Wolf®

MIG140X COMBINATION WELDER

CE

ORIGINAL INSTRUCTIONS

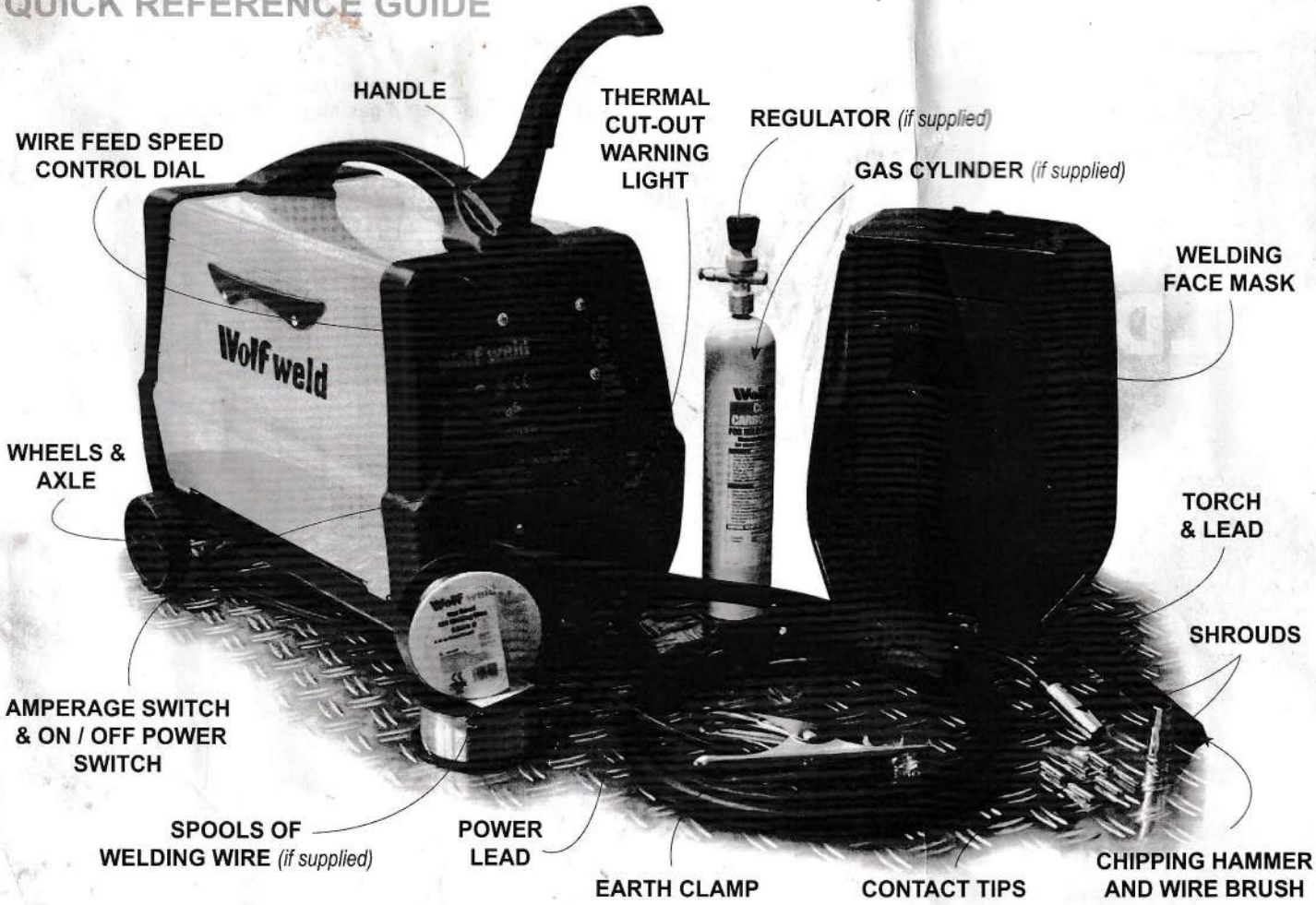
USER'S MANUAL

TECHNICAL SUPPORT:
0330 123 0001

WARNING! For your own safety please read this safety & operating manual carefully before operating this product.

NOTE! Study your Welder and be familiar with its parts.

QUICK REFERENCE GUIDE



CONTENT

ABOUT THIS MANUAL

This manual has been designed to help you assemble, use and maintain your Welder with the minimum of trouble. The manual contains all the information you will need, as well as some other information that you may find useful.

If you have any difficulty finding the information you need, have a look to the left at the contents page and you can also use the **'QUICK REFERENCE GUIDE'** on page 2 to assist you. If you still have unanswered questions please contact our Technical & Customer Care Team on:

0330 123 0001

Alternitively talk to an expert on our website using the live chat facility. The fast and effective way of getting the information you're looking for, go to - **www.ukhs.tv**

WARNING! These points are extremely important and should be read, understood and implemented before attempting to use your Welder. Failure to follow these instructions could result in serious injury or even death.

IMPORTANT! These points are also very important and should be read and understood before using your Welder.

NOTE! These points should also be read and understood as the information may be useful to you.

Important points and warnings have been highlighted throughout this manual. You are advised to read and follow the instructions given. Examples of what these warnings look like are on the left.

The points vary in importance and have been colour-coded accordingly.

RED WARNING! symbols are the most critical, followed by the YELLOW IMPORTANT! symbol and finally the GREEN NOTE symbol.

WARRANTY

Our commitment to quality also includes our service. Should you, contrary to expectations, experience defects due to material or manufacturing faults during private use within 2 years of the date of purchase we shall be liable for warranty in accordance with statutory warranty regulations, provided that: - The product was not put to any use other than the intended.- Was not overloaded. - Was used with the correct accessories. - Repairs were not carried out by any other than an authorised workshop. The warranty is only valid in connection with the original receipt. Please keep in a safe place.

The warranty does not affect your statutory rights. During the warranty period, defective products can be sent FREIGHT PREPAID to the authorised workshop address stated below. We will, at our discretion either repair or exchange the product in accordance with warranty legislation.

Please include the Proof of purchase when sending in your product for repair. After the warranty has expired you may still send defective products for repairs or service FREIGHT PREPAID to the address stated below. Repairs after warranty period are to be paid for in all cases. Ensure the product is sent well packed as no responsibility can be accepted for items lost or damaged in transit.

Should it be necessary for the product to be returned for any reason, it is the customer responsibility to thoroughly clean the product, removing all debris. A sanitising charge will be levied otherwise and no work carried out until the customer has agreed to pay this.

Authorised Workshop:
UK Home Shopping Service Centre
UKHS House,
Prospect Close,
Lowmoor Business Park,
Kirkby In Ashfield,
Nottinghamshire,
NG17 7LF

TECHNICAL AND CUSTOMER CARE INFORMATION

UKHS.tv has a dedicated UK based call centre that can assist you on assembly and answer any questions you have. We can also help with any spare parts you wish to purchase.

0330 123 0001

Monday to **Friday** from **8:00am - 6:00pm**
Saturday from **9:00am - 1:00pm**

To assist our team in helping to solve any problems you may be experiencing please have the Model Number as well as date of purchase information to hand.

It is recommended that you acquire genuine spares directly from us here at UKHS.tv.

Please send any returns to the following address:
UK Home Shopping Ltd, UKHS House, Prospect Close
Kirkby In Ashfield, Nottinghamshire, NG17 7LF

WEEE Producer Registration Number: WEE/FF3570RZ

WEEE (Waste Electrical & Electronic Equipment) Directive
As a responsible retailer of domestic electrical goods, UK Home Shopping Ltd are committed to ensuring that the impact of our equipment to the environment in minimal.
As well as using recycled and recyclable packaging material where we can, we want to ensure that our equipment is disposed of in the correct manner at the end of its useful life.
Please do not throw this product away in the normal household refuse. Any equipment sold by UK Home Shopping Ltd can be taken to your local council waste centre where the item will be disposed of correctly. Alternatively you may return the item to us at the address above, whereby we will dispose of the item safely and in an environmentally friendly way.

SAFETY INSTRUCTIONS

This manual is intended to serve as a guide to the safe and correct operation of your welder ensuring as far as possible safe working practice and reducing any possible injury to the operator.

Following the guidelines contained is this manual will help prevent any abuse of the equipment.

The manual in not intended to provide the operator with a knowledge and skill to become a fully profficient welder. We suggest a comprehensive course is undertaken to achieve this sort of level.

1. Check the MIG Welder and the loose parts and any accessories for transport damage. Save these instructions for future reference.
2. The unit must be correctly set up.
3. MIG welders are simple and safe to operate under normal circumstances. **DO NOT** operate in the rain or very damp conditions.
4. **DO NOT** attempt to lift the welder with the gas cylinder mounted on the rear platform. Always remove the gas cylinder before lifting or moving.
5. Only use the welder on a flat level surface
6. Operating the welder with the covers removed **MUST BE AVOIDED.**
7. Disconnect from the mains supply before under taking servicing or repairs.
8. Electrical repairs must only be carried out by a qualified or approved engineer and only with the welder disconnected from the power supply.

IF IN ANY DOUBT PLEASE SEEK OUR PROFESSIONAL ADVICE.

FIRE PRECAUTIONS

All flammable materials must be removed from the welding area.
DO NOT strike an Arc on or near the gas cylinder.
DO NOT attempt to weld fuel or gas containers unless adequate procedures have been taken to ensure that no vapour remains. Fuel tanks should be thoroughly steam cleaned inside and out before welding.

WELDING FUMES

Toxic gases are given off during the MIG welding process. Always use in a well ventilated area.

ARC GLARE

Always use a face shield or welding helmet fitted with the correct glass filter. Never use damaged or unsuitable safety equipment.

HEAT

Wear welding gloves at all times whilst welding. They will protect the hands from ultraviolet radiation and direct heat from the ARC. It is also recommended that overalls are worn.

ADDITIONAL PROTECTIVE CLOTHING

When welding at high settings wear a leather apron to protect the operator from spatter. When welding in an overhead position, a suitable welding hat should protect the head and neck. We recommend that you wear industrial footwear including steel toe caps.

DRESS PROPERLY

Do not wear loose clothing or jewellery; it can get caught in moving parts, present a fire risk or a shock hazard. Non - skid safety footwear is recommended.

SAFETY INSTRUCTIONS

IMPORTANT:

1. These units should never be exposed to rain or snow.
2. Do not use in wet or damp environments.
3. Do not use to thaw pipes.
4. These units should be connected to the mains supply through a circuit breaker with the following supply.

Model	Circuit Breaker
MIG140X Wolf	30A

STAY ALERT

Watch what you are doing. Use common sense. Do not operate the welder when tired or after taking alcohol or prescription / non-prescription drugs.

WARNING! The welder operates at high current and temperature. Hot molten sparks will be ejected away from the work piece. Always wear suitable safety glasses and other appropriate safety equipment (PPE) when operating, cleaning or servicing. Provide adequate ventilation as fumes can be dangerous. Do not operate this machine or its accessories near other people unless they are wearing appropriate safety equipment also. All persons in the work area should be made aware of all the safety issues relating to welding.

DANGER - Do not look at the welding ARC. Failure to use an appropriate welding mask will seriously damage your eyesight. Always ensure that safety and protective equipment is inspected prior to use and that it is undamaged. Never use the welder with a face shield having a cracked lense otherwise serious damage to your eyes may result.

BEFORE OPERATING THE WELDER, YOU MUST OBSERVE THE SAFETY NOTICE GIVEN BELOW.

PERSONAL SAFETY

Use Personal Protective Safety Equipment

Wear protective clothing, which is designed for and stated for use with MIG welding applications. Wear protective welding gloves and face/eye shields or masks to the correct standard for your welder. Avoid exposing your skin to ultra violet rays given off by welding. Appropriate approved footwear and headgear should be worn, for example on building works, when heavy weights or overhead working is involved.

DRESS PROPERLY

Do not wear loose clothing or jewellery; it can get caught in moving parts, present a fire risk or a shock hazard. Non - skid safety footwear is recommended.

OPERATIONAL SAFETY

What you **MUST NOT** do:

Do not allow routine to lead to mistakes.
Remember that a slight lack of concentration can result in serious injuries in a split second.

Do not use the welder on ladders.
Ensure the correct platforms are used.

Do not eat, drink or smoke in the work area.

Do not touch the work piece or torch and earth clamp.
Avoid direct contact with the welding circuit (work piece, torch and earth) as this presents a very high risk of electric shock. During operation the work piece, torch and earth clamp will become very hot. Even after use these will remain hot for some time. Avoid coming into contact with these. Do not leave flammable liquids or combustible materials near the welder or work piece.

Do not let children or pets in the work area.

Do not abuse the cables.
Never pull the welder by the electrical supply, clamp or torch cables.
Keep cables away from heat and sharp edges.
Do not touch the metal plug pins when connecting or removing the electrical plug.

Do not run the welder in damp conditions.
The welder should never be used in an area where it could be exposed to water or excessively damp conditions. Do not weld in the rain. Damp environments present a high shock hazard.

Do not use this machine if you or any person in the vicinity relies upon electrical or electronic devices for medical reasons.
The electromagnetic field generated by the welding process may interfere with the operation of the electrical or electronic equipment.
People with vital electrical or electronic devices (e.g. pace makers, respirators, etc.) should consult the doctor before entering the vicinity or area where this welding machine is being used and people with vital electrical or electronic devices should not use with this welding machine.

Do not operate the welder in a confined space.
The welder is required to operate in a good air space to aid cooling.

SAFETY INSTRUCTIONS

What you **MUST** do:

Keep the work area clean and provide the correct working conditions. MIG welding produces sparks, high temperature fused metal projectiles and fumes.

- Remove all flammable substances and materials from the work area.
- Provide adequate ventilation of facilities where welding takes place.
- Do not weld on container or pipes that hold or have held flammable liquids or gaseous combustibles (danger of explosions and/or fires) or on materials cleaned with chlorinated solvents or on varnished surfaces (danger of toxic fumes).
- Cluttered areas invite injuries. Make sure the area is clear of obstacles, which could cause you to trip and fall.

Always use personal protective equipment and a face mask.
Personal protective equipment and a suitable face mask must always be worn when welding.

Check your face mask for damage. Never use damaged safety equipment.

Always turn off at the on/off switch before unplugging from the mains.

Avoid unintentional Arcing of the welder.
When the welder is not in use turn the welder off at the mains. Live electrodes present a hazard, as they could arc against the earthed metal.

Using the welder.
Before using the welder, check every time that the cable connections are fully tightened and that there are no broken or worn parts.

Keep cables and clamps in good conditions.
Keep welding cables, torch and the earth clamp in good condition. Poor contact through the welding circuit caused by defective cables and clamps can be dangerous and produce poor welds.

WARNING! DO NOT look at the weld arc without the correct Personal Protective Equipment (PPE) eye protection. This could result in serious damage to the eyes.

WARNING! UV light emitted from the weld arc can cause serious damage to the skin. Personal Protective Equipment (PPE) should cover any and all exposed areas.

TECHNICAL SPECIFICATION

This smooth DC output welder offers both gas and no gas MIG welding, and is easily interchangeable between the two. With simple polarity changing (requiring no tools).

Technical Specification:

- Turbo fan cooled
- 30 amps - 135 amps welding current range
- 6 selectable power settings
- Smooth DC output current
- Non live torch
- Fully portable
- Operates from a 230v single phase supply

Wolf'weld COMBINATION GAS / NO GAS MIG 150 WELDER			Year of Manufacture: 2018						
			EN 60974-10-2014						
	U_0:40V	~50Hz	30A / 15.5V - 135A / 20.75V						
			X %	10	15	20	50	60	100
S	1~	V_{mm}=10.3m/min	1_2A	135	105	78	52	43	30
		D=0.6-0.9mm	U_2V	20.75	19.25	17.9	16.6	16.15	15.5
	U_1 :230V	$I_{1\,max}$= 26.45A		$I_{1\,eff}$ = 9.8A					
		H					IP21S		

INSTALLING THE WELDER

WARNING! We strongly recommend that a suitably qualified electrician installs this welder. For futher assistance please call our Technical Advisors on: 0330 123 0001.

Installation instructions for the qualified electrician.

The brown (Live) wire must be connected to the positive terminal and the blue (negative) wire must be connected to the negative terminal of the plug ensure that the yellow / green wire is connected to the earth terminal.

Ensure that your supply voltage corresponds to the voltage stated on the rating plate on the welder. The welder must be connected to an electrical supply capable of delivering L_1 maximum (as stated on the data plate, printed on top of the welder). For welding currents up to a maximum of 65 amps, a 13 amp domestic plug and fuse maybe used. When using the welder for prolonged periods below 65 amps a 230v industrial plug, socket and power supply must be used.

Above 65 amps welding current we advise the welder is wired directly through an isolator, to a 30 amp mains supply minimum.

Ensure the mains supply is protected with adequate mains fusing.

WARNING! Ensure you use adequate mains fusing to protect the welder.

IMPORTANT! For best welding results, we recommend that the welder is wired directly through an isolator, to a minimum of 30 amp or above mains supply.

PRE-OPERATION CHECKS

1. Ensure materials to be welded are clean and dry.
2. Ensure good, clean contact between earth clamp and material.
3. Ensure smooth passage of wire.
4. Ensure wire is no longer than 13mm from tip to work piece.
5. Ensure gas flow is adequate.
6. Ensure mains supply is suitable.
7. Adopt a comfortable welding position.
8. Test weld on a piece of scrap material to determine correct set-up for the job in hand.
9. Ensure no flamable material is in the area.
10. Ensure no people or animals are in the area when welding, this could result in them becoming victim of arc eye.

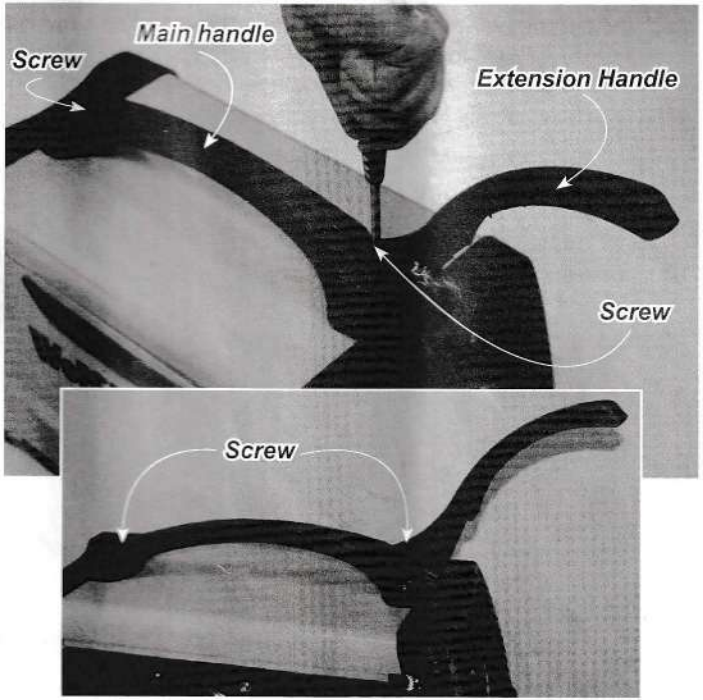
WARNING! DO NOT look at the weld arc without the correct Personal Protective Equipment (PPE) eye protection. This could result in serious damage to the eyes.

WARNING! UV light emitted from the weld arc can cause serious damage to the skin. Personal Protective Equipment (PPE) should cover any and all exposed areas.

ASSEMBLY

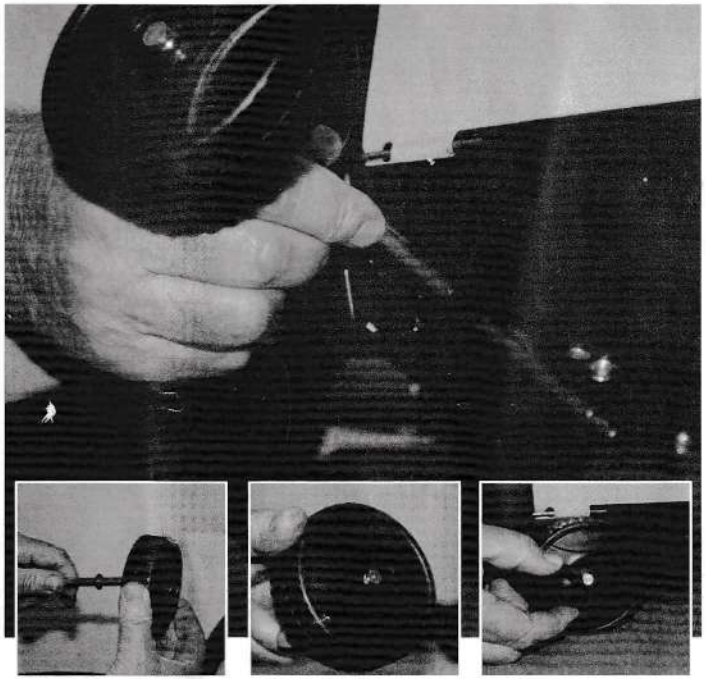
Fitting the Handle

Align the hole in the handle with the holes on the top of the welder and tighten the screws securely. Be careful not to cross the threads.



Fitting the Axle Bracket

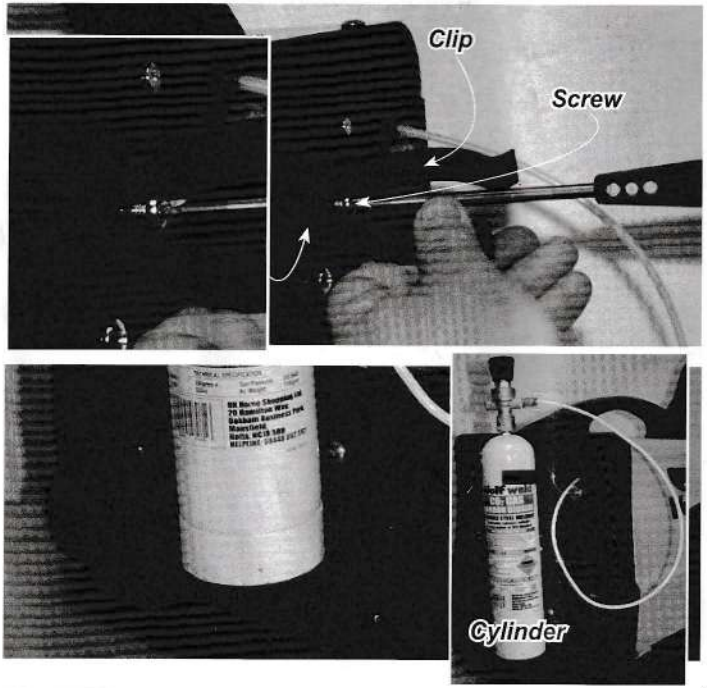
Fit one E-clip to the inner slot of the axle, then slide the wheel on to the axle and fit the outer E-clip. Slide the axle through the brackets on base of welder then repeat to fit the other wheel. When secured fit wheel caps.



ASSEMBLY

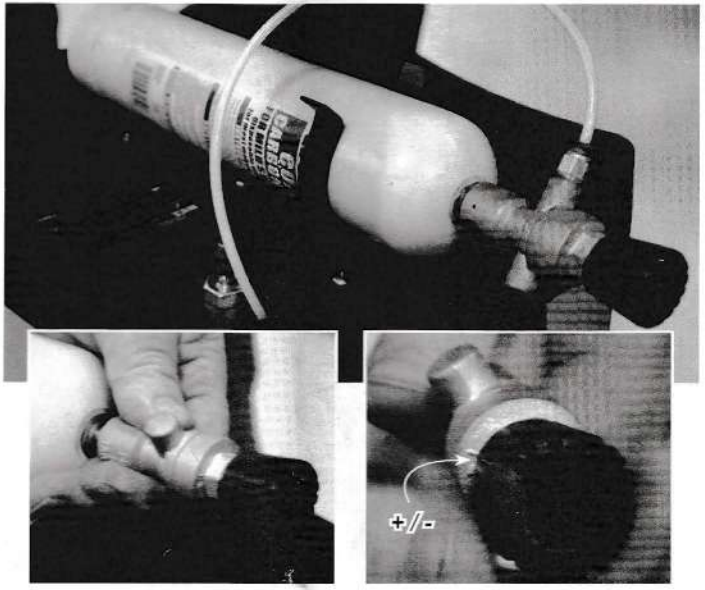
Fitting the Cylinder Brackets

Fit the cylinder clip bracket to the tapped hole at the rear of the welder. Fully tighten the screw until the bracket is secured.



Fitting the Regulator

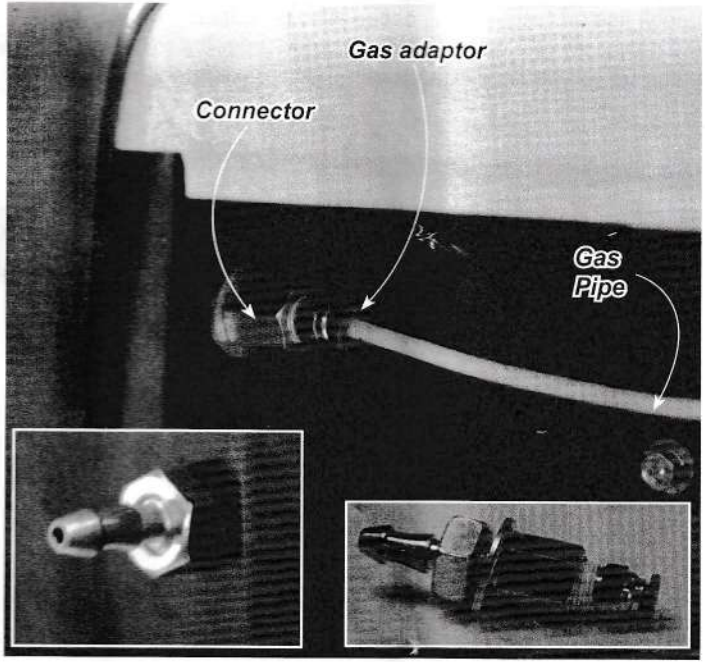
To fit the regulator to the cylinder ensure the regulator is fully closed by turning the adjusting wheel in the direction of the minus sign which is cast into the regulator body. Screw the regulator on to the cylinder valve in a clockwise direction when you reach the point at which the cylinder valve needle is depressed there will be a rush of escaping gas go past this point to seal the valve on to the cylinder. DO NOT over tighten as this could damage the neoprene seal.



OPERATION

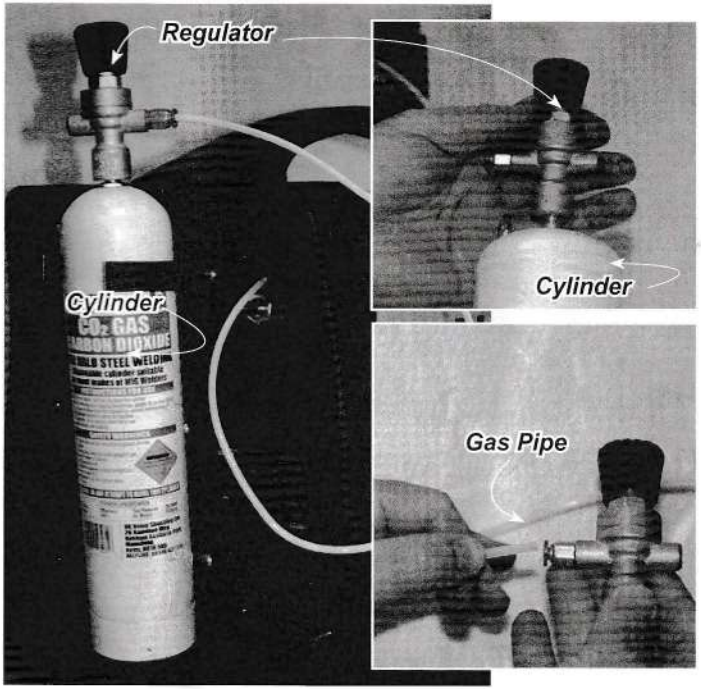
Industrial Gas Adaptor

The welder maybe used with an industrial gas cylinder and gauge set (not supplied). The gas feed pipe should be pushed into the gas adaptor and the gas hose pipe from the gauge set pushed on and clipped to the connector.



Mini Cylinder Gas Set-Up

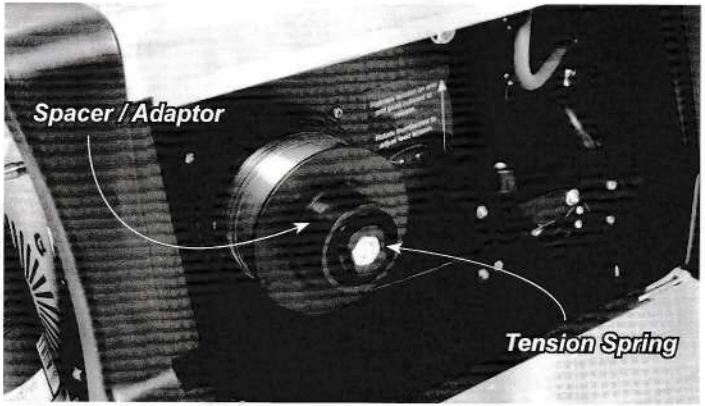
Push the gas hose into the gas adaptor on the regulator and attach the cylinder to the welder. To remove the pipe from the adaptor pull back on the blue collar and pull the pipe firmly.

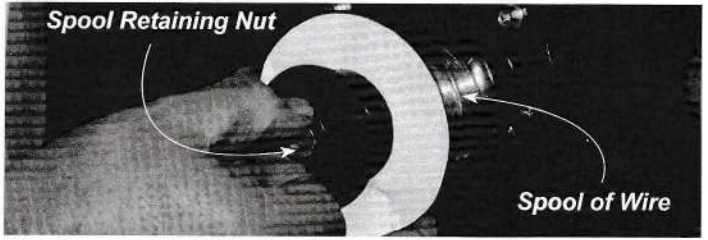


OPERATION

Fitting the Wire Spool

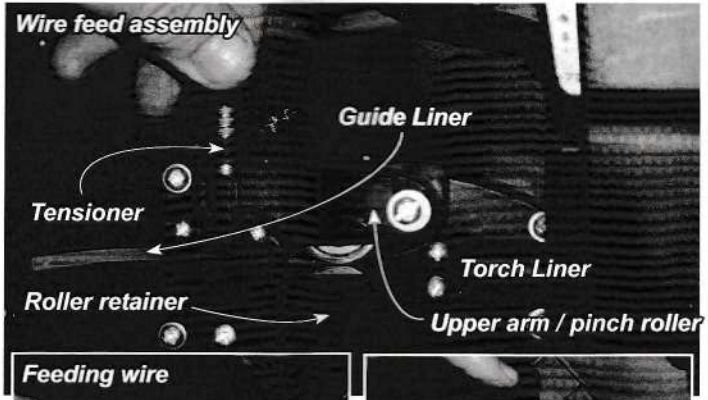
To fit the wire spool remove the nut, spring and spacer from the spool holder. Locate the spool on to the shaft ensuring the wire will feed from the bottom of the spool. Refit the spacer, spring and nut tighten sufficiently to allow the spool to turn but not free wheel.

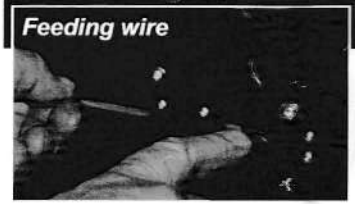




Loading the Wire

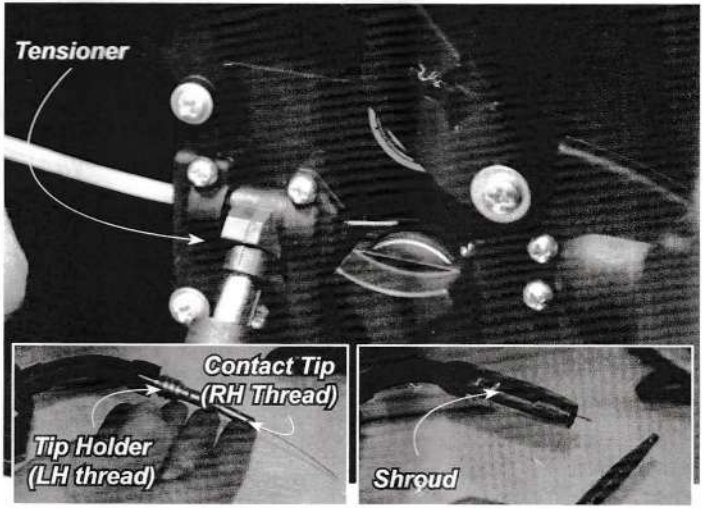
Select the correct groove on the drive roller to suit the welding wire being used (0.6mm, 0.8mm & 0.9mm Flux). Remove the roller retainer to show the roller. The position of the groove should be to the outside, replace the retainer. Undo the wire on the spool take great care to hold the wire on to the spool as it will naturally try to uncoil itself. (A mass of uncoiled wire is difficult to rewind). Feed the newly cut wire end into the guide liner over the roller upper arm in the up position in the torch liner for approximately 150mm (6").





Loading the Wire (continued).

The wire feed tensioner should be adjusted so that the pinch roller skids on the wire when the wire sticks or is stopped from passing through the end of the torch. Remove shroud and contact tip from the end of the torch set the wire feed speed to half way, set the amperage to position one switch on the machine. Keep the torch lead as straight as possible press the torch trigger and allow the wire to feed through the hose and torch and stop. Replace the contact tip over the wire and screw into the holder replace the shroud and cut back the wire to between 6 - 8mm from the end of the shroud.



Control Panel

Thermal overload warning light

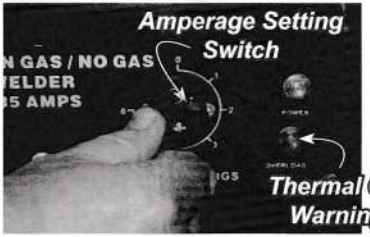
This will light up when the welder cuts out because the transformer is over heating which may be caused by long periods of welding above the duty cycle of the machine. i.e. at the lower setting of the welding amperage, 35 amps the welder will weld continuosly whilst at the top end of the welding amperage, 135 amps the welding cycle is 20% which is 2 minutes in 10 minutes.

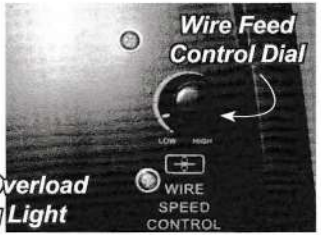
On / Off Switch & Amperage Setting Switch

Set the switch between 1 - 6 depending on the welding job.
0 = Off.

Wire Feed Control Dial

This allows you to trim the wire feed speed for a given amperage setting, the higher settings allow more wire through to the weld pool, the lower settings reduce the amount of wire to the weld pool.

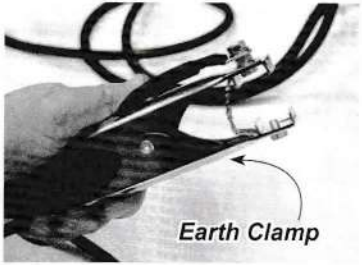




OPERATION

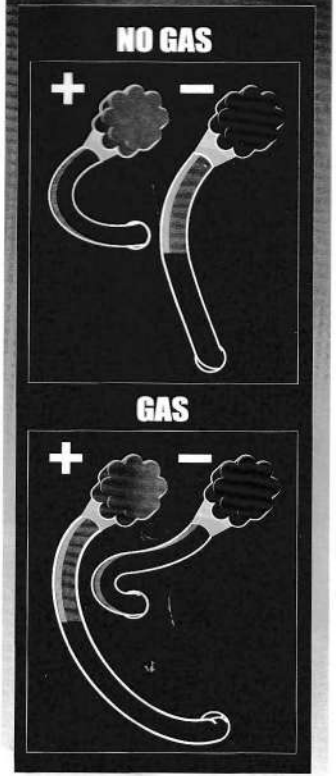
Earth Clamp & Lead

The earth clamp must be situated on the work piece in an area where bare metal is exposed. It is impossible to achieve a correct weld if paint, grease or rust is present.



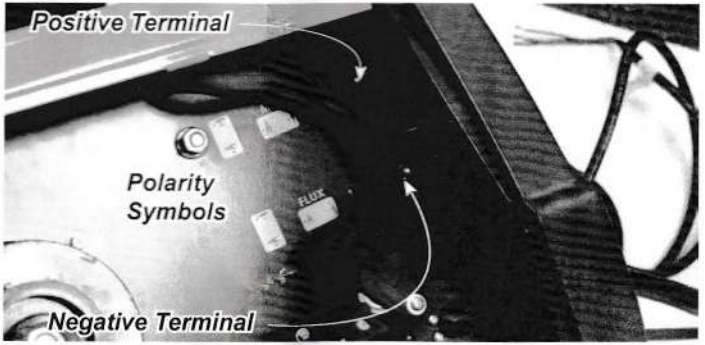
When carrying out welding on a motor vehicle always disconnect the battery and remove the fuel tank. Heavy corroded bodywork must be removed completely.

This diagram should help you when changing the polarity from Gas to No Gas.



Setting Polarity for Gas Welding

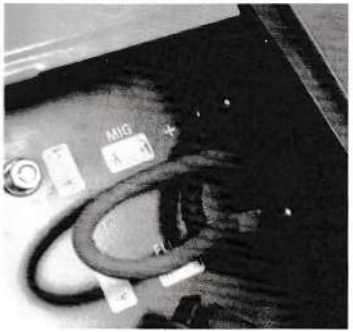
For gas welding the positive (+) torch lead needs to be positioned on the positive (+) red terminal. The earth clamp lead negative (-) to the black negative (-) terminal.



Setting Polarity for No Gas Welding (Fluxed Wire)

For no gas welding (Fluxed) the positive torch lead needs to be positioned on the negative black terminal. The earth clamp lead negative (-) to the red positive (+) terminal.

On this particular welder the negative earth clamp lead is thicker than the positive torch lead.



MAINTENANCE

Routine Maintenance

Keep the machine clean and tidy.

Store the machine in a dry environment.

Electrical repairs must only be carried out by a qualified or approved engineer.

Spray the torch trigger with a contact spray periodically, make sure the spray gets into the torch handle.

Welding cables must be regularly inspected. Burnt or damaged cables must be replaced, all connections must be good and tight.

The torch must be regularly inspected clean the contact tip and shroud removing any spatter that will eventually disrupt the arcing process and flow of gas.

The torch lead outer covering protects the cables and liner within and should be replaced with a new lead if outer cover is damaged or burnt.

Spraying the tip and shroud with an anti-spatter spray will reduce the build up of spatter.

Replace the tip periodically to maintain a good electrical contact between the tip and the wire.

To remove the contact tip support the contact tip holder and grip the contact tip and turn anti clockwise (normal right hand thread). The contact tip holder has a left hand thread and will naturally tighten if not supported and being made of brass can easily be damaged.

Blow clean dry air through the torch liner from time to time to ensure the wire passes freely through it.

Replace the liner periodically or when experiencing poor wire passage.

Whenever feeding the wire through the liner ensure the torch lead is straight to avoid the wire punching a hole through the liner.

During welding operations conserve gas by turning the handle wheel fully to minus and for long periods when not in use remove the regulator completely.

If the welder is not used for a long period remove the welding wire spool and store in a dry place.

MIG GAS VALVE FITTING NOTICE

Please not that before fitting the regulator onto the gas cylinder, check that the handle wheel of the regulator is turned fully off (this means the direction of the negative symbol - . Check the directional arrow on the brass part of the regulator showing the + and - direction.

Next, check that the clear washer is located around the activating pin in the threaded part of the regulator where it screws on to the gas cylinder.

When fitting the regulator, you will hear a hiss of gas escape through the relief hole near the bottom of the regulator. This is normal and does not mean that there is a problem. The gas which is released is intentionally being displaced during the making of the connection. As the regulator makes contact with the clear seal the leakage will stop.

DO NOT OVER TIGHTEN THE REGULATOR ON TO THE GAS CYLINDER.

Do not over tighten the reguator onto the gas cylinder or the clear washer will create a lock nut effect and there is a risk that the gas valve may be dislodged when unscrewing the regulator which will cause the cylinder to be thrust violently from your hand.
When removing regulators from gas cylinders always do so at arm's length. keep a watchful eye to ensure that the cylinder's gas valve is not disturbed. If you see the gas valve start to unscrew, it will be that the regulator has been over tightened.

Under this circumstance, you must retighten the regulator immediatley and discharge all the gas to the atmosphere by turning the regulator hand wheel to open (+) before re-attempting to remove the regulator.