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## ANDELI MIG-135 Plus

# ANDELI MIG-135 Plus 135Amp MIG Welder Instruction Manual

Model: MIG-135 Plus

## 1. INTRODUCTION

This manual provides essential information for the safe and effective operation of your ANDELI MIG-135 Plus 135Amp MIG Welder. Please read this manual thoroughly before operating the equipment and retain it for future reference. Proper understanding and adherence to these instructions will ensure optimal performance and longevity of your welding machine.

## 2. SAFETY INFORMATION

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

### 2.1 General Safety Precautions

- **Wear appropriate personal protective equipment (PPE):** This includes a welding helmet with proper shade, flame-resistant clothing, welding gloves, and safety shoes.
- **Ensure adequate ventilation:** Welding fumes can be hazardous. Work in a well-ventilated area or use fume extraction equipment.
- **Prevent electric shock:** Ensure the welder is properly grounded. Do not operate in wet conditions. Inspect cables for damage before each use.
- **Fire prevention:** Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Eye and skin protection:** Welding arcs emit intense UV and IR radiation that can cause severe burns to eyes and skin.
- **Work area:** Keep the work area clean and free of clutter. Ensure stable footing.

### 2.2 Electrical Safety

- Always disconnect power before performing any maintenance or changing accessories.
- Do not use damaged cables or equipment.
- Ensure the power supply matches the welder's requirements (110V/220V).

## 3. PACKAGE CONTENTS

Upon unpacking, verify that all items listed below are present and undamaged:

- ANDELI MIG-135 Plus Welder (1 unit)
- Electrode Holder (10ft) (1 unit)
- Welding Torch (10ft) (1 unit)
- Gasless Wire (1 spool)
- User Manual (This document)



Figure 1: ANDELI MIG-135 Plus Welder with included flux-cored wire.



Figure 2: The ANDELI MIG-135 Plus Welder and its primary accessories, including the welding torch, electrode holder, and flux-cored wire.

## 4. SETUP

### 4.1 Connecting Components

- MIG Torch Connection:** Connect the MIG torch cable to the dedicated MIG port on the front panel of the welder. Ensure a secure connection.
- Electrode Holder Connection (for MMA/Stick Welding):** Connect the electrode holder cable to the appropriate terminal on the front panel.
- Ground Clamp Connection:** Connect the ground clamp cable to the designated terminal on the front panel. Secure the ground clamp firmly to the workpiece or a clean metal surface near the welding area to ensure a good electrical connection.

### 4.2 Wire Installation (Flux-Cored Wire)

- Open the wire feed compartment cover on the welder.
- Mount the flux-cored wire spool onto the spool holder. Ensure the wire unwinds smoothly from the bottom of the spool.
- Thread the wire through the wire feed mechanism, ensuring it passes through the correct groove on the feed roller for the wire diameter being used.

4. Close the wire feed mechanism and adjust the wire tension. The tension should be sufficient to feed the wire without slipping, but not so tight as to deform the wire.
5. Feed the wire through the MIG torch liner until it emerges from the contact tip. This may require pressing the wire feed button or holding the torch trigger (refer to Operating section).



Figure 3: Internal view of the welder, illustrating the wire feed mechanism and spool holder for flux-cored wire installation.

#### 4.3 Power Connection

The ANDELI MIG-135 Plus supports dual voltage (110V/220V). Connect the power cable to an appropriate power outlet. The welder automatically detects the input voltage.

### 5. OPERATING INSTRUCTIONS

#### 5.1 Powering On/Off

- To power on, flip the main power switch located on the rear panel to the "ON" position. The LED display will illuminate.

- To power off, flip the main power switch to the "OFF" position. The machine may continue to run its cooling fan for a short period to dissipate residual heat.

## 5.2 Control Panel Overview

The 4.1-inch LED display provides real-time welding parameters. The control panel features intuitive knobs and buttons for mode selection and parameter adjustment.

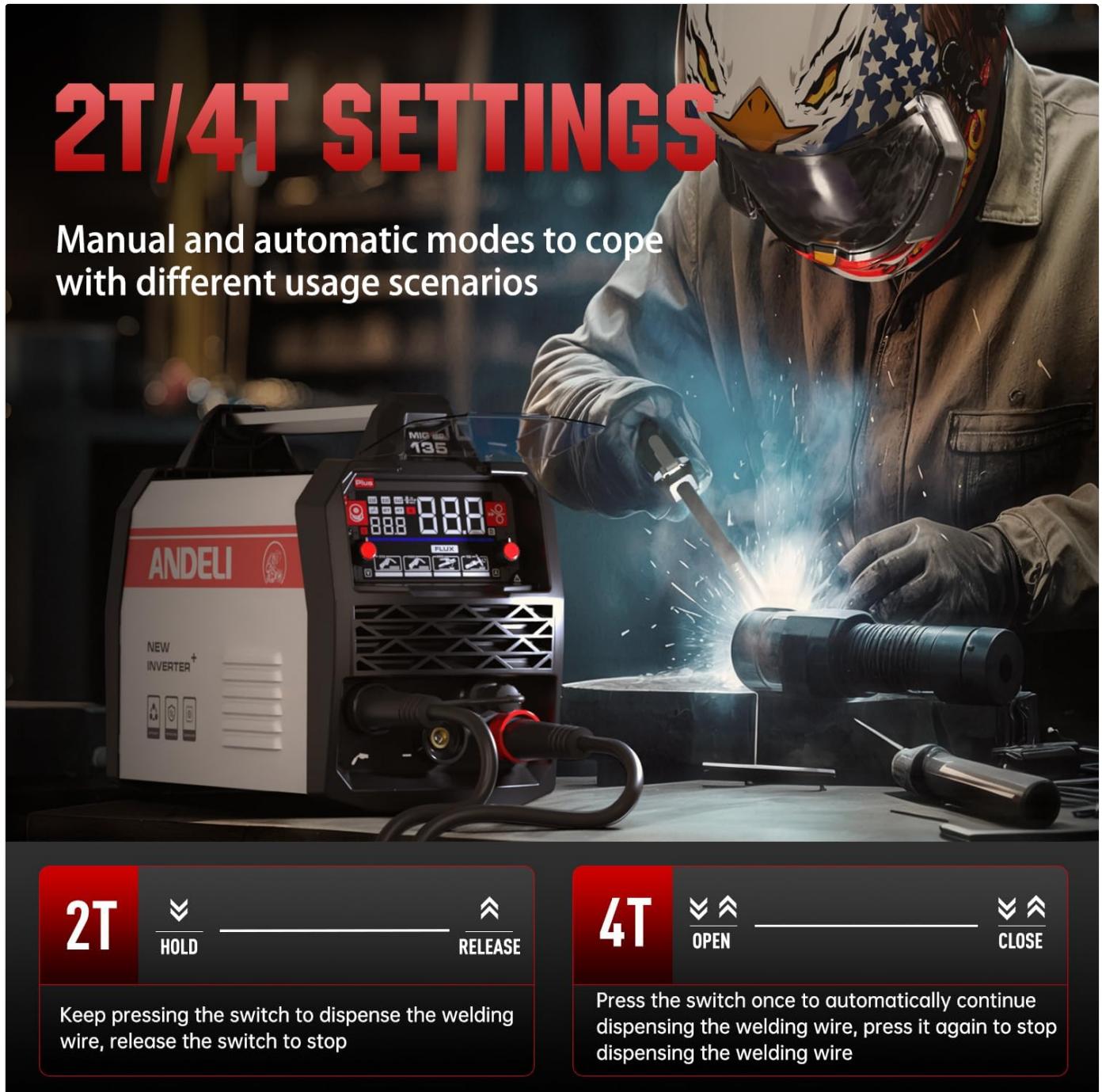


Figure 4: Detailed view of the ANDELI MIG-135 Plus control panel, highlighting the large LED display and control knobs.

## 5.3 Welding Mode Selection

The MIG-135 Plus supports multiple welding processes:

- **SYN MIG Welding:** Synergic MIG mode for automatic optimization of voltage and wire feed speed.
- **MAN MIG Welding:** Manual MIG mode for independent adjustment of voltage and wire feed speed.
- **MMA Welding (Stick Welding):** For welding with coated electrodes.
- **Lift TIG Welding:** For TIG welding (TIG torch not included).

Use the mode selection button on the control panel to cycle through the available welding processes.



Figure 5: The welder's display indicating the selection of various welding modes, including SYN MIG, MAN MIG, MMA, and Lift TIG.

#### 5.4 Parameter Adjustment (Synergic Control)

In Synergic mode, adjusting the amperage or selecting the wire diameter will automatically optimize the voltage and wire feed speed for optimal welding results. For manual control, adjust voltage and current independently using the dedicated knobs.

# TWO CONTROL MODES

Automatic adjustment and precise control modes for different usage scenarios

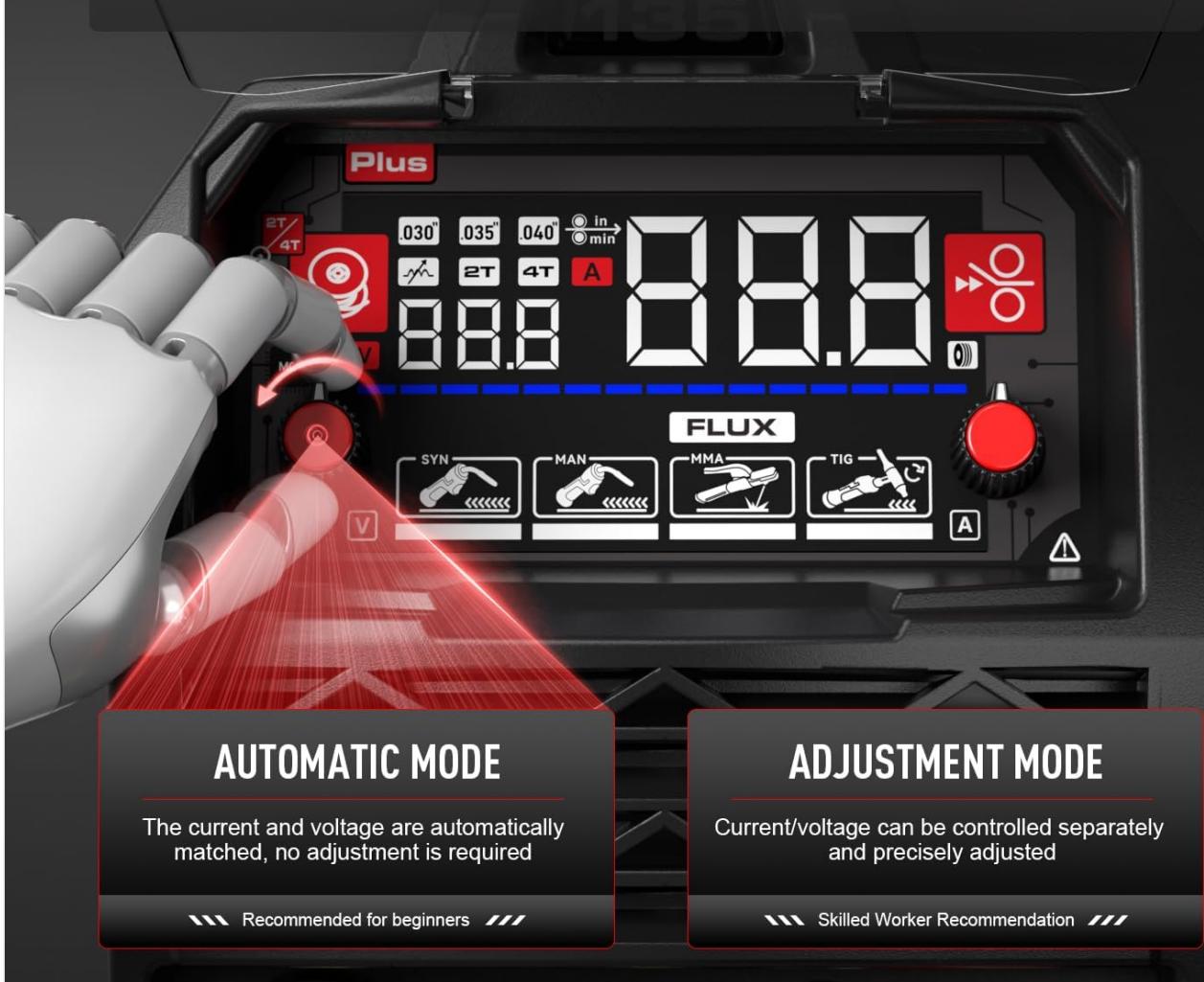


Figure 6: The control panel illustrating the automatic and adjustment modes for welding parameters.

## 5.5 2T/4T Settings

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

- **2T Mode:** Press and hold the torch trigger to start welding; release to stop.
- **4T Mode:** Press and release the torch trigger to start welding; press and release again to stop. This mode is useful for longer welds to reduce hand fatigue.

# LARGER LED DISPLAY

DELIVERING REAL-TIME DATA WITH CRYSTAL-CLEAR VISIBILITY



Figure 7: Visual explanation of 2T and 4T trigger settings for the welding torch.

## 5.6 Inductive Mode

The inductive mode allows for adjustment of arc softness and hardness, providing greater control over the weld bead appearance and penetration.



ANDELI

HIGH FEEDABILITY

LOW SPATTER

FULL COVERAGE

STABILIZING THE ARC



Figure 8: The function settings on the control panel, detailing the 2T/4T modes and the inductive mode.

## 6. SPECIFICATIONS

Feature	Specification
Model	MIG-135 Plus
Output Current	Up to 135A
Input Voltage	110V/220V (Dual Voltage)
Welding Modes	SYN MIG, MAN MIG, MMA, Lift TIG
Max Mild Steel Thickness	2/5 inches
Display	4.1-inch Precision LED Display

Feature	Specification
Dimensions (L x W x H)	13" x 6" x 8"
Weight	9 lbs
Protection Features	Automatic voltage compensation, over-current, overload, overheating, over-voltage protection

## 7. MEDIA RESOURCES

### 7.1 Official Product Videos

#### ANDELI MIG-205PRO MAX Accessory Kit User Guide

Your browser does not support the video tag.

This video provides a detailed user guide for the accessory kit of the ANDELI MIG-205PRO MAX, demonstrating installation and setup procedures for various welding modes. While the model number differs slightly, the accessory kit and setup principles are highly relevant to the MIG-135 Plus.

## 8. MAINTENANCE

- Regular Cleaning:** Keep the welder clean and free from dust, dirt, and metal particles. Use compressed air to clean the cooling vents periodically.
- Cable Inspection:** Regularly inspect all welding cables, connections, and the torch for wear, cuts, or damage. Replace any damaged components immediately.
- Contact Tip and Nozzle:** For MIG welding, regularly check and clean the contact tip and nozzle. Replace worn contact tips to ensure consistent wire feeding and arc stability.
- Wire Feed Mechanism:** Keep the wire feed rollers clean. Ensure the correct roller groove is used for the wire diameter and that tension is properly set.

## 9. TROUBLESHOOTING

This section addresses common issues that may arise during operation. For problems not listed here, contact customer support.

Problem	Possible Cause	Solution
No power to welder	Power switch off, loose power cable, tripped circuit breaker	Turn on power switch, check cable connections, reset circuit breaker
No arc/poor arc starting	Poor ground connection, incorrect settings, worn contact tip, wire feed issue	Ensure good ground, verify settings, replace contact tip, check wire feed path
Wire not feeding	Wire tangled, feed roller tension incorrect, clogged liner, wrong contact tip size	Untangle wire, adjust tension, clean liner, use correct contact tip
Excessive spatter	Incorrect voltage/wire feed speed, improper stick-out, dirty workpiece	Adjust settings (use synergic mode), maintain proper stick-out, clean workpiece

## 10. WARRANTY AND SUPPORT

For warranty information, technical support, or service inquiries, please refer to the contact details provided on the product

packaging or the official ANDELI website. Keep your purchase receipt as proof of purchase for warranty claims.