



MMA INVERTER WELDER

Instruction Manual

MMA 135/ MMA 160



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GUARANTEE

We give our unreserved guarantee that the Inverter Welding and Cutting Power Source series comply with IEC60974 international safety standard.
Maintenance for one year since the date of purchase.

INTRODUCTION

This range of inverter welders is designed for semi-professional use, ideal for DIY enthusiasts and light users. The functions HOT START, ARC FORCE and ANTI-STICKING allow users to weld easily.

The MMA range promotes the following features:

- High efficiency and powerful switch design.
- Compact, handy and very light weight.
- Lower welding spatter and perfect arc stability.
- Air-cooling & overload protection.
- Can be used with all types of electrodes: rutils, basic, stainless steel and cast iron.

SAFETY

- You may be faced with dangers during the course of welding, so please read the manual carefully before commencing operation.
- Please use welding tools of high quality.
- Operators should be qualified for welding.

Electric-shock:

- Do not touch live electrical parts
- Check and be sure that the input power cable earth wire is properly connected to the earth in the mains input plug.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.

Fumes

- Avoid a prolonged period in the smoke
- When welding, make sure you are in a well-ventilated area to avoid breathing in the smoke.


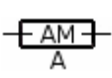

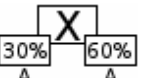
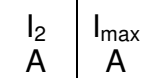


Arc-emission

- Wear suitable welding mask and clothing to protect your eyes and skin.
- Use a suitable screen or curtain.
- The welding splash may cause fire, so ensure that there are no flammable items near to the work place.

Noise

- Use approved earplugs or earmuffs if noise level is high.
- Warn others nearby about noise hazard.

TECHNICAL DATA

	 50/60Hz	 AM A	 Ø mm	U ₀	 30% A	 60% A	I ₂ A	I _{max} A	IP ₂₁		Size (cm)	 KG
MMA135	230V 1~	16	1.6 – 2.5	56	95	85	10 – 105	10 5	•	•	12X24X16	2.8
MMA160	230V 1~	16	1.6 – 3.2	56	135	100	10 – 135	13 5	•	•	12X24X16	3.1

INSTALLATION

- The input voltage should be AC230V ±15%
- If you use your own generator make sure the voltage of the generator is greater than welder's required voltage.

WORKING ENVIRONEMNT

1. Machine best suited for working in dry conditions: moisture level $\leq 80\%$
2. Best working temperature should be between 40°F
3. Avoid working in the sun or rain
4. Avoid working in the environment where there is much dust or corrosive gas.

OPERATION

1. Turn on the power switch, and the meter indicates the set current value, and the fan begins to spin.
2. Set welding current to required welding rod size.
3. Generally, the welding current of each rod is:

Φ 1.6: 90A;	Φ2.5: 110A;
Φ 3.2: 135A;	Φ4.0: 160A;
4. Turn switch to "OFF" position prior to adjusting the current on the panel board for different size rods.

TROUBLESHOOTING

The ON/ OFF switch is not lit	<ul style="list-style-type: none"> • Check the power to ensure the voltage is AC 230V $\pm 15\%$. • Check the fuse in the plug is in full working order
Main switch is ON but the yellow & Green light is OFF	<ul style="list-style-type: none"> • Make sure the voltage is AC230V $\pm 15\%$.
Main switch and the Green light is ON but the Yellow light is OFF	<ul style="list-style-type: none"> • Check the extension cable, the earth and the plug.

If you have any problems in setting up or operating, please first consult this manual.

If you are still having difficulties after reading this manual, please contact Inverter Fusion Ltd direct.



INVERTER FUSION LTD

PRODUCT WARRANTY

September 2010

This limited warranty supersedes all previous Inverter Fusion Limited warranties and applies to sales of Inverter Fusion Limited equipment in the UK.

Warranty

Subject to the following terms and conditions, Inverter Fusion Limited warrants to the original retail purchaser that new Inverter Fusion Limited equipment sold in the UK is free of defects in material and workmanship at the time of its despatch from Inverter Fusion Limited for the warranty period advertised for the product at the time of sale.

Within the warranty period as listed, Inverter Fusion Limited will repair or replace any warranted parts or components that fail due to such defects in material or workmanship, provided the warranty has been registered at the time of purchase.

Inverter Fusion Product Warranty shall not apply to:

- Consumable items and accessories supplied by Inverter Fusion Limited but manufactured by others. These items will be covered by the manufacturer's warranty, if any.
- Electrodes, contactors and relays.
- Equipment that has been modified or repaired in any way
- Equipment that has been improperly installed, misused, improperly operated, or used in a manner that does not comply with an industry standard.
- Equipment that has been used for a purpose outside the specifications for that equipment
- Equipment that has not been maintained in a condition that would make it suitable for use.
- Equipment which has been used in conjunction with parts or consumables which affect the equipment operation which are deemed by Inverter Fusion Ltd to be of inferior quality or no fit for that purpose

In the event of a valid warranty claim being made on any Inverter Fusion Limited product, the exclusive remedies shall be, at the discretion of Inverter Fusion Limited, either the repair or replacement of the product

To the extent permitted by Law, the remedies provided herein are the sole and exclusive remedies.

Inverter Fusion Limited liability under this warranty shall not exceed the cost of correcting the defect. In no event shall Inverter Fusion Limited be liable for direct, indirect, special, incidental or consequential damages (including loss of profit), whether based on contract, tort, or any other legal theory.

Any express warranty not provided herein and any implied warranty, guarantee, or representation as to the performance, and any remedy for breach of contract, tort or any other legal theory which, but for this provision, might arise by implication, operation of Law, Custom of Trade, or course of dealing, including and implied warranty or merchantability for a particular purpose, with respect to any and all equipment furnished by Inverter Fusion Limited, is excluded and disclaimed by Inverter Fusion Limited.

Warranty Registration

In order for any warranty to be valid, the Warranty Registration Card enclosed must be completed and returned at the time of purchase in order to register the warranty with Inverter Fusion Limited. Alternatively the warranty may be registered via the company's website www.inverterfusion.com

Warranty Claims Procedure

In the event of a claim, the claimant must first contact Inverter Fusion Limited for a warranty claim authorization number. Following this, the Warranty Claim form, as printed on the reverse side of this page should be completed with all the details as requested and forwarded to Inverter Fusion Limited at the address below along with the faulty product and a copy of the original purchase receipt. The claimant will be responsible for all carriage, insurance and transportation costs in returning the product to Inverter Fusion Limited.

Upon receipt and inspection of the product, if valid the product will be repaired or replaced at the discretion of Inverter Fusion Limited. In the event of a repair being required that is not considered to be a warranty issue, the claimant will be contacted for his further instruction.

Following the completion of any authorized warranty claim work, the product will be returned to the original claimant at the cost of Inverter Fusion Limited. (UK Customers Only)

Failure to comply with the above procedure could invalidate or delay the completion of any warranty work.

Improper use, abuse or any attempt to repair the product by an unauthorized third party will invalidate any warranty claim.

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