOIN-110/130P Inverter Welder User Manual

Model: 29959

1. INTRODUCTION

Thank you for choosing the Pretul SOIN-110/130P Inverter Welder. This compact and efficient welding machine is designed for both coated electrode (SMAW) and tungsten (TIG) welding processes. It features an automatic BI-VOLTAGE 127-220V adaptation system, ensuring seamless operation across different power inputs without manual adjustments. This manual provides essential information for safe operation, setup, maintenance, and troubleshooting to ensure optimal performance and longevity of your welder.

2. SAFETY INSTRUCTIONS

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

- **Electric Shock Can Kill:** Do not touch live electrical parts. Wear dry welding gloves and protective clothing. Insulate yourself from work and ground.
- **Fumes and Gases Can Be Dangerous:** Keep your head out of the fumes. Use ventilation or exhaust to remove fumes from the breathing zone.
- **Arc Rays Can Burn Eyes and Skin:** Wear a welding helmet with a proper shade filter. Wear safety glasses with side shields. Use protective clothing to cover all exposed skin.
- **Fire and Explosion Hazard:** Remove all flammables from the welding area. Have a fire extinguisher readily available. Do not weld on containers that have held combustibles.
- **Hot Parts Can Cause Severe Burns:** Allow the welder and workpieces to cool before handling. Use insulated gloves and tongs.
- **Read the Entire Manual:** Understand all safety warnings and operating procedures before use.
- **Use in a Well-Ventilated Area:** Ensure adequate airflow to prevent overheating and fume buildup.
- **Proper Grounding:** Always ensure the welder is properly grounded according to local electrical codes.

3. PACKAGE CONTENTS

Carefully unpack the box and ensure all items are present and undamaged. If any items are missing or damaged, contact your supplier immediately.



Figure 3.1: Pretul SOIN-110/130P Inverter Welder with all included accessories.

- Pretul SOIN-110/130P Inverter Welder Unit
- Power Cable with Plug
- 1 kg of 1/8" E6013-4 Electrodes
- Ground Clamp Cable (2 m, #5 AWG / 16 mm²)
- Electrode Holder Cable (2 m, #5 AWG / 16 mm²)
- Protective Welding Mask
- Wire Brush

4. PRODUCT OVERVIEW

Familiarize yourself with the components and controls of your Pretul Inverter Welder.



Figure 4.1: Front view of the welder with key components labeled.

- **Power Cable:** Connects the welder to the electrical supply.
- **On/Off Switch:** Powers the unit on or off.
- **Thermal Protection Light:** Illuminates to indicate overheating, activating the thermal protection system.
- **Digital Display:** Shows current settings and other operational information.
- **Current Adjustment Knob:** Used to precisely set the welding current (Amperage).
- **Quick-Change Terminals (Bornes):** 3/8" terminals for quick and secure connection of welding cables.
- **Handle:** For easy portability of the unit.

Key Technologies

Accesorios incluidos:



Cable con tenza
para tierra:

Cable integrado: 2 m
#5 AWG (16 mm²)



Cable con tenza
portaelectrodo:

Cable integrado: 2 m
#5 AWG (16 mm²)



Correa



Careta protectora



Cepillo de alambre



Cable de alimentación (2 m) con clavija



1 kg Electrodos

Figure 4.2: Overview of integrated welding technologies.

- **IGBT Inverter Technology:** Allows the welder to operate efficiently at any current level, providing a stable arc and reducing power consumption compared to conventional welders.
- **Thermal Protect:** An integrated protection system that safeguards the machine from overheating due to prolonged use or excessive load. The thermal protection light will illuminate when active.
- **Arc Force:** Automatically adjusts the optimal arc value, enabling stable welding and allowing for welding in various positions.
- **Anti Stick:** Prevents the electrode from sticking to the workpiece, reducing overheating and making it easier to restart the arc.
- **Hot Start:** Facilitates easy arc ignition by providing a temporary increase in current at the start of welding.

5. TECHNICAL SPECIFICATIONS

Below are the detailed technical specifications for the Pretul SOIN-110/130P Inverter Welder.

Feature	Specification
Model Number	29959
Input Voltage	BI-VOLTAGE 127V / 220V (Automatic Adaptation)
Current Range (1 Phase)	20 A DC - 110 A DC
Current Range (2 Phases)	20 A DC - 130 A DC
Welding Processes	SMAW (Coated Electrode), TIG (Tungsten)
Electrode Compatibility (SMAW)	6013, 6011 (Up to 5/32"), 7018 (Up to 1/8")
Tungsten Electrode Compatibility (TIG)	1 mm (0.039")
Quick-Change Terminals	3/8"
Dimensions (Package)	36 x 27 x 22 cm
Weight (Package)	6.24 kg



6. SETUP

Follow these steps to set up your Pretul Inverter Welder for operation.

1. **Choose a Suitable Location:** Select a dry, well-ventilated area free from flammable materials. Ensure stable footing for the welder.
2. **Connect Ground Clamp:** Attach the ground clamp cable to the negative (-) quick-change terminal on the welder. Securely attach the ground clamp to the workpiece or a clean, bare metal part of the welding table, ensuring good electrical contact.
3. **Connect Electrode Holder:** For SMAW (stick welding), attach the electrode holder cable to the positive (+) quick-change terminal. Insert the appropriate electrode into the holder. For TIG welding, connect the TIG torch (not included) to the appropriate terminal and gas supply.
4. **Power Connection:** Ensure the welder's ON/OFF switch is in the OFF position. Plug the power cable into a suitable 127V or 220V electrical outlet. The welder will automatically detect and adapt to the input voltage.
5. **Prepare for Welding:** Put on all necessary personal protective equipment (PPE), including a welding helmet, gloves, and protective clothing.

7. OPERATING INSTRUCTIONS

Once the welder is set up, follow these steps for safe and effective operation.

1. **Power On:** Turn the ON/OFF switch to the ON position. The digital display will illuminate.
2. **Set Current:** Use the current adjustment knob to set the desired amperage for your welding task. Refer to electrode manufacturer recommendations or a welding chart for appropriate settings.
3. **Start Welding:** Bring the electrode into contact with the workpiece to initiate the arc. The Hot Start feature will assist in easy arc ignition. Maintain a consistent arc length and travel speed.
4. **Monitor Thermal Protection:** If the thermal protection light illuminates, stop welding immediately. Allow the machine to cool down before resuming operation. Do not bypass this safety feature.
5. **Finish Welding:** When finished, turn the welder off. Allow the workpiece and electrode holder to cool before handling.
6. **Clean Up:** Use the wire brush to clean slag from the weld.

Welding Tips:

- Practice on scrap metal to get a feel for the machine and settings.
- Maintain a consistent arc length for a stable weld.
- Adjust amperage based on material thickness and electrode type.
- Ensure good ventilation to disperse welding fumes.

8. MAINTENANCE

Regular maintenance ensures the longevity and safe operation of your welder.

- **Cleaning:** Regularly clean the exterior of the welder with a dry cloth. Use compressed air to blow out dust and

debris from the ventilation openings. Ensure the welder is unplugged before cleaning.

- **Cable Inspection:** Periodically inspect all cables (power, ground, electrode) for cuts, fraying, or damaged insulation. Replace damaged cables immediately.
- **Terminal Check:** Ensure quick-change terminals are clean and free of corrosion. Tighten connections as needed.
- **Storage:** Store the welder in a dry, clean environment, away from direct sunlight and extreme temperatures.
- **Professional Service:** For internal cleaning or repairs, always consult a qualified service technician. Do not attempt to open the welder casing yourself.

9. TROUBLESHOOTING

This section addresses common issues you might encounter with your welder.

Problem	Possible Cause	Solution
Welder does not power on.	No power supply; faulty power cable; internal fuse blown.	Check power outlet and connections. Inspect power cable for damage. If problem persists, seek professional service.
Thermal protection light is on.	Overheating due to prolonged use or insufficient ventilation.	Stop welding and allow the machine to cool down. Ensure proper ventilation around the unit.
Arc is difficult to strike or unstable.	Incorrect amperage setting; poor ground connection; damp or incorrect electrode; worn electrode holder.	Adjust amperage. Ensure ground clamp has good contact. Use dry, appropriate electrodes. Check electrode holder for wear.
Electrode sticks to workpiece.	Low amperage setting; improper arc length; Anti Stick feature not functioning.	Increase amperage. Practice maintaining proper arc length. If Anti Stick is not working, professional service may be required.
Poor weld quality (porosity, spatter).	Incorrect settings; dirty workpiece; improper technique; damp electrodes.	Adjust amperage and travel speed. Clean workpiece thoroughly. Use proper welding technique. Ensure electrodes are dry.

10. WARRANTY AND SUPPORT






Pretul products are manufactured to high-quality standards and are backed by a manufacturer's warranty against defects in materials and workmanship. Please refer to the warranty card included with your product for specific terms and conditions, or visit the official Pretul website for detailed warranty information.

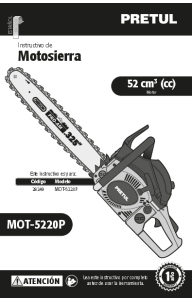
For technical support, service, or to inquire about replacement parts, please contact Pretul customer service through their official channels. Keep your purchase receipt as proof of purchase for warranty claims.

Online Support: www.pretul.com.mx (Note: This is a placeholder URL, please refer to the actual brand website for support.)



Related Documents - 29959

	<p>Manual de Usuario Pretul SOIN-520BP: Soldadora Inversora</p> <p>Descubra cómo operar, instalar y mantener su soldadora inversora Pretul SOIN-520BP de forma segura y eficiente. Este manual completo incluye especificaciones técnicas, advertencias de seguridad y guías de solución de problemas.</p>
	<p>Manual de Soldadora Inversora PRETUL SOIN-310MP: Guía de Uso y Seguridad</p> <p>Descubra cómo operar su soldadora inversora PRETUL SOIN-310MP de forma segura y eficiente con este completo manual de usuario. Incluye especificaciones técnicas, instrucciones de instalación, uso, mantenimiento y precauciones de seguridad.</p>
	<p>Instructivo de Soldadora Inversora PRETUL SOIN-313MBP</p> <p>Manual de usuario para la soldadora inversora PRETUL modelo SOIN-313MBP. Contiene especificaciones técnicas, advertencias de seguridad, guía de instalación, operación, mantenimiento y solución de problemas. Visite www.truper.com para más información.</p>
	<p>PRETUL SOIN-130P Inverter Welder User Manual and Safety Guide</p> <p>This manual provides comprehensive instructions for the PRETUL SOIN-130P Inverter Welder, covering technical specifications, safety precautions, installation procedures for SMAW and TIG welding, startup, maintenance, troubleshooting, and warranty information.</p>
	<p>PRETUL ROTO-1/2P6 Hammer Drill User Manual</p> <p>This manual provides essential information for the safe operation, maintenance, and warranty of the PRETUL ROTO-1/2P6 Hammer Drill (Model 28112). Learn about its features, safety precautions, and troubleshooting.</p>

	<p>Manual de Usuario Motosierra PRETUL MOT-5220P</p> <p>Guía completa de seguridad, operación, mantenimiento y solución de problemas para la motosierra PRETUL MOT-5220P. Incluye especificaciones técnicas y consejos para un uso eficiente.</p>
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