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haxiaoer ARC205

haxiaoer 205A Stick Welder / Lift TIG Welding Machine Instruction Manual

Model: ARC205

1. General Safety Information

Welding operations involve significant risks. Always prioritize safety to prevent injury or damage. Read and understand all safety warnings and instructions before operating this machine.

- **Electric Shock:** Can kill. Do not touch live electrical parts. Wear dry welding gloves and protective clothing. Ensure proper grounding.
- **Fumes and Gases:** Can be hazardous to your health. Keep your head out of the fumes. Use adequate ventilation or exhaust at the arc.
- **Arc Rays:** Can burn eyes and skin. Wear a welding helmet with a proper shade filter. Wear protective clothing to cover exposed skin.
- **Fire and Explosion:** Welding sparks can cause fire or explosion. Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Hot Parts:** Can cause severe burns. Allow hot parts to cool before touching. Use insulated gloves and tools.

2. Product Overview

The haxiaoer 205A Stick Welder is a versatile 2-in-1 MMA (Manual Metal Arc) / Lift TIG (Tungsten Inert Gas) welding machine designed for various welding tasks. It features dual voltage compatibility (110V/220V) and includes advanced functions such as adjustable VRD (Voltage Reduction Device), ARC FORCE, and HOT START for enhanced performance and ease of use. The large LCD display provides clear operational feedback, making it suitable for both beginners and experienced users.



Image: haxiaoer 205A Stick Welder and included accessories.



Image: Visual representation of key features including Easy to Carry, Multi-protection, LED Display, ARC Force, IP21S, IGBT Technology, Hot Start, and Anti-stick.

3. Package Contents

- 1 x haxiaoer 205A Stick Welder Machine
- 1 x 150cm/60in Power Cord
- 1 x 30cm/12in Small American to Large American Power Cord Adapter

- 1 x 290cm/115in 10-25 Ground Clamp
- 1 x Welding Torch Pliers (Electrode Holder)

4. Setup

4.1 Power Connection

1. Ensure the welder's power switch is in the OFF position.
2. Connect the appropriate power cord (150cm for 110V/220V or 30cm adapter for specific American outlets) to the welder's power input.
3. Plug the power cord into a suitable 110V or 220V AC power outlet. The machine automatically detects the voltage.

4.2 Electrode Holder and Ground Clamp Connection

1. For MMA (Stick) welding: Connect the welding torch pliers (electrode holder) cable to the positive (+) terminal and the ground clamp cable to the negative (-) terminal on the front panel of the welder.
2. For Lift TIG welding: Connect the TIG torch (not included) to the negative (-) terminal and the ground clamp cable to the positive (+) terminal.
3. Securely tighten all connections.

4.3 TIG Torch Connection (for Lift TIG - Torch not included)

1. If using Lift TIG, connect your WP17V TIG torch (compatible, but not included) to the negative (-) terminal.
2. Connect the gas hose from the TIG torch to your argon gas cylinder (not included) via a regulator.

5. Operating Instructions

5.1 Power On and Mode Selection

1. Turn the power switch on the rear panel to the ON position. The LCD display will illuminate.
2. Use the 'Mode Selection' button (labeled '1' in the image below) to toggle between MMA (Stick) and Lift TIG welding modes.



Image: Front panel showing mode selection (1), ON/OFF VRD (2), and adjustment knob (3).

5.2 Adjusting Welding Parameters

1. **Current Adjustment:** Use the main rotary knob (labeled '3' in the image above) to adjust the welding current (Amps). The LCD display will show the current setting.
2. **VRD (Voltage Reduction Device):** Press the 'ON/OFF VRD' button (labeled '2' in the image above) to activate or deactivate the VRD function. VRD reduces the open-circuit voltage for increased safety.
3. **ARC FORCE & HOT START:** In MMA mode, toggle the main rotary knob to adjust ARC FORCE and HOT START

settings. These features enhance arc stability and ease of arc ignition.

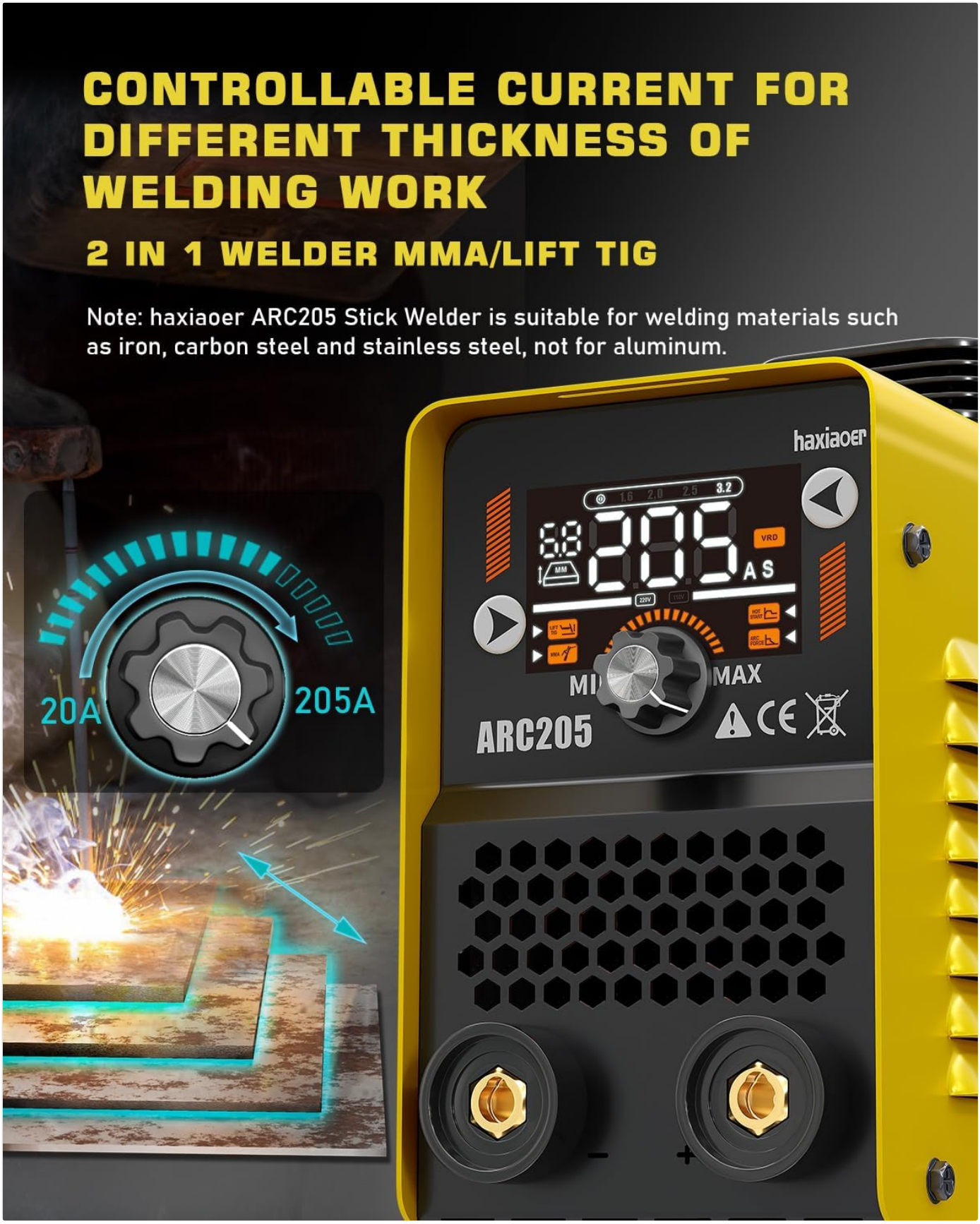


Image: Display showing current adjustment from 20A to 205A for different welding thicknesses.

5.3 Electrode Compatibility

- The machine is designed to work with acid and basic welding rods ranging from 1.6-4.0mm (e.g., E6013, E7018).
- For Lift TIG, compatible tungsten pins are below 3.2mm.
- **Note:** Reverse connection is required for welding acidic electrodes.

5.4 Welding Techniques

Ensure proper preparation of the workpiece, including cleaning and beveling if necessary. Maintain a consistent arc length and travel speed for optimal weld quality. Practice on scrap material to familiarize yourself with the machine's settings and your chosen welding process.



Image: User demonstrating the portability and ease of operation of the haxiaoer 205A welder.

6. Maintenance

6.1 Cleaning

- Regularly clean the machine's exterior with a dry, soft cloth.
- Periodically use compressed air to blow out dust and debris from the ventilation openings. Ensure the machine is unplugged before cleaning.
- Clean the electrode holder and ground clamp connections to ensure good electrical contact.

6.2 Storage

- Store the welder in a dry, dust-free environment away from direct sunlight and extreme temperatures.
- Keep the machine covered to prevent dust accumulation.

6.3 Inspection

- Before each use, inspect all cables, connections, and the machine housing for any signs of damage or wear.
- Replace any damaged parts immediately to ensure safe operation.

7. Troubleshooting

- **No Power:** Check power cord connection, wall outlet, and circuit breaker. Ensure the power switch is ON.
- **No Arc:** Verify electrode holder and ground clamp connections. Ensure the workpiece is clean and properly grounded. Check welding current settings.
- **Poor Weld Quality:** Adjust welding current, arc force, and hot start settings. Ensure correct electrode type and size for the material. Clean the workpiece thoroughly.
- **Overheating:** If the machine stops due to overheating, allow it to cool down. Ensure ventilation openings are clear and not obstructed.

8. Specifications

Specification	Value
Brand	haxiaoer
Model Number	ARC205
Part Number	205A Stick Welder
Size	205A 110V/220V-A
Color	Yellow
Material	Metal
Power Source	AC/DC
Item Weight	4.99 kg
Parcel Dimensions	32.11 x 22.81 x 19.2 cm
Included Components	150cm/60in power cord, 205A Stick Welder Machine, 290cm/115in 10-25 ground clamp, 30cm/12in small American, welding torch pliers

9. Warranty and Support

haxiaoer offers a three-year warranty covering defects in material or workmanship for the 205A Stick Welder. For any issues or inquiries, please contact our professional after-sales engineers.

Additionally, haxiaoer provides welding tutorials and FAQs to assist users in improving their welding skills and resolving common operational questions. Refer to the official haxiaoer website or contact customer support for more resources.

Contact Information: Please refer to the product packaging or official haxiaoer website for the most up-to-date contact details for support.

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