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haxiaoer 200A Aluminum MIG Welder

haxiaoer 200A 6-in-1 Multiprocess MIG Welder Instruction Manual

Model: 200A Aluminum MIG Welder

Brand: haxiaoer

1. Safety Instructions

Always prioritize safety when operating welding equipment. Failure to follow safety precautions can result in serious injury or death.

- **Personal Protective Equipment (PPE):** Always wear a welding helmet with appropriate shade, flame-resistant clothing, welding gloves, and safety shoes.
- **Ventilation:** Ensure adequate ventilation to remove welding fumes. Work in a well-ventilated area or use fume extraction equipment.
- **Fire Prevention:** Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Electrical Safety:** Ensure the welding machine is properly grounded. Do not operate in wet conditions. Inspect cables for damage before each use.
- **Eye and Skin Protection:** Welding arcs emit intense UV and IR radiation that can cause severe burns to eyes and skin.
- **Gas Cylinders:** Handle gas cylinders with care. Secure them to prevent tipping.



Image: The haxiaoer MIG Welder features advanced digital control and safety mechanisms, including MCU Technology Control, IGBT Inverters, Smart Fan, Overcurrent Protection, Overvoltage Protection, Overheat Protection, and Overload Protection. These features are designed to enhance user safety and equipment longevity.

2. Product Overview

The haxiaoer 200A Multiprocess MIG Welder is a versatile 6-in-1 welding machine designed for various metalworking applications. It supports multiple welding processes and offers dual voltage operation for flexibility.



Image: The haxiaoer 6-in-1 Multiprocess MIG Welder, illustrating its capabilities for Gas MIG, Gasless MIG (Flux Core), MMA (Stick), Spot Welding, Single Pulse MIG, and Lift TIG welding. The machine is yellow with a digital control panel.

Key Features:

- **6-in-1 Multiprocess Welding:** Supports Flux Core MIG, Gas MIG, Single Pulse MIG, Lift TIG, Stick welding, and 2T 4T Spot welding.
- **Dual Voltage Operation:** Compatible with both 110V and 220V power sources.
- **200A Output:** Delivers up to 200 amperes for various metal thicknesses.
- **Aluminum Welding Capable:** Designed for welding aluminum and other metals.
- **Advanced Synergy Technology:** Automatically adjusts welding parameters for optimal performance.
- **Professional Grade Construction:** Durable aluminum components for reliability.

3. Package Contents

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



Image: A visual representation of the haxiaoer MIG Welder and its accompanying accessories. The main welder unit is shown with various components laid out around it, each numbered for identification.

1. 1x MIG200 Welder
2. 4x Wire Feed Roller
3. 4x Conductive Nozzle
4. 1x Ground Clamp
5. 1x Welding Torch Clamp
6. 1x Brush
7. 1x Gas Tube
8. 1x MB15 Gas Torch
9. 1x Graphite Tube
10. 1x 0.5kg/1.0mm Flux Cored Wire
11. 1x 0.5kg/1.0mm Aluminium Welding Wire
12. 1x 0.5kg/1.0mm Solid Wire

4. Setup

4.1 Power Connection

The welder supports both 110V and 220V power sources. Ensure the correct voltage is selected and the machine is connected to a suitable power outlet with proper grounding.

- Connect the power cord to the appropriate power supply.
- Verify the voltage setting on the machine matches your power source.

4.2 Wire Installation

Proper wire installation is crucial for consistent welding. Refer to the image below for the wire conveyor structure.



Image: Close-up view of the wire conveyor structure inside the haxiaoer MIG Welder. It shows the wire spool, feed rollers, and the path the welding wire takes. The image highlights the ability to handle wire diameters from 0.8mm to 1.2mm and different types of feed rollers.

1. Open the wire compartment cover.

2. Place the wire spool onto the spindle, ensuring it rotates freely.
3. Thread the welding wire through the guide tube and into the wire feed rollers.
4. Adjust the tension of the wire feed rollers to prevent slipping or crushing the wire.
5. Select the appropriate wire feed roller and conductive nozzle for your wire diameter (0.8mm-1.2mm).
6. Feed the wire through the torch liner until it exits the nozzle.

4.3 Gas Connection (for Gas MIG)

For Gas MIG welding, connect the gas tube to the welder and the gas cylinder.

- Connect one end of the gas tube to the gas inlet on the welder.
- Connect the other end to your shielding gas regulator on the gas cylinder.
- Ensure all connections are secure and leak-free.

5. Operating Instructions

The haxiaoer MIG Welder features a user-friendly digital control panel and Synergy mode for simplified operation.



Image: The multifunctional digital operation panel of the haxiaoer MIG Welder. It shows the display for amperage and voltage, along with buttons and knobs for selecting welding modes, materials, wire diameter, and adjusting current/voltage. A step-by-step guide for operation is overlaid on the image.

5.1 General Operation Steps:

1. **Power On:** Turn on the main power switch.
2. **Select Welding Mode:** Use the control panel to select the desired welding process (MIG, TIG, Stick, etc.).
3. **Select Material/Gas:** Choose the appropriate welding material (e.g., Fe for steel, AlSi for aluminum-silicon alloy, AlMg for aluminum-magnesium alloy) and gas type (if applicable).
4. **Choose Wire Diameter:** Set the wire diameter to match the installed welding wire.
5. **Adjust Current/Voltage:** Use the knobs to fine-tune the welding current (Amps) and voltage.
6. **Begin Welding:** Once settings are confirmed, proceed with welding, ensuring all safety precautions are observed.

5.2 Synergy Mode (SYN)

The Synergy mode simplifies setup by automatically suggesting optimal welding parameters based on your selected material and wire diameter. This is particularly helpful for beginners.



Image: A diagram illustrating the "SYN Manual" process for the haxiaoer MIG Welder. Steps include: Click SYN, Choose welding process, Choose metal materials, Select wire diameter, and Adjust current welding. This visual guide simplifies the use of the Synergy mode.

1. **Click SYN:** Press the SYN button on the control panel.
2. **Choose Welding Process:** Select your desired welding process.
3. **Choose Metal Materials:** Select the type of metal you are welding.
4. **Select Wire Diameter:** Input the diameter of your welding wire.
5. **Adjust Current Welding:** The machine will suggest parameters; fine-tune as needed.

5.3 Welding Modes:

- **Flux Core MIG:** For welding without external shielding gas.
- **Gas MIG:** For welding with shielding gas (e.g., Argon, CO2, or mixtures).
- **Single Pulse MIG:** Provides controlled heat input for specific applications, often for aluminum.
- **Lift TIG:** For precise welding with a tungsten electrode. Requires a TIG torch (not included).
- **Stick (MMA):** For welding with coated electrodes.
- **2T/4T Spot Welding:** Trigger control modes for spot welding applications.

5.4 Material Compatibility:

This welder is capable of working with a wide range of metals.



Image: A collage demonstrating the wide range of metals that can be welded with the haxiaoer MIG Welder. Examples include Ferroalloy, Cast Iron, Welding aluminum, Round Tube, Carbon Steel, Sheet Metal, Stainless Steel, Square Pipe, and Copper.

Common applications include:

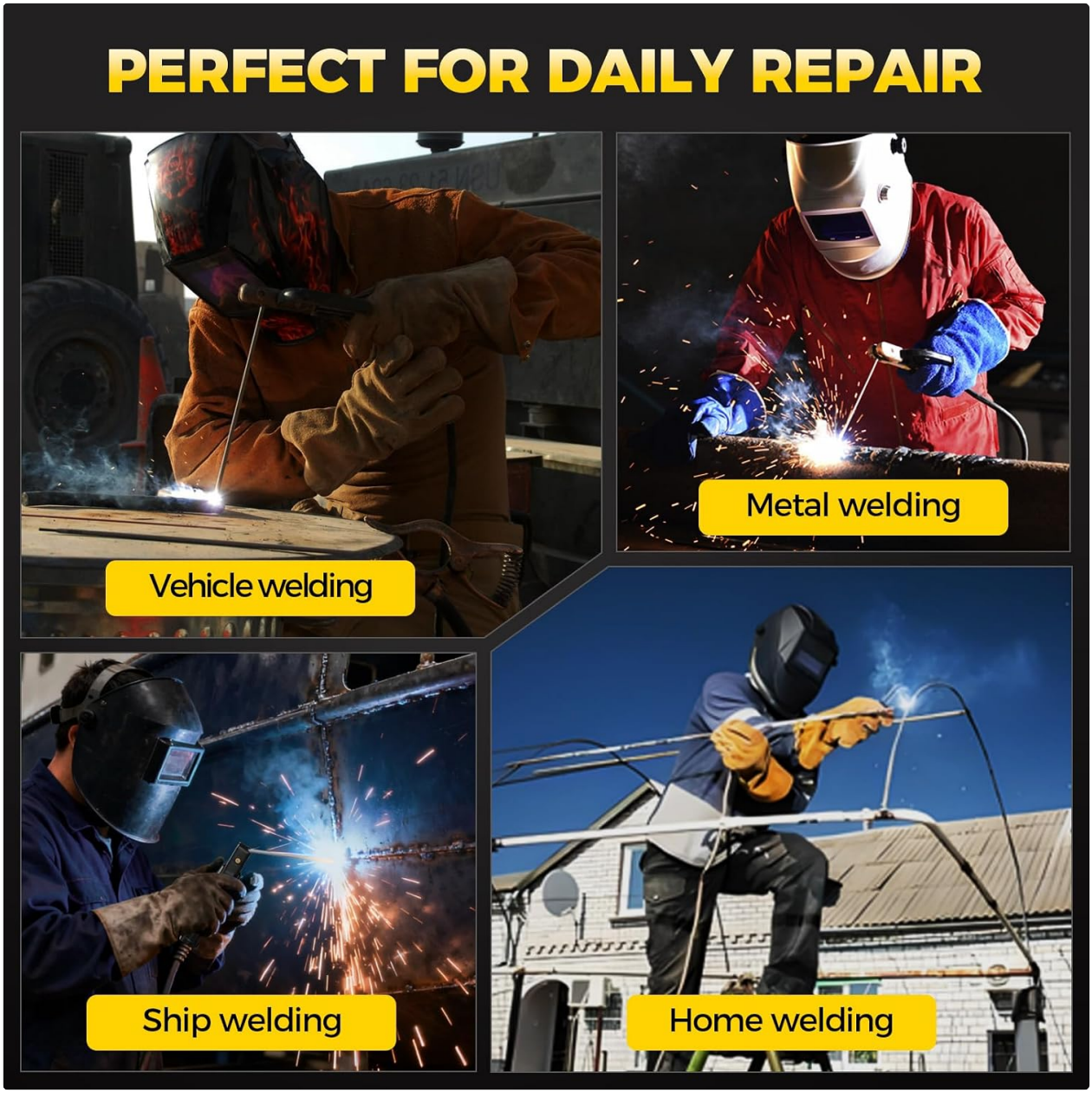


Image: A four-panel image showing various applications for the haxiaoer MIG Welder in daily repair. These include Metal welding, Vehicle welding, Ship welding, and Home welding, illustrating its versatility.

6. Maintenance

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

- **Cleaning:** Periodically clean the exterior of the machine with a dry cloth. Use compressed air to clear dust from internal components, ensuring the machine is unplugged first.
- **Wire Feed System:** Inspect the wire feed rollers and liner for wear or blockages. Replace worn parts as necessary.
- **Torch and Consumables:** Regularly check the welding torch, contact tip, gas nozzle, and diffuser for wear and spatter buildup. Clean or replace consumables as needed.
- **Cables:** Inspect all welding cables and power cords for cuts, abrasions, or loose connections. Repair or replace damaged cables immediately.

7. Troubleshooting

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

Problem	Possible Cause	Solution
No power	Power cord unplugged, circuit breaker tripped, machine switch off.	Check power connections, reset breaker, turn on machine.
No arc	Poor ground connection, incorrect settings, worn contact tip, wire feed issue.	Ensure ground clamp is secure, verify settings, replace contact tip, check wire feed.
Poor weld quality	Incorrect parameters (voltage/amperage), improper wire feed speed, contaminated material, insufficient shielding gas.	Adjust settings, clean material, check gas flow, ensure correct wire feed.
Wire feeding issues	Incorrect tension on feed rollers, kinked liner, wrong size contact tip, dirty liner.	Adjust roller tension, straighten liner, use correct tip, clean liner.

8. Specifications

Feature	Detail
Model Number	200A Aluminum MIG Welder
Manufacturer	haxiaoer
Item Weight	33.6 pounds
Package Dimensions	19.76 x 13.94 x 13.5 inches
Power Source	AC/DC
Voltage	110V/220V
Material	Metal
Color	Yellow
Welding Processes	Flux Core MIG, Gas MIG, Single Pulse MIG, Lift TIG, Stick, 2T 4T Spot
Max Output Current	200A

9. Warranty and Support

For warranty information, technical support, or service inquiries, please contact the manufacturer, haxiaoer, or

your authorized dealer. Keep your purchase receipt as proof of purchase.
Manufacturer: haxiaoer
For specific contact details, please refer to the documentation included with your product or visit the official haxiaoer website.

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