DEWALT®



DXWDMMA220IEC DXWDMMA260IEC

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WARNING

ELECTRIC SHOCK can kill. Have an electrician install and service this equipment. Turn the input power off at the fuse box, disconnect supply lines and allow machine to sit for five minutes minimum to allow the power capacitors to discharge before working inside this equipment. Do not touch electrically hot parts. WARNING. Do not open this machine and do not introduce anything into its openings. Power supply must be disconnected from the machine before each maintenance and service. After each repair, perform proper tests to ensure safety.

CAUTION

The power supply must be disconnected from the machine before each maintenance and service. Always use gloves in compliance with the safety standards. Repair and maintenance must be carried out by qualified persons.

CUSTOMER SERVICE

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SAFETY INFORMATION

General Welding Safety

The Workshop Environment

Housekeeping is extremely important to avoid injury from slips, trips and falls, damage to equipment and fire. The work area should be kept clean and tidy at all times. Combustible materials must not be discarded or stored in the vicinity of the welding area.

Avoid using your welder in the vicinity of:

a) other supply cables, control cables, signalling and telephone cables; above, below and adjacent to the welding equipment;

b) radio and television transmitters and receivers;

c) computer and other control equipment;

d) safety critical equipment, e.g. guarding of industrial equipment;

e) pacemakers and hearing aids etc.;

f) equipment used for calibration or measurement;

g) other equipment in the environment. The user shall ensure that other equipment being used in the environment is compatible. This may require additional protection measures;

It may be possible to avoid the above by changing the time of day that welding or other activities are to be carried out.

The size of the surrounding area to be considered will depend on the structure of the building and other activities that are taking place. The surrounding area may extend beyond the boundaries of the premises.

Electrical Safety



Electric Shock Can Kill. Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

1. Do not touch live electrical parts.
2. Wear dry, hole-free insulating gloves and body protection.
3. Insulate yourself from work and ground using dry insulating mats or covers.
4. Disconnect input power or stop engine before installing or servicing this equipment. Lock input power disconnect switch open, or remove line fuses so power cannot be turned on accidentally.
5. Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
6. Turn off all equipment when not in use. Disconnect power to equipment if it will be left unattended or out of service.
7. Use fully insulated electrode holders. Never dip holder in water to cool it or lay it down on the ground or the work surface. Do not touch holders connected to two welding machines at the same time or touch other people with the holder or electrode.
8. Do not use worn, damaged, undersized, or poorly spliced cables.
9. Do not wrap cables around your body.
10. Ground the workpiece to a good electrical (earth) ground.
11. Do not touch electrode while in contact with the work (ground) circuit.
12. Use only well-maintained equipment. Repair or replace damaged parts at once.
13. In confined spaces or damp locations, do not use a welder with AC output unless it is equipped with a voltage reducer. Use equipment with DC output.
14. Wear a safety harness to prevent falling if working above floor level.
15. Keep all panels and covers securely in place.

SAFETY INFORMATION

Shock Prevention
Exposed live conductors or other bare metal in the welding circuit, or in unearthed, electrically-LIVE equipment can fatally shock a person whose body becomes a conductor. DO NOT STAND, SIT, LIE, LEAN ON, OR TOUCH a wet surface when welding, without suitable protection.

Protection for Wearers of Pacemakers
Magnetic fields from high currents can affect pacemaker operation. Persons wearing electronic life support equipment (pacemaker) should consult with their doctor before going near arc welding, gouging, or spot welding operations.

To Prevent Against Shock
Keep body and clothing dry. Never work in damp area without adequate insulation against electrical shock. Stay on a dry duckboard, or rubber mat when dampness or sweat can not be avoided. Sweat, sea water, or moisture between body and an electrically LIVE part - or earthed metal - reduces the body surface electrical resistance, enabling dangerous and possibly lethal currents to flow through the body.

Earthing the Equipment
When arc welding equipment is earthed according to the National Electrical Code, and the workpiece is earthed, a voltage may exist between the electrode and any conducting object.

Examples of conducting objects include, but are not limited to, buildings, electrical tools, work benches, welding power source cases, workpieces, etc.

Never touch the electrode and any metal object unless the welding power source is off. When installing, connect the frames of each unit such as welding power source, control, work table, and water circulator to the building earth.

Conductors must be adequate to carry earth currents safely. Equipment made electrically LIVE by stray current may shock, possibly fatally. Do NOT EARTH to electrical conduit, or to a pipe carrying ANY gas or a flammable liquid such as oil or fuel.

Electrode Holders
Fully insulated electrode holders should be used. Do NOT use holders with protruding screws or with any form of damage.

Connectors
Fully insulated lock-type connectors should be used to join welding cable.

Cables
Frequently inspect cables for wear, cracks and damage. IMMEDIATELY REPLACE those with excessively worn or damaged insulation to avoid possibly lethal shock from bared cable. Cables with damaged areas may be taped to give resistance equivalent to original cable. Keep cable dry, free of oil and grease, and protected from hot metal and sparks.

Terminals And Other Exposed Parts
Terminals and other exposed parts of electrical units should have insulating covers secured before operation.

Electrode
Equipment With Output On/Off Control (Contactor)
Welding power sources for use with the gas metal arc welding, gas tungsten arc welding and similar processes normally are equipped with devices that permit on/off control of the welding power output. When so equipped the electrode wire becomes electrically LIVE when the power source switch is ON and welding gun switch is closed. Never touch the electrode wire or any conducting object in contact with the electrode circuit unless the welding power source is off.

Equipment Without Output On/Off Control (No Contactor)
Welding power sources used with shielded metal arc welding and similar processes may not be equipped with welding power output on/off control devices. With such equipment the electrode is electrically LIVE when the power switch is turned ON. Never touch the electrode unless the welding power source is off.

SAFETY INFORMATION

Changing Electrodes
The electrode holder should be isolated when changing the electrode, where a work piece is earthed. If the electrode is changed without isolating the electrode holder, the welder is relying on the insulation properties of the glove to avert shock from the OCV (Open Circuit Voltage) which can be 80V between the electrode and earth. If the glove is wet, the electrode a bad insulator or the welder in contact with a conductive surface, one or more of these layers of insulation may be ineffective.

Safety Devices
Safety devices such as interlocks and circuit breakers should not be disconnected or shunted out. Before installation, inspection, or service of equipment, shut OFF all power and remove line fuses (or lock or red-tag switches) to prevent accidental turning ON of power. Do not open power circuit or change polarity while welding. If, in an emergency, it must be disconnected, guard against shock burns, or flash from switch arcing.

Always shut OFF and disconnect all power to equipment. Power disconnect switch must be available near the welding power source.

Checking the Equipment
Check that the equipment is suitable for the operation and connected in accordance with the manufacturer's recommendations. The welder is responsible for checking the equipment (cable, electrode holder and coupling devices) daily for damage and defects. All external connections should be clean and tight and checked each time a reconnection is made. The welding return clamp should be connected directly to the work piece, as close as possible to the point of welding or to the metal work bench on which the work piece is placed. Any damaged or defective parts must be replaced before continuing the welding operation.

Fumes And Gases



The welding process vapourises metals, and anything that is resting on the surface. This gives rise to fumes, which is condensed fine particulate material. The fume is mostly oxides of the metals, including any alloying elements, but it also contains gases produced in the arc, such as ozone or oxides of nitrogen, and decomposition products from any paint or coating which was on the metal surface. The nature and quantity of this fume depends critically upon the welding process, the materials and the welding parameters.

Severe discomfort, illness or death can result from fumes, vapours, heat, or oxygen enrichment or depletion that welding (or cutting) may produce. Prevent them with adequate ventilation. NEVER ventilate with oxygen. Lead, cadmium, zinc, mercury and beryllium, bearing materials, when welded (or cut) may produce harmful concentrations of toxic fumes. Adequate local exhaust ventilation must be used, or each person in the area as well as the operator must wear an airsupplied respirator. For beryllium, both must be used. Metals coated with or containing materials that emit toxic fumes should not be heated unless coating is removed from the work surface, the area is well ventilated, or the operator wears an air-supplied respirator. Work in a confined space only while it is being ventilated and, if necessary, while wearing an air-supplied respirator. Vapours from chlorinated solvents can be decomposed by the heat of the arc (or flame) to form PHOSGENE, a highly toxic gas, and other lung and eye irritating products. The ultraviolet (radiant) energy of the arc can also decompose trichloroethylene and perchloroethylene vapours to form phosgene. DO NOT WELD or cut where solvent vapours can be drawn into the welding or cutting atmosphere or where the radiant energy can penetrate to atmospheres containing even minute amounts of trichloroethylene or perchloroethylene.

1. Keep your head out of the fumes. Do not breath the fumes.
2. If inside, ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.
3. If ventilation is poor, use an approved air-supplied respirator.
4. Read the Material Safety Data Sheets (MSDSs) and the manufacturer’s instruction for metals, consumables, coatings, and cleaners.

SAFETY INFORMATION

5. Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator.

   Shielding gases used for welding can displace air causing injury or death. Be sure the breathing air is safe.

6. Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.

7. Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and if necessary, while wearing an airsupplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.

Noise



Welding environments are frequently noisy as other operations such as grinding, etc. may also be taking place. Some operations, such a de-slagging may take the noise up to such a level where it will damage hearing. In such cases hearing protection must be used.

Fire and Explosion Prevention



Causes of fire and explosion are:

1) combustibles reached by the arc, flame, flying sparks, hot slag or heated material;

2) misuse of compressed gases and cylinders;

3) short circuits.

BE AWARE THAT flying sparks or falling slag can pass through cracks, along pipes, through windows or doors, and through wall or floor openings, out of sight of the goggled operator. Sparks and slag can fly 10M.

To prevent fires and explosion: keep equipment clean and operable, free of oil, grease, and (in electrical parts) of metallic particles that can cause short circuits.

If combustibles are in area, do NOT weld or cut. Move the work if practicable, to an area free of combustibles.

Avoid paint spray rooms, dip tanks, storage areas, ventilators. If the work cannot be moved, move combustibles at least 10M, away out of reach of sparks and heat; or protect against ignition with suitable and snug fitting, fire-resistant covers or shields.

Walls, ceilings, and floor near work should be protected by heat resistant covers or shields. Fire watcher must be standing by with suitable fire extinguishing equipment during and for some time after welding or cutting if:

a) appreciable combustibles (including building construction) are within 10m.

b) appreciable combustibles are further than 10m but can be ignited by sparks.

c) openings (concealed or visible) in floors or walls within 10m can expose combustibles to sparks.

d) combustibles adjacent to walls, ceilings, roofs or metal partitions can be ignited by radiant or conducted heat.

After work is done, check that area is free of sparks, glowing embers, and flames.

An empty container that held combustibles, or that can produce flammable or toxic vapours when heated, must never be welded on or cut, unless container has first been cleaned. This includes a thorough steam or caustic cleaning (or a solvent or water washing, depending on the combustible's solubility) followed by purging and inerting with nitrogen or carbon dioxide, and using protective equipment.

Water filling just below working level may substitute for inerting.

A container with unknown contents should be cleaned (see paragraph above), do NOT depend on sense of smell or sight to determine if it is safe to weld or cut.

Hollow castings or containers must be vented before welding or cutting - they can explode.

In explosive atmospheres, never weld or cut where the air may contain flammable dust, gas, or liquid vapours.

SAFETY INFORMATION

Cylinders Can Explode If Damaged
Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

1. Protect compressed gas cylinders from excessive heat, mechanical shocks, and arcs.
2. Install and secure cylinders in an upright position by chaining them to a stationary support or equipment cylinder rack to prevent falling or tipping.
3. Keep cylinders away from any welding or other electrical circuits.
4. Never allow a welding electrode to touch any cylinder.
5. Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
6. Turn face away from valve outlet when opening cylinder valve.
7. Keep protective cap in place over valve except when cylinder is in use or connected for use.

Welding Can Cause Fire Or Injury



Sparks and spatter fly off from the welding arc. The flying sparks and hot metal, weld spatter, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode or welding wire to metal objects can cause sparks, overheating, or fire.

1. Protect yourself and others from flying sparks and hot metal.
2. Do not weld where flying sparks can strike flammable material.
3. Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
4. Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
5. Watch for fire, and keep a fire extinguisher nearby.
6. Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
7. Do not weld on closed containers such as tanks or drums.
8. Connect work cable to the work as close to the welding area as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock and fire hazards.
9. Do not use welder to thaw frozen pipes.
10. Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
11. When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.

Moving Parts Can Cause Inury



Moving parts, such as fans, rotors, and belts can cut fingers and hands and catch loose clothing.

1. Keep all doors, panels, covers, and guards closed and securely in place.
2. Stop engine before installing or connecting unit.
3. Have only qualified people remove guards or covers for maintenance and troubleshooting as necessary.
4. To prevent accidental starting during servicing, disconnect negative (-) battery cable from battery.
5. Keep hands, hair, loose clothing, and tools away from moving parts.
6. Reinstall panels or guards and close doors when servicing is finished and before starting engine.

SAFETY INFORMATION

Sparks Can Cause Battery Gases To Explode



SPARKS can cause BATTERY GASES TO EXPLODE; BATTERY ACID can burn eyes and skin. Batteries contain acid and generate explosive gases.

1. Always wear a face shield when working on a battery.
2. Stop engine before disconnecting or connecting battery cables.
3. Do not allow tools to cause sparks when working on a battery.
4. Do not use welder to charge batteries or jump start vehicles.
5. Observe correct polarity (+ and –) on batteries.

Flying Sparks Can Cause Injury



FLYING SPARKS AND HOT METAL can cause injury.

Chipping and grinding cause flying metal.

As welds cool, they can throw off slag.

1. Wear approved face shield or safety goggles. Side shields recommended.
2. Wear proper body protection to protect skin.

Steam And Pressurised Hot Coolant Can Burn



STEAM AND PRESSURIZED HOT COOLANT can burn face, eyes, and skin.

The coolant in the radiator can be very hot and under pressure.

1. Do not remove radiator cap when engine is hot. Allow engine to cool.
2. Wear gloves and put a rag over cap area when removing cap.
3. Allow pressure to escape before completely removing cap.

Falling Unit Can Cause Injury



1. Lift unit with handle on top of case.
2. Use handcart or similar device of adequate capacity.
3. If using a fork lift vehicle, place and secure unit on a proper skid before transporting.

Optical Radiation



The welding process produces a large quantity of visible light, ultraviolet and infrared. Exposure to the radiation from an arc causes damage to the eyes (Arc Eye). For this reason, welders need to wear efficient eye protection, which is usually supplied in the form of a protective shield.

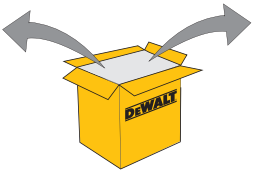
The precise choice of the shade of glass filter in these shields depends on the type of welding operation, since they vary in their light output.

ARC RAYS can burn eyes and skin; NOISE can damage hearing.

Arc rays from the welding process produce intense heat and strong ultraviolet rays that can burn eyes and skin. Noise from some processes can damage hearing.

1. Wear a welding helmet fitted with a proper shade of filter (ANSI Z49.1) to protect your face and eyes when welding or watching.
2. Wear approved safety glasses. Side shields recommended. Never wear contact lenses while welding.
3. Use protective screens or barriers to protect others from flash and glare; warn others not to watch the arc.
4. Wear protective clothing made from durable, flame-resistant material (wool and leather) and foot protection.
5. Use approved ear plugs or ear muffs if noise level is high

INCLUSIONS



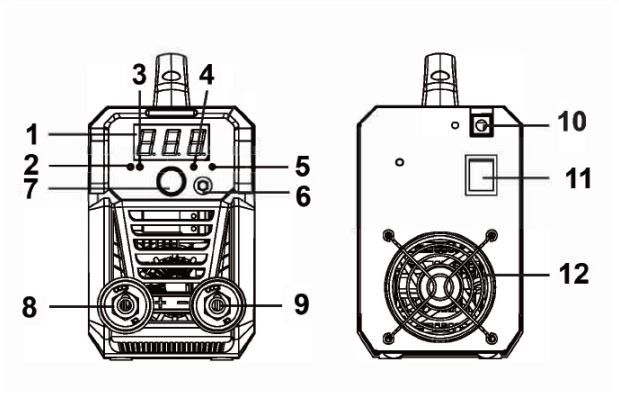
x1		Earth Clamp	300A @35% Connector 35-50
x1		Electrode Holder	200A@35% Connector 35-50
x1		Hammer Brush	

INTRODUCTION

The products DXWDMMA220IEC and DXWDMMA260IEC are inverter technology MMA welding machines. The welder is able to weld (MMA) rutile, basic, stainless steel and cast iron electrodes. The main features are:

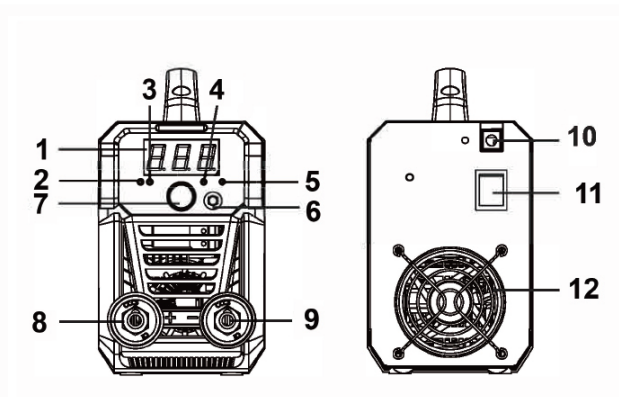
- MMA
- Lift TIG function available
- Built in arcforce and hotstart

MACHINE DESCRIPTION



DXWDMMA220IEC

1. Display
2. Power Indicator
3. Protection Indicator
4. MMA Mode
5. Lift TIG Mode
6. Mode Selection
7. Knob
8. Positive Connector
9. Negative Connector
10. Power Cord
11. Switch
12. Fan Guard

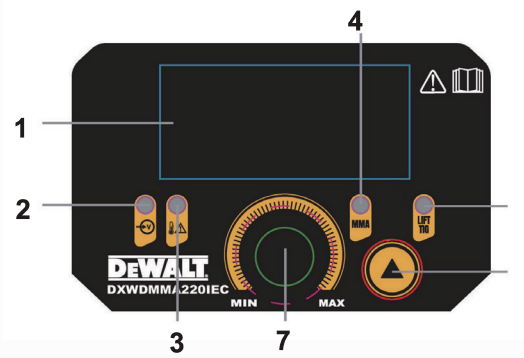


DXWDMMA260IEC

1. Display
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5. Lift TIG Mode
6. Mode Selection
7. Knob
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9. NegativeConnector
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11. Switch
12. Fan Guard

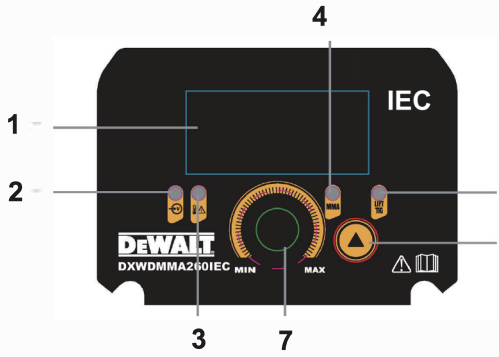
Control Panel

The machine functions are controlled by the control panel placed on the front panel. The control panel consists of 1 knob, 1 selection key, 1 display and indicators.



DXWDMMA220IEC

1. Display
2. Power indicator
3. Protection Indicator
4. MMA mode
5. Lift TIG mode
6. Mode Selection
7. Knob



DXWDMMA260IEC

1. Display
2. Power indicator
3. Protection Indicator
4. MMA mode
5. Lift TIG mode
6. Mode Selection
7. Knob

The installation must be made by trained personnel in compliance to the standard IEC 60974-9 and the current legislation. The input voltage must match the voltage indicated on the technical plate located on the product. When assembling a socket, make sure it is matching the input voltage and the technical data stated on the technical plate and that the yellow / green cord is connected to the ground pin. The socket to which is connected must have the ground connection. Lifting the machine must be carried out through the eyebolts present on the top of the product.

MMA WELDING

This welding machine also offers the possibility of welding coated electrodes.
Connect the ground clamp connector and that of the electrode holder clamp to the connectors of the device, choosing the polarity (direct or reverse) according to the coating of the electrodes (for further information, consult the data on the electrode packaging). Connect the ground clamp to the piece to be welded and clamp the electrode to the electrode holder clamp. Connect the power cable to the mains and turn on the welding machine using on/off switch on the rear panel. Select MMA welding mode (4) using the key (7) and set the welding current (8) according to the type of electrode selected. As soon as the MMA function is activated, the no-load voltage is present between the output poles (indicated on the data label).
The no-load voltage can be reduced to 9V for safety reasons by selecting the MMA VRD function.

Lift TIG WELDING

LIFT-TIG function can be activated via selecting Lift TIG function (6) using the key (7). TIG DC welding can be started without HF arc ignition. In sensitive environments where high frequency used for arc ignition can cause disturbance it is advisable to use this function. The arc now starts by touching the workpiece with tungsten electrode.

1. Plug the Ground Clamp cable into Positive Socket. Twist clockwise all the way to lock in place. Connect the Clamp to the work piece. Ensure that it has a good connection to the work piece and is connected on clean, bare metal (not rusty or painted.)
2. Plug the TIG torch into the Negative Socket. Connect the gas tube to gas cylinder.
   Remark: Use 100% argon gas when TIG welding.
3. Plug the machine to a properly grounded 220VAC outlet.
4. Turn on the Power Switch 'ON' on the back panel. The Power Indicator on the front panel will light up.
5. Toggle the welding mode switch on the front panel to TIG mode.
6. Fix the tungsten electrode so that it protrudes approximately 6mm from the torch nozzle.
   Remark: Ensure the TIG torch is safely away from all the conductive materials.
7. Turn on the gas at the gas regulator, then open the valve on the torch handle, check for gas flow and adjust flow rate as needed.
8. Initiate the weld arc with a lift arc technique.

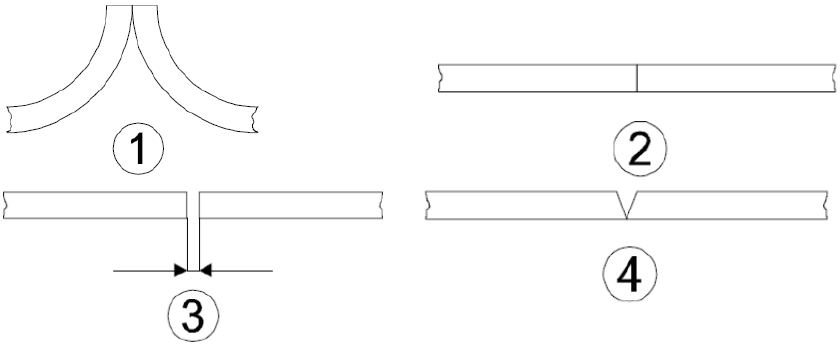
THERMAL PROTECTION

The thicker the material being welded, the greater the current required, therefore, the hotter the machine will become and the quicker it will cut out. When the windings reach performance temperature the cut out switch will operate and the digital display will show "E-3". After a few minutes the cut out switch will reset and the welder will be ready for use.
IMPORTANT - Thermostatic Protection (Duty Cycle)

This product has a rated duty cycle of 15%.The percentage represents the welding time in a 10 minute period for example 15% means that the welding time is 1.5 minutes with a rest time of 8.5 minutes in a ten minute period although the actual duty cycle will depend on the amperage used. If the Welding Power Supply is used for longer than the duty cycle or if you are welding using large welding rods you may experience a temporary current shut off. This is to protect the transformer inside the Welding Power Supply from overheating.

WELDING GUIDELINES

Welding joint forms



MAINTENANCE

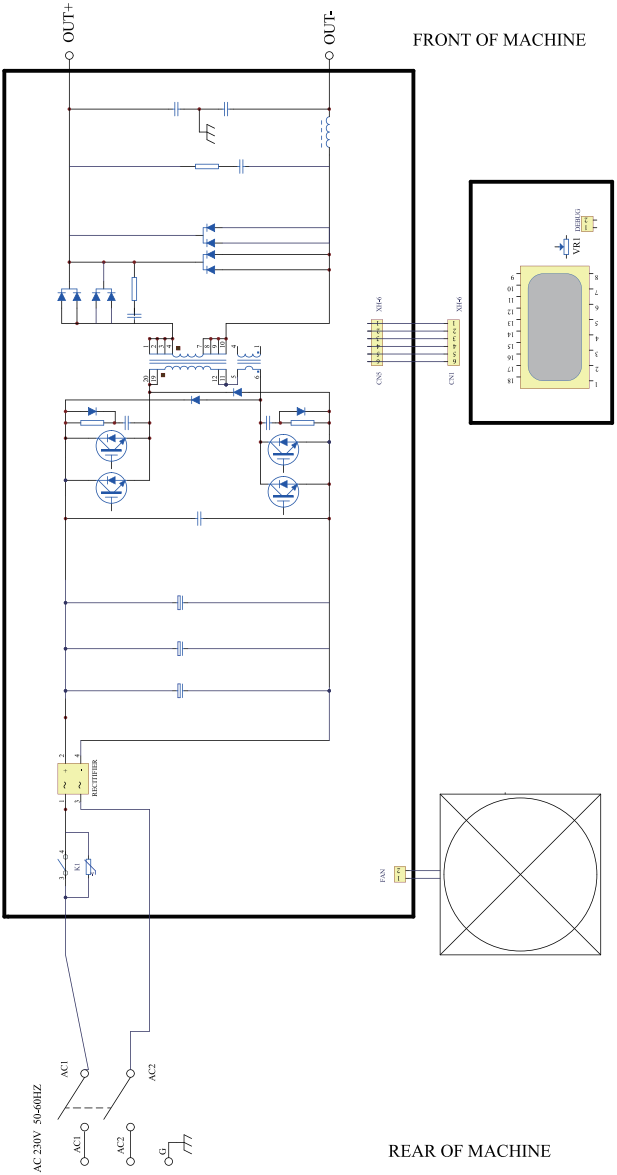
Refer all servicing to qualified personnel following the standard reference (IEC 60974-4).

TROUBLESHOOTING

Fault	Causes	Remedies
The machine suddenly stops working after long use (F01)	The machine is overheated due to excessive use and thermal protection intervened	Wait until the temperature LED turns off then welding can be restarted.
During the welding, the operator feels a tingling in the hand.	Defective electrical ground system	Check the plug and grounding system of the power supply.
Arc off	Poor contact between earth clamp and workpiece	-) Tighten the earth clamp and check the work piece surface -) Clean or replace electrode and gas nozzles
Your unit does not weld correctly.	Polarity error	Check the torch or electrode holder connection (+ or -)
TIG		
Unstable arc	- Incorrect tungsten electrode - Too high gas flow rate	- Use a tungsten electrode with the correct size - Reduce gas flow rate
The electrode melts	Polarity error	Check that the earth clamp is really connected to "+"

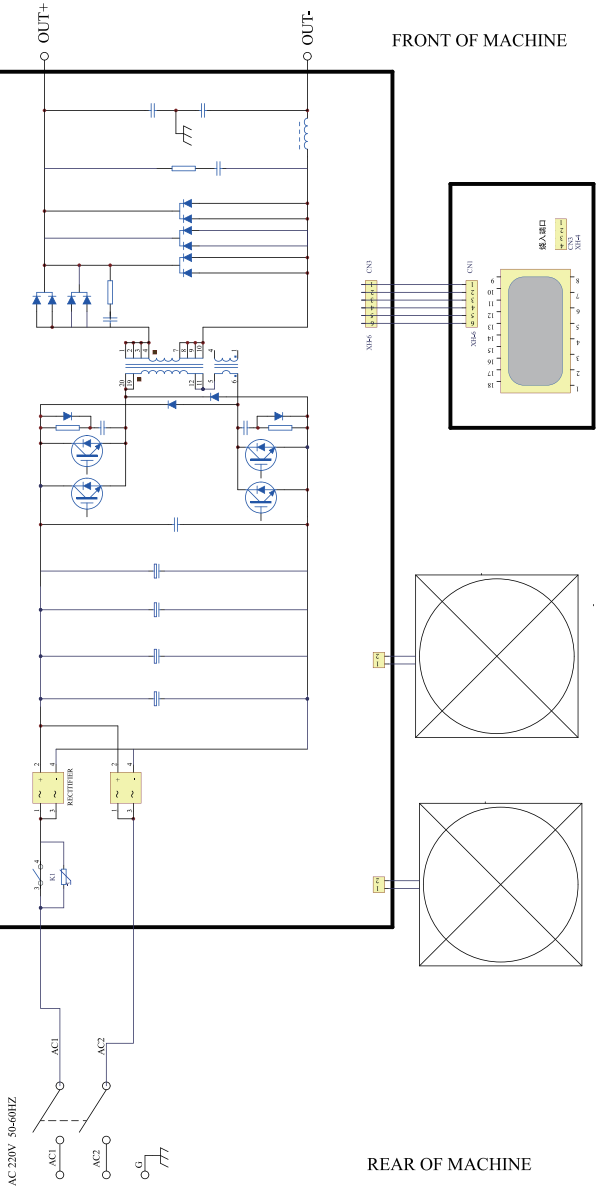
SCHEMATIC DIAGRAM

DXWDMMA220IEC



SCHEMATIC DIAGRAM

DXWDMMA260IEC

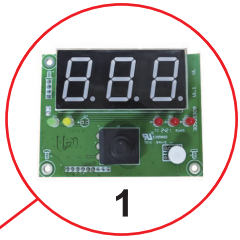


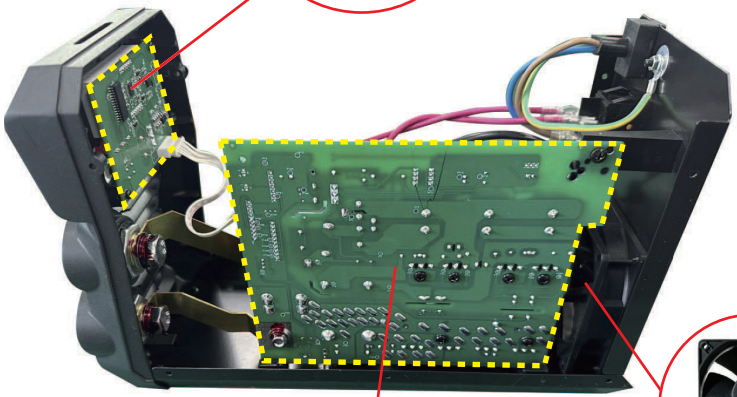
MAINTENANCE GUIDE

1. Don't take apart the machine without permission, it may damage the machine.
2. When moving the machine, make sure the power is off.
3. Do not block the fan of the running machine or touch the fan position. Check the ventilation before each use.
4. Always start by reading the manual for your specific welding equipment.
5. Regularly clean your welding equipment to remove any dirt, debris, or metal shavings that could clog up the machinery. Use a soft brush or compressed air to clean any cooling fans, vents, or filters.
6. Inspect the welding cables regularly for any damage or wear and tear. Replace any cables that show signs of damage, such as fraying, s, or cracks.
7. Check the consumables, such as tips, nozzles, and electrodes, regularly for wear and tear. Replace any consumables that are damaged or worn out. Using damaged consumables can negatively affect the quality of your welds.
8. Check the gas cylinder regularly for pressure and leaks. Replace the gas cylinder if it is empty or damaged.
9. When not in use, store your welding equipment in a clean, dry, and safe location. Keep the equipment covered to protect it from dust, moisture, and other environmental factors.
10. Check the welding machine output wiring specifications, firmness, and the cable connection screws for rust and oxidation.
11. Do not short-circuit the conductive nozzle and the workpiece. The short circuit will burn out the conductive nozzle. Once burned out, it needs to be replaced, otherwise it will affect the welding quality.

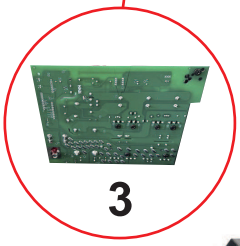
SPARE PARTS LIST

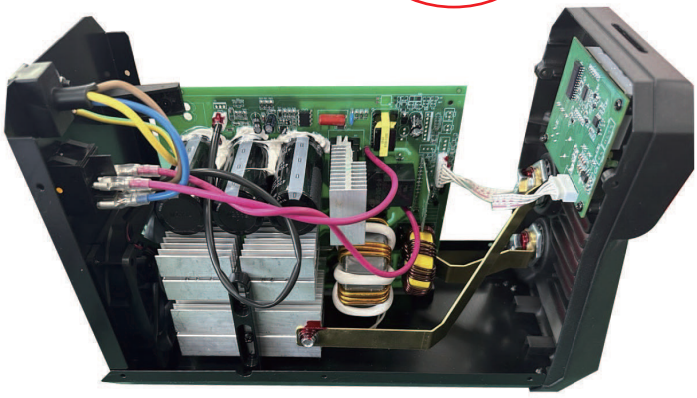
DXWDMMA220IEC

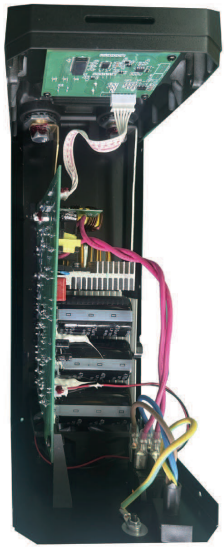










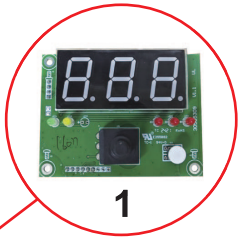


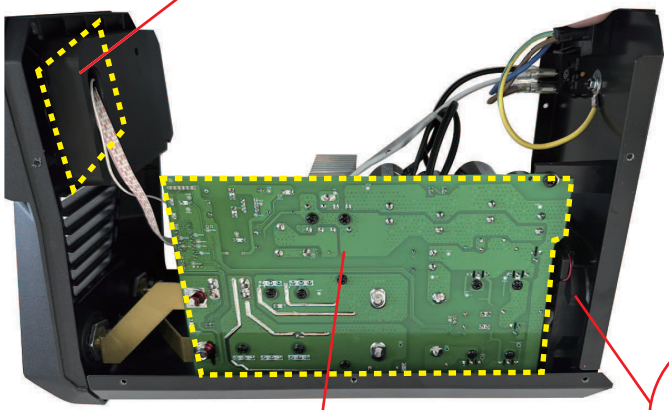

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DEWALT
PRO
INVERTER
WELDING
MMA220IEC


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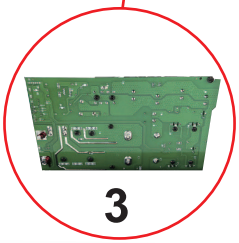
NO	DESC	PCS
1	Display Board	1
2	Fan	1
3	Main Board	1
4	Handle + plastic holder	1
5	Plastic front/rear panel	1
6	Welding current connector	1
7	Upper mantle	1
8	DX-SX panel	1
9	Supply cable	1
10	Power switch	1

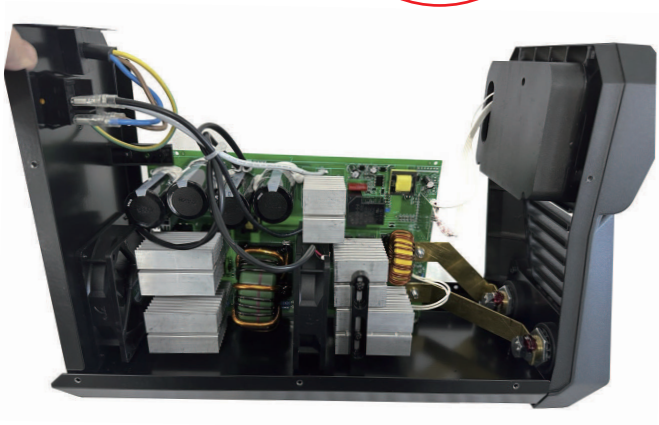
DXWDMMA260IEC





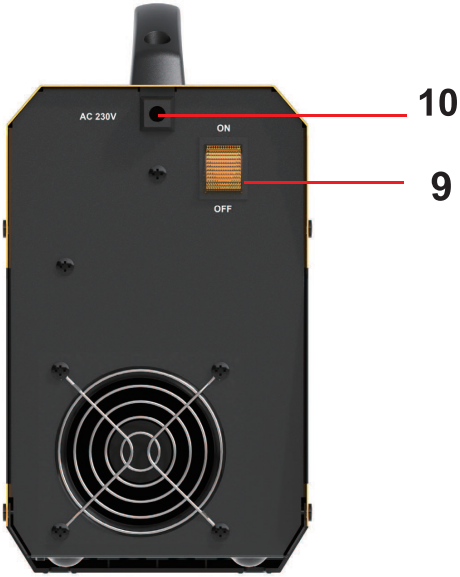









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NO	DESC	PCS
1	Display Board	1
2	Fan	1
3	Main Board	1
4	Handle + plastic holder	1
5	Plastic front/rear panel	1
6	Welding current connector	1
7	Upper mantle	1
8	DX-SX panel	1
9	Supply cable	1
10	Power switch	1

WELDING MACHINE TECHNICAL DATA

MOD	Ph	$I_{2\,max}$ [A] - X%	W x H x L [mm]	[Kg]
DXWDMMA220IEC	1~ 230V 50-60 Hz	160A-20%	132x240x320	3,7

MOD	Ph	$I_{2\,max}$ [A] - X%	W x H x L [mm]	[Kg]
DXWDMMA260IEC	1~ 230V 50-60 Hz	200A-20%	160x300x400	5,1

MMA WELDING

Electrode size [mm]	1,6	2,0	2,5	3,2	4,0	5,0
Rutile AWS E6013	30-55A	45-70A	50-100A	80-130A	120-200A	150-250A
BASIC AWS E7018	50-75A	60-100A	70-120A	110-150A	140-200A	190-260A
Stainless Steel AWS E308	25-35A	30-60A	40-80A	70-100A	90-140A	
Cast Iron AWS E307			40-80A	70-100A	80-140A	90-170A

TIG WELDING

Tungsten Φ mm	Welding Current (A)
1.6mm	15-130A
2.0mm	15-180A
2.4mm	15-200A
2.4mm	15-230A

MMA WELDING TROUBLESHOOTING

Problem	Possible Cause	Remedy
Welding current varying.	Control knob is set at a value that causes the welding current to vary excessively with the arc length.	Reduce the control knob until welding current is reasonably constant while prohibiting the electrode from sticking to the workpiece when you “dig” the electrode into the workpiece.
A gap is left by failure of the weld metal to fill the root of the weld.	Welding current too low. Electrode too large for joint. Insufficient gap.	Increase welding current. Use smaller diameter electrode. Allow wider gap.
Non-metallic particles are trapped in the weld metal.	Non-metallic particles may be trapped in undercut from previous run. Joint preparation too restricted. Irregular deposits allow slag to be trapped. Lack of penetration with slag trapped beneath weld bead. Rust or mill scale is preventing full fusion. Wrong electrode for position in which welding is done.	If a bad undercut is present clean slag bout and cover with a run from a smaller gauge electrode. Allow for adequate penetration and room for cleaning out the slag. If very bad, chip or grind out irregularities. Use smaller electrode with sufficient current to give adequate penetration. Use suitable tools to remove all slag from corners. Clean joint before welding. Use electrodes designed for position in which welding is done, otherwise proper control of slag is difficult.
A groove has been formed in the base metal adjacent to the toe of a weld and has not been filled by the weld metal (undercut).	Welding current is too high. Welding arc is too long. Angle of the electrode is incorrect. Joint preparation does not allow correct electrode angle. Electrode too large for joint. Insufficient deposit time at edge of weave.	Reduce welding current. Reduce the length of the welding arc. Electrode should not be inclined less than 45° to the vertical face. Allow more room in joint for manipulation of the electrode. Use smaller gauge electrode. Pause for a moment at edge of weave to allow weld metal buildup.

MMA WELDING TROUBLESHOOTING

Problem	Possible Cause	Remedy
Portions of the weld run do not fuse to the surface of the metal or edge of the joint.	Small electrodes used on heavy cold plate.	Use larger electrodes and preheat the plate.
	Welding current is too low.	Increase welding current.
	Wrong electrode angle.	Adjust angle so the welding arc is directed more into the base metal.
	Travel speed of electrode is too high.	Reduce travel speed of electrode.
	Scale or dirt on joint surface.	Clean surface before welding.
Gas pockets or voids in weld metal (porosity).	High levels of sulphur in steel.	Use an electrode that is designed for high sulphur steels.
	Electrodes are damp.	Dry electrodes before use.
	Welding current is too high.	Reduce welding current.
	Surface impurities such as oil, grease, paint, etc.	Clean joint before welding.
	Welding in a windy environment.	Shield the weld area from the wind.
	Electrode damaged ie. flux coating incomplete.	Discard damaged electrodes and only use electrodes with a complete flux coating.
Crack occurring in weld metal soon after solidification commences.	Rigidity of joint.	Redesign to relieve weld joint of severe stresses or use crack resistance electrodes.
	Insufficient throat thickness.	Travel slightly slower to allow greater build up in throat.
	Weld current is too high.	Decrease welding current.
Excessive spatter	Improper welding polarity	Make sure the electrode holder is plugged into the positive “+” output terminal.
	Long Arc Length.	Move the electrode closer into the weld joint.
	Weld current is too high.	Decrease welding current.

GENERAL TROUBLE SHOOTING

Problem	Possible Cause	Remedy
Turn on the machine, the fan doesn't work, and no welding output.	Check if the power switch is ON.	No input power.
Turn on the machine, the fan works, but the output current is unstable and can't be controlled by potentiometer (Regulator knob) when welding.	The current potentiometer fails. Loose contact.	Replace it. Check if any loose contact exists inside the machine. If any, reconnect.
Turn on the machine, the power is on, the fan works, but no welding output.	Loose contact. The overheating “F01” message is displayed on the digital display.	Check if any loose contact exists inside the machine. If any, reconnect. Open circuit or loose contact occurs at the joint of output terminal. The machine is under over-heating protection status. It can recover automatically after the welding machine is cooled. Check if the thermal switch is ok. Replace it if damaged. Check if the thermal switch is loosely connected, and reconnect it if necessary.
The electrode holder becomes very hot.	The rated current of the electrode holder is smaller than its actual working current.	Replace it with a bigger rated current.

EXTENDED PRODUCERS' RESPONSIBILITY

This product complies with obligations for producers of the Electrical & Electronic Equipment category EETW6 under India E-Waste (Management) Rules, 2022.

In case of Any Queries & Service Requirements please contact –

Toll Free Number : 1800 309 4535
WhatsApp Number : +91 78457 35301

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