

Quick Start Guide – MIG160i

QUICK SET-UP

1. *Install* a 220v electrical plug
 - The **Green/yellow** wire is the **Ground**
 - The Blue wire and the Brown wire are hot wires
2. *Install* welding wire and torch assembly
 - follow the instructions in your owner's manual.
3. *Power on* using the **on/off Switch** on the back
 - A boot up display will appear, then the Home Screen
4. *Set Up* Gas Bottles with a **Regulator** and *Adjust Gas Flow* (see Pg. 3)

***You will use the Red Knob for all menu and settings selections**

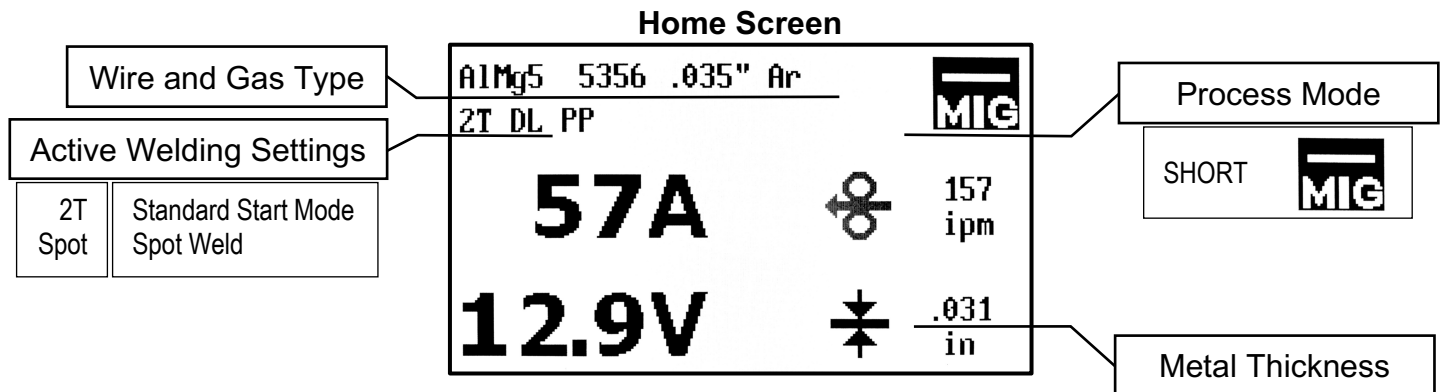
5. *Press and Hold* until you see the **Main Menu** (Process Parameters)
6. *Click* to open the **Wire Selection** Menu
7. *Turn to scroll* and highlight the kind of wire and gas you are using
8. *Click* to select your wire and gas
9. You will be at the **Main Menu** (Process Parameters) screen again.
 - The Settings you selected should be at the top of the menu
10. *Press and Hold* to return to the **Home Screen**.
11. *Turn* to Set the **Thickness** of your material
 - Shown in the lower right corner of the display.
12. **YOU ARE NOW READY TO WELD**

Main Menu	
Process Parameters	
Prog	SS 308L .030" Ar2:CO2
Process	SHORT
Start Mode	2T
Spot	OFF
HSA	OFF
CRA	OFF
Double Level	OFF

Wire Selection Menu	
Wire Selection	
Fe Steel	.030" CO2
Fe Steel	.035" Ar25:CO2
Fe Steel	.035" CO2
Fe Steel	.040" Ar25:CO2
Fe Steel	.040" CO2
SS 308L	.030" Ar2:CO2
SS 308L	.035" Ar2:CO2

This welder uses a Synergic Curve Principle

- * The wire speed is preset to the thickness
- * The welding amps and welding voltage change as you weld
- * Simply set the metal **Thickness** adjust the **Welding Gas Flow** (see Pg. 3)



MIG160i Wire Selection Guide

Application	Wire Type	Wire Size	Weld Thickness	Shielding Gas
Steel All Purpose Thin to Structural	Steel Fe	.035"	.03"-.2"	75% Argon 25% CO2
			.03"-.165"	100% CO2
		.040"	.03"-.15"	75% Argon 25% CO2
			.03"-.27"	100% CO2
Stainless Steel 301, 302, 304, 305	Stainless Steel 308L	.030"	.03"-.16"	98% Argon 2% CO2
		.035"	.04"-.26"	
		.040"	.04"-.26"	
OE Aluminum Repairs Required by manufacturers	Aluminum 5554 AlMgMn2.7 2.7% Magnesium	.040"	.04"-.26"	100% Argon
		.045"	.04"-.28"	
Aluminum Panels All-Purpose body panels	Aluminum 5356 AlMg5 5% Magnesium	.035"	.03"-.24"	100% Argon
		.040"	.04"-.32"	
Aluminum Parts Forged and Cast	Aluminum 4047 AlSi12 12% Silicon	.035"	.04"-.32"	100% Argon
		.040"	.04"-.24"	
MIG Brazing Very Thin Metal Dissimilar metals Galvanized Steel	Silicon Bronze 6560 CuSi3 Copper Silicon 3%	.030"	.03"-.12"	100% Argon
		.035"	.03"-.16"	
		.040"	.03"-.2"	
Honda Repairs Specific Applications	Union x 96 Steel	.030"	.03"-.2"	82% Argon 18% CO2
		.035"	.03"-.2"	75% Argon 25% CO2

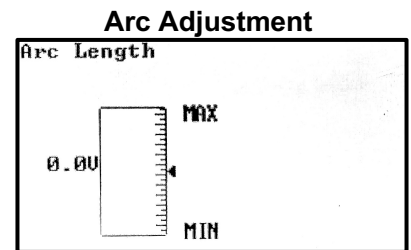
Advanced Settings – MIG160i

Welding Gas Set Up

1. *Open* the gas bottle.
2. *Press and Hold* the **Torch Trigger** to open the gas solenoid
 - You may release the wire feeder within the machine to stop the wire from feeding
3. *Turn* the **Regulator Flow Knob** to your desired amount while the gas is flowing
 - For Steel and Brazing set the gas flow to 30 CFH
 - For Aluminum set the gas flow to 40 CFH
4. After a few seconds the gas flow will shut off and the wire speed increases
 - This allows you to quickly feed wire without wasting gas.

Arc Length Adjustment

- * The arc length is preset when you select your metal thickness
1. *Click* while on the **Home Screen**
 2. The **Arc Length** adjustment menu will appear
 3. *Turn* to highlight your desired Arc Adjustment
 - Positive voltage will increase heat
 - Negative voltage will decrease heat
 4. *Click* to confirm change and exit to the **Home Screen**



Resetting to Factory Preset

1. *Press and Hold* until you see the **Main Menu** (Process Parameters)
2. *Turn* to scroll down to **Factory** and *Click* to select
3. *Turn* to highlight **Reset** and *Click* to confirm selection
4. *Click* to OK then *Press and Hold* to exit to the **Home Screen**

Spot Welding Mode

5. *Press and Hold* until you see the **Main Menu** (Process Parameters)
6. *Turn* to scroll down to **Spot** and *Click* to select
7. *Turn* to highlight **On** or **Off** and *Click* to confirm selection

Spot Weld			
Process Parameters			
Prog	Fe Steel	.035"	Ar25%CO2
Process			SHORT
Start Mode			2T
Spot			ON
Spot Time			1.0s
Pause Time			OFF
HSA			OFF

Spot Time

- * The **Length of Time** for the spot weld
 - Factory Preset at **1.0s**

Pause Time

- * The **Off Time** between each Spot Weld period when trigger is held down
 - Factory Preset at **OFF (0.0s)**

Please read the Owner's Manual for more detailed instructions and advanced welding options.