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› [ANDELI](#) /

› ANDELI MIG Welder 135PLUS User Manual

ANDELI MIG-135MINI

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Model: MIG-135MINI

1. INTRODUCTION

This manual provides detailed instructions for the safe and efficient operation of your ANDELI MIG Welder 135PLUS. This multiprocess welding machine supports MIG, Lift TIG, and MMA (Stick Arc) welding modes, operating on both 110V and 220V power supplies. It is designed for versatility, suitable for various welding tasks on thin steel and iron.

The ANDELI MIG Welder 135PLUS features an intuitive control panel and a unified adjustment mode, allowing users to quickly master its operation. Its high-quality integrated wire feeder ensures smooth wire delivery, with adjustable welding voltage and current for precise control.

2. SAFETY INFORMATION

Always prioritize safety when operating welding equipment. Failure to follow safety guidelines can result in serious injury or property damage.

- **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, which can be hazardous to health.
- **Fire Hazards:** Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Electrical Safety:** Ensure the machine is properly grounded. Do not operate in wet conditions. Inspect cables for damage before each use.
- **Arc Rays:** Welding arcs produce intense visible and invisible (UV and IR) rays that can burn eyes and skin. Protect yourself and bystanders.

The ANDELI MIG Welder 135PLUS incorporates automatic protection functions for over-current, over-voltage, and over-heating, enhancing operational safety and reliability. However, these features do not replace the need for proper safety practices.

3. PACKAGE CONTENTS

The ANDELI MIG Welder 135PLUS package typically includes the following components:

- ANDELI MIG-135PLUS Welding Machine
- MIG Torch
- Electrode Holder (for MMA welding)
- Ground Clamp
- Power Cables

Note: Specific accessories may vary. Refer to your product packaging for a complete list.

4. PRODUCT OVERVIEW

The ANDELI MIG Welder 135PLUS is a compact and portable multiprocess welding machine. It features a clear digital display and an intuitive control panel for selecting welding modes (MIG, Lift TIG, MMA) and adjusting parameters.

A unique air channel design is integrated to increase the heat dissipation efficiency of the power device and control circuits. This design also minimizes dust absorption, significantly improving the longevity and reliability of the machine.



Image 1: The ANDELI MIG Welder 135PLUS shown with its included accessories, including the MIG torch, ground clamp, electrode holder, power cables, and a spool of flux-cored welding wire. The machine features a digital display and control panel on the front.

5. SETUP

1. **Power Connection:** Connect the power cable to a suitable 110V or 220V AC power outlet. Ensure the power supply matches the machine's requirements.
2. **Ground Clamp Connection:** Attach the ground clamp cable to the appropriate terminal on the welder and securely fasten the clamp to the workpiece or welding table, ensuring good electrical contact.
3. **Welding Torch/Holder Connection:**
 - **MIG Welding:** Connect the MIG torch to the designated MIG output terminal.
 - **MMA Welding:** Connect the electrode holder to the positive (+) terminal and the ground clamp to the negative (-) terminal.
 - **Lift TIG Welding:** Connect the TIG torch (if purchased separately) to the negative (-) terminal and the ground clamp to the positive (+) terminal.
4. **Wire Installation (MIG):** Open the wire feeder compartment. Install a 0.030 inch (1kg) flux-cored welding wire

spool. Thread the wire through the feeder mechanism and into the MIG torch liner. Adjust the wire tension appropriately.

5. **Gas Connection (Optional for MIG/TIG):** If using shielded gas for MIG or TIG welding, connect the gas hose from your gas cylinder regulator to the gas inlet on the welder. This model supports gasless flux-cored MIG welding.

6. OPERATING INSTRUCTIONS

6.1 General Operation

1. Turn on the main power switch of the welder.
2. Select the desired welding mode (MIG, Lift TIG, or MMA) using the control panel.
3. Adjust the welding parameters (current, voltage, wire feed speed) according to the material thickness and welding process. The unified adjustment mode simplifies this process.

6.2 MIG Welding (Flux-Cored / Gasless)

- Ensure flux-cored wire is correctly installed and the MIG torch is connected.
- Set the machine to MIG mode.
- Adjust the wire feed speed and voltage. Start with recommended settings for your wire size and material, then fine-tune as needed.
- Position the MIG torch at the starting point of the weld. Press the trigger to initiate the arc and begin welding.

6.3 Lift TIG Welding

- Ensure the TIG torch (if applicable) and gas supply are connected.
- Set the machine to Lift TIG mode.
- Adjust the welding current.
- To start the arc, gently touch the tungsten electrode to the workpiece and then lift it slightly. The arc will initiate without high-frequency interference.

6.4 MMA (Stick Arc) Welding

- Ensure the electrode holder and ground clamp are correctly connected.
- Select MMA mode.
- Insert the appropriate electrode into the holder.
- Adjust the welding current based on the electrode type and diameter.
- Strike the electrode against the workpiece to initiate the arc and begin welding.

7. 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. Use compressed air to clear dust from the cooling vents.
- **Wire Feeder:** Inspect and clean the wire feeder rollers and guide tubes regularly to prevent wire feeding issues.
- **Cables and Connections:** Check all welding cables, power cords, and connections for wear, cuts, or loose

fittings. Replace damaged components immediately.

- **MIG Torch:** Clean the contact tip, gas nozzle, and diffuser regularly. Replace worn-out parts.

8. TROUBLESHOOTING

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

Problem	Possible Cause	Solution
Machine does not power on	No power supply; Faulty power cable; Internal fault	Check power outlet and circuit breaker; Inspect power cable; Contact service center
No welding arc	Poor ground connection; Incorrect settings; Damaged torch/holder	Ensure good ground contact; Verify welding parameters; Inspect and replace damaged parts
Wire feeding issues (MIG)	Incorrect wire tension; Clogged liner; Worn contact tip	Adjust wire tension; Clean or replace liner; Replace contact tip
Overheating protection activated	Excessive duty cycle; Blocked ventilation	Allow machine to cool down; Ensure clear ventilation paths

9. SPECIFICATIONS

Technical specifications for the ANDELI MIG Welder 135PLUS (MIG-135MINI):

Feature	Specification
Model Number	MIG-135MINI
Manufacturer	XINGYI
Input Voltage	110V/220V AC
Welding Processes	MIG, Lift TIG, MMA (Stick Arc)
Item Weight	18.85 pounds
Package Dimensions	19.7 x 14.6 x 13.4 inches
Compatible Wire	0.030 inch (1kg) flux-cored welding wire
ASIN	B0FXRBCLB2
Date First Available	July 24, 2021

10. WARRANTY AND SUPPORT

For warranty information, technical assistance, or to inquire about replacement parts, please refer to the

documentation provided with your original purchase or contact ANDELI customer service directly through their official channels. Extended protection plans may be available for purchase separately.

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