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ANDELI MIG-135 PLUS AE

ANDELI MIG-135 PLUS AE 135Amp Multiprocess Welder Instruction Manual

Model: MIG-135 PLUS AE | Brand: ANDELI

1. Introduction

The ANDELI MIG-135 PLUS AE is a versatile 3-in-1 multiprocess welding machine designed for various welding needs. It supports Flux-Cored MIG, Lift TIG, and Stick (MMA) welding, offering flexibility for both home DIY projects and demanding workshop conditions. Featuring dual 110V/220V voltage capability, it adapts to different power sources, providing robust output for welding mild steel up to 5.0 mm (0.19").

This portable welder incorporates IGBT technology and an integrated wire feed system for automatic parameter adjustments, making it user-friendly for beginners while offering precise control for experienced welders. The large 4.1-inch LED display provides real-time data with clear visibility, protected by a transparent cover for durability.



Figure 1: ANDELI MIG-135 PLUS AE Welder with included accessories.

2. Safety Information

Always prioritize safety when operating welding equipment. Failure to follow safety precautions can result in serious injury or death. Ensure you read and understand all safety warnings and instructions before use.

- **Electric Shock:** Welding current can kill. Do not touch live electrical parts. Wear dry welding gloves and protective clothing.
- **Fumes and Gases:** Welding fumes and gases can be hazardous to your health. Work in a well-ventilated area.
- **Arc Rays:** Arc rays can injure eyes and burn skin. Wear a welding helmet with appropriate shade and protective clothing.
- **Fire and Explosion:** Welding sparks and hot metal can cause fire or explosion. Keep flammable materials away from the work area.
- **Burns:** Hot metal and electrodes can cause burns. Wear protective gloves and clothing.
- **Overcurrent/Overheat/Overvoltage Protection:** The machine is equipped with safety features to prevent damage. If protection activates, allow the machine to cool down.



Figure 2: Safety features of the ANDELI MIG-135 PLUS AE Welder.

3. Package Contents

The ANDELI MIG-135 PLUS AE welder comes with a comprehensive set of accessories to get you started:

- ANDELI MIG-135 Plus Welder (x1)
- Gasless Wire (x1)
- Welding Hood (x1)
- Auto Darkening Welding Glasses (x1)
- Welding Gloves (x1)
- Electrode Holder (x1)
- Welding Torch (x1)



Figure 3: All components included with the ANDELI MIG-135 PLUS AE Welder.

4. Setup

4.1 Power Connection

The MIG-135 PLUS AE supports dual voltage input (110V/220V AC/DC). Connect the appropriate power cable to the welder and plug it into a suitable power outlet. The welder automatically detects the voltage.

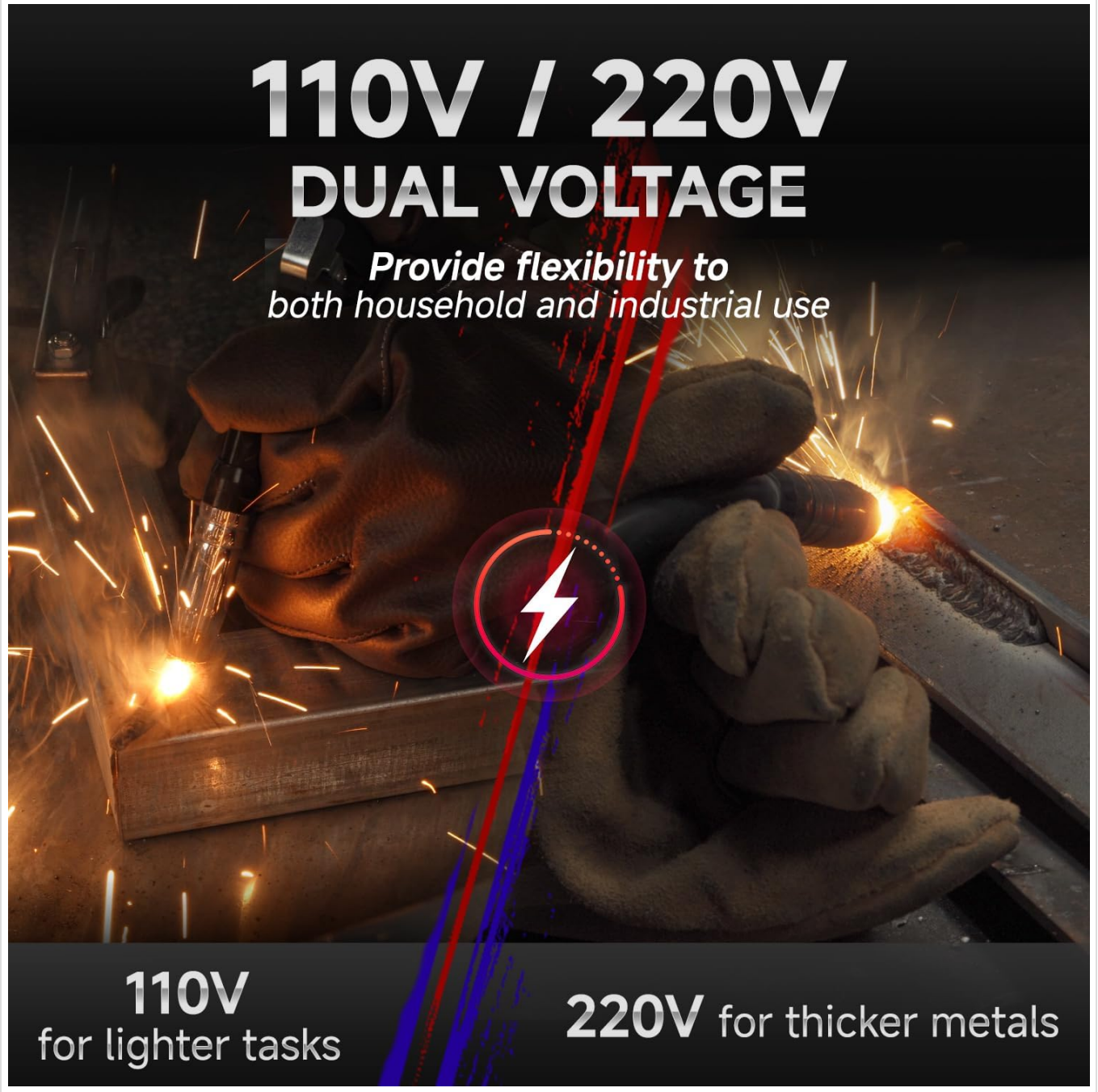


Figure 4: Dual voltage capability for 110V and 220V power sources.

4.2 Wire Installation (Flux-Cored)

1. Open the wire feeder compartment on the side of the welder.
2. Mount the gasless flux-cored wire spool onto the spindle. Ensure the wire unwinds smoothly.
3. Thread the wire through the feed mechanism, ensuring it passes through the correct groove on the drive roller for the wire diameter being used.
4. Close the wire feeder compartment.
5. Press and hold the wire feed button on the control panel to feed the wire through the MIG torch until it exits the nozzle.

4.3 Connecting Accessories

Connect the ground clamp to the appropriate terminal (usually negative for flux-cored MIG). Connect the MIG torch or electrode holder to their respective terminals based on the welding mode you intend to use.

▶ **Watch video online**
ANDELI MIG-135 PLUS AE Accessory Kit User Guide

Video 1: Detailed guide on installing accessories and setting up the ANDELI MIG-135 PLUS AE Welder.

5. Operating Modes

The MIG-135 PLUS AE offers three primary welding processes:



Figure 5: Overview of the welder's multiprocess capabilities.

5.1 Flux-Cored MIG Welding (Gasless/SYN)

This mode is ideal for welding carbon steel, stainless steel, or thicker materials without the need for shielding gas. The welder features a synergistic control system that automatically adjusts voltage and wire speed based on your current settings. Manual adjustment is also available for fine-tuning.

- **2T Setting:** Simple and precise. Hold the torch trigger to feed wire and weld; release to stop.
- **4T Setting:** Perfect for long welds without hand fatigue. Press the torch trigger once to start automatic wire feeding and welding; press again to stop.

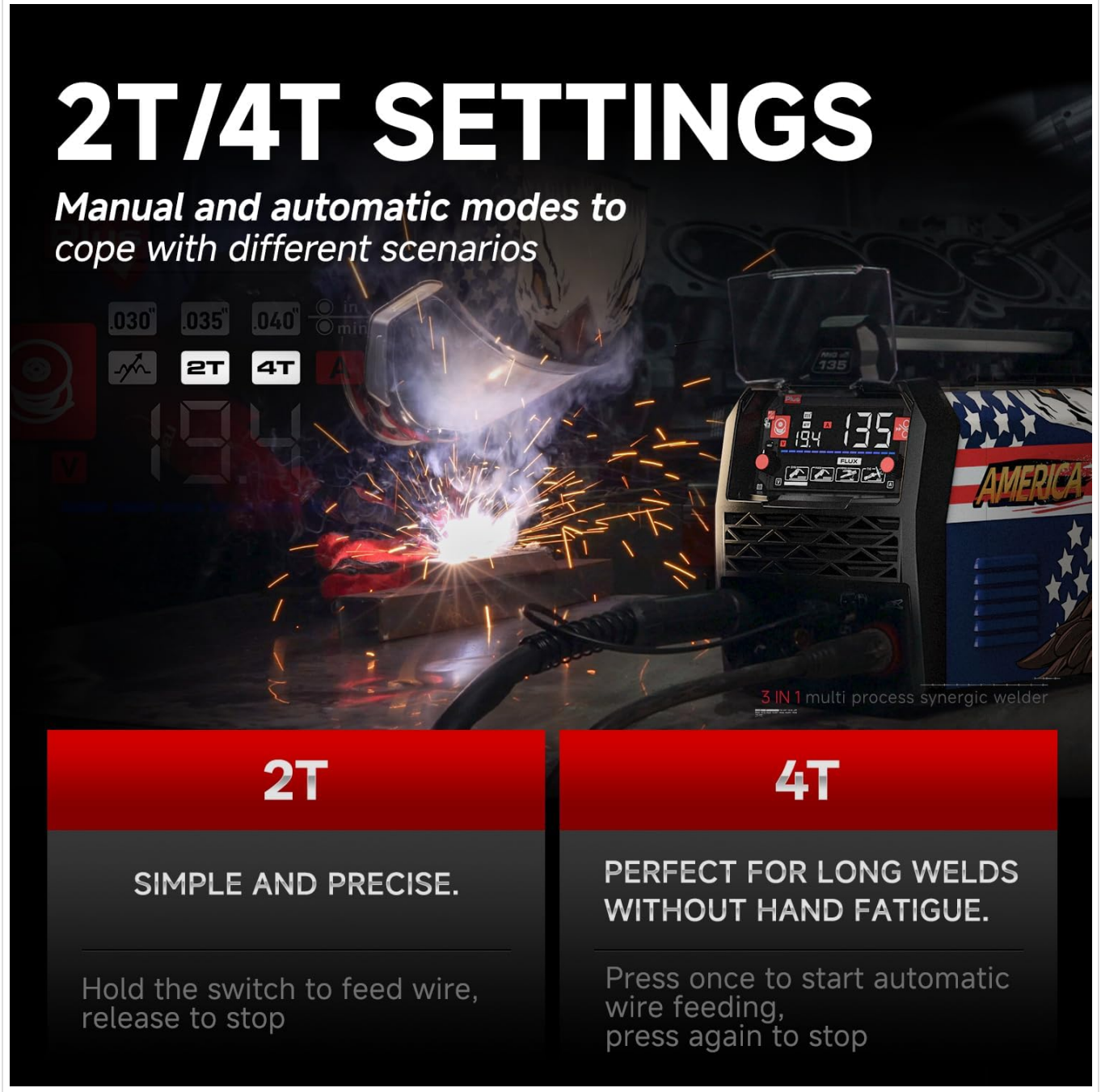


Figure 6: Explanation of 2T and 4T trigger settings.

5.2 Lift TIG Welding

Lift TIG welding provides a stable arc and precise control, suitable for stainless steel and other non-ferrous metals. A Lift TIG torch is sold separately and is required for this mode of operation. Connect the TIG torch to the negative terminal and the ground clamp to the positive terminal.

5.3 Stick (MMA) Welding

MMA welding is suitable for various types of electrodes and provides a strong, deep penetrating weld. Adjustable Hot Start and Arc Force functions ensure a superior experience. Connect the electrode holder to the positive terminal and the ground clamp to the negative terminal.

6. Control Panel Overview

The welder features a large 4.1-inch LED display for clear visibility and easy adjustment of welding parameters. A transparent protection cover safeguards the display from impacts and sparks.

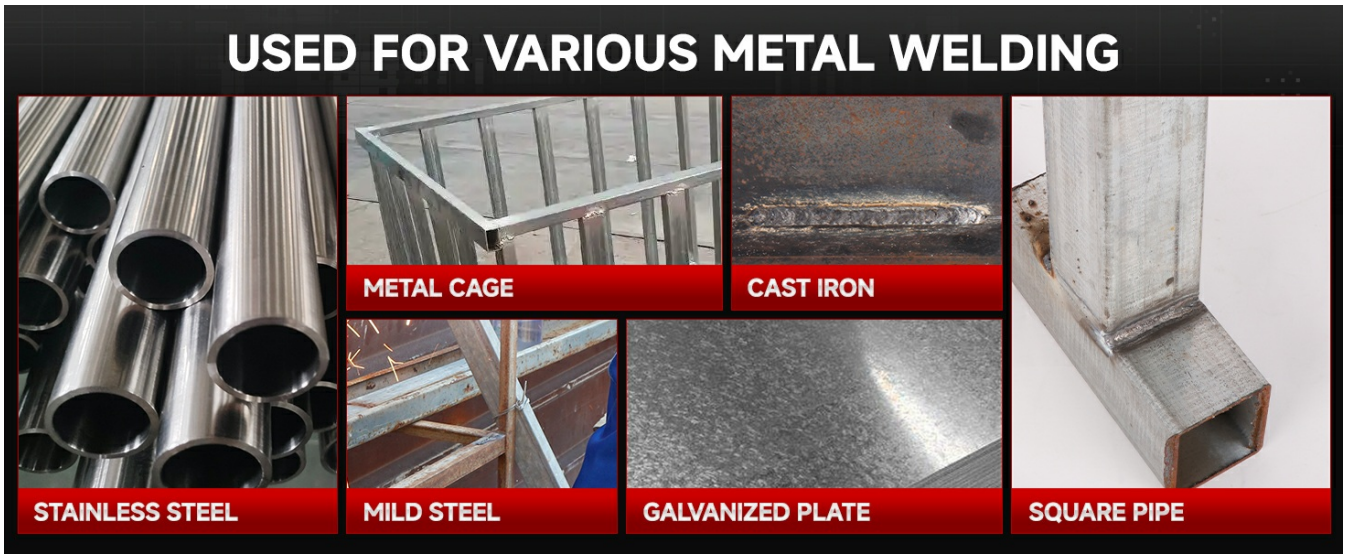


Figure 7: Control Panel Introduction.

1. **2T/4T/Wire Diameter Selection Button:** Used to select trigger mode and wire diameter.
2. **Parameters Display:** Shows selected welding parameters.
3. **Real-Time Voltage:** Displays current welding voltage.
4. **Real-Time Current:** Displays current welding amperage.
5. **Wire Test:** Button to manually feed wire.
6. **Voltage Knob/Inductance Knob:** Adjusts voltage or inductance.
7. **Weld Modes:** Indicators for SYN MIG, MAN MIG, MMA, and Lift TIG.
8. **Current Knob/Weld Mode Button:** Adjusts current or selects welding mode.



Figure 8: Large LED display for clear parameter visibility.

7. Welding Parameters (Flux-Cored)

The following table provides recommended settings for flux-cored welding. These values serve as general guidelines; actual welding performance may vary depending on material, environmental factors, and specific project requirements.

Flux-Cored Welding Recommended Parameter Settings

Plate Thickness	Voltage	Current	Wire Feeding Speed		
			0.030"/0.8mm	**0.035"/0.9mm**	**0.040"/1.0mm**
0.047" (1.2mm)	15V	20A	48" (1.22m)	38" (0.97m)	31" (0.79m)
0.059" (1.5mm)	15.3V	30A	73" (1.85m)	59" (1.50m)	48" (1.22m)
0.071" (1.8mm)	15.7V	40A	99" (2.51m)	79" (2.01m)	64" (1.63m)

Plate Thickness	Voltage	Current	Wire Feeding Speed		
			0.030"/0.8mm	0.035"/0.9mm	0.040"/1.0mm
0.083" (2.1mm)	16.2V	50A	124" (3.15m)	100" (2.54m)	81" (2.06m)
0.094" (2.4mm)	16.6V	60A	150" (3.81m)	121" (3.07m)	98" (2.49m)
0.11" (2.7mm)	17.1V	70A	175" (4.45m)	141" (3.58m)	114" (2.90m)
0.12" (3.0mm)	17.6V	80A	201" (5.11m)	162" (4.11m)	131" (3.33m)
0.14" (3.6mm)	18V	90A	226" (5.74m)	182" (4.62m)	148" (3.76m)
0.15" (3.8mm)	18.4V	100A	249" (6.32m)	200" (5.08m)	162" (4.11m)
0.16" (4.0mm)	18.8V	110A	274" (6.96m)	221" (5.61m)	179" (4.55m)
0.17" (4.2mm)	19.3V	120A	300" (7.62m)	242" (6.15m)	196" (4.98m)
0.18" (4.5mm)	19.7V	130A	325" (8.26m)	262" (6.65m)	212" (5.38m)
0.19" (5.0mm)	20V	135A	340" (8.64m)	274" (6.96m)	222" (5.64m)

Table 1: Flux-Cored Welding Recommended Parameter Settings.

8. Maintenance

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

- **Cleaning:** Regularly clean the welding machine, especially the fan and ventilation openings, to prevent dust and debris buildup.
- **Cable Inspection:** Periodically inspect all cables, torches, and clamps for damage, wear, or loose connections. Replace any damaged components immediately.
- **Wire Feeder:** Keep the wire feeder mechanism clean and free from rust or debris. Check the drive rollers for wear and ensure they are correctly aligned for the wire diameter.

9. Troubleshooting

If you encounter issues with your welder, refer to the following basic troubleshooting steps. For complex problems, contact customer support.

- **No Power:** Check power cable connection, power switch, and circuit breaker.
- **No Arc:** Ensure ground clamp is securely attached to the workpiece. Check torch connections and contact tip for blockages.
- **Poor Weld Quality:** Adjust welding parameters (voltage, wire speed, current) according to the material and thickness. Ensure the workpiece is clean and free of rust or paint.

10. Specifications

Below are the technical specifications for the ANDELI MIG-135 PLUS AE Welder:

Feature	Specification

Feature	Specification
Manufacturer	ANDELI
Item Weight	18.46 pounds
Package Dimensions	15.3 x 12.1 x 11.8 inches
Item Model Number	MIG-135 PLUS AE
Power Source	AC/DC
Input Voltage	110V/220V Dual Voltage
Welding Processes	Flux Core MIG, Lift TIG, Stick (MMA)
Max Current (110V)	135A (20% Duty Cycle)
Max Current (220V)	135A (60% Duty Cycle)
Protection Grade	IP21S
Insulation Grade	F
Cooling	Air-cool



Figure 9: Product Parameters for MIG-135 PLUS AE.

11. Warranty & Support

For warranty information, technical support, or service inquiries, please contact ANDELI customer service through the official channels provided at the time of purchase. Keep your purchase receipt as proof of warranty.

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