YESWELDER FLUX-135PRO

YESWELDER FLUX-135 PRO 3-in-1 Welding Machine User Manual

Comprehensive guide for setup, operation, and maintenance of your YESWELDER FLUX-135 PRO.

Product Overview

The YESWELDER FLUX-135 PRO is a versatile 3-in-1 welding machine designed for Gasless Flux Core MIG, Stick, and Lift TIG welding. This compact and portable unit is suitable for a wide range of welding applications, offering both ease of use for beginners and advanced features for experienced users.

Figure 1: YESWELDER FLUX-135 PRO Welding Machine with included accessories.

Key Features

- **Multi-Process Capability:** Supports Gasless Flux Core MIG, Stick, and Lift TIG welding.
- **High Output:** 135 Amp output capable of welding mild steel up to 2/5 inches thick.
- **Synergic Control:** Automatic voltage matching with adjustable wire feeding speed for optimized welding.
- **Digital Display:** Advanced interface for clear monitoring of real-time current and settings.
- **Portable Design:** Weighs just 11.4 lbs, making it easy to transport with its integrated carrying handle.
- **Safety Features:** Includes automatic compensation for voltage fluctuation, robust protections against over-current, over-load, and over-heating.

Setup and Installation

Unpacking and Inspection

Carefully unpack all components from the packaging. Verify that all items listed in the accessories section are present and undamaged. If any items are missing or damaged, contact customer support immediately.

Figure 2: Included accessories for the FLUX-135 PRO. These typically include the welder unit, MIG gun, flux core welding wire, electrode holder, work clamp, and MIG gun tips.

Connecting the Machine

1. **Power Connection:** Ensure the welder is connected to a stable 110V power source.
2. **Work Clamp Connection:** Connect the work clamp cable to the appropriate output terminal on the front panel. For Flux Core MIG and Stick welding, connect the work clamp to the negative (-) terminal. For Lift TIG, connect to the positive (+) terminal.
3. **MIG Gun/Electrode Holder Connection:**
    - For Flux Core MIG, connect the MIG gun to the MIG gun socket.
    - For Stick welding, connect the electrode holder cable to the positive (+) output terminal.
    - For Lift TIG, connect the TIG torch (not included) to the negative (-) output terminal and the control switch socket.
4. **Wire Spool Installation (for Flux Core MIG):** Open the wire feeder compartment. Install the 2LB flux core welding wire spool onto the spindle. Ensure the wire feeds smoothly through the drive roller and liner to the MIG gun.

Figure 3: Proper installation of the 2LB welding wire spool within the machine's wire feeder compartment.

Operating Instructions

Control Panel Overview

Figure 4: Front panel controls and digital display of the FLUX-135 PRO.

1. **Mode Switch:** Selects welding process (Stick, Lift TIG, Flux Core).
2. **Wire Diameter Switch:** Sets wire diameter for Flux Core mode (.030" or .035").
3. **Feed Wire Button:** Manually feeds welding wire without activating the arc.
4. **Value Knob:** Adjusts welding current (Amps) or wire feeding speed.
5. **Parameter Switch:** Toggles between adjustable parameters like Hot Start and Arc Force in Stick mode, or fine-tuning voltage in Synergic MIG mode.
6. **Digital Display:** Shows selected mode, current settings, and real-time welding parameters.

Welding Modes

Figure 5: The FLUX-135 PRO supports Stick, Lift TIG, and Flux Cored welding processes.

Flux Core MIG Welding

- Select "FLUX" mode using the Mode Switch.
- Set the correct wire diameter (.030" or .035") using the Wire Diameter Switch.
- Adjust the wire feeding speed using the Value Knob. The voltage will automatically adjust in synergic control. Fine-tune voltage if necessary using the Parameter Switch.
- Ensure proper polarity: Work clamp to negative (-), MIG gun to positive (+).

Stick Welding (SMAW)

- Select "STICK" mode using the Mode Switch.
- Connect the electrode holder to the positive (+) terminal and the work clamp to the negative (-) terminal.
- Adjust the welding current (Amps) using the Value Knob.
- Adjust Hot Start and Arc Force parameters as needed via the Parameter Switch for improved arc ignition and stability.

Lift TIG Welding (GTAW)

- Select "LIFT TIG" mode using the Mode Switch.
- Connect the TIG torch (not included) to the negative (-) terminal and the work clamp to the positive (+) terminal.
- Adjust the welding current (Amps) using the Value Knob.
- Note: An additional Lift TIG torch (e.g., B08BXGGNFL) is required for this process.

Welding Parameters Guide

Refer to the following table for recommended welding parameters based on workpiece thickness and welding process. These are starting points and may require fine-tuning based on material, joint type, and operator skill.

Table 1: Recommended Welding Parameters

Process	Wire Diameter	Workpiece Thickness	Wire Feeding Speed (in/min)	Welding Voltage (V)	Welding Current (A)
Flux MIG	.030" (0.8mm)	.040" (1.0mm)	196	14.5	63
		.059" (1.5mm)	292	15.3	94
		5/64" (2.0mm)	358	16.3	115
		3/32" (2.5mm)	420	16.5	135
Flux MIG	.035" (0.9mm)	.040" (1.0mm)	144	14	63
		.059" (1.5mm)	216	15.6	94
		5/64" (2.0mm)	262	16.6	115
		3/32" (2.5mm)	308	16.9	135
TIG	Tungsten Needle	.040" (1.0mm)	N/A	N/A	20-40
		1/16" (1.6mm)	N/A	N/A	50-80
		5/64" (2.0mm)	N/A	N/A	90-135
STICK	Welding Rod	.059" (1.5mm)	N/A	N/A	60
		3/16" (3.2mm)	N/A	N/A	100-135

Maintenance

Regular maintenance ensures the longevity and optimal performance of your YESWELDER FLUX-135 PRO. Always disconnect the welder from the power supply before performing any maintenance.

Daily Maintenance

- Clean the exterior of the machine with a dry, soft cloth.
- Inspect all cables and connections for wear, damage, or loose fittings. Replace or tighten as necessary.
- Check the MIG gun nozzle and contact tip for spatter buildup and wear. Clean or replace as needed.

Monthly Maintenance

- Use compressed air to blow out dust and debris from the cooling vents and internal components. Ensure the air is dry and oil-free.
- Inspect the wire feeder mechanism for proper tension and cleanliness. Clean any debris from the drive rollers.
- Check the condition of the ground clamp and electrode holder.

Troubleshooting

This section provides solutions to common issues you might encounter with your welding machine. For problems not listed here, contact customer support.

Table 2: Common Troubleshooting Guide

Problem	Possible Cause	Solution
No power to the machine	Power switch off, loose power cord, tripped circuit breaker	Turn on power switch, check power cord connection, reset circuit breaker
No arc when welding	Incorrect welding mode, poor work clamp connection, worn contact tip, incorrect polarity	Verify mode selection, ensure good work clamp contact, replace contact tip, check polarity settings
Wire not feeding smoothly (MIG)	Wire spool tangled, incorrect drive roller tension, clogged liner, wrong drive roller size	Untangle wire, adjust drive roller tension, clean or replace liner, ensure correct drive roller for wire diameter
Overheat warning light on	Exceeded duty cycle, blocked cooling vents, high ambient temperature	Allow machine to cool down, clear vents, operate in a cooler environment

Specifications

Detailed technical specifications for the YESWELDER FLUX-135 PRO welding machine.

- **Model:** FLUX-135PRO
- **Input Voltage:** 110V
- **Power Source:** DC
- **Output Current:** 135 Amps (Max)
- **Welding Processes:** Flux Core MIG, Lift TIG, Stick
- **Welding Capacity (Mild Steel):** Up to 2/5 inches thick
- **Compatible Wire:** 2LB .030" and .035" flux core welding wire
- **Item Weight:** Approximately 11.4 lbs (5.17 kg)
- **Parcel Dimensions:** 45.2 x 34.29 x 19.4 cm
- **Cooling Mode:** Fan Cooling
- **Insulation Grade:** F
- **Protection Standard:** IP21S

Figure 6: Detailed electrical specifications and duty cycle information for the FLUX-135 PRO.

Warranty and Support

Return Policy

This product is subject to a 30-day return policy for refund or replacement. Please refer to the retailer's specific return guidelines for full details.

Customer Support

For technical assistance, warranty claims, or any questions regarding your YESWELDER FLUX-135 PRO, please contact YESWELDER customer service. Contact information can typically be found on the manufacturer's official website or through your purchase platform.
Visit the official YESWELDER Store for more information: YESWELDER Store