

HONE FC135

HONE FC135 3-in-1 MIG/Stick/Lift TIG Welder User Manual

Model: FC135 | Input Voltage: 110V | Max Output: 135A

1. IMPORTANT SAFETY INFORMATION

WARNING: Welding can be dangerous. Always follow safety precautions to prevent injury or death.

- Always wear appropriate personal protective equipment (PPE), including a welding helmet with proper shade, flame-resistant clothing, welding gloves, and safety shoes.
- Ensure adequate ventilation to avoid inhaling welding fumes.
- Protect bystanders from arc rays and hot metal.
- Never weld near flammable materials.
- Ensure the welding machine is properly grounded.
- Disconnect power before performing any maintenance or changing accessories.
- Read and understand all instructions before operating the machine.

2. PRODUCT OVERVIEW

The HONE FC135 is a versatile 3-in-1 welding machine designed for Flux-Cored MIG, Stick (MMA), and Lift TIG welding processes. It operates on a 110V power supply and offers up to 135 Amps of output, suitable for various welding tasks on mild steel up to 1/4 inch thickness.



Figure 2.1: HONE FC135 3-in-1 MIG Welder Machine with accessories.

Key Features:

- **3-in-1 Welding Capability:** Supports Flux MIG, Stick (MMA), and Lift TIG welding.
- **Synergic Control:** Simplifies settings for Flux MIG welding, making it easier for beginners.
- **Digital Display:** Large LED display for clear and easy operation.
- **Advanced IGBT Inverter Technology:** Provides stable welding current and smooth arc.
- **Built-in Protections:** Includes over-current, over-voltage, over-heat, and overload protection.
- **Portable Design:** Lightweight (approx. 9.7 lbs) with a handle and shoulder strap for easy transport.

3 IN 1 Multi-Function Welder



Figure 2.2: Illustration of the FC135's three welding functions: Flux MIG, Stick, and Lift TIG.

3. PACKAGE CONTENTS

Verify that all items listed below are included in your package:

- HONE FC135 3-in-1 Gasless MIG Welder/Stick Welder/Lift TIG Synergic Welding Machine (1 pc)
- Welding Gun (MIG Torch) 8.2 ft (2.5 m) (1 pc)
- Electrode Holder with welding cable and cable joint 6.6 ft (2 m) (1 pc)
- Earth Clamp with welding cable and cable joint 6.6 ft (2 m) (1 pc)
- Brush Hammer (1 pc)

- Adjustable Shoulder Strap (1 pc)
- Contact Tip .030-inch (2 pcs)
- Contact Tip .035-inch (2 pcs)
- Flux-cored wire 0.030 inch 1LB (1 pc)
- User Manuals (1 pc)



Figure 3.1: All components included with the HONE FC135 welding machine.

4. SETUP AND CONNECTIONS

4.1 Front Panel Controls and Connections

DIGITAL SMART CONTROL SYSTEM

Easy to weld even if you are beginner



Figure 4.1: Front panel layout and controls of the HONE FC135.

1. **Handle:** For carrying the machine.
2. **LED Light:** Illuminates the work area.
3. **Display Meter:** Shows welding parameters.
4. **Function Select:** Button to choose between MIG, Stick, and Lift TIG modes.
5. **Welding Voltage Adjustable Knob:** Adjusts welding voltage.
6. **Welding Current Adjustable Knob (Wire Speed Knob):** Adjusts welding current and wire speed in MIG mode.
7. **Torch Connector:** Connection point for the MIG torch.
8. **(-) Negative Output Terminal:** Connects to the ground clamp or electrode holder depending on the process.
9. **(+) Positive Output Terminal:** Connects to the ground clamp or electrode holder depending on the process.

4.2 Power Connection

Connect the machine to a standard 110V AC power outlet. Ensure the outlet can provide sufficient current for welding operations (refer to specifications).

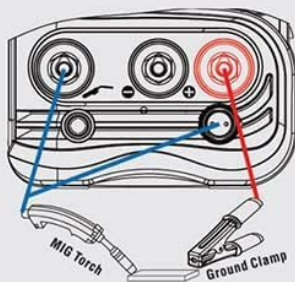
4.3 Flux MIG Welding Setup

1. Install the flux-cored wire spool into the wire feeder compartment. Ensure the wire size matches the contact tip (.030" or .035").
2. Feed the wire through the liner and out of the MIG torch.
3. Connect the MIG torch to the Torch Connector.
4. Connect the ground clamp to the (-) Negative Output Terminal.
5. Attach the ground clamp securely to the workpiece.

Synergic Control, Powerful Speedy Wire Feeder Easier for Beginners



MIG Welding Connection



Real Shooting of Welding Effect



Figure 4.2: MIG welding connection diagram and examples of welding results.

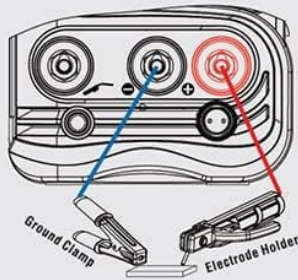
4.4 Stick (MMA) Welding Setup

1. Connect the electrode holder to the (+) Positive Output Terminal.
2. Connect the ground clamp to the (-) Negative Output Terminal.
3. Insert the appropriate welding electrode (e.g., E6013, E7018) into the electrode holder.
4. Attach the ground clamp securely to the workpiece.

For E6013 E7018 E6010 etc.



MMA Welding Connection



Real Shooting of Welding Effect



Figure 4.3: MMA welding connection diagram and common electrode types.

4.5 Lift TIG Welding Setup

Note: A TIG torch is not included with this machine and must be purchased separately.

1. Connect the TIG torch to the (-) Negative Output Terminal.
2. Connect the ground clamp to the (+) Positive Output Terminal.
3. Ensure the TIG torch has a suitable tungsten electrode installed.
4. Attach the ground clamp securely to the workpiece.

5. OPERATING INSTRUCTIONS

5.1 Selecting Welding Mode

Press the 'Function Select' button on the front panel to cycle through the available welding modes: Flux MIG, Stick (MMA), and Lift TIG. The selected mode will be indicated on the digital display.

5.2 Adjusting Parameters

Use the 'Welding Voltage Adjustable Knob' and 'Welding Current Adjustable Knob' to set the desired welding parameters. For Flux MIG, the current knob also controls wire speed. The digital display will show the current settings.



Figure 5.1: Recommended settings for minimum (1/32 inch, 20A) and maximum (1/4 inch, 135A) workpiece thicknesses.

5.3 Welding Process

- **Flux MIG:** Position the MIG torch nozzle close to the workpiece. Press the trigger to initiate the arc and feed wire. Maintain a consistent travel speed and arc length for optimal results.
- **Stick (MMA):** Strike the electrode against the workpiece to initiate the arc, then maintain a steady arc length and travel speed. The machine's Hot-start, Arc-force, and Anti-stick features assist in easier arc striking and smoother welding.
- **Lift TIG:** Gently touch the tungsten electrode to the workpiece, then lift it slightly to initiate the arc. Maintain a small arc gap and feed filler rod manually if required.



Figure 5.2: Examples of quality welding beads achieved with Flux Core MIG, Stick, and Lift TIG processes.

6. MAINTENANCE

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

- **Cleaning:** Periodically clean the machine's exterior with a dry cloth. Ensure cooling vents are free from dust and debris.
- **Consumables:** Regularly inspect and replace MIG contact tips, nozzles, and TIG tungsten electrodes as they wear out. Check the electrode holder and ground clamp for damage.
- **Wire Feeder:** Keep the wire feeder mechanism clean and free of dust or wire shavings. Ensure the drive rollers are correctly tensioned for smooth wire feeding.
- **Cables:** Inspect all welding cables for cuts, cracks, or loose connections. Replace damaged cables immediately.
- **Cooling System:** The machine features a fast air cooling system. Ensure the fan intake and exhaust are not obstructed to prevent overheating.

FAST AIR COOLING

Ensure the stable operation



Large wind cooling
make it to work for
a long time

7. TROUBLESHOOTING

If you encounter issues with your HONE FC135 welder, refer to the following common problems and solutions:

Problem	Possible Cause	Solution
No power to machine	Power cord unplugged, circuit breaker tripped, faulty power outlet.	Check power connections, reset circuit breaker, try a different outlet.
No arc / Weak arc	Poor ground connection, incorrect settings, worn consumables, wrong polarity.	Ensure ground clamp is on clean metal, adjust voltage/current, replace contact tip/electrode, verify polarity for process.
Wire feeding issues (MIG)	Incorrect wire tension, clogged liner, wrong drive roller size, tangled wire.	Adjust wire tension, clean or replace liner, ensure correct drive roller, untangle wire spool.
Overheat protection activated	Exceeded duty cycle, obstructed cooling vents.	Allow machine to cool down, ensure proper ventilation, clear any obstructions from vents.
Poor weld quality	Incorrect settings, improper technique, contaminated workpiece.	Adjust voltage/current, practice technique, clean workpiece thoroughly before welding.

If the problem persists after attempting these solutions, please contact HONE customer service for further assistance.

8. SPECIFICATIONS

Feature	Specification
Model	FC135
Input Voltage	AC110V (90 ~ 135V)
Rated Input Current (A)	34A (MIG) / 41A (MMA) / 26A (TIG)
No Load Voltage	25V (Flux-cored) / 55V (MMA) / 12V (Lift-TIG)
Welding Current (A)	20 ~ 140A (MIG & MMA) / 10 ~ 140A (TIG)
Duty Cycle (%)	35% MIG / 30% MMA / 40% TIG
Compatible Flux Core Wire	Mild Steel E71TGS .030 / .035 inch, 2-Pound Spool
Compatible Electrode Diameter	1/16 inch ~ 1/8 inch (1.6mm ~ 3.2mm)
Compatible Electrode Type	AWS E6013, E7018, E6011, E6010, E308L etc
Protection Grade	IP21S
Insulation Grade	H
Item Weight	9.7 lbs (approx.)

Feature	Specification
Product Dimensions	14.2 x 5.9 x 7.8 inches

9. WARRANTY AND SUPPORT

HONE offers a one-year warranty and lifetime technical support for every customer. If you have any questions or concerns regarding the use or performance of your HONE FC135 welder, please feel free to contact HONE customer service via email. Our customer service center aims to reply within 24 hours.

For support, please refer to the contact information provided with your product packaging or visit the official HONE website.

ASK A QUESTION ABOUT THIS MANUAL

Ask about setup, troubleshooting, compatibility, parts, safety, or missing instructions. Manuals+ will review the question and use this page’s manual context to help answer it.

Name

Anonymous

Email

you@example.com

After a successful submission, we securely hash the supplied account or form email before sending it to Microsoft Advertising for conversion attribution. [Privacy details](#).

Question

Example: How do I reset this device or fix this error?

Details

Model number, symptoms, what you tried, or the section of the manual you are using.

Submit question