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> [haxiaoer 140A Stick Welder 2 in 1 MMA Lift TIG Welding Machine User Manual](#)

haxiaoer MMA140A Stick Welder

haxiaoer 140A Stick Welder Instruction Manual

Model: MMA140A Stick Welder

1. INTRODUCTION

The haxiaoer 140A Stick Welder is a compact and powerful 2-in-1 welding machine, offering both MMA (Manual Metal Arc) and Lift TIG welding modes. Designed with user-friendliness in mind, it features a digital smart LCD display for precise parameter control and is equipped with IGBT technology for enhanced reliability. This manual provides essential information for safe and effective operation, maintenance, and troubleshooting of your welding machine.

2. WHAT'S INCLUDED

Upon unboxing your haxiaoer 140A Stick Welder, please verify that all components listed below are present and in good condition:

- 1x ARC140 Stick Welder Machine
- 1x Welding Handle (2.0m 10-25 welding torch clamp)
- 1x Earth Clamp
- 1x Carrying Strap
- 1x Simple Mask
- 10x 2.5mm Welding Rods
- 1x Instruction Manual (this document)



Image: The haxiaoer 140A Stick Welder shown with its complete set of included accessories, including the welding handle, earth clamp, carrying strap, simple mask, and welding rods.

3. KEY FEATURES

3.1. Easy to Use Interface

The haxiaoer 140A welder is equipped with an intuitive digital smart LCD display that provides precise welding parameters, including welding current, workpiece thickness, and electrode diameter. The 3-key button interface allows for quick and efficient parameter adjustments, streamlining your welding process.

3 Key Buttons Operation

User-friendly buttons for operation, saves time than ONE button

1
VRD Button

2
Welding Mode Button

3
Parameter Knob



Image: A detailed view of the welder's control panel, highlighting the 3-key button operation for VRD, Welding Mode, and Parameter Knob, simplifying adjustments.

Smart LCD Display

Provide accurate welding parameters



Image: The Smart LCD Display clearly showing current data, rod diameter, and metal thickness, along with the 3 key buttons for easy navigation.

3.2. 2-in-1 Welding Modes

This portable inverter welder supports both Stick/ARC and Lift TIG welding modes (Lift TIG torch not included). This versatility makes it suitable for welding various metal materials, including stainless steel and mild steel.

2 In 1 Welder

Not Include TIG Torch



Image: The haxiaoer 140A welder, emphasizing its dual functionality for Stick/ARC and Lift TIG welding, noting that the TIG torch is sold separately.

3.3. Synergic Control

The synergic control feature automatically matches the electrode diameter and workpiece thickness once the welding current is selected. This simplifies setup and is ideal for beginners learning to weld, ensuring a more consistent and beautiful weld.

Synergic Control

Easier for beginners



Image: A welder at work, with an overlay showing the synergic control display, indicating how parameters are automatically adjusted for easier use, especially for beginners.

3.4. Portable & Durable Design

Built with IGBT power devices, the welder utilizes a unique control mode to enhance reliability. Its compact size and included carrying strap make it highly portable. It can light up 2.5-3.2mm E6010, E6011, E6013, and 7018 rods with its 140A current.

Multi-function Stick Welder



Easy to Carry



LED Display



IP21S



Multi-protection



Anti Stick



Hot Start



ARC Force



IGBT Technology



Image: The haxiaoer 140A Multi-function Stick Welder displayed with icons representing its key features: Easy to Carry, LCD Display, Anti Stick, Hot Start, ARC Force, Multi-protection, and IGBT Technology.

3.5. Advanced Welding Functions: Hot Start, Arc Force, and VRD

The adjustable Hot Start feature boosts the current during arc initiation, ensuring easy, quick, and reliable arc starts. Arc Force provides a superimposed current value (0-10A) to prevent the electrode from sticking and achieve smooth welds. The adjustable VRD (Voltage Reduction Device) function enhances safety by preventing the electrode from sticking in the molten pool, with an open VRD voltage less than 25.6V for anti-electric shock protection.

Rapid ARC Starting & Stable

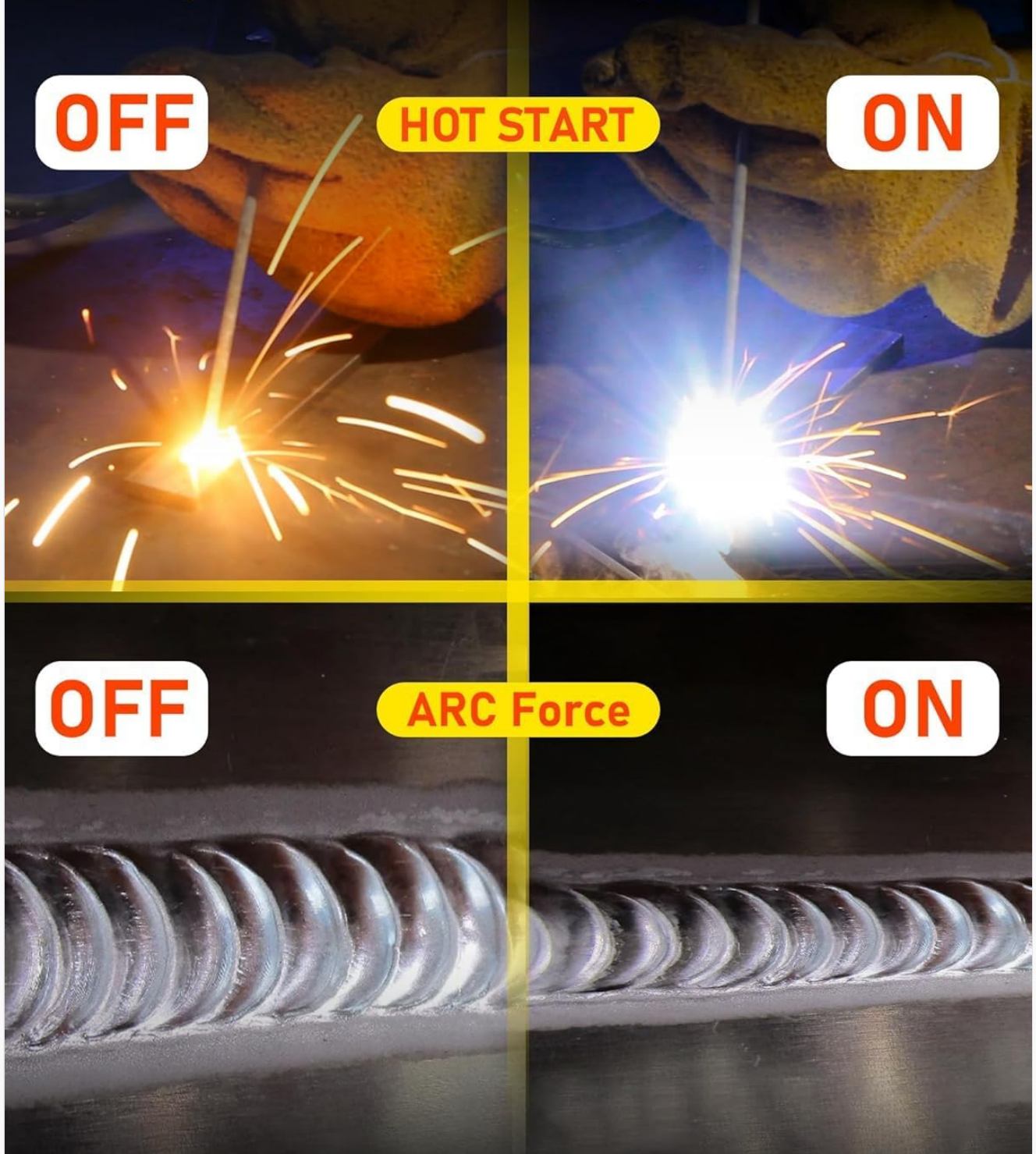


Image: Visual demonstration of 'Rapid ARC Starting & Stable', showing the difference between 'OFF' and 'ON' states for Hot Start (arc initiation) and Arc Force (weld bead appearance).

HOT START

Boosts the Current During Starting to Provide Easy, Quick, and Reliable Arc Starts

Image: A graphic explaining the 'Hot Start' feature, illustrating how it boosts current during starting for easy, quick, and reliable arc starts.

ARC FORCE

Superimposed Current Value (0~10A) to Make No Sticking and Smooth Welds

Image: A graphic explaining the 'ARC FORCE' feature, showing how a superimposed current value helps prevent sticking and creates smooth welds.

VRD

ON
Open VRD Voltage is Less Than 25.6V,
Anti-Electric Shock
Protection Welder Safety

OFF
Turn Off. VRD Can Arc Easier,
Excellent Welding Effect

Image: A graphic explaining the 'VRD' (Voltage Reduction Device) feature, detailing its ON/OFF states and how it provides anti-electric shock protection.

3.6. Efficient Cooling System

The machine incorporates an efficient cooling system with slotted heat dissipation, side heat dissipation, a powerful fan, and bottom heat dissipation. This design improves work efficiency by up to 80% and extends the overall life of

the machine.

High-End & Durable Machine

An efficient cooling system improves work efficiency up to 80%. and extend the life of the machine.



Slotted Heat Dissipation



Side Heat Dissipation



Powerful Fan



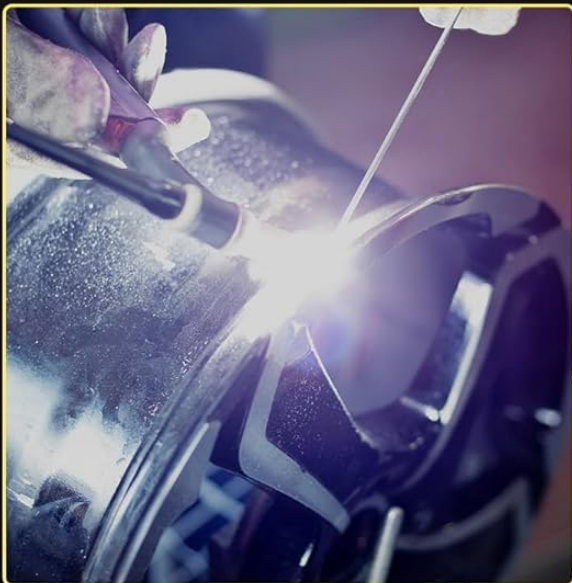
Bottom Heat Dissipation

Image: A visual breakdown of the welder's cooling system, showing slotted heat dissipation, side heat dissipation, a powerful fan, and bottom heat dissipation for enhanced durability.

3.7. Wide Range of Applications

This welding machine is suitable for various applications, including automotive maintenance, lawn & garden maintenance, home maintenance, and DIY metal crafts.

WIDE RANGE OF WELDING APPLICATIONS



Automotive Maintenance



Lawn & Garden Maintenance



Home Maintenance



DIY Metal Crafts

Image: A collage showcasing the wide range of welding applications for the haxiaoer 140A welder, including automotive, lawn & garden, home maintenance, and DIY metal crafts.

WELDING CONSUMABLES AND EFFECTS

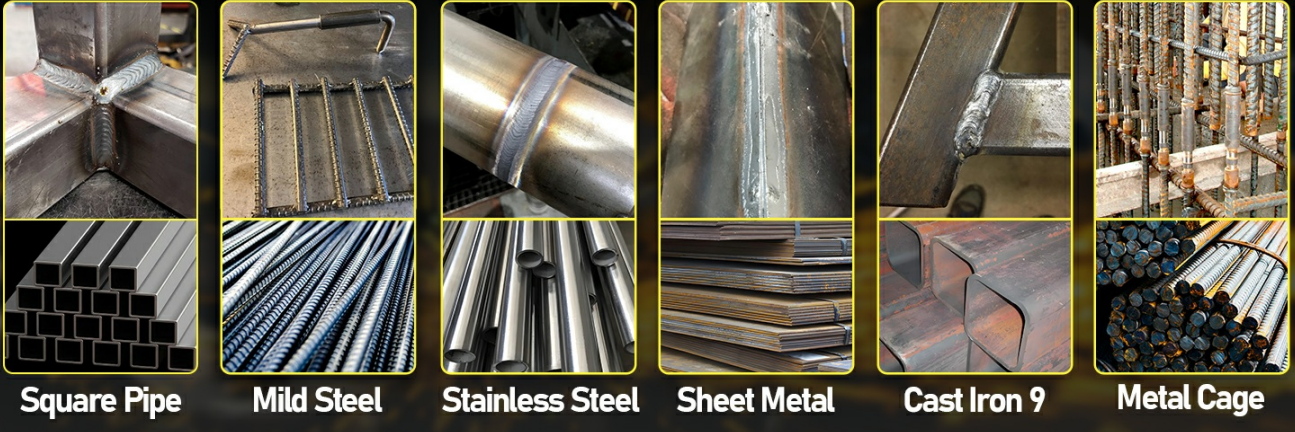


Image: A visual guide to welding consumables and their effects on various materials such as square pipe, mild steel, stainless steel, sheet metal, cast iron, and metal cage.

4. SETUP

1. **Unpacking:** Carefully remove the welding machine and all accessories from the packaging. Inspect for any signs of damage during transit.
2. **Placement:** Place the welder on a stable, level, and non-flammable surface. Ensure adequate ventilation around the machine to prevent overheating.
3. **Power Connection:** Connect the power cord to a suitable 110V power outlet. The machine is designed to be switchable from 110V to 220V, but ensure the correct voltage is used for your setup.
4. **Connect Welding Cables:**
 - Connect the welding handle (electrode holder) cable to the positive (+) terminal on the front of the machine.
 - Connect the earth clamp cable to the negative (-) terminal on the front of the machine.
5. **Attach Earth Clamp:** Securely attach the earth clamp to the workpiece or a clean, bare metal part of the welding table to ensure a good electrical connection.
6. **Insert Welding Rod:** Insert the appropriate welding rod into the electrode holder. The machine supports 2.5-3.2mm rods.

5. OPERATING INSTRUCTIONS

1. **Power On:** Locate the ON/OFF switch on the back of the machine and switch it to the 'ON' position. The LCD display will illuminate.
2. **Select Welding Mode:** Use the 'Welding Mode Button' (Key 2 on the display diagram) to switch between MMA (Stick/ARC) and Lift TIG modes.
3. **Adjust Parameters:** Use the 'Parameter Knob' (Key 3) to adjust the welding current. The synergic control will automatically suggest appropriate electrode diameter and workpiece thickness settings based on your current selection.
4. **Activate VRD (Optional):** If desired, press the 'VRD Button' (Key 1) to activate or deactivate the Voltage Reduction Device for enhanced safety.
5. **Begin Welding:** With appropriate safety gear (including the simple mask provided), bring the electrode into

contact with the workpiece to initiate the arc. The Hot Start and Arc Force features will assist in smooth arc initiation and stable welding.

6. **Monitor Display:** Continuously monitor the LCD display for real-time feedback on welding parameters.

Recommended Welding Rod Parameters

For optimal performance, refer to the following recommended parameters:

- 20-80A: Φ 2.0MM Rod
- 80-100A: Φ 2.5MM Rod
- 100-140A: Φ 3.2MM Rod



Image: A chart illustrating recommended welding rod parameters based on current, showing optimal rod diameters for different amperage ranges.

6. MAINTENANCE

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

- **Cleaning:** Periodically clean the exterior of the machine with a dry, soft cloth. Ensure the ventilation openings are free from dust and debris to maintain proper airflow for cooling.
- **Cable Inspection:** Regularly inspect all welding cables, connections, and the power cord for any signs of wear, cuts, or damage. Replace damaged components immediately.
- **Storage:** Store the welding machine in a dry, clean, and well-ventilated area when not in use. Protect it from direct sunlight, moisture, and extreme temperatures.
- **Electrode Holder & Earth Clamp:** Keep the electrode holder and earth clamp clean and free of spatter to ensure good electrical contact.

7. TROUBLESHOOTING

If you encounter issues with your haxiaoe 140A Stick Welder, refer to the following common problems and solutions:

Problem	Possible Cause	Solution
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Problem	Possible Cause	Solution
No power to the machine	Power switch off, loose power cord, tripped circuit breaker, no power from outlet	Turn on power switch, check power cord connection, reset circuit breaker, test outlet with another device
No arc or weak arc	Poor earth clamp connection, incorrect current setting, damp/damaged electrode, loose welding cables	Ensure good earth connection, adjust current, use dry/new electrode, tighten cable connections
Electrode sticking	Low current setting, improper arc length, damp electrode, Arc Force feature off	Increase current, maintain proper arc length, use dry electrode, activate Arc Force
Overheating indicator on	Prolonged use, blocked ventilation, high ambient temperature	Allow machine to cool down, clear ventilation openings, operate in a cooler environment

If the problem persists after attempting these solutions, please contact haxiaoer customer support.

8. SPECIFICATIONS

Specification	Detail
Manufacturer	haxiaoer
Part Number	MMA140A Stick Welder
Item Weight	8.36 pounds
Package Dimensions	12.52 x 9.29 x 7.64 inches
Item Model Number	MMA140A Stick Welder
Size	140A-110V
Color	Yellow
Material	metal
Item Package Quantity	1
Batteries Included?	No
Batteries Required?	No
Date First Available	July 14, 2025

9. WARRANTY AND SUPPORT

haxiaoer offers a three-year after-sales service for its welding machines. If you encounter any problem when using this machine, please feel free to contact haxiaoer customer support for assistance. For further information or to explore other products, visit the official haxiaoer store on Amazon: [haxiaoer Store](#).

