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- › [Esab](#) /
- › [ESAB Rogue LHN ES245i Inverter Welder User Manual](#)

Esab Rogue ES245i

ESAB Rogue LHN ES245i Inverter Welder User Manual

1. INTRODUCTION

This manual provides essential information for the safe and effective operation, setup, and maintenance of your ESAB Rogue LHN ES245i Inverter Welder. The Rogue ES 245i is a robust and high-performance inverter designed for demanding welding tasks, suitable for workshops, locksmiths, construction, maintenance, and minor repairs. It offers clean and stable welding for electrodes up to 4 mm (including cellulose) and TIG processes for thin sheets. Please read this manual thoroughly before using the equipment.

2. SAFETY INFORMATION

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

- **Eye and Face Protection:** Always wear a welding helmet with appropriate shade filters to protect your eyes and face from arc rays and sparks.
- **Protective Clothing:** Wear flame-resistant clothing, gloves, and sturdy footwear to protect against burns and electric shock.
- **Ventilation:** Ensure adequate ventilation to remove welding fumes and gases from the work area.
- **Electrical Safety:** Never operate the welder in wet conditions. Ensure all electrical connections are secure and properly grounded. Do not touch live electrical parts.
- **Fire Prevention:** Keep a fire extinguisher nearby. Remove flammable materials from the welding area.
- **Work Area:** Keep the work area clean and free of clutter. Ensure stable footing.
- **Read Instructions:** Always read and understand the entire instruction manual before operating the welder.

3. PRODUCT CONTENTS

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

- 1 x ESAB Rogue ES 245i Inverter Welding Machine
- 1 x Electrode holder with 3-meter 100% copper cable

- 1 x Negative clamp with 3-meter 100% copper cable
- 1 x Ergonomic carrying handle
- 1 x User Manual (this document)

4. SETUP

4.1 Unpacking and Placement

Carefully remove the welder and all accessories from the packaging. Place the machine on a stable, level surface, ensuring adequate clearance for ventilation around the unit.



Figure 1: Side view of the ESAB Rogue ES245i Inverter Welder, showing the power input and output connections.

4.2 Electrical Connections

1. **Power Supply:** Connect the welder to a single-phase 220 V \pm 10% power outlet. Ensure the circuit is protected by a 40 A recommended breaker.
2. **Electrode Holder:** Connect the electrode holder cable to the positive (+) terminal on the front panel.
3. **Ground Clamp:** Connect the negative clamp cable to the negative (-) terminal on the front panel. Attach the ground clamp securely to the workpiece, ensuring good electrical contact.



Figure 2: Front panel of the ESAB Rogue ES245i, displaying the control knob, digital display, and electrode/ground connections.

5. OPERATING INSTRUCTIONS

5.1 Powering On and Basic Controls

1. Turn on the main power switch located on the rear of the unit.
2. The digital display on the front panel will illuminate.
3. Use the control knob to select the desired welding process (SMAW or TIG) and adjust the current (Amperage). The digital control ensures maximum precision.
4. The welder features automatic **HotStart** for easy arc ignition and **ArcForce** for a stable arc, even with challenging electrodes.

5.2 SMAW (Shielded Metal Arc Welding) / Electrode Welding

1. Select the SMAW mode using the control panel.
2. Insert the appropriate electrode into the electrode holder. The Rogue ES 245i supports electrodes up to 4 mm,

including cellulose types.

3. Set the current according to the electrode manufacturer's recommendations and the material thickness.
4. Strike the arc carefully and maintain a consistent arc length and travel speed for optimal weld quality.

5.3 TIG (Tungsten Inert Gas) Welding

The Rogue ES 245i is capable of TIG welding for thin sheets. For TIG welding, additional equipment such as a TIG torch with gas valve and a shielding gas cylinder will be required (not included).

1. Connect the TIG torch to the appropriate terminal (usually negative for DC TIG).
2. Connect the ground clamp to the workpiece.
3. Connect the shielding gas hose to the TIG torch and open the gas cylinder valve.
4. Select TIG mode on the welder and set the desired current.
5. Initiate the arc using the scratch start method or a high-frequency start if your TIG torch supports it.

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, soft cloth. Ensure ventilation openings are free from dust and debris. Do not use solvents.
- **Cable Inspection:** Regularly inspect all cables (power, electrode, ground) for cuts, fraying, or damage. Replace damaged cables immediately.
- **Connection Points:** Check that all electrical connections are tight and free from corrosion.
- **Storage:** Store the welder in a clean, dry environment when not in use.

7. TROUBLESHOOTING

This section provides solutions to common issues you might encounter. For problems not listed here, contact qualified service personnel.

Problem	Possible Cause	Solution
Welder does not power on.	No power supply; main switch off; faulty power cable.	Check power outlet and circuit breaker; ensure main switch is on; inspect power cable.
No arc or weak arc.	Poor ground connection; incorrect current setting; damp electrode; faulty electrode holder.	Ensure ground clamp has good contact; adjust current; use dry electrodes; inspect electrode holder.
Overheating indicator on.	Exceeded duty cycle; blocked ventilation.	Allow machine to cool down; ensure ventilation openings are clear.
Poor weld quality.	Incorrect settings; improper technique; contaminated workpiece.	Adjust current/voltage; review welding technique; clean workpiece thoroughly.

8. SPECIFICATIONS

Technical specifications for the ESAB Rogue LHN ES245i Inverter Welder:

Feature	Value
Model	Rogue ES 245i
Product Code	752315
Power Supply Voltage	Single-phase 220 V ± 10%
Frequency	50/60 Hz
Idle Voltage	83 V (with VRD <25 V)
Current Range	10 to 200 A
Output Capacity	200 A
Duty Cycle (SMAW)	200 A/28 V @ 40%, 126 A/25 V @ 100%
Duty Cycle (TIG)	200 A/18 V @ 40%, 126 A/15 V @ 100%
Recommended Generator	10 kVA
Recommended Breaker	40 A
Protection Class	IP21S
Standard	IEC 60.974
Dimensions (L x W x H)	440 x 155 x 325 mm (17.3 x 6.1 x 12.8 inches)
Weight	8.9 kg (19.6 lbs)