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> AZZUNO MIG-200PRO Multiprocess Welder User Manual

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Model: MIG-200PRO

1. PRODUCT OVERVIEW

The AZZUNO MIG-200PRO is an advanced 8-in-1 multiprocess welding machine designed for versatility and performance. It supports a wide range of welding functions, making it suitable for both hobbyists and professionals. This manual provides detailed instructions for safe and effective operation.



Image: The AZZUNO MIG-200PRO Multiprocess Welder shown with its included accessories, highlighting its compact design and comprehensive kit.

Key Features:

- **8-in-1 Multiprocess Capability:** Flux Core MIG, Gas MIG, MAG, Aluminum MIG, Spot MIG, Lift TIG, Stick Welding, and Spool Gun compatibility.
- **Dual Voltage Input:** Operates on both 110V and 220V power supplies.
- **Synergic Control:** Automatic adjustment of welding parameters for optimal performance.
- **Wire Compatibility:** Supports 1 lb to 10 lbs wire spools with various diameters and types (Solid, Flux Core, Aluminum).

8-IN-1 MULTIPROCESS WELDER



Image: Visual representation of the eight welding processes supported by the AZZUNO MIG-200PRO, including Gasless MIG, Gas MAG (CO₂), Gas MAG (MIX), Aluminum MIG, Spool Gun, Spot MIG, MMA (Stick), and Lift TIG.

2. SAFETY INFORMATION

Always prioritize safety when operating welding equipment. Read and understand all safety warnings and instructions before use. Failure to do so may result in serious injury or death.

General Safety Precautions:

- **Electric Shock:** Welding current can cause fatal electric shock. Ensure proper grounding, wear dry gloves, and insulate yourself from the workpiece and ground.
- **Fumes and Gases:** Welding fumes and gases can be hazardous to your health. Work in a well-ventilated area or use an approved respirator.
- **Arc Rays:** Arc rays can injure eyes and burn skin. Wear a welding helmet with appropriate shade, safety glasses, and protective clothing.

- **Fire and Explosion:** Welding can cause fire or explosion. Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Hot Parts:** Welded parts are hot and can cause severe burns. Allow parts to cool before handling or wear appropriate heat-resistant gloves.

3. PACKING LIST

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

- AZZUNO MIG-200PRO Welder Machine x1
- 15AK MIG Torch x1
- Ground Clamp x1
- Electrode Holder x1
- 110V~220V Adapter x1
- Brush & Hammer x1
- Gas Hose x1
- Hose Band x2
- Drive Roller x2
- Contact Tip x4
- Teflon Liner x1
- User Manual x1



Image: A visual display of the AZZUNO MIG-200PRO welder and all its standard accessories, including the MIG torch, ground clamp, electrode holder, power adapter, and various consumables.

4. SETUP

4.1 Power Connection

The MIG-200PRO supports dual voltage input (110V/220V). Use the appropriate power adapter and ensure the power source matches the machine's requirements.

- For 110V operation, connect the provided 110V adapter to the main power cord.
- For 220V operation, connect the main power cord directly to a 220V outlet.



Image: A graphic demonstrating the dual voltage capability of the welder, showing connections for both 110V and 220V power sources and their respective welding capacities.

4.2 Wire Installation

The machine accommodates wire spools from 1 lb to 10 lbs. Select the correct drive roller for your wire type.

- **Flux Core Wire:** Use knurled (K) rollers.
- **Solid Wire:** Use V-groove rollers.
- **Aluminum Wire (AlMg5356):** Use U-groove rollers.

1. Open the wire feed compartment.
2. Place the wire spool onto the spindle, ensuring it rotates freely.
3. Thread the wire through the drive roller mechanism and into the MIG torch liner.
4. Close the compartment and adjust the wire tension.



Image: An illustration of how to install a welding wire spool (1lb-10lbs) into the welder, along with a visual guide to selecting the correct K-groove, V-groove, or U-groove drive roller for different wire types.

4.3 Torch and Clamp Connections

Connect the MIG torch, ground clamp, and electrode holder to their respective terminals on the front panel.

- **MIG Torch:** Connect the 15AK MIG Torch to the Euro connector.

- **Ground Clamp:** Connect to the appropriate terminal based on polarity requirements for your welding process.
- **Electrode Holder:** Connect for Stick welding.
- **Spool Gun:** If using a spool gun (sold separately), connect it to the dedicated 2-pin plug and ensure the 'Spool Gun Mode' switch is engaged.

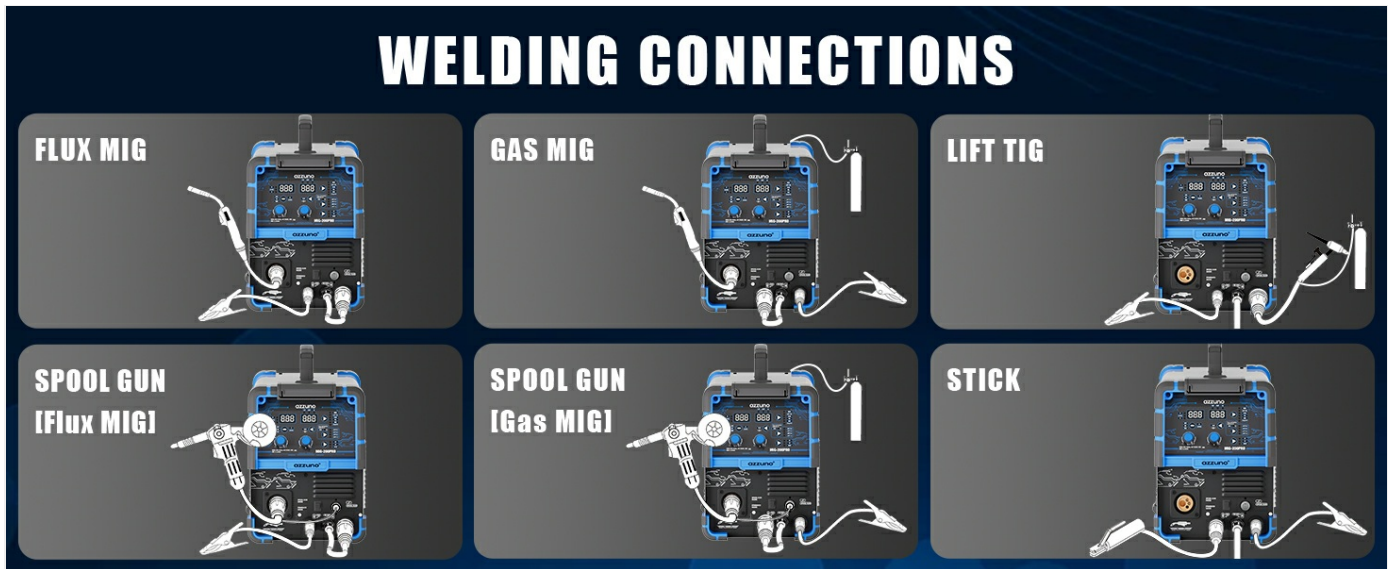


Image: Detailed diagrams illustrating the correct connection setups for Flux MIG, Gas MIG, Lift TIG, Spool Gun (Flux MIG), Spool Gun (Gas MIG), and Stick welding modes.

4.4 Aluminum MIG Welding Setup

For Aluminum MIG welding, you have two options:

1. **Teflon Liner:** Replace the existing liner in the MIG torch with the included Teflon liner. This provides a smoother feed for aluminum wire.
2. **Spool Gun:** For more advanced aluminum welding tasks, use a compatible spool gun (sold separately).



Image: A visual guide explaining the two methods for Aluminum MIG welding: replacing the torch liner with a Teflon liner, or using a separate spool gun.

5. OPERATING INSTRUCTIONS

5.1 Control Panel Overview

Familiarize yourself with the control panel for optimal welding performance.



Image: A close-up view of the AZZUNO MIG-200PRO's control panel, labeling key functions such as Welding Modes, Wire Diameter, 2T/4T/Spot Modes, Stick Welding Mode, Amp & Speed Switch, and Fast Wire Feeding.

- **1. Welding Modes:** Select between MMA (Stick), TIG, Flux Core, CO₂ (Gas MIG), MIX (Gas MIG), and AlMg5356 (Aluminum MIG).
- **2. Wire Diameter/SYN:** Adjust wire diameter settings. Press and hold for 3 seconds to activate SYNERGIC mode for automatic parameter adjustment.
- **3. 2T/4T/SPOT Modes:** Select trigger operation (2T for momentary, 4T for continuous) or Spot welding for precise, short welds.
- **4. Stick Welding Mode:** Dedicated settings for Stick welding, including Hot Start, Arc Force, Anti Stick, and VRD.
- **5. Amp & Speed Switch:** Adjust welding amperage and wire feed speed.
- **6. Fast Wire Feeding:** Button for quickly feeding wire without striking an arc.

5.2 Welding Modes and Applications

The MIG-200PRO offers various welding modes for different applications.



Image: A split image demonstrating the multi-functional capabilities for both MIG welding (with 2T, 4T, Spot, Inch, Synergic, and Manual Control options) and Stick welding (with Hot Start, Arc Force, Anti Stick, and VRD features).

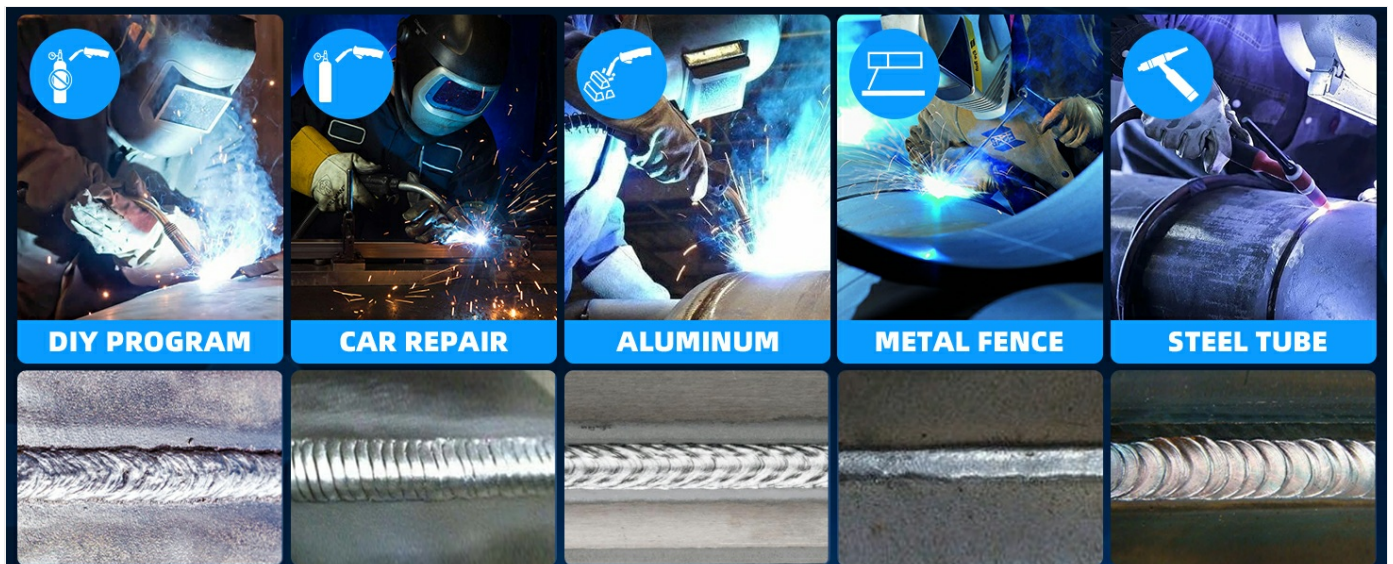


Image: A collage showcasing various welding applications such as DIY projects, car repair, aluminum welding, metal fence fabrication, and steel tube welding, accompanied by examples of high-quality weld beads produced by the machine.

6. MAINTENANCE

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

General Maintenance:

- **Cleaning:** Regularly clean the machine's exterior with a dry cloth. Use compressed air to blow out dust and debris from cooling vents.
- **Wire Feed System:** Inspect the drive rollers and wire liner for wear or blockages. Clean or replace as necessary to ensure smooth wire feeding.
- **Connections:** Check all cable connections (torch, ground clamp, electrode holder) for tightness and signs of damage.
- **Consumables:** Replace contact tips, nozzles, and other consumables as they wear out to maintain weld quality.
- **Storage:** Store the welder in a dry, clean environment when not in use.

7. TROUBLESHOOTING

This section addresses common issues you might encounter during operation.

| Problem | Possible Cause | Solution |
|---------------------------------|--|--|
| No power/Machine not turning on | Power cord not connected, circuit breaker tripped, incorrect voltage. | Check power connections, reset breaker, ensure correct 110V/220V input. |
| No arc/Poor arc starting | Poor ground connection, incorrect settings, worn contact tip, wire feed issue. | Ensure good ground, adjust parameters, replace contact tip, check wire feed. |
| Wire not feeding smoothly | Incorrect drive roller, wire tangle, dirty liner, tension too loose/tight. | Use correct roller, untangle wire, clean/replace liner, adjust tension. |
| Overheating/Thermal overload | Exceeding duty cycle, poor ventilation. | Allow machine to cool, ensure adequate airflow around the unit. |

Q Is the TIG torch included, and which model of TIG torch is compatible?

A The machine does not include a TIG torch. The compatible TIG torch model for this welding machine is WP-17V (35-50mm²).

Q Is it possible to use with 10 lbs of welding wire?

A Yes, this machine can accommodate welding wires ranging from 1 lb to 10 lbs.

Q Which types and diameters of welding wire are suitable for different MIG welding modes? How should the various drive rollers be used?

A Both Gasless MIG and Gas MIG welding modes are compatible with wire diameters of .023"/.030"/.035"/.040", but Gasless MIG requires flux-cored wire, while Gas MIG uses solid wire. For Aluminum MIG, AlMg5356 wire in .035" and .040" diameters is recommended. Gasless MIG should be paired with knurled (K) rollers, Gas MIG with V-groove rollers, and Aluminum MIG with U-groove rollers.

Image: A question and answer section addressing common user queries, such as TIG torch compatibility, 10 lbs welding wire accommodation, and suitable wire types/drive rollers for different MIG welding modes.

8. SPECIFICATIONS

Technical specifications for the AZZUNO MIG-200PRO Multiprocess Welder.

| Feature | Specification |
|---------------------|--|
| Model | MIG-200PRO |
| Input Voltage | 110V/220V Dual Voltage |
| Max Output Current | 200A |
| Welding Processes | Flux Core MIG, Gas MIG, MAG, Aluminum MIG, Spot MIG, Lift TIG, Stick Welding |
| Wire Spool Capacity | 1 lb - 10 lbs |

| Feature | Specification |
|--------------------|---|
| Item Weight | 30 pounds (approx. 13.6 kg) |
| Package Dimensions | 22 x 16.5 x 14 inches (approx. 55.9 x 41.9 x 35.6 cm) |

| | | $U_1 = 110V \sim$ | | | $U_1 = 220V \sim$ | | | |
|----------------|-------------|------------------------|--------------------|-------|--|------|------|------|
| | | 40A / 16V ~ 120A / 20V | | | 40A / 16V ~ 200A / 24V ($\varphi 0.9$) | | | |
| S | $U_0 = 55V$ | X | 50% | 60% | 100% | 50% | 60% | 100% |
| | | I ₂ | 120A | 110A | 80A | 200A | 180A | 140A |
| | | U ₂ | 20V | 19.5V | 18V | 24V | 23V | 21V |
| DC: ~1-50/60Hz | | $U_1 = 110V$ | $I_{Lmax} = 41.5A$ | | $I_{Loff} = 29.3A$ | | | |
| | | $U_1 = 220V$ | $I_{Lmax} = 45.3A$ | | $I_{Loff} = 32A$ | | | |

PANEL INTRODUCTION

Image: A comprehensive panel introduction alongside a detailed table of technical specifications, including voltage, current, and duty cycle for various welding modes.

SIZE

18"x9.5"x12.5"

WEIGHT

24 LBS

Image: A visual representation of the welder's dimensions (18"x9.5"x12.5") and weight (24 lbs), emphasizing its portability.

9. WARRANTY AND SUPPORT

For warranty information and technical support, please refer to the warranty card included with your product or visit the official AZZUNO website. Keep your purchase receipt as proof of purchase for warranty claims.

Contact Information: Please refer to the contact details provided in your product packaging or on the AZZUNO official website for customer service and technical assistance.

