

PUWU TK-FLUX-135PRO

PUWU FLUX 135A 110V 3-in-1 MIG Welder Instruction Manual

Model: TK-FLUX-135PRO

Brand: PUWU

1. INTRODUCTION AND SAFETY INFORMATION

This manual provides essential instructions for the safe and effective operation, maintenance, and troubleshooting of your PUWU FLUX 135A 110V 3-in-1 MIG Welder (Model TK-FLUX-135PRO). Please read this manual thoroughly before using the equipment to ensure proper function and to prevent injury or damage.

General Safety Warnings:

- Always wear appropriate personal protective equipment (PPE), including welding helmet, gloves, and protective clothing.
- Ensure adequate ventilation in the work area to avoid inhaling welding fumes.
- Never operate the welder in wet conditions or near flammable materials.
- Disconnect power before performing any maintenance or adjustments.
- Keep children and unauthorized personnel away from the welding area.

2. PRODUCT OVERVIEW AND FEATURES

The PUWU FLUX 135A 110V Welder is a versatile 3-in-1 IGBT Inverter machine designed for Flux Core, Lift TIG, and Stick welding. It features a bright LED digital display for precise current monitoring and advanced safety mechanisms.



Figure 2.1: Front view of the PUWU FLUX 135A 110V 3-in-1 MIG Welder.

Key Features:

- **Precise Digital Control & Versatile Welding:** 135A welding performance with LED digital display. Supports Flux MIG, Lift TIG, and Stick welding, compatible with 7018 and 6011 electrodes.
- **Advanced Safety Protection System:** Includes thermal protection, overcurrent protection, VRD technology, and anti-stick function.
- **Professional Performance Features:** Adjustable arc force, hot start for easy ignition, and stable output.
- **Compact and Portable Design:** Lightweight and easy to transport for various projects.



Figure 2.2: Detailed view of the control panel, highlighting the digital display, function selection, and current adjustment.

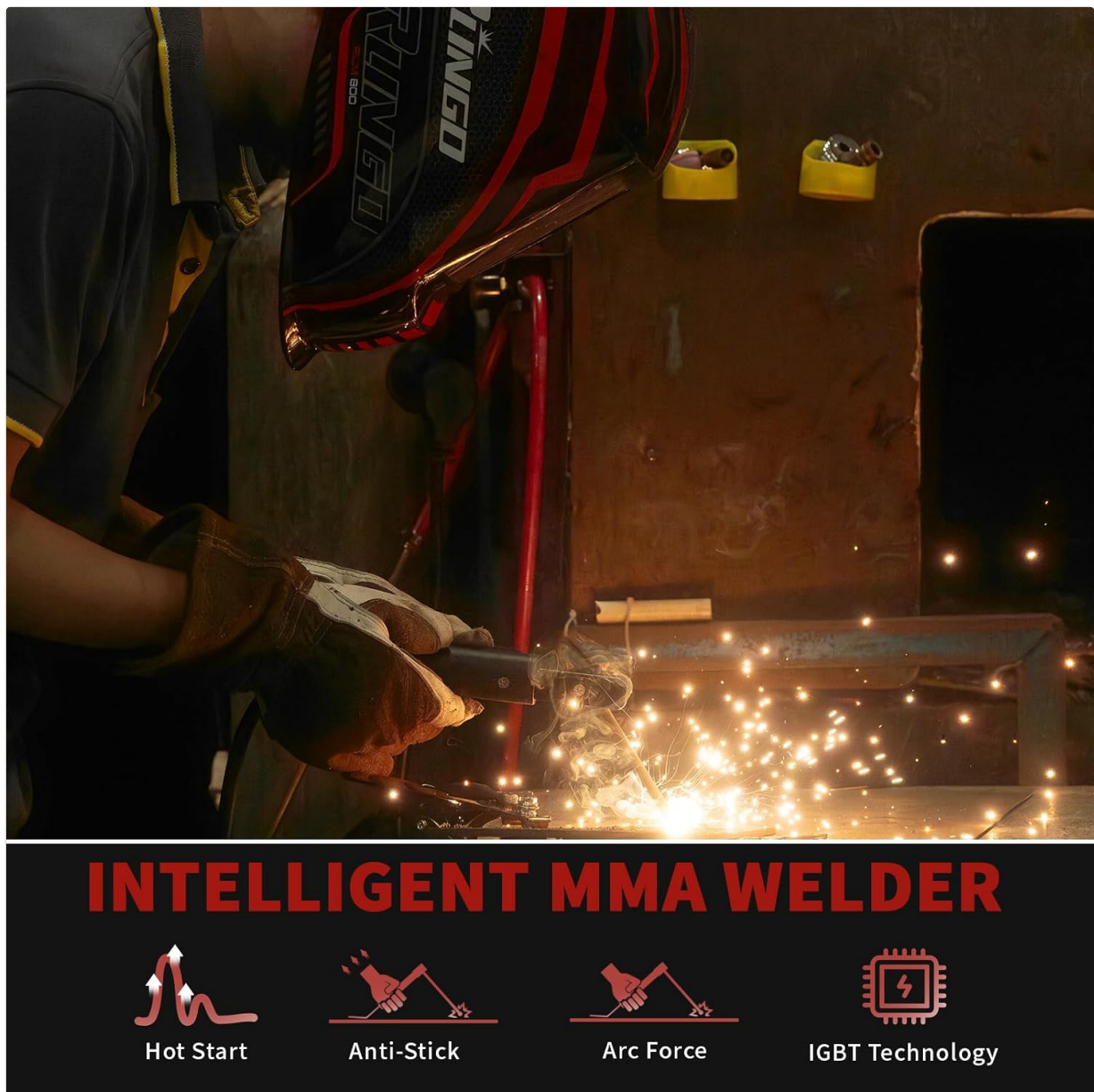


Figure 2.3: Overview of intelligent features including Hot Start, Anti-Stick, Arc Force, and IGBT Technology.

3. PACKAGE CONTENTS

Verify that all items listed below are included in your package. If any items are missing or damaged, please contact customer support.

- PUWU FLUX-135 PRO Welder Unit
- 1.5m Electrode Holder (red 10-25)
- 1.5m Ground Clamp (black 10-25)
- 1.5m ET-12 Flux-Core MIG Torch
- Instruction Manual
- Contact Tips



Figure 3.1: Included accessories with the FLUX-135 PRO welder.

4. SETUP INSTRUCTIONS

4.1 Connecting the Electrode Holder and Ground Clamp

1. Connect the electrode holder cable to the positive (+) terminal on the welder.
2. Connect the ground clamp cable to the negative (-) terminal on the welder.
3. Ensure connections are secure.

4.2 Connecting the MIG Torch

1. Insert the MIG torch connector into the designated port on the front panel.
2. Secure the connection by twisting the collar.
3. Install the appropriate flux-core wire spool inside the welder's wire feed compartment (refer to internal diagrams for specific routing).

4.3 Power Connection

Connect the 1.5-meter 14AWG power cord with the American-style plug to a suitable 110V power outlet. Ensure the welder's power switch is in the "OFF" position before plugging it in.

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Video 4.1: Demonstration of connecting the welding accessories and a brief welding demonstration for the PUWU FLUX-135 PRO.

5. OPERATING INSTRUCTIONS

The FLUX-135 PRO supports three welding modes: Flux MIG, Lift TIG, and Stick welding. Select the appropriate mode using the function selection key on the control panel.

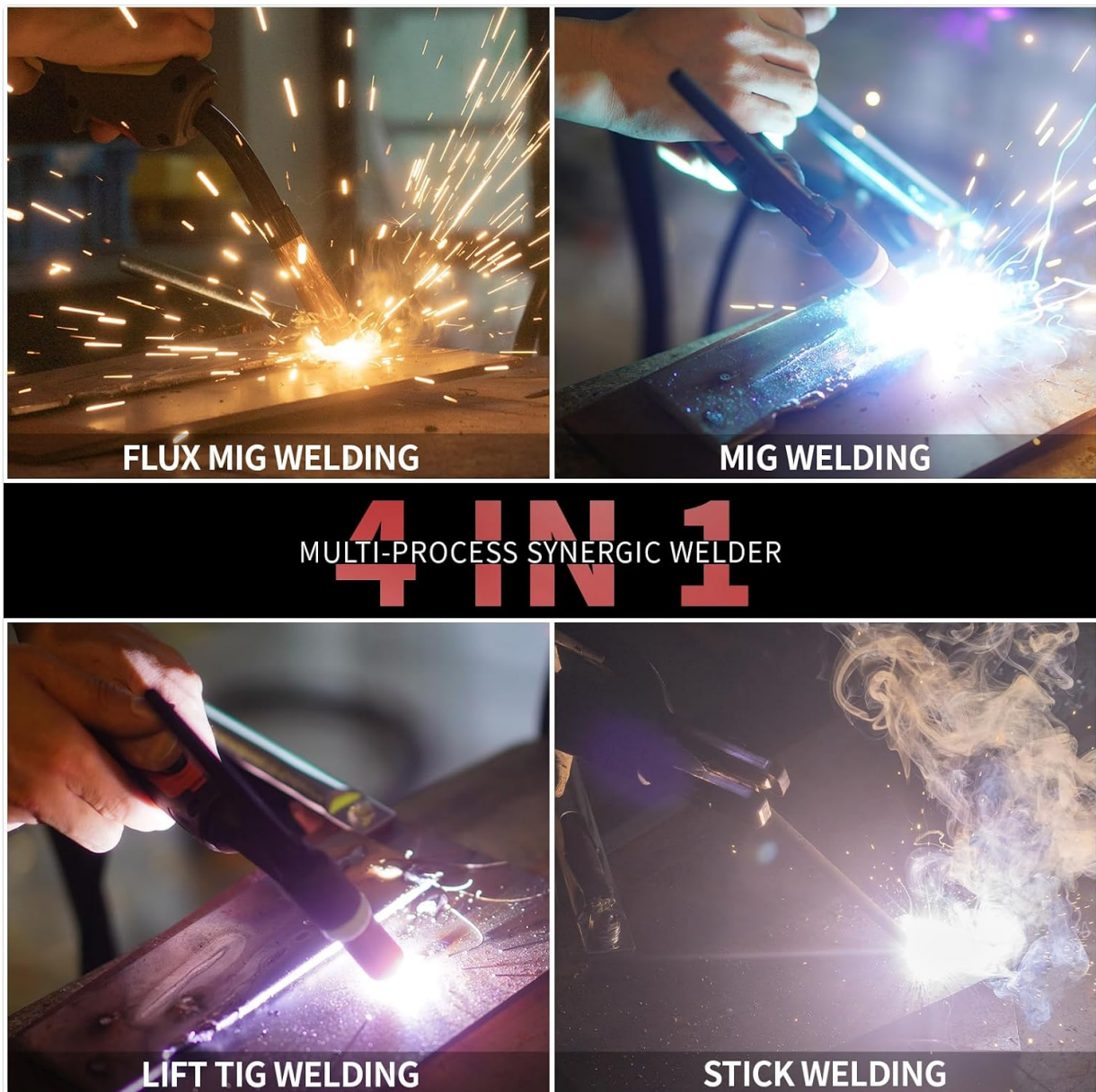


Figure 5.1: Visual representation of different welding processes supported by the machine.

5.1 Mode Selection and Current Adjustment

- Turn on the welder using the main power switch.
- Use the **Function Selection Key** to cycle through Flux MIG, Lift TIG, and Stick welding modes. The selected mode will be indicated on the LED display.
- Adjust the welding current using the **Current Adjustment Key** (rotary knob) to match your material thickness and welding process requirements. Refer to the welding parameters table for guidance.

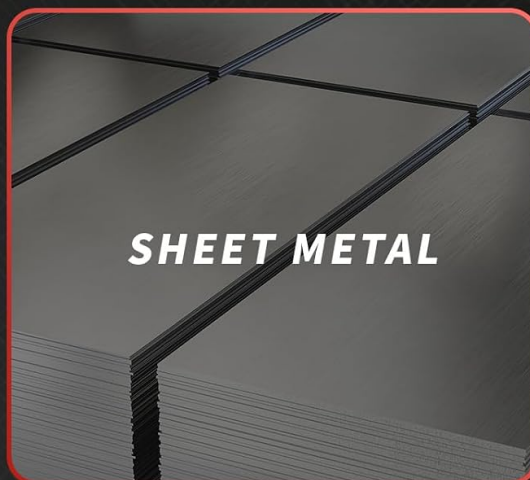
5.2 Welding Process Overview

For detailed instructions on each welding process (Flux MIG, Lift TIG, Stick), consult specialized welding guides and practice on scrap material before attempting critical welds. Always ensure proper grounding and material preparation.

CAPABLE WELDING MATERIAL



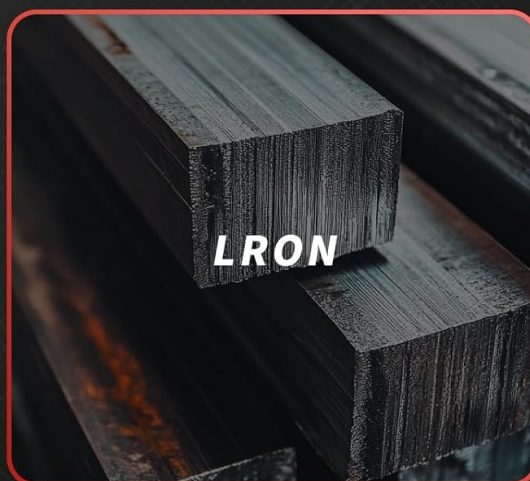
STAINLESS STEELS



SHEET METAL



CARBON STEEL



IRON

Figure 5.2: Types of materials suitable for welding with this machine.

6. MAINTENANCE

Regular maintenance ensures the longevity and safe operation of your welder.

- **Cleaning:** Periodically clean the welder's exterior with a dry cloth. Ensure cooling vents are free from dust and debris.
- **Cable Inspection:** Regularly inspect all cables, connections, and torches for wear, damage, or loose connections. Replace damaged components immediately.
- **Storage:** Store the welder in a dry, clean environment, away from direct sunlight and extreme temperatures.

7. TROUBLESHOOTING

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

customer support.

Problem	Possible Cause	Solution
Welder does not power on.	No power supply; power switch off; faulty cable.	Check power outlet, ensure switch is ON, inspect power cord.
No arc or weak arc.	Poor ground connection; incorrect current setting; worn electrode/contact tip.	Ensure good ground, adjust current, replace consumables.
Wire feed issues (MIG).	Kinked wire; clogged liner; incorrect tension; wrong contact tip size.	Check wire path, clean liner, adjust tension, use correct tip.
Overheating/Thermal Protection.	Exceeded duty cycle; blocked ventilation.	Allow welder to cool down, clear vents, reduce welding time.

8. SPECIFICATIONS

Detailed technical specifications for the PUWU FLUX 135A 110V 3-in-1 MIG Welder.



Figure 8.1: Welding Parameters for FLUX-135 PRO.

Feature	Detail
Model Number	TK-FLUX-135PRO
Input Voltage	110V
Welding Current	135A (Max)
Welding Processes	Flux Core MIG, Lift TIG, Stick (MMA)
Technology	IGBT Inverter
Display	LED Digital Display
Safety Features	Thermal Protection, Overcurrent Protection, VRD, Anti-Stick
Dimensions (L x W x H)	10.35" x 5.56" x 5.98" (approx.)
Weight	7.38 lbs (approx.)



Figure 8.2: Dimensions and weight of the FLUX-135 PRO welder.

9. WARRANTY AND CUSTOMER SUPPORT

For warranty information, technical assistance, or to purchase replacement parts, please contact PUWU customer support. Refer to the contact details provided with your product packaging or visit the official PUWU website.

Online Resources: For additional tips, tutorials, and FAQs, visit the PUWU official website or search for "PUWU FLUX-135 PRO" online.

