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ANDELI MIG-135MINI

ANDELI MIG135 Multiprocess Welder User Manual

Model: MIG-135MINI

1. Introduction

This manual provides essential instructions for the safe and effective operation, setup, and maintenance of your ANDELI MIG135 Multiprocess Welder. The MIG135 is a versatile welding machine designed for MIG, Lift TIG, and MMA (Stick) welding processes, suitable for various applications from home DIY to general maintenance tasks.
Please read this manual thoroughly before operating the welder to ensure proper usage and to prevent potential hazards.

2. Safety Instructions

WARNING: Welding can be dangerous. Always follow safety precautions to prevent injury or death.

- **Eye Protection:** Always wear a welding helmet with appropriate shade lenses to protect your eyes from arc rays.
- **Body Protection:** Wear flame-resistant clothing, gloves, and safety shoes to protect against sparks, heat, 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 flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Work Area:** Keep the work area clean and free of clutter. Ensure stable footing.
- **Read Labels:** Always read and understand the safety labels on the welder and welding consumables.

3. Product Overview

The ANDELI MIG135 is a compact and portable multiprocess welding machine. It features a user-friendly control panel and is designed for efficient welding operations.



Figure 3.1: The ANDELI MIG135 welder unit, a MIG torch, an electrode holder, a ground clamp, a spool of flux-cored wire, and a welding helmet.

Key Features:

- **Multiprocess Capability:** Supports MIG, Lift TIG, and MMA (Stick) welding modes.
- **User-Friendly Interface:** Simple control panel with unified adjustment for ease of use.
- **Advanced Cooling System:** Unique air channel design enhances heat dissipation and minimizes dust absorption, improving longevity.
- **Safety Protections:** Equipped with automatic protection functions for over-current, over-voltage, and over-heating.
- **Portability:** Compact design for easy transport and use in various locations.

4. Setup

4.1 Unpacking and Inspection

Carefully unpack the welder and all accessories. Inspect for any shipping damage. Report any damage to your supplier immediately.

4.2 Power Connection

The ANDELI MIG135 operates on 110V AC power. Ensure the power source matches the welder's requirements and is properly grounded. Use a dedicated circuit if possible to avoid overloading.

4.3 Connecting Welding Cables

Refer to the markings on the welder for correct polarity connections for each welding process.

- **Ground Clamp:** Connect the ground clamp cable to the appropriate terminal on the welder and securely attach the clamp to the workpiece, ensuring good electrical contact.
- **MIG Torch:** Connect the MIG torch to the designated MIG connector. Install the flux-cored wire spool into the wire feeder compartment, threading the wire through the feeder mechanism and into the torch liner.
- **Electrode Holder (MMA):** For MMA welding, connect the electrode holder cable to the appropriate terminal.
- **TIG Torch (Lift TIG):** For Lift TIG welding, connect the TIG torch to the designated terminal. Ensure the tungsten electrode is correctly installed.

5. Operating Instructions

The ANDELI MIG135 features a simple control panel for selecting welding modes and adjusting parameters.

5.1 Mode Selection

Use the mode selection button on the control panel to switch between MIG, Lift TIG, and MMA welding processes.

5.2 Parameter Adjustment

The welder features a unified adjustment mode. Use the control knob to adjust welding voltage and current according to the material thickness and welding process. Start with recommended settings and fine-tune as needed.

5.3 MIG Welding (Flux-Cored)

This machine is designed for flux-cored welding without external shielding gas. It can be installed with 0.030 inch (1kg) flux-cored welding wire.

1. Select MIG mode.
2. Set appropriate voltage and wire feed speed.
3. Ensure proper ground connection.
4. Position the MIG torch and initiate the arc.
5. Maintain a consistent travel speed and torch angle.

5.4 Lift TIG Welding

For Lift TIG welding, a TIG torch (not always included) and appropriate tungsten electrodes are required.

1. Select Lift TIG mode.
2. Set the desired welding current.
3. Gently touch the tungsten electrode to the workpiece and then lift it slightly to initiate the arc.
4. Maintain a short arc length and consistent travel speed.

5.5 MMA (Stick) Welding

For MMA welding, an electrode holder and appropriate welding electrodes are required.

1. Select MMA mode.
2. Set the welding current based on the electrode type and diameter.
3. Strike the electrode against the workpiece to initiate the arc.
4. Maintain a consistent arc length and travel speed.

6. Maintenance

Regular maintenance ensures the longevity and optimal performance of your welder.

- **Cleaning:** Periodically clean the welder's exterior and ventilation openings to prevent dust buildup. The unique air channel design helps minimize dust absorption, but regular cleaning is still recommended.
- **Cable Inspection:** Regularly inspect all welding cables, torch, and ground clamp for damage, cuts, or loose connections. Replace damaged components immediately.
- **Wire Feeder:** Clean the wire feeder rollers and guide tubes to ensure smooth wire feeding. Check for wear on the rollers.
- **Torch Consumables:** Inspect and replace MIG torch nozzles, contact tips, and TIG collets/tungsten electrodes as they wear out.
- **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.

Problem	Possible Cause	Solution
No power to welder	Power cord unplugged, circuit breaker tripped, faulty power switch.	Check power cord connection, reset circuit breaker, contact service if switch is faulty.
No arc / Weak arc	Poor ground connection, incorrect settings, worn consumables, loose cable connections.	Ensure good ground, verify settings, replace consumables, tighten connections.
Wire feeding issues (MIG)	Kinked wire, clogged liner, incorrect roller tension, worn contact tip.	Straighten wire, clean/replace liner, adjust roller tension, replace contact tip.
Overheat protection activated	Exceeded duty cycle, blocked ventilation.	Allow welder to cool down, ensure clear ventilation, reduce welding time.

8. Specifications

Parameter	Value
Model Number	MIG-135MINI
Manufacturer	XINGYI
Input Power	110V AC

Parameter	Value
Welding Processes	MIG (Flux-Cored), Lift TIG, MMA (Stick)
Item Weight	18.85 pounds (approx. 8.55 kg)
Package Dimensions	19.7 x 14.6 x 13.4 inches (approx. 50 x 37 x 34 cm)
Date First Available	July 24, 2021

9. Warranty and Support

For warranty information, technical support, or service inquiries, please contact the seller or manufacturer directly. Details regarding specific warranty periods and terms are typically provided at the point of purchase or on the manufacturer's official website.
Always refer to your purchase documentation for the most accurate and up-to-date warranty details.

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