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ANDELI MIG-135 Plus

ANDELI 135Amp MIG Welder & Flux-Cored Wire User Manual

Model: MIG-135 Plus

1. Introduction

Thank you for choosing the ANDELI MIG-135 Plus Welder. This manual provides essential information for the safe and effective operation, setup, and maintenance of your new welding machine. Please read this manual thoroughly before operating the welder to ensure proper use and to prevent injury or damage.



Image: The ANDELI MIG-135 Plus Welder, showcasing its compact design and included flux-cored wire.

2. Safety Instructions

Welding can be dangerous if proper precautions are not taken. Always follow these safety guidelines to prevent electric shock, fire, burns, or other serious injuries.

2.1 General Safety

- Always wear appropriate Personal Protective Equipment (PPE), including a welding helmet with proper shade, flame-resistant clothing, welding gloves, and safety shoes.
- Ensure the work area is well-ventilated to avoid inhaling welding fumes.
- Keep flammable materials away from the welding area.
- Do not weld on containers that have held combustible materials.
- Always disconnect power before performing any maintenance or adjustments.

2.2 Electrical Safety

- Ensure the welder is properly grounded.

- Do not operate the welder in wet conditions or with wet hands.
- Inspect power cords and welding cables for damage before each use. Replace damaged cables immediately.
- Use only properly rated extension cords if necessary.

3. Package Contents

Upon opening your ANDELI MIG-135 Plus Welder package, please verify that all the following items are included:

- ANDELI MIG-135 Plus Welder (1 unit)
- Electrode Holder (10ft) (1 unit)
- Welding Torch (10ft) (1 unit)
- Gasless Wire (1 unit)



Image: The ANDELI MIG-135 Plus Welder displayed with its complete set of accessories, including the electrode holder, welding torch, and a spool of flux-cored wire.

4. Product Features

The ANDELI MIG-135 Plus Welder is designed with advanced features to enhance your welding experience, offering precision, versatility, and durability.

4.1 Precision LED Display

Equipped with an oversized 4.1-inch LED screen, this welder provides crystal-clear visibility of real-time welding data, allowing for precise adjustments without removing your helmet. A transparent protection cover safeguards the display from impacts, sparks, and debris.



Image: A detailed view of the welder's large LED display, highlighting its clear readability and the various parameters shown during operation.

4.2 Smart Synergic Control Technology

This technology simplifies operation by automatically optimizing voltage and wire feed speed when you adjust amperage or wire diameter. This feature is beneficial for both beginners and experienced welders, ensuring

consistent and high-quality welds.

4.3 High-Power Output & Dual-Voltage Versatility

Delivering up to 135A, the welder can handle mild steel plates up to 2/5 inches thick. Its dual-voltage design (110V/220V) allows for flexible use in various environments, from home DIY projects to professional industrial applications.

4.4 Advanced Protection & Stability System

Built-in safeguards include automatic voltage compensation, over-current, overload, overheating, and over-voltage protection. These systems prevent damage from power surges or misuse, ensuring reliable performance and extended machine lifespan.

4.5 Ultra-Compact and Portable Design

The MIG-135 Plus welder features a space-saving and lightweight build (13” x 6” x 8”, weighing just 9 lbs), making it ideal for tight spaces and easy to transport between job sites.



Image: An infographic detailing the four welding modes supported by the ANDELI MIG-135 Plus: Synergic MIG, Manual MIG, MMA (Stick), and Lift TIG welding.



Image: A close-up of the flux-cored welding wire, emphasizing its key performance characteristics such as high feedability and low spatter.

5. Setup

Follow these steps to set up your ANDELI MIG-135 Plus Welder for operation.

5.1 Power Connection

- Ensure the welder's power switch is in the OFF position.
- Connect the power cord to a suitable 110V or 220V power outlet, depending on your project requirements and available power source.

5.2 Wire Installation

- Open the wire feed compartment.
- Place the spool of flux-cored wire onto the spindle, ensuring it rotates freely.

- Thread the wire through the wire feed mechanism and into the welding torch liner.
- Close the compartment securely.

5.3 Connecting Torch and Ground Clamp

- Connect the welding torch cable to the appropriate positive (+) terminal on the front panel.
- Connect the ground clamp cable to the negative (-) terminal on the front panel.
- Attach the ground clamp securely to the workpiece or welding table, ensuring good electrical contact.

6. Operating Instructions

This section details how to operate your welder for various welding tasks.

6.1 Powering On and Mode Selection

- Turn the power switch to the ON position. The LED display will illuminate.
- Use the mode selection button to cycle through the available welding modes: SYN MIG, MAN MIG, MMA, and LIFT TIG. Select the mode appropriate for your welding task.

6.2 Parameter Adjustment

Adjust welding parameters based on your chosen mode and material thickness.

- **Synergic MIG (SYN MIG):** Adjust the amperage or wire diameter, and the welder will automatically set the optimal voltage and wire feed speed. This is recommended for beginners.
- **Manual MIG (MAN MIG):** Manually adjust voltage and wire feed speed independently for precise control. This is recommended for skilled workers.
- **MMA (Stick)** / **LIFT TIG:** Adjust amperage as needed for your electrodes or TIG setup.



Image: An illustration differentiating between the Automatic Mode (synergic, recommended for beginners) and Adjustment Mode (manual, recommended for skilled workers) for parameter control.

6.3 2T/4T Settings

The welder supports 2T (Two-Touch) and 4T (Four-Touch) trigger modes for the welding torch.

- **2T Mode:** Press and hold the torch trigger to dispense wire and weld. Release the trigger to stop. Ideal for short welds.
- **4T Mode:** Press and release the trigger once to start welding (wire dispenses continuously). Press and release again to stop. Ideal for long welds, reducing hand fatigue.



Image: A visual guide explaining the functionality of 2T (Two-Touch) and 4T (Four-Touch) trigger settings for controlling the welding process.



Image: A detailed view of the welder's function settings, including the 4T and 2T trigger modes, and the inductive mode for arc adjustment.

6.4 Welding Process

- Ensure your workpiece is clean and properly grounded.
- Position the welding torch at the correct angle and distance from the workpiece.
- Initiate the arc by pressing the trigger (2T) or pressing and releasing (4T).
- Maintain a steady travel speed and consistent arc length for optimal weld quality.
- After completing the weld, release the trigger (2T) or press and release again (4T).



Image: A welder in action, demonstrating the welding process, with an inset showing examples of desired and undesired weld bead appearances.

7. Maintenance

Regular maintenance ensures the longevity and optimal performance of your welder.

7.1 Cleaning

- Periodically clean the exterior of the welder with a dry, soft cloth.
- Use compressed air to blow out dust and debris from the cooling vents. Ensure the welder is unplugged before cleaning.

7.2 Wire Feed Mechanism

- Inspect the wire feed rollers for wear and tear. Replace if necessary.
- Ensure the wire liner in the torch is free from kinks or blockages.

7.3 Cable Inspection

- Regularly check all welding cables and power cords for cuts, abrasions, or loose connections. Repair or replace any damaged components immediately.

7.4 Storage

- Store the welder in a clean, dry environment, away from excessive dust, moisture, and extreme temperatures.

8. Troubleshooting

This section provides solutions to common issues you might encounter.

Problem	Possible Cause	Solution
Welder does not power on	No power supply; Power switch off; Damaged power cord	Check power outlet and circuit breaker; Turn power switch ON; Inspect and replace power cord if damaged
No arc or weak arc	Poor ground connection; Incorrect settings; Damaged welding cables	Ensure ground clamp has good contact; Adjust amperage/voltage settings; Check and replace cables if damaged
Wire feed issues	Wire tangled; Worn feed rollers; Kinked torch liner; Incorrect tension	Untangle wire; Inspect and replace feed rollers; Straighten or replace liner; Adjust wire tension
Overheat protection activated	Excessive use; Blocked ventilation	Allow welder to cool down; Ensure vents are clear and work area is well-ventilated

9. Specifications

Key technical specifications for the ANDELI MIG-135 Plus Welder:

- **Model:** MIG-135 Plus
- **Output Current:** Up to 135A
- **Input Voltage:** 110V/220V (Dual Voltage)
- **Max Plate Thickness:** Up to 2/5 inches (mild steel)
- **Display:** 4.1-inch Precision LED
- **Dimensions:** Approximately 13” x 6” x 8”
- **Weight:** Approximately 9 lbs
- **Welding Modes:** SYN MIG, MAN MIG, MMA, LIFT TIG

10. Warranty and Support

ANDELI is committed to providing high-quality products. This product comes with a standard manufacturer's warranty. Please refer to the warranty card included in your package for specific terms and conditions, including warranty period and coverage details.
For technical support, troubleshooting assistance, or warranty claims, please contact ANDELI customer service through the official channels provided at the time of purchase or on the ANDELI brand website. Please have your product model and purchase information ready when contacting support.

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