Generico 350A MIG-MMA

Generico 350A MIG-MMA Inverter Welder

INSTRUCTION MANUAL

1. Important Safety Information

Read and understand all safety warnings and instructions before operating this welding machine. Failure to follow these instructions may result in electric shock, fire, serious injury, or death. Keep this manual for future reference.

- **Electric Shock:** Welding current can kill. Do not touch live electrical parts. Wear dry welding gloves and protective clothing. Ensure the work area is dry and well-insulated.
- **Fumes and Gases:** Welding produces fumes and gases that can be hazardous to your health. Work in a well-ventilated area. Use an exhaust fan or fume extractor if necessary.
- **Arc Rays:** Arc rays can burn eyes and skin. Wear a welding helmet with a proper shade filter and protective clothing. Protect bystanders with non-reflective screens.
- **Fire and Explosion:** Welding sparks and hot metal can cause fire or explosions. Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Burns:** Hot metal and electrodes can cause severe burns. Do not touch hot parts with bare hands. Allow welded materials to cool before handling.
- **Personal Protective Equipment (PPE):** Always wear appropriate PPE, including a welding helmet, safety glasses, welding gloves, protective clothing, and safety shoes.

2. Product Overview

The Generico 350A Inverter Welder is a versatile single-phase machine designed for both MIG (Gasless Flux-Cored Wire) and MMA (Shielded Metal Arc) welding. It offers a wide current range for various applications, from light fabrication to repair work. Its inverter technology provides stable arc performance and energy efficiency.

Figure 1: Generico 350A Inverter Welder with the top cover open, revealing the internal wire spool holder and the wire feed mechanism on the right side.

Key Features:

- **Dual Functionality:** Supports both MIG (Gasless Flux-Cored Wire) and MMA (Electrode) welding.
- **High Power Output:** Up to 350A for demanding welding tasks.
- **Automatic Wire Feed:** Ensures consistent wire delivery for smooth MIG welding.
- **Portable Design:** Compact and lightweight for easy transport and use in various locations.
- **Inverter Technology:** Provides stable arc, precise control, and energy efficiency.

3. Package Contents

Verify that all items listed below are included in your package. If any items are missing or damaged, contact your retailer immediately.

- 1 x Generico 350A Inverter Welder
- 1 x Ground Clamp
- 1 x MIG Torch for Flux-Cored Wire
- 1 x Welding Mask (basic)
- 1 x Wire Brush
- 1 x Spool of Flux-Cored Wire
- 3 x 1.0 mm Nozzles

- 1 x Instruction Manual (English)

4. Technical Specifications

Feature	Specification
Input Voltage	220-240 V
MMA Welding Current Range	20-350 A
MIG Welding Current Range (0.8mm wire)	35-350 A
MIG Welding Current Range (1.0mm wire)	50-350 A
Electrode Diameter (MMA)	2.5 - 5.0 mm
Wire Feed Speed	0.5 - 13 m/min
Wire Diameter (MIG)	0.8 - 1.0 mm
Spool Diameter	1.0 mm (Note: This likely refers to the wire diameter, not spool diameter. Assuming it means compatible wire diameter for the included spool.)

5. Setup

5.1 General Setup

1. **Placement:** Place the welding machine on a stable, level surface in a well-ventilated area, away from flammable materials.
2. **Power Connection:** Ensure the machine is switched off. Connect the power cord to a suitable 220-240V power outlet with appropriate circuit protection.
3. **Grounding:** Always ensure the workpiece is properly grounded.

5.2 MIG (Gasless) Setup

1. **Open Wire Compartment:** Lift the top cover of the welder to access the wire spool holder and feed mechanism (refer to Figure 1).
2. **Install Wire Spool:** Place the flux-cored wire spool onto the spool holder. Ensure it rotates freely.
3. **Feed Wire:** Guide the wire through the wire feed mechanism rollers. Ensure the wire is seated correctly in the groove corresponding to its diameter (0.8mm or 1.0mm). Close the pressure arm to secure the wire.
4. **Connect MIG Torch:** Connect the MIG torch to the appropriate connector on the front panel of the welder.
5. **Install Nozzle:** Ensure a 1.0mm nozzle (or appropriate for your wire) is securely installed on the MIG torch.
6. **Purge Wire:** With the machine powered on and in MIG mode, press the torch trigger to feed the wire through the torch liner until it emerges from the nozzle. Cut off any bent wire.
7. **Connect Ground Clamp:** Attach the ground clamp cable to the negative (-) terminal on the welder

and securely clamp it to the workpiece, ensuring good electrical contact.

5.3 MMA (Electrode) Setup

1. **Connect Electrode Holder:** Connect the electrode holder cable to the positive (+) terminal on the welder.
2. **Connect Ground Clamp:** Connect the ground clamp cable to the negative (-) terminal on the welder and securely clamp it to the workpiece, ensuring good electrical contact.
3. **Insert Electrode:** Insert the desired electrode into the electrode holder. Ensure it is held firmly.

6. Operating Instructions

6.1 MIG (Gasless) Welding

1. **Power On:** Switch on the welding machine.
2. **Select Mode:** Set the machine to MIG mode.
3. **Adjust Settings:** Set the welding current and wire feed speed according to the wire diameter, material thickness, and desired weld. Start with recommended settings and adjust as needed.
4. **Wear PPE:** Put on your welding helmet, gloves, and other protective gear.
5. **Welding:** Position the torch nozzle close to the workpiece. Press the trigger to start the arc and feed the wire. Maintain a consistent travel speed and torch angle.
6. **Stop Welding:** Release the trigger to stop the arc.

6.2 MMA (Electrode) Welding

1. **Power On:** Switch on the welding machine.
2. **Select Mode:** Set the machine to MMA mode.
3. **Adjust Settings:** Set the welding current based on the electrode type and diameter, and the material thickness.
4. **Wear PPE:** Put on your welding helmet, gloves, and other protective gear.
5. **Strike Arc:** Lightly tap or scratch the electrode against the workpiece to strike an arc. Lift the electrode slightly to maintain the arc.
6. **Welding:** Maintain a consistent arc length and travel speed.
7. **Stop Welding:** Pull the electrode away from the workpiece to break the arc.

7. Maintenance

Regular maintenance ensures the longevity and safe operation of your welding machine. Always disconnect the machine from the power supply before performing any maintenance.

- **Cleaning:** Periodically clean the inside of the machine with compressed air to remove dust and metal particles. Clean the wire feed rollers and torch liner to prevent wire feeding issues.
- **Cable Inspection:** Regularly inspect all cables (power, ground, torch) for cuts, cracks, or damage. Replace damaged cables immediately.
- **Nozzle and Contact Tip:** For MIG welding, regularly clean or replace the nozzle and contact tip as they wear out.
- **Storage:** Store the welding machine in a clean, dry place, away from moisture and extreme temperatures.

8. Troubleshooting

This section provides solutions to common problems you might encounter.

Problem	Possible Cause	Solution
No power to the machine	Power cord unplugged, circuit breaker tripped, machine switch off	Check power connection, reset circuit breaker, turn machine switch on
Poor or unstable arc (MMA)	Incorrect current setting, damp electrode, poor ground connection, wrong electrode type	Adjust current, use dry electrodes, ensure good ground, use correct electrode
Wire feed issues (MIG)	Wire tangled, clogged liner, worn contact tip, incorrect roller tension	Untangle wire, clean/replace liner, replace contact tip, adjust roller tension
No wire feed (MIG)	Wire spool empty, wire jammed, motor fault	Replace spool, clear jam, contact support if motor fault suspected
Overheating	Exceeding duty cycle, poor ventilation	Allow machine to cool, ensure adequate ventilation, reduce welding time

9. Warranty and Support

This Generico welding machine comes with a standard manufacturer's warranty. For specific warranty terms and conditions, please refer to the documentation provided at the time of purchase or contact your retailer. For technical support, troubleshooting assistance beyond this manual, or to inquire about spare parts, please contact your authorized Generico dealer or the customer service department of your retailer. Please have your purchase receipt and product model information ready when contacting support.

10. Disposal

Do not dispose of this product with general household waste. This product contains electronic components that require special disposal. Please follow local regulations for the proper recycling and disposal of electronic equipment to protect the environment and human health.