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> YESWELDER FLUX-135 MINI 135Amp 3-in-1 Welding Machine User Manual

YESWELDER FLUX-135 MINI

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Model: FLUX-135 MINI

1. INTRODUCTION

This manual provides comprehensive instructions for the safe and effective operation, setup, and maintenance of your YESWELDER FLUX-135 MINI 135Amp 3-in-1 Welding Machine. This versatile unit supports Flux Core MIG, Lift TIG, and Stick welding processes, offering robust performance for various welding tasks. Please read this manual thoroughly before operating the machine to ensure proper usage and safety.



Figure 1.1: The YESWELDER FLUX-135 MINI 3-in-1 Welding Machine, shown alongside a box of E7018 low hydrogen carbon steel stick electrodes.

2. SAFETY INFORMATION

Welding can be dangerous. It is essential to follow all safety precautions to prevent injury or damage. Always wear appropriate personal protective equipment (PPE) including welding helmet, gloves, protective clothing, and safety shoes. Ensure adequate ventilation in your work area to avoid inhaling fumes.

General Safety Precautions:

- **Electric Shock Can Kill:** Do not touch live electrical parts. Insulate yourself from work and ground.
- **Fumes and Gases Can Be Dangerous:** Keep your head out of the fumes. Use ventilation or exhaust to remove fumes from the breathing zone.
- **Arc Rays Can Burn Eyes and Skin:** Wear a welding helmet with a proper shade of filter lens to protect your eyes and face. Wear appropriate clothing to protect your skin.
- **Fire and Explosion Hazard:** Remove all flammable materials from the welding area. Have a fire extinguisher readily available.

- **Hot Parts Can Cause Severe Burns:** Allow welded materials to cool before handling.
- **Read the Manual:** Always read and understand the entire instruction manual before installation and operation.

3. PRODUCT FEATURES

The YESWELDER FLUX-135 MINI is designed with advanced features to enhance your welding experience:

- **Multi-Process Capability:** This 135Amp 3-in-1 welder supports Flux Core Gasless MIG, Stick, and Lift TIG welding processes. This versatility allows it to handle a wide array of welding tasks with ease.
- **Synergic Control:** Features an intelligent synergic control system where adjusting the wire feeding speed automatically matches the recommended voltage. This simplifies operation, making it suitable for both beginners and experienced welders.
- **Easy Operation:** The intuitive control panel provides effortless adjustment of welding modes, voltage, and current/wire feed speed, ensuring both convenience and productivity.
- **E7018 Electrode Compatibility:** The included E7018 electrodes are low-hydrogen iron powder type, producing high-quality X-ray welds. They can be used in all positions on AC or DC reverse polarity welding current.
- **All-Position Welding:** Recommended for welding medium-grade carbon steels where no preheat is used, and on cold-rolled steels normally exhibiting excessive porosity when welded with conventional electrodes.



3-IN-1

Multi-function welding machine



Figure 3.1: The FLUX-135 MINI supports three welding processes: Flux Cored Welding, Lift TIG Welding, and Stick Welding.

SIMPLE PANEL

Synergic Control & High Efficiency



Figure 3.2: The simple and intuitive control panel of the FLUX-135 MINI, featuring synergic control for ease of use.

4. PACKAGE CONTENTS

Upon opening the package, please verify that all components are present and undamaged:

- YESWELDER FLUX-135 MINI 3-in-1 Welding Machine
- Flux Core MIG Torch (integrated or included)



Figure 4.2: Professional packing of the E7018 rods in a durable plastic case, ensuring they remain in good condition.

5. SETUP

5.1 Power Connection

1. Ensure the welding machine's power switch is in the OFF position.
2. Connect the power cord to a suitable 110V power outlet. Verify that the outlet can provide sufficient amperage for the welder's maximum output.

5.2 Connecting Welding Accessories

The FLUX-135 MINI features standard quick-connect terminals for easy accessory attachment.



Figure 5.1: Front panel connections for the welding machine, including ports for the MIG torch, ground clamp, and electrode holder.

For Flux Core MIG Welding:

- Connect the MIG torch to the designated port on the front panel.
- Connect the ground clamp cable to the appropriate terminal and attach the clamp securely to the workpiece.
- Install the flux core welding wire spool inside the wire feeder compartment. Ensure the wire size matches the machine's capabilities (e.g., 2LB spool, 0.030"/0.8mm wire).
- Thread the wire through the feeder mechanism and into the MIG torch liner.

COMPATIBLE WITH

2LB WELDING WIRE

(Spool Diameter: 4")



Figure 5.2: The internal wire feeder compartment, demonstrating compatibility with a 2LB welding wire spool (4" diameter).

For Stick (MMA) Welding:

- Connect the electrode holder cable to the positive (+) terminal and the ground clamp cable to the negative (-) terminal for DCEN (Direct Current Electrode Negative) or vice versa for DCEP (Direct Current Electrode Positive), depending on the electrode type. For E7018 rods, DCEP is typically recommended.
- Securely attach the ground clamp to the workpiece.

- Insert an E7018 electrode into the electrode holder.

For Lift TIG Welding:

- A separate Lift TIG torch (not included) is required. Connect the Lift TIG torch to the appropriate terminal.
- Connect the ground clamp cable to the workpiece.
- Ensure a suitable tungsten electrode is installed in the TIG torch.

6. OPERATING INSTRUCTIONS

6.1 General Operation

1. After connecting all necessary components, turn on the power switch located on the machine.
2. Select the desired welding process (MIG, Stick, or Lift TIG) using the mode selector switch on the control panel.
3. Adjust the welding parameters (voltage, wire feed speed, or amperage) using the control knobs. The synergic control feature will assist in setting optimal parameters for MIG welding.
4. Always perform test welds on scrap material to fine-tune settings before welding your actual workpiece.

6.2 Flux Core MIG Welding

- Select "MIG" mode.
- Adjust the wire feed speed knob. The machine's synergic control will automatically suggest the corresponding voltage. Fine-tune as needed.
- Ensure proper stick-out of the wire from the contact tip.
- Begin welding by pressing the trigger on the MIG torch. Maintain a consistent travel speed and angle.

6.3 Stick (MMA) Welding

- Select "STICK" mode.
- Adjust the amperage knob according to the electrode diameter and material thickness. For E7018 3/32" rods, typical amperage ranges are provided on the electrode packaging.
- Strike the arc by lightly tapping or scratching the electrode on the workpiece.
- Maintain a consistent arc length and travel speed.



Figure 6.1: Common electrode sizes and their standard length, important for selecting appropriate welding parameters.

6.4 Lift TIG Welding

- Select "LIFT TIG" mode.
- Adjust the amperage knob.
- To initiate the arc, gently touch the tungsten electrode to the workpiece and then lift it slightly. The arc will ignite.
- Maintain a short arc length and consistent travel speed.

7. MAINTENANCE

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

- **Cleaning:** Periodically clean the internal components of the machine using compressed air to remove dust and metal particles. Ensure the machine is unplugged before cleaning.
- **Cable Inspection:** Regularly inspect all welding cables, torch, and ground clamp for signs of wear, cuts, or damage.

Replace damaged components immediately.

- **Contact Tip and Nozzle:** For MIG welding, regularly check and replace worn contact tips and clean the nozzle to prevent spatter buildup.
- **Electrode Holder/Ground Clamp:** Ensure good electrical contact by keeping these components clean and free of corrosion.
- **Storage:** Store the welding machine in a clean, dry environment, away from excessive dust, moisture, and extreme temperatures.

8. TROUBLESHOOTING

This section addresses common issues you might encounter. For problems not listed here, please contact customer support.

Problem	Possible Cause	Solution
No power to the machine	Power cord unplugged, circuit breaker tripped, faulty power switch.	Check power connections, reset circuit breaker, contact service if switch is faulty.
No arc/Poor arc starting	Poor ground connection, incorrect settings, worn contact tip (MIG), damp electrodes (Stick).	Ensure ground clamp is secure and on bare metal. Adjust parameters. Replace contact tip. Store electrodes properly.
Wire feeding issues (MIG)	Incorrect wire tension, clogged liner, wrong drive roller size, worn contact tip.	Adjust tension. Clean or replace liner. Ensure correct drive rollers. Replace contact tip.
Overheating/Thermal overload	Exceeding duty cycle, blocked ventilation.	Allow machine to cool down. Ensure clear airflow around the machine.

9. SPECIFICATIONS

Key technical specifications for the YESWELDER FLUX-135 MINI:

- **Model:** FLUX-135 MINI
- **Input Voltage:** 110V
- **Output Current:** 135 Amp (Max)
- **Welding Processes:** Flux Core Gasless MIG, Lift TIG, Stick (MMA)
- **Compatible Wire Spool:** 2LB (4" diameter)
- **Compatible Electrode Sizes (Stick):** 3/32", 1/8", 5/32" (E7018 included)
- **Style:** YESWELDER FLUX-135 MINI & E7018 3/32" 5LB Welding Rod
- **ASIN:** B0DJVGLPJF
- **First Available:** October 11, 2024

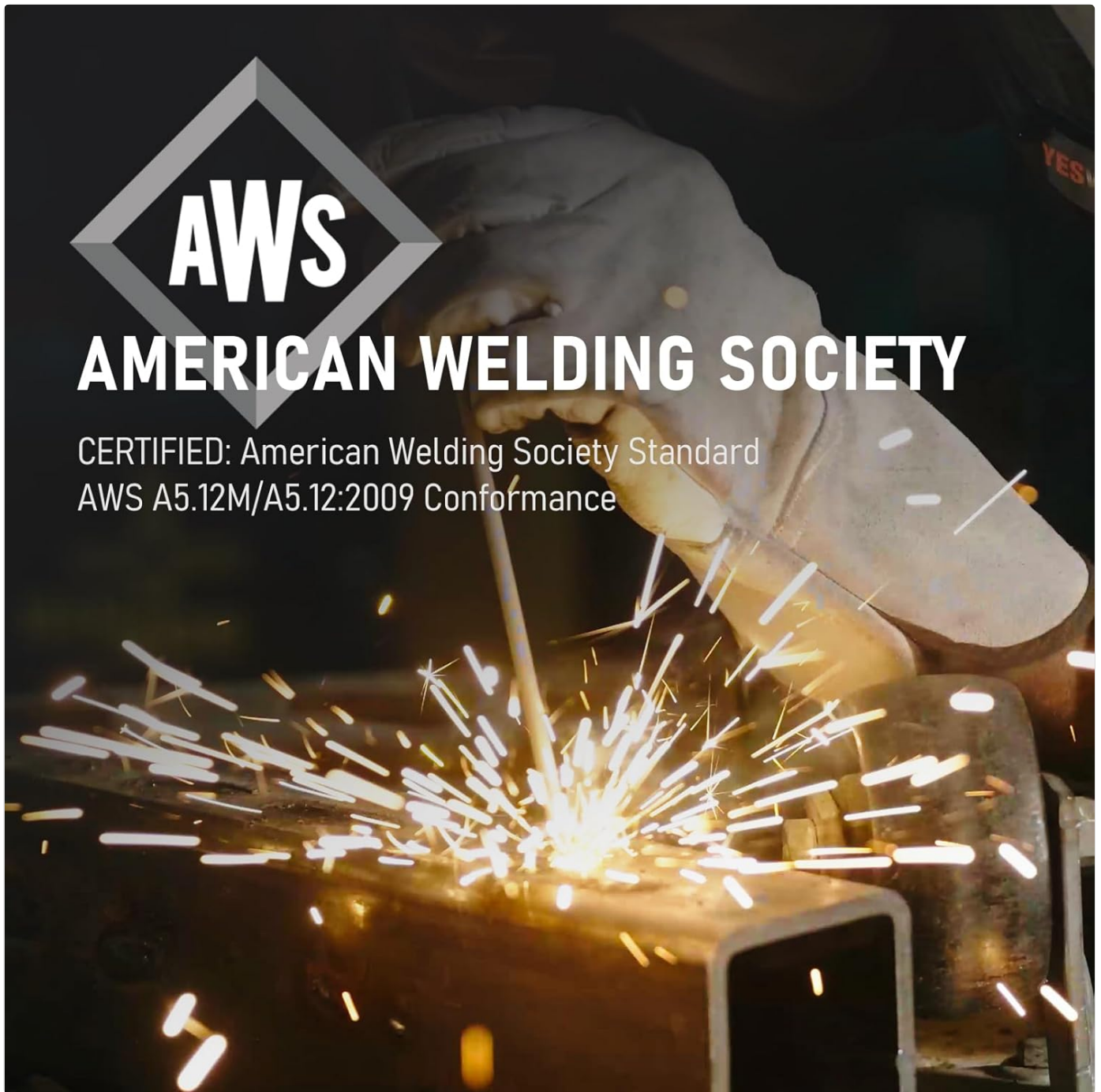


Figure 9.1: The product adheres to American Welding Society (AWS) standards, specifically AWS A5.12M/A5.12:2009 Conformance.

10. WARRANTY AND SUPPORT

For warranty information, technical support, or service inquiries, please contact YESWELDER customer service. Keep your purchase receipt as proof of purchase.

YESWELDER Customer Service:

Visit the official YESWELDER website for contact details and support resources: www.yeswelder.com

Refer to the contact information provided on your product packaging or warranty card.



