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› Parkside Inverter Flux-Cored Wire Welder PIFDS 120 B2 User Manual

Parkside PIFDS 120 B2

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Model: PIFDS 120 B2

1. INTRODUCTION & SAFETY INFORMATION

1.1 Product Overview

The Parkside PIFDS 120 B2 Inverter Flux-Cored Wire Welder is a compact and powerful device designed for efficient welding without the need for protective gas. Its lightweight inverter technology makes it ideal for mobile use, offering low energy consumption and optimal welding results even for inexperienced users. The synergistic rotary knob simplifies adjustments for material thickness, and automatic controls ensure consistent welding current and wire feed.



Figure 1: Parkside PIFDS 120 B2 Inverter Flux-Cored Wire Welder. This image shows the main unit of the welding machine, highlighting its compact design and green color scheme.

1.2 Important Safety Instructions

Always observe the following safety precautions to prevent injury or damage to the equipment. Welding can be dangerous if proper safety measures are not followed.

- **Read the Manual:** Before operating the welder, thoroughly read and understand all instructions and safety warnings in this manual.

- **Personal Protective Equipment (PPE):** Always wear appropriate PPE, including a welding helmet with a suitable shade filter, welding gloves, protective clothing, and safety shoes.
- **Ventilation:** Ensure adequate ventilation in the work area to disperse welding fumes, which can be hazardous to health.
- **Electrical Safety:** Connect the welder to a properly grounded power outlet. Do not operate in wet conditions. Inspect cables for damage before each use.
- **Fire Hazards:** Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Arc Rays:** Welding arc rays can cause eye and skin burns. Protect yourself and bystanders.
- **Hot Parts:** Welded materials and equipment parts will be hot. Allow them to cool before handling.
- **Maintenance:** Perform maintenance only when the welder is unplugged and cooled down.

2. PRODUCT COMPONENTS

2.1 Main Unit Features

- **Inverter Technology:** Provides a lightweight and compact design with efficient power usage.
- **Synergistic Rotary Knob:** Allows for easy adjustment based on material thickness (0.8 to 3.0 mm), automatically setting welding current and wire feed speed.
- **Fan Cooling:** Ensures optimal operating temperature and extends machine lifespan.
- **Overload Protection:** Integrated thermal controller with indicator light protects the unit from overheating.
- **Robust Housing:** Durable construction designed for longevity and portability.
- **Carrying Strap:** For convenient transport of the unit.

2.2 Included Accessories

The following accessories are included with your Parkside PIFDS 120 B2 welder:

- 1 x 0.45 kg (0.9 mm) Welding Wire (flux-cored)
- 1 x Burner Nozzle (pre-assembled)
- 4 x Welding Nozzles (1 pre-assembled, for Ø 0.6 / 0.8 / 0.9 / 1.0 mm wires)
- 1 x Welding Protection Shield
- 1 x Welding Hammer with Wire Brush
- 1 x Carrying Strap

3. SETUP

3.1 Unpacking and Inspection

1. Carefully remove all components from the packaging.
2. Inspect the welder and accessories for any signs of damage during transit. Do not use if damaged.
3. Keep packaging materials for future storage or transport.

3.2 Connecting Power

- Ensure the welder's power switch is in the "OFF" position.
- Connect the power cable to a suitable 230 V ~ 50 Hz grounded power outlet.

- Verify that the power supply meets the welder's specifications.

3.3 Installing Welding Wire

1. Open the wire feed compartment.
2. Place the 0.9 mm flux-cored welding wire spool onto the spindle, ensuring it rotates freely.
3. Feed the wire through the guide tube and into the wire feed rollers.
4. Close the wire feed compartment and adjust the tension on the wire feed rollers as needed (refer to the diagram inside the compartment if available).

3.4 Attaching Ground Clamp

- Connect the ground cable's E-clamp to the workpiece or a sturdy metal workbench that is electrically connected to the workpiece.
- Ensure a clean, bare metal contact point for optimal electrical conductivity.

4. OPERATING INSTRUCTIONS

4.1 Preparing for Welding

- **Work Area:** Ensure your welding area is clean, dry, and well-ventilated. Remove all flammable materials.
- **Workpiece Preparation:** Clean the workpiece thoroughly to remove rust, paint, oil, or any contaminants that could affect weld quality.
- **Safety Gear:** Put on all required PPE, including your welding helmet, gloves, and protective clothing.

4.2 Adjusting Settings

- Turn on the welder using the main power switch.
- Use the synergistic rotary knob to select the appropriate material thickness (0.8 mm to 3.0 mm). The welder will automatically adjust the welding current and wire feed speed for optimal performance.
- Perform a test weld on scrap material of the same thickness to fine-tune settings if necessary.

4.3 Flux-Cored Welding Process

1. Position the welding torch nozzle approximately 10-15 mm from the workpiece.
2. Lower your welding helmet.
3. Press the trigger on the welding torch to initiate the arc and wire feed.
4. Maintain a consistent travel speed and torch angle (typically 10-15 degrees push angle) to create a uniform weld bead.
5. Release the trigger to stop welding.
6. Allow the weld to cool before removing slag with the included welding hammer and wire brush.

5. MAINTENANCE AND CARE

Regular maintenance ensures the longevity and optimal performance of your welding machine.

- **Cleaning:** Regularly clean the exterior of the welder with a dry cloth. Use compressed air to blow out dust from ventilation openings. Ensure the unit is unplugged before cleaning.

- **Welding Nozzle:** Inspect the welding nozzle for spatter buildup. Clean or replace as necessary to ensure proper wire feeding and gas flow (though this is a gasless welder, keeping the nozzle clean is still important for consistent arc).
- **Wire Feed Mechanism:** Periodically check the wire feed rollers for wear and cleanliness. Ensure the wire guide tube is free of kinks or blockages.
- **Cables and Connections:** Inspect all cables (power, welding, ground) for cuts, abrasions, or loose connections. Replace damaged cables immediately.
- **Storage:** Store the welder in a dry, dust-free environment when not in use.

6. TROUBLESHOOTING GUIDE

This section provides solutions to common issues you might encounter.

Problem	Possible Cause	Solution
No power to the unit.	Power cable unplugged, circuit breaker tripped, faulty outlet.	Check power cable connection. Reset circuit breaker. Test outlet with another device.
Welder overheats, indicator light on.	Exceeded duty cycle, poor ventilation, blocked fan.	Allow welder to cool down. Ensure adequate ventilation. Clean fan vents.
Wire not feeding.	Wire tangled, wire feed rollers loose/dirty, clogged nozzle, incorrect wire size.	Check wire spool. Adjust roller tension. Clean nozzle. Ensure correct wire diameter.
Poor weld quality (e.g., excessive spatter, weak penetration).	Incorrect settings, improper technique, dirty workpiece.	Adjust synergistic knob for material thickness. Review welding technique. Clean workpiece thoroughly.
No arc.	Poor ground connection, faulty torch, incorrect settings.	Ensure ground clamp has good contact. Check torch cable. Verify settings.

7. TECHNICAL SPECIFICATIONS

Detailed technical data for the Parkside PIFDS 120 B2 Inverter Flux-Cored Wire Welder:

Parameter	Value
Power Supply	230 V ~ 50 Hz
No-Load Voltage	22 V
Welding Current (max.)	20 A / 15 V - 120 A / 20 V
Adjustable Welding Current	20 - 120 A (continuously adjustable)
Compatible Wire Diameter	0.6 / 0.8 / 0.9 / 1.0 mm
Recommended Material Thickness	0.8 - 3.0 mm
Power Cable Length	4 m
Welding Cable Length	2 m (1 x 10 mm ²)

Parameter	Value
Ground Cable Length (with E-clamp)	2 m (1 x 10 mm ²)
Materials	Steel sheet, plastic, stainless steel
Dimensions (L x W x H)	Approx. 33.1 x 16.1 x 19.9 cm
Weight (Welder with cable)	Approx. 4.2 kg
Weight (Ground cable with clamp)	Approx. 345 g
Weight (Welding visor)	Approx. 155 g
Weight (Combined wire brush with hammer)	Approx. 62 g

8. WARRANTY AND CUSTOMER SUPPORT

Your Parkside PIFDS 120 B2 Inverter Flux-Cored Wire Welder comes with a manufacturer's warranty. Please refer to the warranty card or your purchase documentation for specific terms and conditions, including the warranty period and coverage details.

For technical assistance, spare parts, or warranty claims, please contact the customer support service provided by your retailer or the official Parkside service center in your region. Contact information can typically be found on your purchase receipt or the product packaging.

When contacting support, please have your product model number (PIFDS 120 B2) and purchase date readily available.