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DEKO DKEMMAX140C2

DEKO 140A 220V MMA ARC Inverter Welder Instruction Manual

Model: DKEMMAX140C2

1. INTRODUCTION

Thank you for choosing the DEKO 140A 220V MMA ARC Inverter Welder. This manual provides essential information for the safe and efficient operation, setup, maintenance, and troubleshooting of your welding machine. Please read this manual thoroughly before use and retain it for future reference.

The DEKO 140A welder is a compact and portable unit designed for various welding tasks, including home repairs, metal crafts, and general maintenance. It incorporates advanced IGBT inverter technology for stable arc performance and features built-in safety mechanisms.



Figure 1: DEKO 140A MMA ARC Inverter Welder with electrode holder, earth clamp, and power cable.

2. SAFETY INFORMATION

Welding operations involve significant risks. Always prioritize safety to prevent injury or damage. Adhere to all local safety regulations and guidelines.

2.1 General Safety Precautions

- **Personal Protective Equipment (PPE):** Always wear a welding helmet with appropriate shade, flame-resistant clothing, welding gloves, and safety shoes. Protect bystanders with welding screens.
- **Ventilation:** Ensure adequate ventilation to remove welding fumes and gases, which can be hazardous to health. Work in a well-ventilated area or use fume extractors.
- **Electrical Safety:** Ensure the welding machine is properly grounded. Do not operate in wet conditions. Inspect cables for damage before each use. Never touch live electrical parts.
- **Fire Hazards:** Keep flammable materials away from the welding area. Have a fire extinguisher readily available. Welding sparks can travel considerable distances.

- **Arc Rays:** The welding arc produces intense visible and invisible (UV and IR) rays that can burn eyes and skin. Never look at the arc without proper eye protection.
- **Work Area:** Keep the work area clean and free of clutter. Ensure stable footing.

2.2 Product Specific Safety Features

The DEKO 140A Inverter Welder is equipped with multiple protection systems to enhance user safety and product longevity:

- **Over-Heating Protection:** Automatically shuts down the machine if internal temperature exceeds safe limits.
- **Over-Voltage Protection:** Safeguards the machine from damage due to excessive input voltage.
- **Over-Current Protection:** Prevents damage from excessive current draw.
- **Over-Load Protection:** Protects the internal components from sustained high loads.



Figure 2: Integrated safety features of the DEKO 140A welder.

3. PRODUCT OVERVIEW

3.1 Components Included

Upon unpacking, ensure all the following components are present:

- DEKO 140A MMA Welder Unit
- 1.5 M Cable with 200A Electrode Holder Clamp
- 1.5 M Cable with 200A Earth Clamp
- 1.5 M Power Cable
- Instruction Manual
- Wire Brush

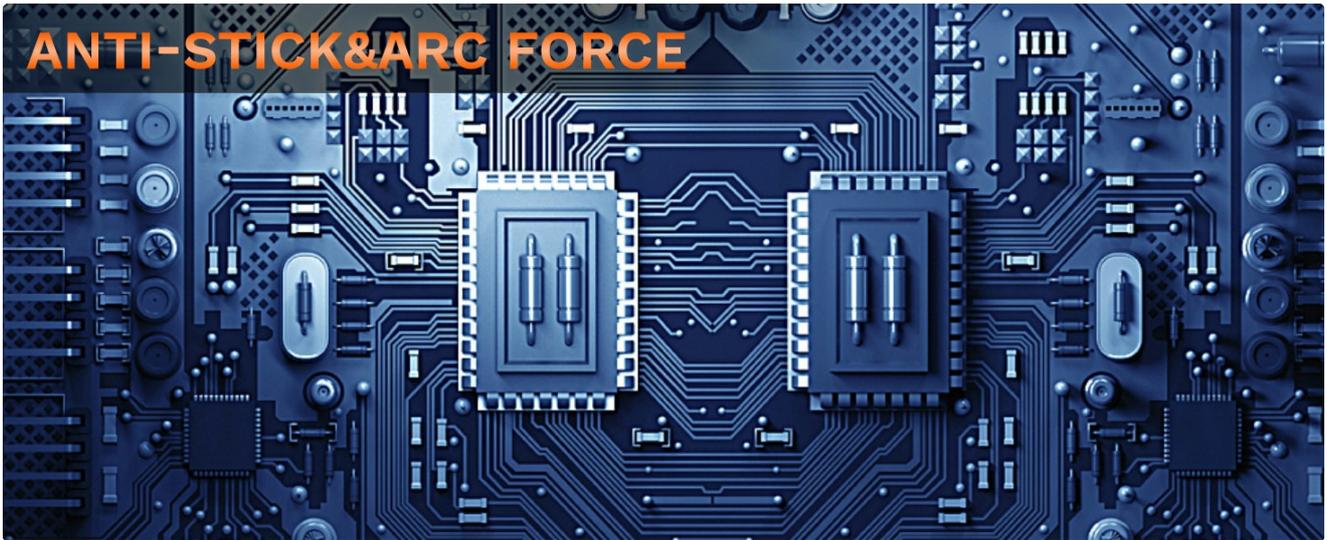


Figure 3: Contents of the DEKO 140A Welder package.

3.2 Control Panel and Connections

Familiarize yourself with the welder's front and back panels for proper operation and connection.



Figure 4: Front and Back Panel overview of the DEKO 140A Welder.

- **Power Indicator Light:** Illuminates when the machine is powered on.
- **Overheat Indicator Lights:** Illuminates if the machine overheats, indicating a temporary shutdown for cooling.
- **Current Display:** Digital LED display showing the set welding current.
- **Welding Current Adjustment Knob:** Used to adjust the welding current (Amperes).

- **Positive Output Terminal (+):** Connects to the electrode holder cable.
- **Negative Output Terminal (-):** Connects to the earth clamp cable.
- **Power Control Switch:** Turns the welder ON/OFF.
- **Power Cord:** Connects the welder to the main power supply.

4. SETUP

4.1 Unpacking and Inspection

Carefully remove the welder and all accessories from the packaging. Inspect all components for any signs of damage. If any damage is found, do not operate the machine and contact customer support.

4.2 Connecting Welding Cables

Ensure the welder is turned OFF and unplugged from the power source before connecting or disconnecting any cables.

1. **Connect the Electrode Holder:** Insert the connector of the electrode holder cable into the **Positive Output Terminal (+)** on the front panel. Twist clockwise to secure.
2. **Connect the Earth Clamp:** Insert the connector of the earth clamp cable into the **Negative Output Terminal (-)** on the front panel. Twist clockwise to secure.
3. **Connect to Power:** Plug the power cord into a suitable 220V AC power outlet. Ensure the outlet is properly grounded and can handle the welder's power requirements.

5. OPERATING INSTRUCTIONS

Before operating, ensure you have read and understood all safety information in Section 2.

5.1 Powering On

Flip the Power Control Switch on the back panel to the 'ON' position. The Power Indicator Light on the front panel will illuminate, and the digital display will show the current setting.

5.2 Adjusting Welding Current

Use the Welding Current Adjustment Knob on the front panel to set the desired welding current (Amperes). The digital LED display will show the selected value. The appropriate current depends on the electrode diameter and the material thickness being welded.

WIDE APPLICATION



Figure 5: Digital display and current adjustment knob.

5.3 Welding Features

The DEKO 140A welder incorporates features to enhance welding performance:

- **Hot Start:** Provides an automatic boost of current at the start of welding to ensure easier arc ignition and prevent the electrode from sticking.
- **Anti-Stick:** Reduces the welding current if the electrode sticks to the workpiece, allowing for easier removal and preventing damage to the electrode or machine.
- **Arc Force:** Automatically increases the current when the arc length becomes too short, maintaining a stable arc and preventing sticking.

140A MMA WELDING MACHINE TECHNICAL DATA

Input Voltage (V) :	AC 1~220
Input Power (KW) :	5
Efficiency (%) :	85
Power Factor :	0.85
No-Load Voltage (V) :	60
Current Range (A) :	10-140
Duty Cycle (%) :	20
Insulation Degree :	F
Protection Degree :	IP 21S



Figure 6: Illustration of the Hot Start feature in action.

5.4 Applicable Materials

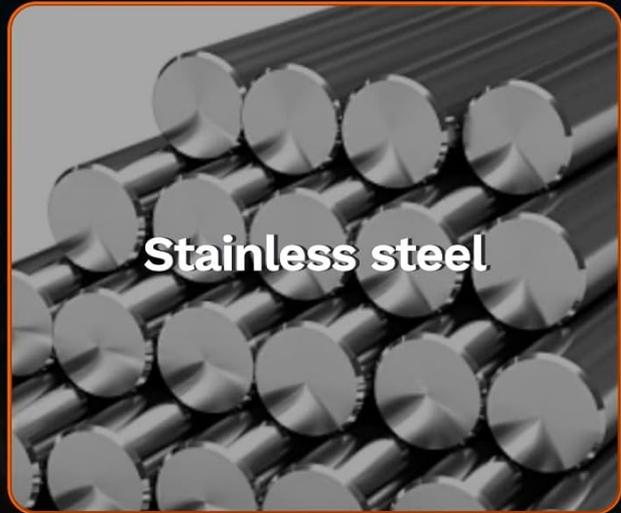
This MMA ARC Inverter Welder is suitable for welding various metal materials, including:

- Iron and Iron Alloys
- Stainless Steel
- Low Carbon Steel
- Medium Carbon Steel

APPLICABLE WELDING MATERIALS



Iron and iron alloys



Stainless steel



Low carbon steel



Medium carbon steel

Figure 7: Examples of applicable welding materials.

6. MAINTENANCE

Regular maintenance ensures the longevity and optimal performance of your welding machine. Always disconnect the welder from the power supply before performing any maintenance.

- **Cleaning:** Periodically clean the exterior of the machine with a dry, soft cloth. Use compressed air to blow out dust from the ventilation openings. Do not use solvents or abrasive cleaners.
- **Cable Inspection:** Regularly inspect all welding cables, electrode holder, and earth clamp for cuts, cracks, or loose connections. Replace damaged components immediately.
- **Storage:** Store the welder in a clean, dry, and dust-free environment when not in use. Protect it from moisture and extreme temperatures.
- **Fan Operation:** Ensure the cooling fan operates freely and is not obstructed.

7. TROUBLESHOOTING

This section addresses common issues you might encounter. For problems not listed here, contact customer support.

Problem	Possible Cause	Solution
Welder does not power on.	No power supply; Power switch off; Faulty power cord.	Check power outlet and circuit breaker; Ensure power switch is ON; Inspect power cord for damage.
No arc or weak arc.	Improper current setting; Poor earth clamp connection; Damp electrode; Faulty electrode holder.	Adjust current; Ensure good contact for earth clamp; Use dry electrodes; Check electrode holder connection.
Overheat indicator light is on.	Machine has exceeded duty cycle; Insufficient ventilation; Obstructed fan.	Allow machine to cool down; Ensure adequate ventilation; Clear any obstructions from the fan.
Electrode sticks frequently.	Low current setting; Incorrect electrode angle; Arc length too short.	Increase welding current; Adjust electrode angle; Maintain proper arc length.

8. TECHNICAL SPECIFICATIONS

The following table outlines the technical specifications for the DEKO 140A MMA ARC Inverter Welder (Model: DKEMMAX140C2).

Feature	Specification
Manufacturer	DEKO
Manufacturer Product ID	DKEMMAX140C2
Product Dimensions	10.5 x 22.5 x 17.5 cm
Product Weight	3.03 kg
Model Number	DKEMMAX140C2
Size	Advanced-140A
Power Source	Corded Electric
Voltage	220 Volts
Input Voltage (V)	AC 1~220
Input Power (KW)	5
Efficiency (%)	85
Power Factor	0.85
No-Load Voltage (V)	60
Current Range (A)	10-140

Feature	Specification
Duty Cycle (%)	20
Insulation Degree	F
Protection Degree	IP 21S



Figure 8: Technical data for the DEKO 140A MMA Welder.

9. WARRANTY AND SUPPORT

DEKO products are manufactured to high-quality standards. For specific warranty terms and conditions, please refer to the warranty card included with your product or contact the seller directly. Keep your purchase receipt as proof of purchase.

9.1 Customer Support

If you encounter any issues or have questions regarding the operation, maintenance, or troubleshooting of your DEKO 140A MMA ARC Inverter Welder, please contact the seller (DEKO-EU) or the manufacturer's customer service department. Provide your model number (DKEMMAX140C2) and a detailed description of the issue for efficient assistance.