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haxiaoer MIG145

HAXIAOER MIG145 145A 3-in-1 Multiprocess Welder Instruction Manual

Model: MIG145 | Brand: HAXIAOER

Introduction | Safety Information | Package Contents | Setup | Operating Modes | Maintenance | Troubleshooting | Specifications | Warranty & Support

1. Introduction

The HAXIAOER MIG145 is a versatile 3-in-1 multiprocess welding machine designed for various welding applications. It supports Gasless MIG, Lift TIG (requires an extra torch), and Stick (MMA) welding. This machine is suitable for both beginners and professionals, offering efficient and high-quality welds for DIY projects, home repairs, farm work, automotive applications, and construction sites.
It features a user-friendly interface with a large LED digital display for clear monitoring and adjustment of welding mode, current, and voltage. The durable metal housing provides protection for internal components, ensuring extended product life.

2. Safety Information

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

- **Eye Protection:** Always wear a welding helmet with appropriate shade lenses to protect your eyes from intense light and UV radiation.
- **Body Protection:** Wear flame-resistant clothing, heavy-duty gloves, and protective footwear to prevent burns and electrical shock.
- **Ventilation:** Ensure adequate ventilation in your work area to disperse welding fumes, which can be hazardous if inhaled.
- **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 flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Fume Hazards:** Avoid inhaling welding fumes. Use a fume extractor or work in a well-ventilated area.

- **Children and Bystanders:** Keep children and unauthorized personnel away from the welding area.
- **Maintenance:** Regularly inspect the welder and its accessories for damage. Do not use damaged equipment.

3. Package Contents

Upon opening your HAXIAOER MIG145 welder package, please verify that all the following items are included:

- 1x HAXIAOER MIG145 Welding Machine
- 1x Welding Torch (MIG/Flux Core)
- 1x Ground Clamp
- 1x Electrode Holder (for MMA/Stick welding)
- 1x Flux Core Wire (0.5 kg, 1.0 mm)
- 10x Welding Electrodes (Rods)
- Contact Tips
- 1x Tension Band
- 1x User Manual
- 1x Welding Mask (basic)
- 1x Wire Brush



Figure 3.1: Included components of the HAXIAOER MIG145 welding machine. This image displays the main welding unit, MIG torch, ground clamp, electrode holder, flux core wire spool, welding electrodes, contact tips, tension band, basic welding mask, and wire brush.

4. Setup

4.1 Wire Spool Installation (Flux Core MIG)

Proper installation of the flux core wire is crucial for smooth operation. Refer to the diagram below for component identification.



Figure 4.1: Exploded view showing the components for wire spool installation, including the spool lock, washer, spring, spool spacer, waterproof cover, spool, and spindle.

1. Open the side panel of the welder to access the wire feed mechanism.
2. Remove the spool lock, washer, spring, and spool spacer from the spindle.

3. Place the flux core wire spool onto the spindle, ensuring it rotates freely.
4. Reinstall the spool spacer, spring, washer, and spool lock, securing the spool in place.
5. Feed the wire through the wire guide and into the wire feed rollers.
6. Close the wire feed roller tension arm and adjust the tension as needed (usually moderate tension to prevent slipping without crushing the wire).
7. Thread the wire through the MIG torch liner until it exits the contact tip.



Figure 4.2: Internal view of the HAXIAOER MIG145 welder showing the wire feed mechanism with a flux core wire spool installed.

4.2 Connecting Accessories

- Connect the MIG torch to the appropriate connector on the front panel.
- Connect the ground clamp cable to the negative (-) terminal and attach the clamp to the workpiece.
- For MMA (Stick) welding, connect the electrode holder to the positive (+) terminal and the ground clamp to the negative (-) terminal.
- For Lift TIG welding, connect the TIG torch (not included) to the negative (-) terminal and the ground clamp to the positive (+) terminal. Ensure a gas supply is connected to the TIG torch if using shielded gas.

5. Operating Modes

The HAXIAOER MIG145 offers three primary welding modes: Gasless MIG (Flux Core), Lift TIG, and MMA (Stick) welding. Select the desired mode using the function select button on the control panel.



Figure 5.1: Close-up of the HAXIAOER MIG145 digital LED display control panel, showing controls for welding mode, current, and voltage adjustment.

5.1 Gasless MIG (Flux Core) Welding

This mode uses flux-cored wire, eliminating the need for external shielding gas. It is ideal for outdoor welding and dirty or rusty materials.

1. Ensure the flux core wire is correctly installed (refer to Section 4.1).

2. Select the MIG mode on the control panel.
3. Adjust the wire feed speed and voltage according to the material thickness and wire diameter. The digital display will show the settings.
4. Attach the ground clamp securely to the workpiece.
5. Position the MIG torch at the starting point of the weld.
6. Press the trigger on the MIG torch to begin welding.



Figure 5.2: Diagram illustrating the synergistic wire feed adjustment steps: 1. Select MIG mode, 2. Select wire size, 3. Adjust current.

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Video 5.1: This video segment demonstrates the process of setting up and operating the HAXIAOER MIG145 for Flux-cored wire welding, including wire installation and initial welding operation.

5.2 Lift TIG Welding

Lift TIG welding provides precise control and high-quality welds, especially for thinner materials and stainless steel. An additional TIG torch and shielding gas (e.g., Argon) are required for this mode.

1. Connect the TIG torch to the negative (-) terminal and the ground clamp to the positive (+) terminal.
2. Ensure the TIG torch is properly assembled with a tungsten electrode and ceramic cup.
3. Connect the shielding gas cylinder to the TIG torch and set the gas flow rate.
4. Select the TIG mode on the control panel.
5. Adjust the welding current according to the material thickness.
6. Attach the ground clamp securely to the workpiece.
7. Initiate the arc by gently touching the tungsten electrode to the workpiece and then lifting it slightly (Lift Arc).
8. Feed the filler rod manually into the weld puddle.

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Video 5.2: This video segment demonstrates the setup and operation of the HAXIAOER MIG145 for Lift-TIG welding, including torch assembly and arc initiation.

5.3 MMA (Stick) Welding

MMA welding is suitable for a wide range of materials and thicknesses, often used for heavy fabrication and outdoor repairs.

1. Connect the electrode holder to the positive (+) terminal and the ground clamp to the negative (-) terminal.
2. Insert the appropriate welding electrode (rod) into the electrode holder.
3. Select the MMA mode on the control panel.
4. Adjust the welding current based on the electrode type and diameter, and the material thickness.
5. Attach the ground clamp securely to the workpiece.
6. Strike the electrode against the workpiece to initiate the arc and begin welding.



Figure 5.3: The HAXIAOER MIG145 welder features Hot Start and Arc Force functions, which aid in easier arc ignition and stable arc performance during MMA welding.

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Video 5.3: This video segment demonstrates the setup and operation of the HAXIAOER MIG145 for MMA (Stick) welding, including electrode holder connection and welding process.

6. Maintenance

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

- **Cleaning:** Periodically clean the internal components of the welder using compressed air to remove dust and metal particles. Ensure the machine is unplugged before cleaning.
- **Cable Inspection:** Inspect all welding cables, torch, and ground clamp for cuts, fraying, or loose connections. Replace damaged components immediately.
- **Wire Feed Mechanism:** Clean the wire feed rollers and guides regularly to prevent wire feeding issues. Check for wear on the rollers and replace if necessary.
- **Contact Tips and Nozzles:** Replace worn contact tips and clean welding nozzles to ensure proper wire transfer and gas flow (if applicable).
- **Storage:** Store the welder in a clean, dry environment, away from excessive dust, moisture, and extreme temperatures.

7. Troubleshooting

This section provides solutions to common issues you might encounter during operation.

Problem	Possible Cause	Solution
No arc or weak arc	Loose connections, incorrect settings, poor ground connection, wrong electrode/wire.	Check all cable connections. Verify welding current/voltage settings. Ensure ground clamp has good contact. Use correct consumables.
Wire feeding issues (MIG)	Incorrect wire tension, clogged liner, worn contact tip, wrong drive roller size.	Adjust wire tension. Clean or replace torch liner. Replace contact tip. Ensure correct drive roller for wire size.
Overheating protection activated	Exceeding duty cycle, poor ventilation, blocked cooling vents.	Allow the machine to cool down. Ensure adequate airflow around the welder. Clear any obstructions from cooling vents.
Poor weld quality	Incorrect settings, improper technique, contaminated workpiece.	Adjust current/voltage. Practice welding technique. Clean workpiece thoroughly before welding.

8. Specifications

Feature	Detail
Model Number	MIG145
Manufacturer	Haxiaoer
Max Output Current	145A
Input Voltage	110V
Welding Processes	Gasless MIG (Flux Core), Lift TIG, MMA (Stick)
Max Material Thickness (Mild Steel)	2/5” (3mm)

Feature	Detail
Display	LED Digital Display
Power Source	Corded Electric
Package Dimensions	12 x 8 x 6 inches
ASIN	B0FYG17SQB

9. Warranty & Support

The HAXIAOER MIG145 welding machine comes with a standard manufacturer's warranty. Please refer to the warranty card included in your package for specific terms and conditions, including warranty duration and coverage details.
For technical support, troubleshooting assistance, or to inquire about replacement parts, please contact HAXIAOER customer service through the contact information provided in your product documentation or on the official HAXIAOER website.
When contacting support, please have your product model number (MIG145) and purchase date available to expedite assistance.

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