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ANDELI MIG-270PLUS

ANDELI MIG-270PLUS Multiprocess Welding Machine User Manual

Comprehensive Guide for Operation, Maintenance, and Troubleshooting

1. Introduction and Overview

The ANDELI MIG-270PLUS is a versatile 5-in-1 multiprocess welding machine designed for both beginners and professional welders. It supports Gas MIG, Flux Core MIG, Spool Gun MIG, Lift TIG, and Stick welding, offering a wide range of applications for various materials and thicknesses. This machine features a new intelligent LCD digital screen display for real-time adjustments and enhanced functionality, ensuring efficiency and accuracy in your welding tasks. Its dual-voltage capability (110V/220V) automatically identifies the input voltage, providing powerful performance up to 250Apm.



Figure 1: ANDELI MIG-270PLUS Multiprocess Welding Machine with included accessories.

2. Safety Information

Welding operations involve inherent risks. Always prioritize safety to prevent injury or damage. This section outlines essential safety precautions.

2.1 Personal Protective Equipment (PPE)

- **Welding Helmet:** Always wear a welding helmet with appropriate shade settings to protect your eyes and face from intense light and sparks.
- **Gloves:** Use heavy, flame-resistant welding gloves to protect hands from heat, sparks, and electrical shock.
- **Protective Clothing:** Wear flame-resistant clothing (e.g., leather jacket, heavy cotton shirt and pants) to cover all exposed skin. Avoid synthetic materials.
- **Footwear:** Wear high-top leather boots to protect feet and ankles from falling objects and sparks.

2.2 Work Area Safety

- **Ventilation:** Ensure adequate ventilation to remove welding fumes and gases, which can be hazardous if inhaled.
- **Fire Prevention:** Keep a fire extinguisher readily available. Remove all flammable materials from the welding area. Be aware of hot metal and sparks.
- **Electrical Safety:** Ensure the welding machine is properly grounded. Do not operate in wet conditions. Inspect cables and connections for damage before use.
- **Clearance:** Maintain a clear and uncluttered workspace to prevent trips and falls.

Always read and understand the entire manual before operating the welding machine. If you are unsure about any safety procedure, consult a qualified professional.

3. Package Contents

The ANDELI MIG-270PLUS package includes the following items:

- MIG Welder MIG-270PLUS (x1)
- Welding Clamp 3m (x1)
- Ground Clamp (x1)
- Protective Nozzle (x2)
- Nozzle (x10)
- Flux Cored Wire (x1)
- User Manual (x1)



Figure 2: Detailed view of the included components with the MIG-270PLUS welding machine.

4. Setup

Before operating your ANDELI MIG-270PLUS, ensure proper setup for safe and effective welding.

4.1 Power Connection

The MIG-270PLUS features dual-voltage capability (110V/220V) and automatically identifies the input voltage. Connect the power cord to a suitable power outlet. Ensure the outlet matches the machine's voltage requirements.

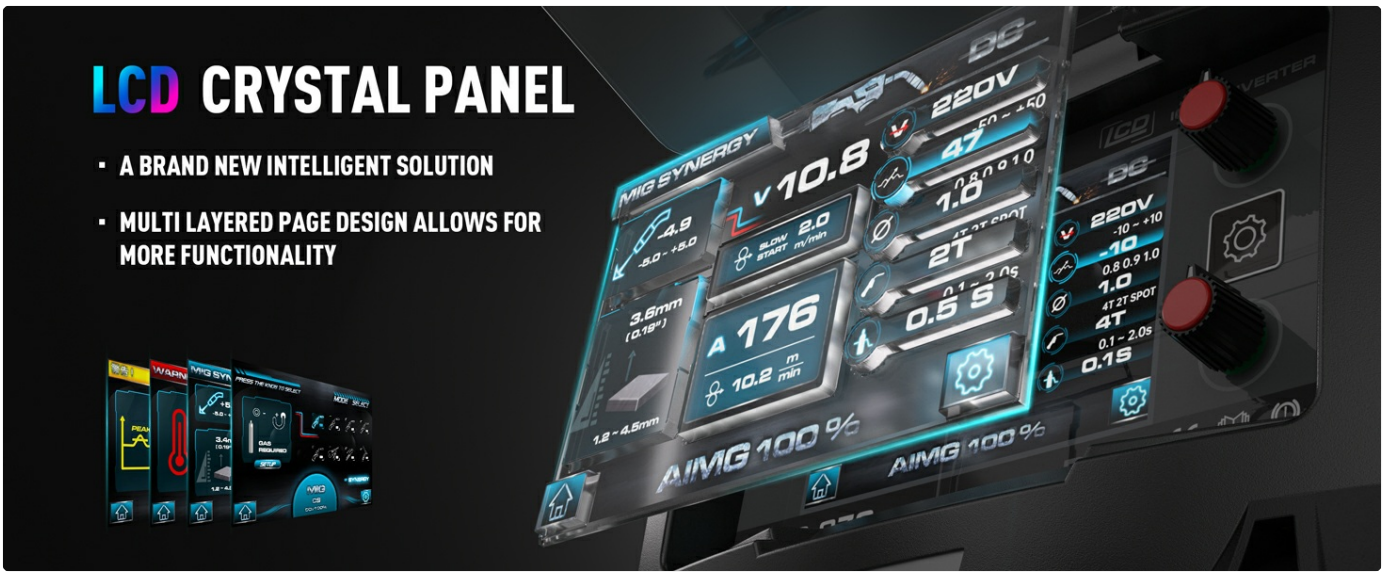


Figure 3: The welder supports both 110V (suitable for family use) and 220V (suitable for work scenarios).

4.2 Connecting Welding Accessories

- **MIG Gun:** Connect the MIG gun cable assembly to the appropriate port on the front panel.
- **Ground Clamp:** Attach the ground clamp cable to the workpiece to ensure a proper electrical circuit.
- **Electrode Holder (for Stick Welding):** If performing Stick welding, connect the electrode holder to the designated port.
- **Spool Gun (Optional):** For aluminum welding, an external spool gun can be connected to the machine. (Spool gun not included and must be purchased separately).

4.3 Wire Installation

Open the side compartment of the welder to install the welding wire spool. Ensure the wire is properly threaded through the wire feeder roller and into the MIG gun. Adjust the wire tension knob to prevent tangling or slipping.

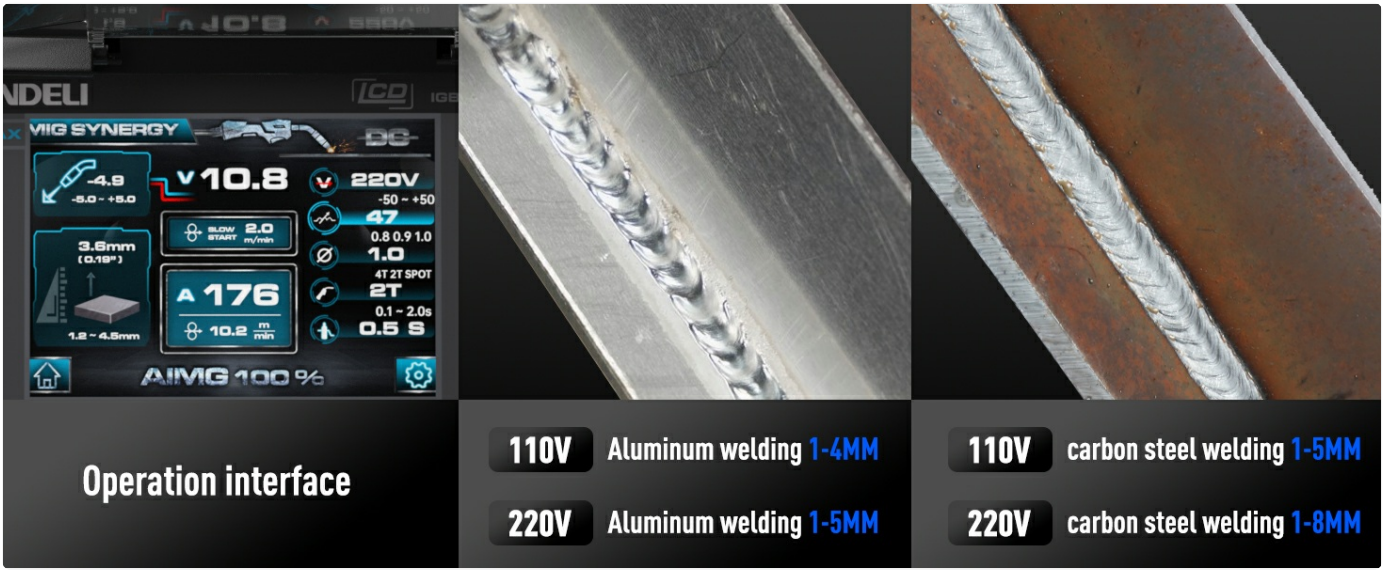


Figure 4: The internal wire feeder supports 1KG and 5KG welding wire spools, ensuring smooth wire feeding.

5. Operating Modes

The ANDELI MIG-270PLUS offers five distinct welding functions. Select the appropriate mode using the intelligent LCD digital screen.



Figure 5: The MIG-270PLUS supports five welding processes: Gas MIG, Flux Core MIG, Spool Gun MIG, Lift TIG, and Stick.

5.1 LCD Digital Screen Display

The intelligent LCD screen allows for real-time adjustments and displays various parameters. Use the knobs to navigate and modify settings such as wire feed speed, voltage, and material thickness. The multi-layered page design provides comprehensive functionality.



Figure 6: The LCD Crystal Panel provides an intelligent solution for real-time parameter display and adjustment.

5.2 Synergic Control

The synergic control feature automatically matches the recommended current and wire feeding speed when you select the diameter of the welding wire and gas material. You can also fine-tune the welding current according to your specific welding habits and requirements.



Figure 7: The operation interface displays recommended settings for various materials and voltages, such as aluminum welding (1-4MM at 110V, 1-5MM at 220V) and carbon steel welding (1-5MM at 110V, 1-8MM at 220V).

5.3 Spool Gun Compatibility

The MIG-270PLUS is compatible with a spool gun (sold separately) for efficient aluminum welding. This feature provides greater convenience and control for specific aluminum applications.



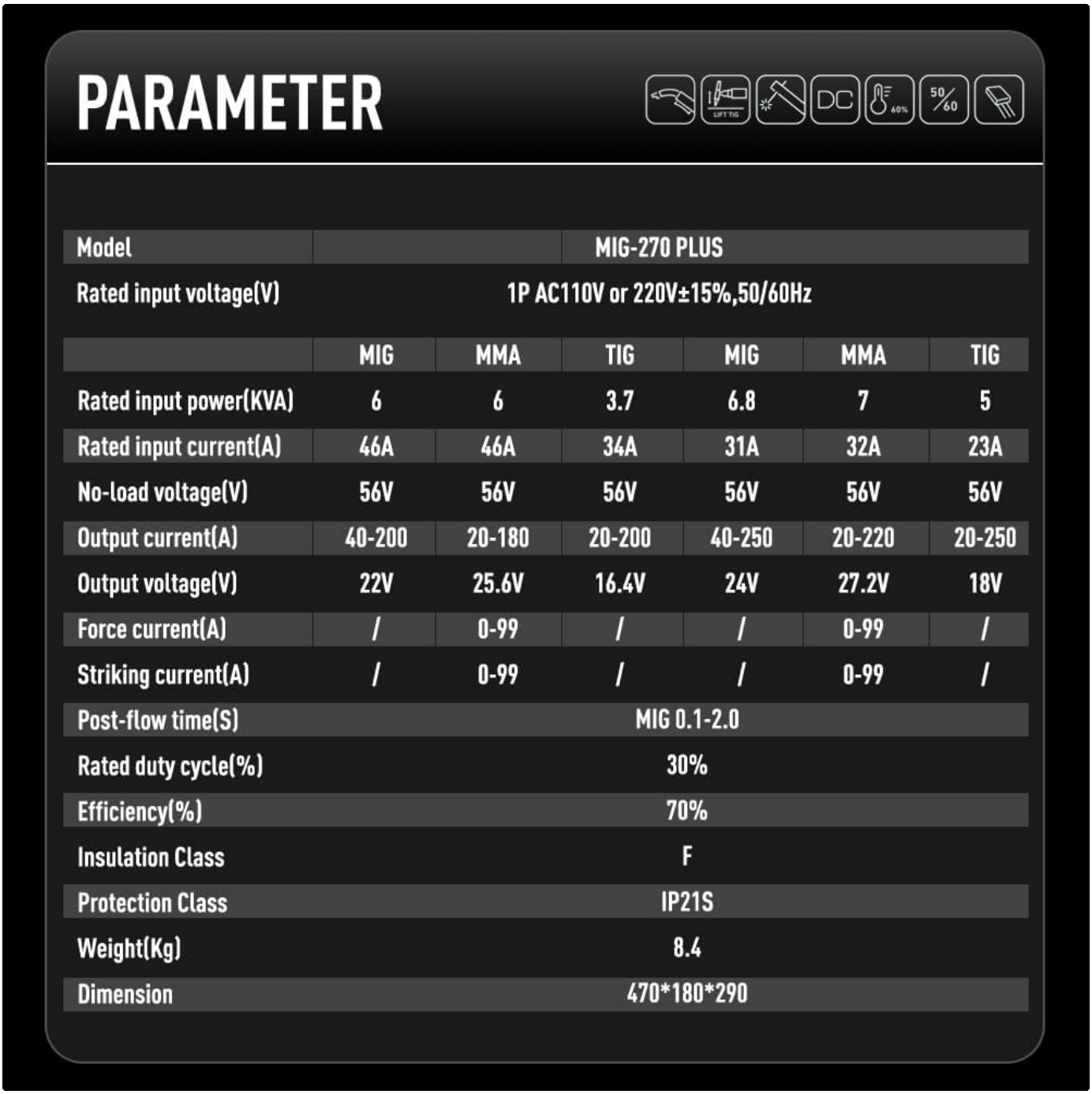
Figure 8: The welder is compatible with a spool gun (purchased separately) for specialized aluminum welding tasks.

6. Specifications

Below are the detailed technical specifications for the ANDELI MIG-270PLUS welding machine:

Feature	Value
Manufacturer	ANDELI
Item Weight	32.4 pounds
Product Dimensions	12.6 x 6.69 x 18.5 inches
Country of Origin	China
Item Model Number	MIG-270PLUS
Power Source	AC

Feature	Value
Batteries Included?	No
Batteries Required?	No
ASIN	B0DKFNGGJ9
Date First Available	October 21, 2024



Model	MIG-270 PLUS					
Rated input voltage(V)	1P AC110V or 220V±15%,50/60Hz					
	MIG	MMA	TIG	MIG	MMA	TIG
Rated input power(KVA)	6	6	3.7	6.8	7	5
Rated input current(A)	46A	46A	34A	31A	32A	23A
No-load voltage(V)	56V	56V	56V	56V	56V	56V
Output current(A)	40-200	20-180	20-200	40-250	20-220	20-250
Output voltage(V)	22V	25.6V	16.4V	24V	27.2V	18V
Force current(A)	/	0-99	/	/	0-99	/
Striking current(A)	/	0-99	/	/	0-99	/
Post-flow time(S)	MIG 0.1-2.0					
Rated duty cycle(%)	30%					
Efficiency(%)	70%					
Insulation Class	F					
Protection Class	IP21S					
Weight(Kg)	8.4					
Dimension	470*180*290					

Figure 9: Detailed electrical parameters for the MIG-270PLUS, including rated input voltage, power, current, and duty cycle.



Figure 10: Synergy MIG parameters table, showing recommended current and voltage settings based on metal type, gas mixture, wire diameter, and plate thickness for both 110V and 220V.

7. Maintenance

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

- **Cleaning:** Periodically clean the machine's exterior and internal components (if accessible and safe) to prevent dust and debris buildup, which can affect cooling and performance.
- **Cable Inspection:** Regularly inspect all welding cables, including the MIG gun cable, ground clamp cable, and electrode holder cable, for cuts, fraying, or damage. Replace damaged cables immediately.
- **Nozzle and Contact Tip:** For MIG welding, regularly clean or replace the nozzle and contact tip as they wear out or become clogged with spatter.
- **Wire Feeder:** Keep the wire feeder mechanism clean and free of debris to ensure smooth wire feeding. Check and adjust wire tension as needed.
- **Storage:** Store the welding machine in a clean, dry environment when not in use to protect it from moisture and extreme temperatures.

8. Troubleshooting

This section provides general guidance for common issues. For complex problems, contact customer support.

- **No Power:**
  - Check if the power cord is securely plugged into a working outlet.
  - Verify the power switch on the back of the machine is in the "ON" position.
  - Ensure the circuit breaker has not tripped.
- **No Arc:**
  - Confirm the ground clamp is securely attached to the workpiece and has good electrical contact.
  - Check if the welding wire or electrode is properly installed and making contact.
  - Verify the correct welding mode and parameters are selected on the LCD screen.
- **Poor Weld Quality (Excessive Spatter, Inconsistent Bead):**
  - Adjust wire feed speed and voltage settings according to the material and wire type (refer to the Specifications section).
  - Ensure the contact tip and nozzle are clean and not worn.
  - For Gas MIG, check gas flow and ensure the gas cylinder is not empty.
- **Overheating Protection:**
  - The machine has an automatic protection feature if it gets too hot. Allow the machine to cool down.

- Ensure adequate ventilation around the machine and that cooling fans are not obstructed.

9. Warranty and Support

For warranty information, technical support, or service inquiries, please refer to the contact details provided in your product packaging or visit the official ANDELI website. Keep your purchase receipt as proof of purchase for any warranty claims.

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