

Pretul 29019

Pretul SOIN-313MBP Bi-Voltage 130 A Mini Inverter Welder User Manual

Model: SOIN-313MBP (29019)

1. PRODUCT OVERVIEW

The Pretul SOIN-313MBP is a lightweight, compact, and highly efficient bi-voltage mini inverter welder designed for Shielded Metal Arc Welding (SMAW) processes. It offers a higher duty cycle and lower power consumption compared to conventional welders, making it ideal for various welding tasks.

This welder features a current adjustment knob and a digital display for precise control. It is compatible with both 127 V and 220 V power supplies, providing flexibility for different work environments.



Figure 1: Pretul SOIN-313MBP Mini Inverter Welder with electrode holder cable, ground clamp cable, protective mask, wire brush, and strap.

2. COMPONENTS INCLUDED

The Pretul SOIN-313MBP Mini Inverter Welder package includes the following components:

- 1x Protective Mask
- 1x Wire Brush
- 1x Strap
- 1x Ground Clamp Cable (1.9 m / 6.2 ft, #5 AWG / 16 mm²)
- 1x Electrode Holder Cable (1.8 m / 5.9 ft, #5 AWG / 16 mm²)
- 1x Power Supply Cable with Plug (2 m / 6.5 ft)

INCLUYE

PRETUL®

- 1 Careta protectora 1X
- 2 Cepillo de alambre 1X
- 3 Correa 1X
- 4 Cable con pinza para tierra 1.9 m (6.2 ft), #5 AWG (16 mm²) 1X
- 5 Cable con pinza porta-electrodo 1.8 m (5.9 ft), #5 AWG (16 mm²) 1X



Figure 2: Detailed view of the accessories included with the welder.

3. SETUP AND CONNECTIONS

Before operating the welder, ensure all connections are secure and the work area is safe and well-ventilated. The welder supports bi-voltage input, automatically adapting to 127 V or 220 V power supplies.

1. **Power Connection:** Connect the power supply cable to a suitable 127 V or 220 V AC outlet. The welder automatically detects the voltage.
2. **Ground Clamp Connection:** Attach the ground clamp cable to the negative (-) terminal of the welder using the quick-change 3/8" borne. Secure the ground clamp to the workpiece or welding table.
3. **Electrode Holder Connection:** Connect the electrode holder cable to the positive (+) terminal of the welder using the quick-change 3/8" borne. Insert the appropriate electrode into the holder.
4. **Protective Mask:** Always wear the protective mask and other personal protective equipment (PPE) before turning on the welder.

Pantalla digital



Perilla para ajuste de corriente



Sistema de refrigeración

Figure 3: Front panel with digital display and current adjustment knob, and rear panel showing the cooling system and power switch.

4. OPERATING INSTRUCTIONS

The Pretul SOIN-313MBP is designed for SMAW (Shielded Metal Arc Welding) processes. Follow these steps for operation:

1. **Power On:** Flip the power switch located on the rear panel to the 'ON' position. The digital display will illuminate.
2. **Current Adjustment:** Use the yellow knob on the front panel to adjust the welding current. The digital display will show the selected amperage.
 - 1 Phase (127 V): Current range 20 A - 100 A
 - 2 Phases (220 V): Current range 20 A - 130 A
3. **Electrode Selection:** This welder is suitable for coated electrodes such as 6013, 6011 (up to 5/32" diameter), and 7018 (up to 3/32" diameter). Select the appropriate electrode for your welding task.
4. **Welding Process:** Begin welding, maintaining proper arc length and travel speed. Always ensure good ventilation and wear appropriate safety gear.
5. **Duty Cycle:** The welder has a duty cycle of 6 minutes of work followed by 4 minutes of rest. Adhering to the duty cycle prevents overheating and prolongs the life of the machine.

**Para proceso de soldadura
de electrodo revestido (SMAW)**



**Ligera, compacta y fácil
de transportar**

**Mayor ciclo
de trabajo**

6 minutos de trabajo
por 4 minutos de descanso

Figure 4: Key features of the welder, including its suitability for SMAW, portability, and duty cycle information.

5. MAINTENANCE

Regular maintenance ensures the longevity and optimal performance of your Pretul SOIN-313MBP welder.

- **Cleaning:** Periodically clean the exterior of the welder with a dry cloth. Ensure the cooling vents (located on the rear panel) are free from dust and debris to maintain proper airflow.
- **Cable Inspection:** Regularly inspect all cables (power, electrode holder, ground clamp) for any signs of damage, fraying, or exposed wires. Replace damaged cables immediately.
- **Terminal Check:** Ensure the quick-change terminals are clean and free of corrosion. A clean connection ensures efficient current transfer.
- **Storage:** When not in use, store the welder in a dry, clean environment, away from direct sunlight and extreme temperatures.

6. TROUBLESHOOTING

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

Problem	Possible Cause	Solution
Welder does not power on.	No power supply; power switch off; faulty cable.	Check power outlet and cable connection. Ensure power switch is ON.
No arc or weak arc.	Poor ground connection; incorrect current setting; damp electrode.	Ensure ground clamp is securely attached. Adjust current. Use dry electrodes.
Welder overheats and shuts off.	Exceeded duty cycle; blocked cooling vents.	Allow welder to cool down. Clear any obstructions from cooling vents. Adhere to duty cycle.

7. SPECIFICATIONS

Detailed technical specifications for the Pretul SOIN-313MBP Mini Inverter Welder:

Feature	Specification
Model Number	SOIN-313MBP (29019)
Manufacturer	Truper
Color	Yellow
Power Source	Electric (AC Powered)
Input Voltage (1 Phase)	127 V AC / 32 A / 50-60 Hz
Input Voltage (2 Phases)	220 V AC / 22 A / 50-60 Hz
Current Range (1 Phase)	20 A - 100 A
Current Range (2 Phases)	20 A - 130 A
Maximum Current	130 A DC
Power	3.5 kVA (1 Phase • 2 Phases)
Open Circuit Voltage	75 V DC (1 Phase) • 62 V DC (2 Phases)
Terminals	3/8" Quick-Change
Duty Cycle	6 minutes work / 4 minutes rest
Dimensions (L x W x H)	26 cm (Depth) x 11 cm (Base) x 17 cm (Height)
Weight	4.32 kg



CARACTERÍSTICAS:

130 A CD
CORRIENTE MÁXIMA

127 V CA /32 A/50- 60 Hz

220 V CA/22 A/50- 60 Hz

ALIMENTACIÓN
(1 FASE • 2 FASES)

3/8"
BORNES

75 V C.C • 62 V C.C.
VOLTAJE DE CIRCUITO
ABIERTO

3.5 kVA
POTENCIA
(1 FASE • 2 FASES)

20 A- 100 A • 20 A- 130 A
RANGO DE CORRIENTE
(1 FASE • 2 FASES)

Figure 5: Dimensions and key electrical characteristics of the welder.

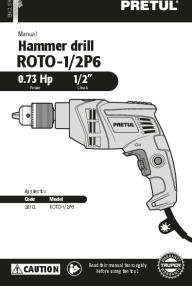
8. WARRANTY AND SUPPORT

For information regarding product warranty, please refer to the warranty card included with your purchase or visit the official Pretul website. For technical support, service, or spare parts, please contact your authorized dealer or the manufacturer's customer service department.

Please retain your proof of purchase for warranty claims.

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This manual is for informational purposes only. Specifications are subject to change without notice.

	Instructivo de Soldadora Inversora PRETUL SOIN-313MBP Manual de usuario para la soldadora inversora PRETUL modelo SOIN-313MBP. Contiene especificaciones técnicas, advertencias de seguridad, guía de instalación, operación, mantenimiento y solución de problemas. Visite www.truper.com para más información.
	Manual de Usuario Pretul SOIN-520BP: Soldadora Inversora Descubra cómo operar, instalar y mantener su soldadora inversora Pretul SOIN-520BP de forma segura y eficiente. Este manual completo incluye especificaciones técnicas, advertencias de seguridad y guías de solución de problemas.
	Manual de Soldadora Inversora PRETUL SOIN-310MP: Guía de Uso y Seguridad Descubra cómo operar su soldadora inversora PRETUL SOIN-310MP de forma segura y eficiente con este completo manual de usuario. Incluye especificaciones técnicas, instrucciones de instalación, uso, mantenimiento y precauciones de seguridad.
	PRETUL SOIN-130P Inverter Welder User Manual and Safety Guide This manual provides comprehensive instructions for the PRETUL SOIN-130P Inverter Welder, covering technical specifications, safety precautions, installation procedures for SMAW and TIG welding, startup, maintenance, troubleshooting, and warranty information.
	PRETUL ROTO-1/2P6 Hammer Drill User Manual This manual provides essential information for the safe operation, maintenance, and warranty of the PRETUL ROTO-1/2P6 Hammer Drill (Model 28112). Learn about its features, safety precautions, and troubleshooting.
	Manual de Usuario Motosierra PRETUL MOT-5220P Guía completa de seguridad, operación, mantenimiento y solución de problemas para la motosierra PRETUL MOT-5220P. Incluye especificaciones técnicas y consejos para un uso eficiente.

