CUTTING EDGE WELDING

USER'S MANUAL

MIG 5200 DOUBLE PULSE
MIG 4200 DOUBLE PULSE
MIG 3200 DOUBLE PULSE
MIG 2800 DOUBLE PULSE
MIG 2800 DOUBLE PULSE T

Double Pulse MIG/MAG Welding Power Source

QUICKSILVER

Introduction

First of all, thank you for choosing an IWELD welding or cutting machine!

Our mission is to support your work with the most up-to-date and reliable tools both for DIY and industrial application.

We develop and manufacture our tools and machines in this spirit.

All of our welding and cutting machines are based on advanced inverter technology, reducing the weight and dimensions of the main transformer.

Compared to traditional transformer welding machines the efficiency is increased by more than 30%.

As a result of the technology used and the use of quality parts, our welding and cutting machines are characterized by stable operation, impressive performance, energy efficient and environmentally friendly operation.

By activating the microprocessor control and welding support functions, it continuously helps maintain the optimum character of welding or cutting.

Read and use the manual instructions before using the machine please!

The user's manual describes the possible sources of danger during welding, includes technical parameters, functions, and provides support for handling and adjustment but keep in mind it doesn't contain the welding knowledge!

If the user's manual doesn't provide you with sufficient information, contact your distributor for more information!

In the event of any defect or other warranty event, please observe the „General Warranty Terms".

The user manual and related documents are also available on our website at the product data sheet.

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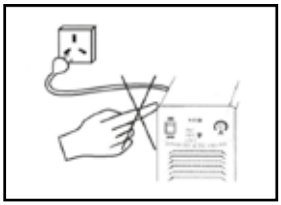
WARNING!

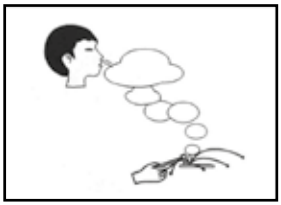
Welding is a dangerous process! The operator and other persons in the working area must follow the safety instructions and are obliged to wear proper Personal Protection Items. Always follow the local safety regulations! Please read and understand this instruction manual carefully before the installation and operation!

- The switching of the machine under operation can damage the equipment.
- After welding always disconnect the electrode holder cable from the equipment.
- Always connect the machine to a protected and safe electric network!
- Welding tools and cables used with must be perfect.
- Operator must be qualified!



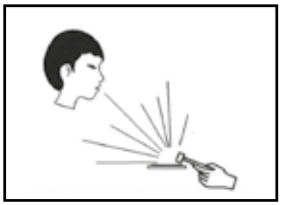
ELECTRIC SHOCK: may be fatal

- Connect the earth cable according to standard regulation.
- Avoid bare hand contact with all live components of the welding circuit, electrodes and wires. It is necessary for the operator to wear dry welding gloves while he performs the welding tasks.
- The operator should keep the working piece insulated from himself/herself.



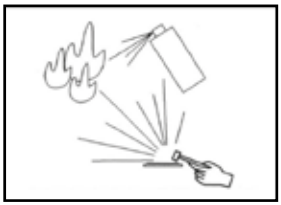
Smoke and gas generated while welding or cutting can be harmful to health.

- Avoid breathing the welding smoke and gases!
- Always keep the working area good ventilated!



Arc light-emission is harmful to eyes and skin.

- Wear proper welding helmet, anti-radiation glass and work clothes while the welding operation is performed!
- Measures also should be taken to protect others in the working area.



FIRE HAZARD

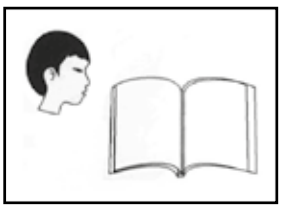
- The welding spatter may cause fire, thus remove flammable materials from the working area.
- Have a fire extinguisher nearby in your reach!

Noise can be harmful for your hearing

- Surface noise generated by welding can be disturbing and harmful. Protect your ears if needed!

Malfunctions

- Check this manual first for FAQs.
- Contact your local dealer or supplier for further advice.



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1. The main parameters

			MIG **5200** DOUBLE PULSE	MIG **4200** DOUBLE PULSE
			800MIG5200DP	800MIG4200DP
GENERAL	Layout		Portable Wire Feeder	
	Water Cooling System		✓	
	Digital Display		OLED	
	Number of Programs		100	
MIG/MAG	Synergic Control		✓	
	Pulse MIG/MAG		✓	
	Double Pulse MIG/MAG		✓	
	Reverse Polarity - FCAW		✓	
	2T/4T		✓	
	2ST/4ST		✓	
	SPOT		✓	
	Number of Wire Feeder Rolls		4	
DC TIG	DC Lift TIG		✓	
	Pulse DC TIG		✗	
MMA	Pulse DC MMA		✗	
	Arc Force		✓	
	Hot Start		✓	
	VRD		✓	
Accessories MIG Torch			IGrip 500W LCD	IGrip 500W LCD
Optional MIG Torch			IGrip 360 LCD	IGrip 360 LCD
Phase number			3	3
Rated input Voltage			3x400V AC ±10%, 50/60 Hz	3x400V AC ±10%, 50/60 Hz
Max./eff. input Current		MMA	41.9A/32.5A	32.2A/24.9A
		MIG	40.8A/31.6A	29.2A/22.6A
Power Factor (cos φ)			0.7	0.7
Efficiency				
Duty Cycle (10 min/40 °C)			500A/39V@60% 400A/34V@100%	400A/34V@60% 310A/29.5V@100%
Welding Current Range		MMA	10A-500A	10A-400A
		MIG	10A-500A	10A-400A
Output Voltage		MMA	20.4V-40V	20.4V-36V
		MIG	14.5V-39V	14.5V-34V
No-Load Voltage			59.8V (MMA:91.9V)	66.3V (MMA:73.8V)
Insulation			F	F
Protection Class			IP21S	IP21S
Welding Wire Diameter			Ø 0.8 - 1.6 mm	Ø 0.8 - 1.6 mm
Size of Coil			Ø 300 mm, 15kg	Ø 300 mm, 15kg
Weight			33.9 kg	27.5 kg
Dimensions (LxWxH)			690 x 260 x 475	700 x 265 x 500

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			MIG **3200** DOUBLE PULSE	MIG **2800** DOUBLE PULSE	MIG **2800** DOUBLE PULSE T
			800MIG3200DP	800MIG2800DPT	800MIG2800DPT
GENERAL	Wire Feeder type		Compact	Portable	Compact
	Water Cooling System		✓	✗	
	Digital Display		OLED		
	Number of Programs		100		
MIG/MAG	Synergic Control		✓		
	Pulse MIG/MAG		✓		
	Double Pulse MIG/MAG		✓		
	Reverse Polarity - FCAW		✓		
	2T/4T		✓		
	2ST/4ST		✓		
	SPOT		✓		
	Number of Wire Feeder Rolls		4		
DC TIG	DC Lift TIG		✓		
	Pulse DC TIG		✗		
MMA	Pulse DC MMA		✗		
	Arc Force		✓		
	Hot Start		✓		
	VRD		✓		
Accessories MIG Torch			IGrip 240W LCD	IGrip 240 LCD	
Optional MIG Torch			IGrip 360 LCD	IGrip 360 LCD	
Phase number			3	3	
Rated input Voltage			3x400V AC ±10%, 50/60 Hz	3x400V AC ±10%, 50/60 Hz	
Max./eff. input Current		MMA	16.3A/12.6A	13.4A/10.4A	
		MIG	14.8A/11.5A	11.9A/9.2A	
Power Factor (cos φ)			0.7	0.7	
Efficiency					
Duty Cycle (10 min/40 °C)			300A/29V @ 60% 235A/25.8V @ 100%	250A/29V @ 60% 195A/25.8V @ 100%	
Welding Current Range		MMA	10A-300A	10A-250A	
		MIG	10A-300A	10A-250A	
Output Voltage		MMA	20.4V-32V	20.4V-30V	
		MIG	14.5V-29V	14.5V-26.5V	
No-Load Voltage			67V (MMA: 70.5V)	77V (MMA:89.2V)	
Insulation			F	F	
Protection Class			IP21S	IP21S	
Welding Wire Diameter			Ø 0.8 - 1.2 mm	Ø 0.8 - 1.2 mm	
Size of Coil			Ø 300 mm, 15kg	Ø 300 mm, 15kg	
Weight			58.5 kg	29.8 kg	
Dimensions (LxWxH)			700 x 260 x 485	700 x 260 x 485	

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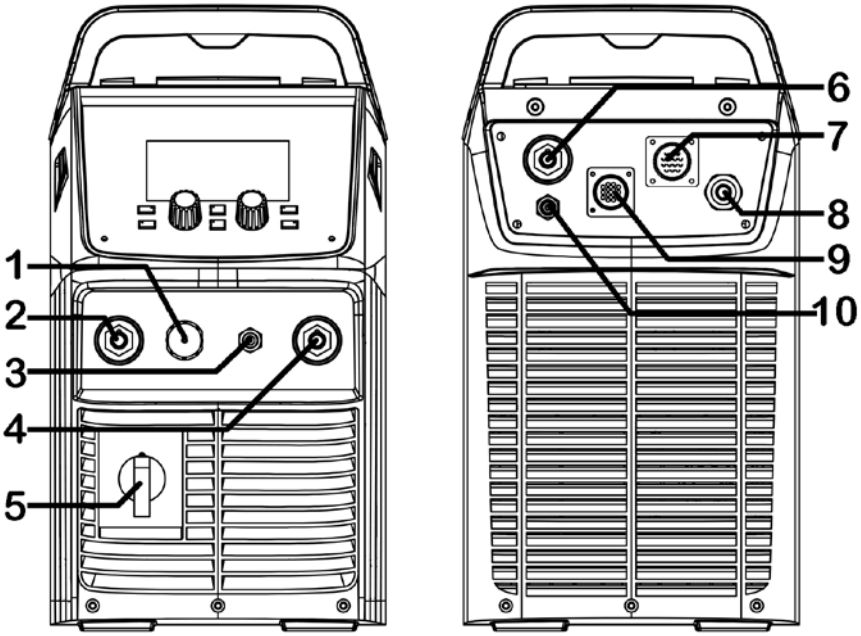
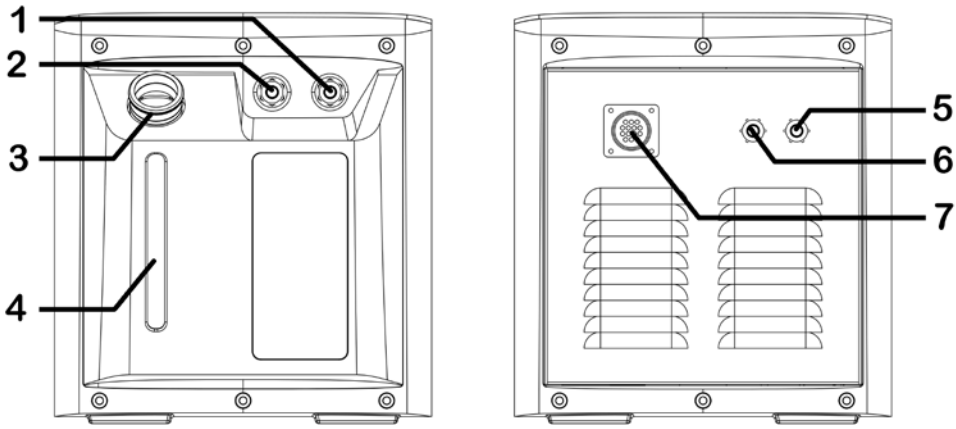
1.1 Machine Layout Description

1.1.1 Front and rear panel layout of welding machine



1	TIG welding gun control connector.
2	Negative output: When MIG mode, this polarity must connect the work piece.
3	Gas outlet: Connect the inlet of TIG welding gun.
4	Positive output: When TIG mode, this polarity must connect the work piece.
5	Power switch: Turn on power supply clockwise and turn off power supply counterclockwise.
6	Positive output anode: Used to connect to the welding cable of wire feeder.
7	Wire feeder connector: Used to connect to the control cable of wire feeder.
8	Power source input: To connect power source.
9	Water box connector: To connect water box.
10	Gas Inlet: Connect the gas hose.

1.1.2 Front and rear panel layout of water cooling unit (for water-cooled models only)



1	Backwater inlet for TIG (red).*
2	Water outlet for TIG (blue).*
3	Refill open: here, can be loaded the water or antifreeze coolant to tank
4	Water level inspection window.*
5	Backwater inlet for MIG (red).*
6	Water outlet for MIG (blue).*
7	Water cooling control connector.*
The words marked * are explained in detail below.	

Further Controls Explained

Inlet (1) and outlet (2) for TIG
The two nozzles on the same side of the front are used for TIG operation and can be connected to the nozzles on TIG welding torch. Blue corresponds to the outlet: cold water is delivered from the tank; red corresponds to the backwater inlet: hot water is flowed into the tank for cooling.
Note: Blue outlet and red backwater inlet must not be interchanged!

Water (coolant) level calibration (4)
Trough the water level inspection window, you can clearly observe the water level in the tank, the highest marking the highest water level: water volume should not exceed the highest water level; the lowest marking the lowest water level: when the water volume is lower than the lowest water level, the water tank will not work properly, need to refill water to the intake in time.

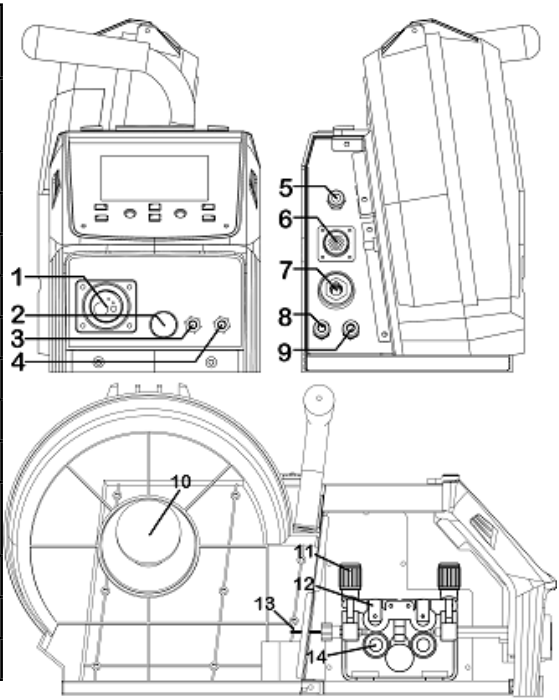
Inlet (5) and outlet (6) for MIG

The two nozzles on the back side are used for MIG operation and can be connected to the nozzles on the wire feeder. Blue corresponds to the outlet: cold water is delivered from the tank; red corresponds to the backwater inlet: hot water is flowed into the tank for cooling.
Note: Blue outlet and red backwater inlet must not be interchanged!

Control connector (7)
Water cooler control connector is used for plugging the connecting cable. The connection cable is used to connect the water cooler with wire feeder or water tank with welding machine. It supplies power to the water tank through the connection cable and receives control and detection signals in time.

1.1.3 Wire feeder (for portable wire feeder models)

1	MIG welding gun central connector.
2	9 pin air socket for Spool welding gun.
3	Water outlet.
4	Backwater inlet.
5	Gas connector.
6	Wire feeder control socket.
7	Positive output.
8	Water inlet.
9	Backwater outlet.
10	Wire reel Shaft.
11	Wire feed tension adjustment (2x).
12	Wire feed tension arm (2x).
13	Wire feeder inlet guide.
14	Wire wheler (2x).



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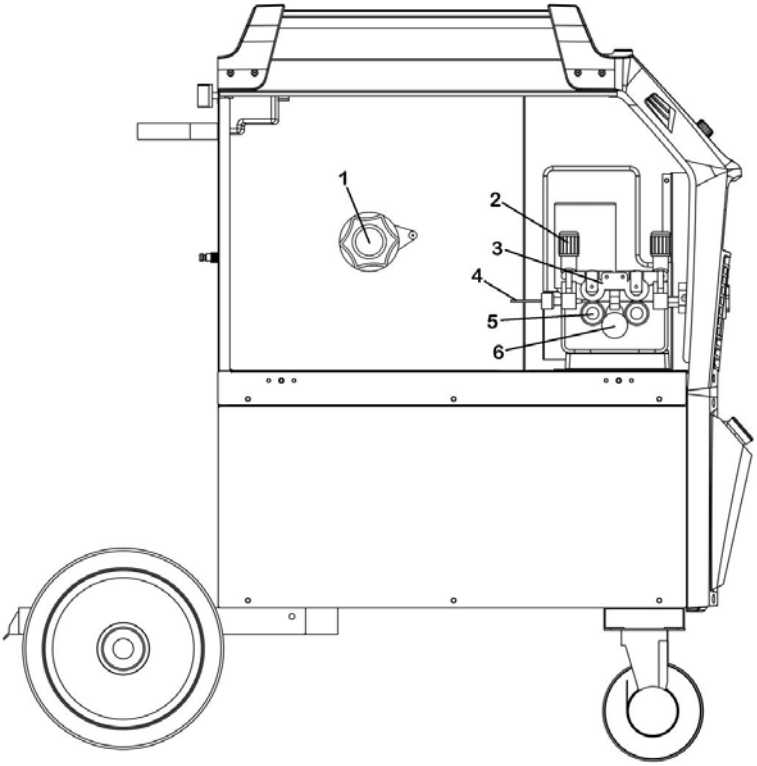
1.1.4 Wire Feeder (for compact models)



1	Spool holder.
2	Wire feed tension adjustment (2x).
3	Wire feed tension arm (2x).
4	Wire feeder inlet guide.
5	Wire feeder roller (2x).
6	Wire drive roller

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1.2 Front Panel Functions and Descriptions

1.2.1 MMA control panel

1.	Welding mode button: Press it to enter MMA welding mode.
2.	L parameter knob: Rotate it to welding current.
3.	R parameter knob: Press it to select Hot Start or Arc Force and rotate it to adjust values.

Hot start
Hot start provides extra power when the weld starts to counteract the high resistance of the electrode and workpiece as the arc is started. Setting range: 0~10.

Arc force
An MMA welding power source is designed to produce constant output current. This means with different types of electrode and arc length; the welding voltage varies to keep the current constant. This can cause instability in some welding conditions as MMA welding electrodes will have a minimum voltage they can operate with and still have a stable arc.
Arc Force control boosts the welding power if its senses the welding voltage is getting too low. The higher the arc force adjustment, the higher the minimum voltage that the power source will allow. This effect will also cause the welding current to increase. 0 is Arc Force off, 10 is maximum Arc Force. This is practically useful for electrode types that have a higher operating voltage requirement or joint types that require a short arc length such as out of position welds.

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1.2.2 Lift TIG control panel

1.	Welding mode button: Press it to enter Lift TIG welding mode.
2.	L parameter knob: Rotate it to adjust welding current. In function interface, rotate it to select parameters, such as trigger mode and Post Flow time.
3.	R parameter knob: rotate it to adjust parameters of TIG function interface.
4.	Function button: Press it to enter the function interface.
5.	Cooling mode button: Press to select the type of the cooling.

Function interface:

1.	Mode: Trigger mode: 2T/4T/ Spot weld.
2.	Down slope time: 0~10s.
3.	Post flow time: 0~10s.

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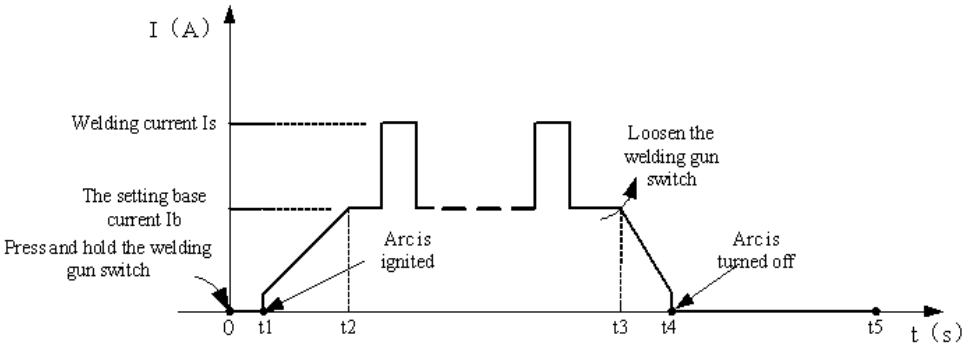
- **2T Mode**

The trigger is pulled and held on to activate the welding circuit, when the trigger is released, the welding circuit stops.

This function without the adjustment of start current and crater current is suitable for the Re-tack welding (transient welding) thin plate welding and so on.



Introduction:

(1) 0: Press the welding gun switch and hold it. Electromagnetic gas valve is turned on. The shielding gas stars to flow.

(2) 0-t1: Pre-gas time (0.1~2.0S)

(3) t1-t2: Arc is ignited and the output current rises to the setting welding current (Iw or Ib) from the min welding current.

(4) t2-t3: During the whole welding process, the welding gun switch is pressed and held without releasing.

Note: Select the pulsed output, the base current and welding current will be outputted alternately; otherwise, output the setting value of welding current;

(5) t3: Release the welding gun switch, the welding current will drop in accordance with the selected down-slope time.

(6) t3-t4: The current drops to the minimum welding current from the setting current (Iw or Ib), and then arc is turned off.

(7) t4-t5: Post-gas time, after the arc is turned off. You can adjust it (0.0~10s) through turnning the knob on the front panel.

(8) t5: Electromagnetic gas valve turned off, the shield gas stops to flow, and welding is finished.

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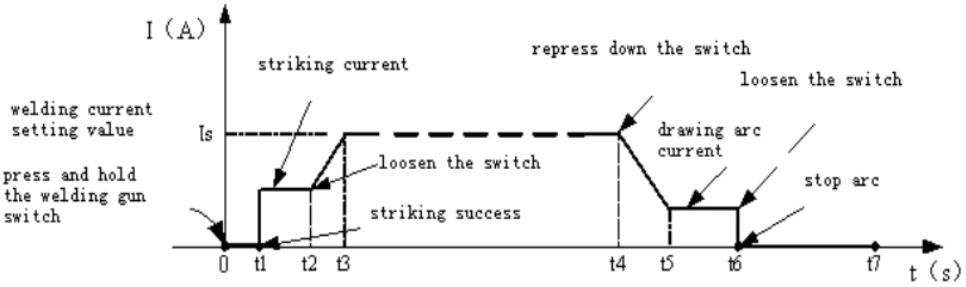
- **4T Mode**

This is known as 'latching' mode. The trigger is pulled once and released to activate the welding circuit, pulled and released again to stops the welding circuit. This function is useful to longer welds as the trigger is not required to be held on continuously. TIG series of welding machines also has more current control options that can be used in 4T mode.
The start current and crater current can be pre-set. This function can compensate the possible crater that appears at the beginning and end of the welding. Thus, 4T is suitable for the welding of medium thickness plates.



Introduction:

(1) 0: Press and hold the welding gun switch, Electromagnetic gas valve is turned on. The shielding gas stars to flow;
(2) 0-t1: Pre-gas time (0.1~2.0S);
(3) t1-t2: Arc is ignited at t1 and then output the setting value of start current;
(4) t2: Loosen the welding gun switch, the output current slopes up from the start current;
(5) t2-t3: The output current rises to the setting value (Iw or Ib), the upslope time can be adjusted;
(6) t3-t4: Welding process. During this period, the welding gun switch is loosen;

Note: Select the pulsed output, the base current and welding current will be outputted alternately; otherwise, output the setting value of welding current;

(7) t4: Press the torch switch again, the welding current will drop in accordance with the selected down-slope time.
(8) t4-t5: The output current slopes down to the crater current. The downslope time can be adjusted;
(9) t5-t6: The crater current time;
(10) t6: Loosen the welding gun switch, stop arc and keep on argon flowing;
(11) t6-t7: Post-gas time can be set by post-gas time adjustment knob on front panel;
(12) t7: Electromagnetic valve is closed and stop argon flowing. Welding is finished.

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1.2.3 MIG Manual control panel

1	Welding mode button: Press it to enter MIG Manual welding mode.
2	L parameter knob: Rotate it to adjust wire feeding speed. In function interface, rotate it to select parameters.
3	R parameter knob: rotate it to adjust Inductance or other parameters.
4	Function button: Press it to enter the function interface.
5	Cooling mode button: Press to select the type of cooling.
6	Gas check button.
7	Manual wire feeding button.

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Function interface:

1	Mode: Trigger mode: 2T/4T/ Spot weld.
2	Pre flow time: 0~10s.
3	Post flow time: 0~10s.
4	Burnback: 0~10.
5	Slow feed time: 0~10s.
6	Spool welding gun: On/OFF.

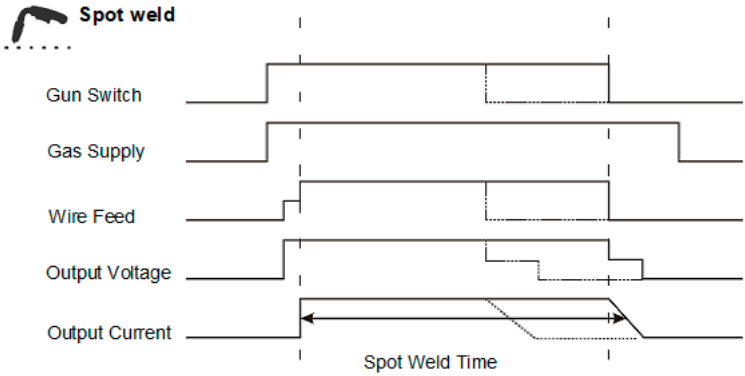
Burnback

Burnback control sets the amount of wire to 'burn back' after you release the trigger of torch. Range: 0~10.

Slow feed

This function is used to regulate the speed of wire feeding increasing. Range: 0~10S.

Spot Weld trigger mode:



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1.2.4 MIG (Dual) Pulse control panel

1	Welding mode button: Press it to enter MIG Manual welding mode.
2	L parameter knob: Rotate it to adjust wire feeding speed. In function interface, rotate it to select parameters.
3	R parameter knob: Rotate it to adjust Inductance or other parameters.
4	Function button: Press it to enter the function interface.
5	Cooling mode button: Press to select water cooling.
6	Gas check button.
7	Manual wire button.

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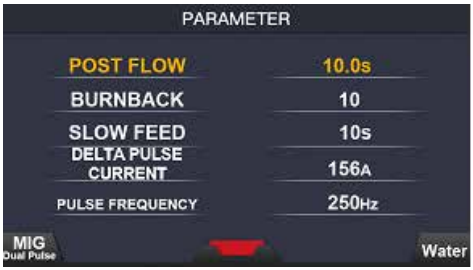
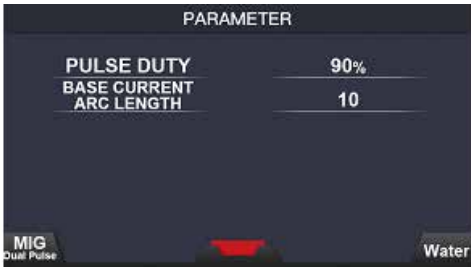
Function interface:





1	Mode: 2T/4T/S4T mode.
2	Wire material: SS solid-cored/ Fe solid-cored/ Fe flux-cored/ Al-Mg solid-cored/ CuSi.
3	Wire diameter: 0.6~1.6mm.
4	Type of gas: CO2 or Ar+CO2 20%.
5	Pre flow time: 0~10s.
6	Post flow time: 0~10s.
7	Burnback: 0~10.
8	Slow feed time: 0~10s.
9	Delta pulse current: 0~200A. (Only be available in Dual pulse welding mode.)
10	Pulse frequency: 0.5~3Hz. (Only be available in Dual pulse welding mode.)
11	Pulse Duty: 10~90%. (Only be available in Dual pulse welding mode.)
12	Base current arc length: -10~10. (Only be available in Dual pulse welding mode.)

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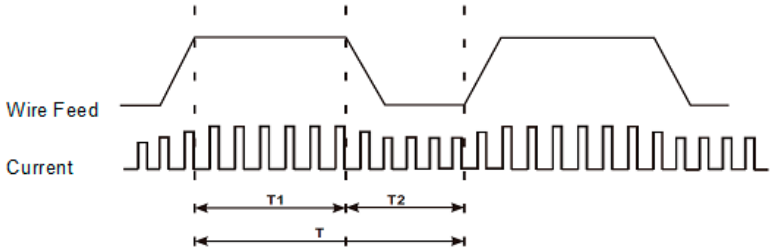
Single Pulse Function
Pulse allows the arc to enter spray transfer at lower currents and feed speeds than manual allowing faster welding with high deposition and smaller heat effected zones due to the extra arc energy provided at peak of pulse. Used for stainless or aluminum edge or seam welds.

Double-Pulse Function
Double pulse allows more precise control of heat input as "peak" is offset by "base" allowing puddle stability. It is mainly used in aluminum alloy welding for strong penetration with narrow bead and smooth surface. It can produce the ripple effect of a TIG weld without torch modulation. Dual pulse reference waveform as shown below:



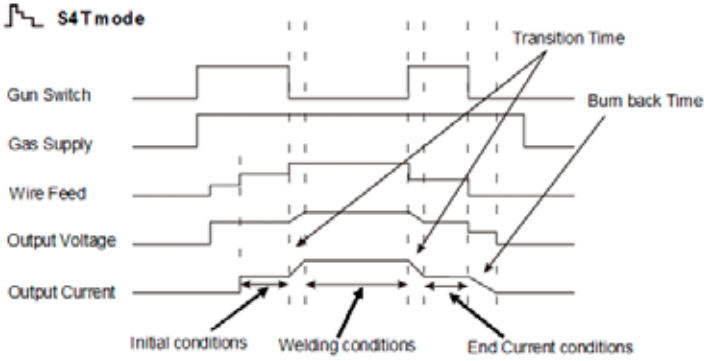
- **DUAL PULSE FREQUENCY**

Set pulse frequency, as shown in Figure regulating the value of time T, namely, ripple pattern of density regulation. Higher Hz produces many short ripples with slightly lower penetration.

- **DUAL PULSE DUTY**

Set strong pulse time T1 (peak) for penetration and low-frequency cycle T2 ratio (cooling), namely the regulation of the proportion of the ripple pattern on weld puddle surface and resulting depth in groove.

S4T trigger mode:



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1.2.5 MIG SYN control panel

The operator simply sets the welding current like MIG welding and the machine calculates the optimal voltage for the material type, wire type and size and shielding gas being used. Obviously other variables such as welding joint type and thickness, air temperature affect the optimal voltage and wire feed setting, so the program provides a voltage fine tuning function for the synergic program selected. Once the voltage is adjusted in a synergic program, it will stay fixed at this variation when the current setting is changed. To reset the voltage for a synergic program back to factory default, change to another program and back again.

1	Welding mode button: Press it to select MIG SYN welding mode.
2	L parameter knob: Rotate it to adjust wire feeding speed. In functional parameter interface, rotate it to select parameters.
3	R parameter knob: Rotate it to adjust parameters.
4	Functional button.
5	Cooling mode button: Press to select the type of the cooling.
6	Manual shield gas check button.
7	Manual wire feeding button.

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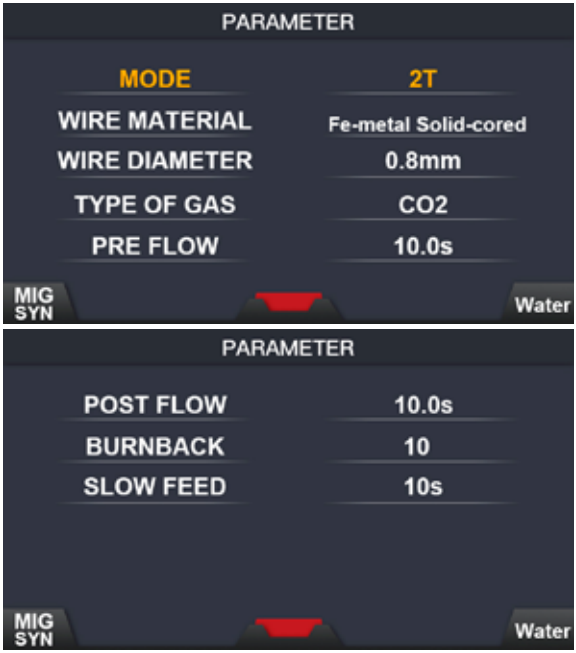
Function interface:



1	Mode: 2T/4T/ S4T/ Spot weld.
2	Wire material: SS solid-cored/Fe solid-cored/Fe flux-cored/ Al-Mg solid-cored/ CuSi.
3	Wire diameter: 0.6~1.6mm.
4	Type of gas: CO2 and Ar+CO2 20%.
5	Pre flow time: 0~10s.
6	Post flow time: 0~10s.
7	Burnback: 0~10.
8	Slow feed time: 0~10s.

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1.2.6 JOB Program control panel

In the JOB mode, different JOB records can be stored and recalled. When leaving the factory, has no saved JOB programs; therefore, operator must first save a program.

1	JOB button: Press it for 3s to enter JOB programs and press it for 1s to save parameters.
2	Parameters display: Here are all the selected parameter that you settings.
3	JOB number display.
4	L parameter knob: Rotate it to turn the page and press it to delete the parameters.
5	R parameter knob: Rotate it to select JOB program number and press it to load the selected JOB program number.

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1.2.7 System setting panel

Press the functional parameter key and hold it for 3s to enter the system interface. Here you can adjust the language, the unit and the brightness setting by L parameter knob and R parameter knob.

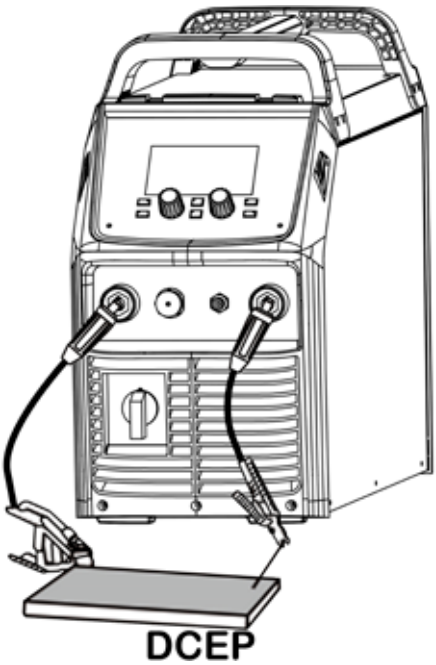
EN

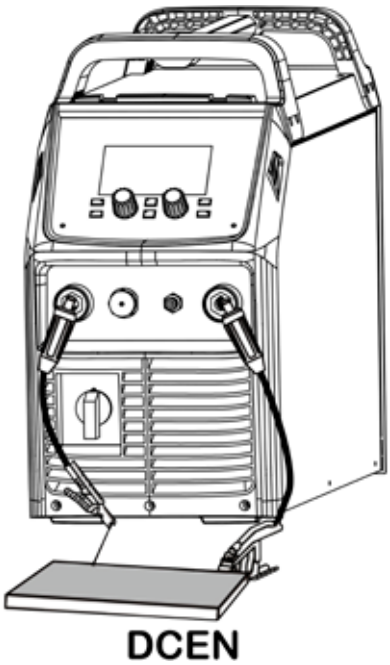
2. Installation & Operation

2.1 Installation for MMA Welding

1. Connection of Output Cables
   Two sockets are available on this welding machine. For MMA welding the electrode holder is shown be connected to the positive socket, while the earth lead (work piece) is connected to the negative socket, this is known as DCEP. However various electrodes require a different polarity for optimum results and careful attention should be paid to the polarity, refer to the electrode manufacturer's information for the correct polarity.

DCEP: Electrode connected to "+" output socket.
DCEN: Electrode connected to "-" output socket.

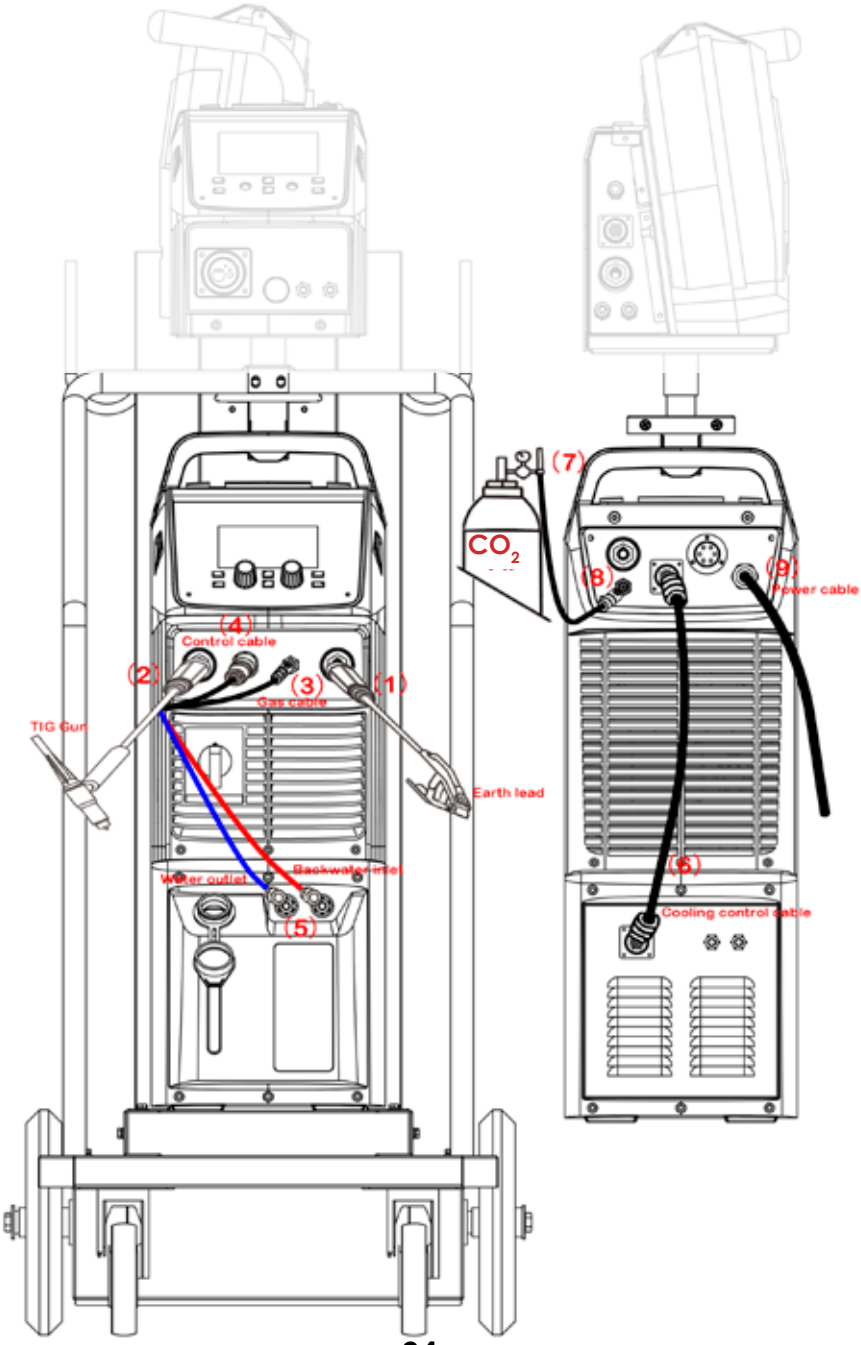




2. Turn the power source on and press the welding mode button to select the MMA function.
3. Set the welding current relevant to the electrode type and size being used as recommended by the electrode manufacturer.
4. Set the Hot Start and Arc Force using the knob.
5. Place the electrode into the electrode holder and clamp tight.
6. Strike the electrode against the work piece to create and arc and hold the electrode steady to maintain the arc.

2.2 Installation & Operation for TIG Welding

2.2.1 Installation for TIG Welding



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1. Insert the earth cable plug into the positive socket on the front of the machine and tighten it.
2. Plug the welding torch into the negative socket on the front panel, and tighten it.
3. Connect the gas line of TIG Welding gun to outlet gas connector on the front of the machine.

Check for Leaks!

4. Connect the control cable of torch switch to 9 pin socket on the front of the machine.
5. Connect the water inlet and outlet pipe of TIG Welding gun to inlet and outlet water connector on the front of the cooling water.
6. Connect the control cable of cooling water with the aero socket on the rear panel of welding machine.
7. Connect the gas regulator to the Gas Cylinder and connect the gas line to the Gas Regulator. **Check for Leaks!**
8. Connect the gas line to the machine inlet gas connector via the quick push lock connector located on the rear panel. **Check for Leaks!**
9. Connect the power cable of welding machine with the output switch in electric box on site.
10. Carefully open the valve of the gas cylinder, set the required gas flow rate.
11. Select TIG welding mode on the front panel.
12. Set torch operation 2T/4T.
13. Select water cooling mode on the front panel.

LIFT ARC DC TIG Operation

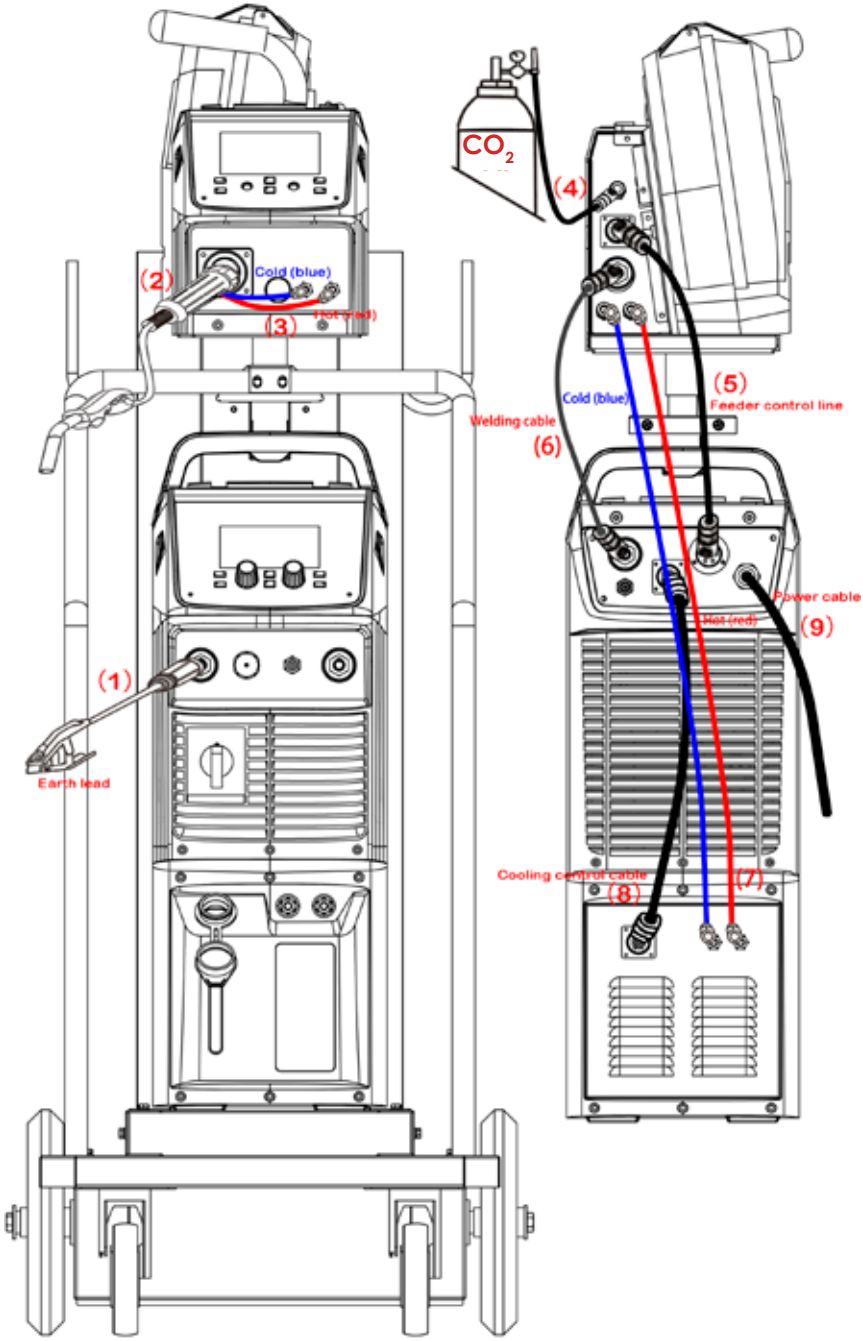
Lift Arc ignition allows the arc to be started easily in DC TIG by simply touching the tungsten to the work piece and lifting it up to start the arc. This prevents the tungsten tip sticking to the work piece and breaking the tip from the tungsten electrode. There is a particular technique called "rocking the cup" used in the Lift Arc process that provides easy use of the Lift Arc function.

1. Select welding current and Down slope Time as required on the front panel. The selected welding current and Down slope Time will show on the screen.
2. Assemble front end parts of the TIG torch making sure they are correctly assembled, use the correct size and type of tungsten electrode for the JOB, the tungsten electrode requires a sharpened point for DC welding.
3. Lay the outside edge of the Gas Cup on the work piece with the Tungsten Electrode 1~2mm from the work piece. Press and hold the torch switch to activate to gas flow and welding power.
4. With a small movement rotate the Gas Cup forward so that the Tungsten Electrode touches the work piece.
5. Now rotate the Gas Cup in the reverse direction to lift the Tungsten electrode from the work piece to create the arc.
6. Release the trigger to stop the welding.

IMPORTANT! - We strongly recommend that you check for gas leaks prior to operation of your machine. We recommend that you close the cylinder valve when the machine is not in use.

2.3 Installation & Operation for MIG Welding

2.3.1 Installation for MIG Welding



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1. Insert the earth cable plug into the negative (-) socket on the front of the machine and tighten it.
2. Plug the welding torch into the MIG torch connection socket on the front panel of the wire feeder, and tighten it.

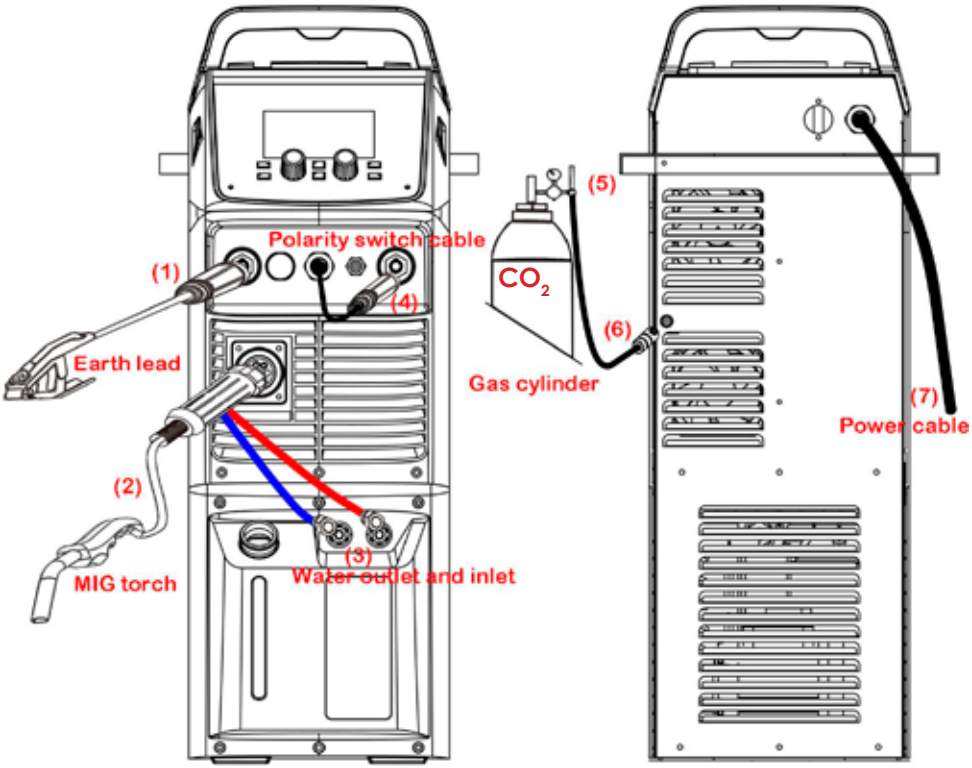
IMPORTANT: When connecting the torch be sure to tighten the connection. A loose connection can result in the connector arcing and damaging the machine and welding gun connector.

3. Connect the water inlet and outlet pipe of MIG Welding gun to the water inlet and outlet connectors on the front of the wire feeder.
4. Connect the gas line to gas connector on the rear panel of wire feeder. Check for Leaks!
5. Connect the control cable of wire feeder with the aero socket on the rear panel of welding machine.
6. Connect the cable of wire feeder with the positive output of welding machine.
7. Connect the water inlet and outlet pipe of wire feeder with the water inlet and outlet connectors on the rear front of cooling water.
8. Connect the control cable of cooling water with the aero socket on the rear panel of welding machine.
9. Connect the power cable of welding machine with the output switch in electric box on site.

NOTE: Air cooling mode without cooling device and the water pipe is not needed for the air cooling mode.

10. Place wire onto spool holder - (spool retaining nut is left hand thread) Feed the wire through the inlet guide tube on to the drive roller.
11. Feed wire over the drive roller into the outlet guide tube, push the wire through approx 150mm.
12. Close down the top roller bracket and clip the pressure arm into place with a medium amount of pressure applied.
13. Remove the gas nozzle and contact tip from the front end of the MIG torch.
14. Press and hold the manual wire button to feed the wire down the torch cable through to the torch head.
15. Fit the correct size contact tip over the wire and fasten tightly into the tip holder.
16. Fit the gas nozzle to the torch head.
17. Carefully open the gas cylinder valve and set the required gas flow rate.
18. Select torch trigger mode: 2T or 4T.
19. Select water cooling mode.
20. Select the required welding parameters using the knobs and buttons.

Installation for MIG Welding (for compact models)



1. Insert the earth cable plug into the negative (-) socket and twist to
2. Plug the MIG welding gun into MIG torch euro connector on the front panel and tighten locking nut securely.
3. Connect the water inlet and outlet pipe of MIG G un to the water inlet and outlet connectors on the front of the cooling water.
4. Insert the polarity switching cable plug into the positive socket on the front of the machine and tighten it.
5. Connect the gas regulator to the gas cylinder and connect the gas line to the regulator.
6. Connect the gas line to gas connector on the rear panel.
7. Connect the power cord of welding machine with the outlet on electrical box.

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8. Place wire onto spool holder (spool retaining nut is left hand thread) feed wire through the inlet guide tube on to the drive roller.
9. Carefully feed the wire over the drive roller into the outlet guide tube, feed through about ½" (150mm) into the torch receptacle.
10. Check that the drive roller size is compatible with the wire diameter, replace the roller if necessary.
11. Align the wire into the groove of the drive roller and close the top roller tension arms making sure the wire is in the groove of the bottom drive roller, lock the tension arms into place with pressure knobs and tighten by turning clockwise.
12. Remove the gas nozzle and contact tip from the torch
13. Press and hold the manual wire button to feed the wire through to the torch neck, release the manu al wire button when the wire exits the torch neck.
14. Fit the correct sized contact tip and feed the wire through it, screw the contact tipinto the tip holder of the torch neck and nip it up tightly.
15. Fit the gas nozzle to the torch
16. Carefully open the gas cylinder valve , set the required gas flow rate on the regulator.
17. Select MIG function mode and parameters according to your requirement, such as the wire diameter and trigger mode.

2.3.2 Wire Feed Roller Selection

The importance of smooth consistent wire feeding during MIG welding cannot be emphasized enough. Simply put the smoother the wire feed then the better the welding will be.
Feed rollers or drive rollers are used to feed the wire mechanically along the length of the welding welding gun. Feed rollers are designed to be used for certain types of welding wire and they have different types of grooves machined in them to accommodate the different types of wire. The wire is held in the groove by the top roller of the wire drive unit and is referred to as the pressure roller, pressure is applied by a tension arm that can be adjusted to increase or decrease the pressure as required. The type of wire will determine how much pressure can be applied and what type of drive roller is best suited to obtain optimum wire feed.

Solid Hard Wire - like Steel, Stainless Steel requires a drive roller with a V shape groove for optimum grip and drive capability. Solid wires can have more tension applied to the wire from the top pressure roller that holds the wire in the groove and the V shape groove is more suited for this. Solid wires are more forgiving to feed due to their higher cross sectional column strength, they are stiffer and don't bend so easy.

Soft Wire - like aluminum requires a U shape groove. Aluminum wire has a lot less column strength, can bend easily and is therefore more difficult to feed. Soft wires can easily buckle at the wire feeder where the wire is fed into inlet guide tube of the torch. The U-shaped roller offers more surface area grip and traction to help feed the softer wire. Softer wires also require less tension from the top pressure roller to avoid deforming the shape of the wire, too much tension will push the wire out of shape and cause it to catch in the contact tip.

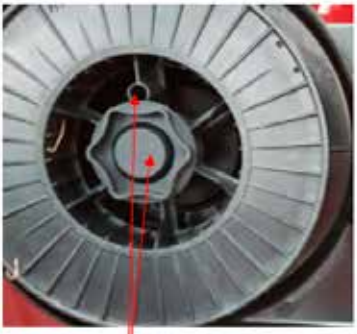
Flux Core/ Gasless Wire - these wires are made up of a thin metal sheath that has fluxing and metal compounds layered onto it and then rolled into a cylinder to form the finished wire. The wire cannot take too much pressure from the top roller as it can be crushed and deformed if too much pressure is applied. A knurled drive roller has been developed and it has small serrations in the groove, the serrations grip the wire and assist to drive it without too much pressure from the top roller. The down side to the knurled wire feed roller on flux cored wire is it will slowly over time eat away at the surface of the welding wire, and these small pieces will eventually go down into the liner. This will cause clogging in the liner and added friction that will lead to welding wire feed problems. A U groove wire can also be used for flux core wire without the wire particles coming of the wire surface. However it is considered that the knurled roller will give a more positive feed of flux core wire without any deformation of the wire shape.

2.3.3 Wire Installation and Set Up Guide

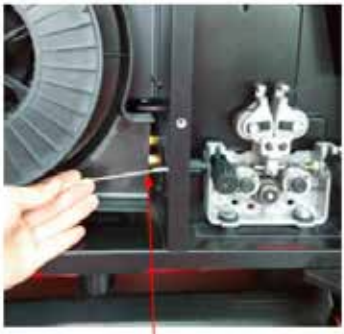
Again the importance of smooth consistent wire feeding during MIG welding cannot be emphasized enough. The correct installation of the wire spool and the wire into the wire feed unit is critical to achieving an even and consistent wire feed. A high percentage of faults with MIG welders emanate from poor set up of the wire into the wire feeder. The guide below will assist in the correct setup of your wire feeder.

(1) Remove the spool retaining nut.

(2) Note the tension spring adjuster and spool locating pin.



(3) Fit the wire spool onto the spool holder fitting the locating pin into the location holeon the spool. Replace the spool retaining nut tightly.



(4) Snip the wire carefully, be sure to hold the wire to prevent the spool uncoiling. Carefully feed the wire into the inlet guide tube of the wire feed unit.

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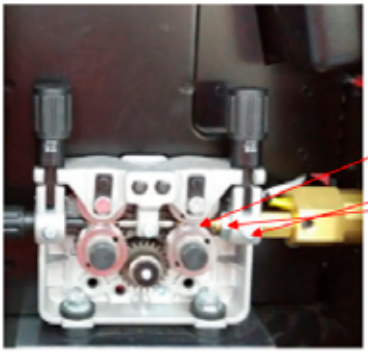
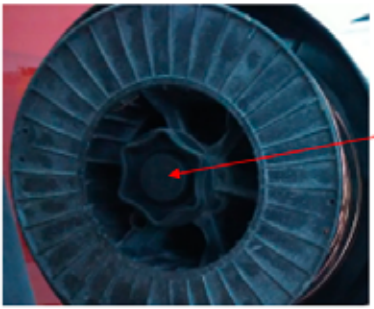
(5) Feed the wire through the drive roller and into the outlet guide tube of the wire feeder.

(6) Lock down the top pressure roller and apply a medium amount of pressure us-ing the tension adjustment knob.



(7) Check that the wire passes through the centre of the outlet guide tube without touching the sides. Loosen the locking screw and then loosen the outlet guide tube retaining nut too make adjustment if required. Carefully retighten the locking nut and screw to hold the new position.

(8) A simple check for the correct drive tension is to bend the end of the wire over hold it about 100mm from your hand and let it run into your hand, it should coil round in your hand without stopping and slipping at the drive rollers, increase the tension if it slips.



(9) The weight and speed of the wire spool turning creates an inertia that can cause the spool to run on and the wire loop over the side of the spool and tangle. if this happens increase the pressure on the tension spring inside the spool holder assembly using the tension adjustment screw.

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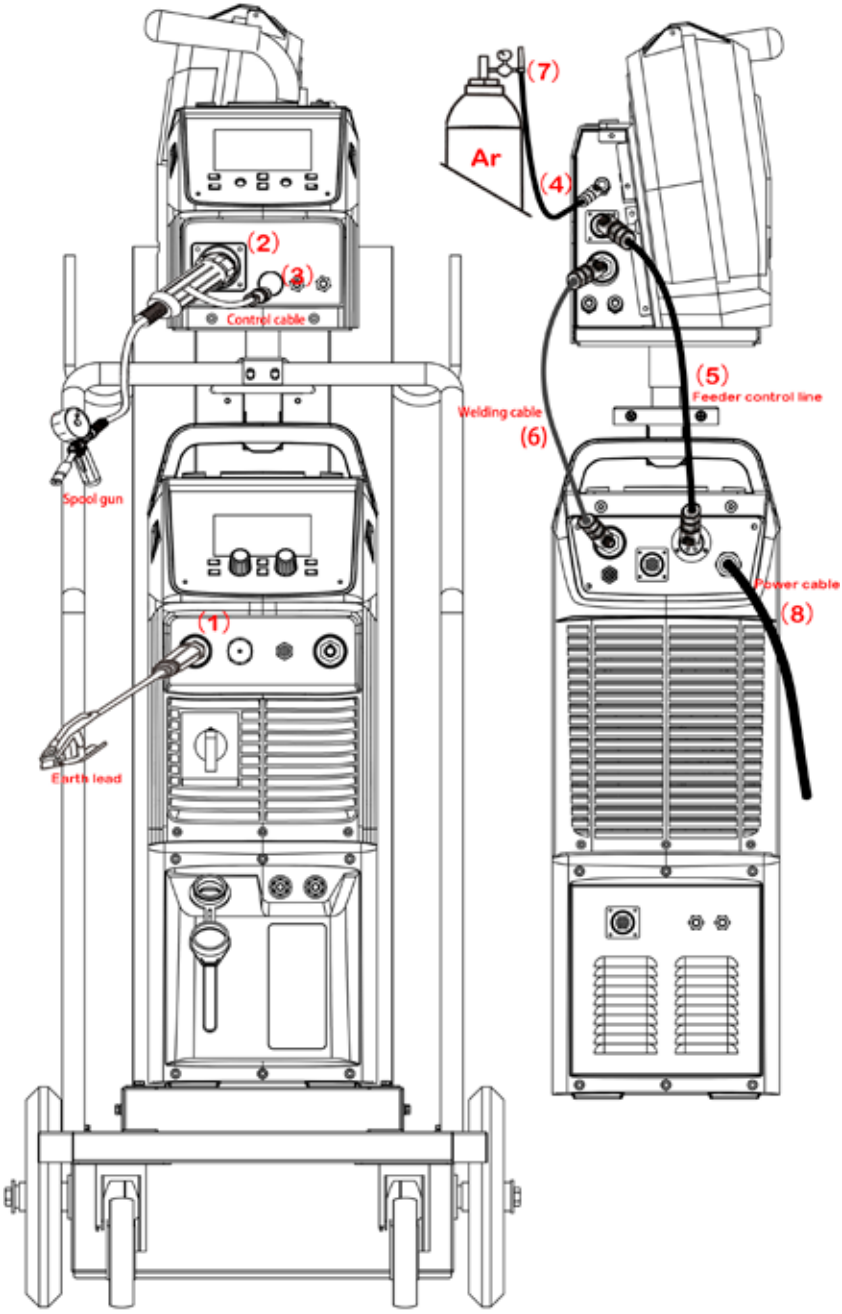
2.4 Installation for Spool Welding Gun



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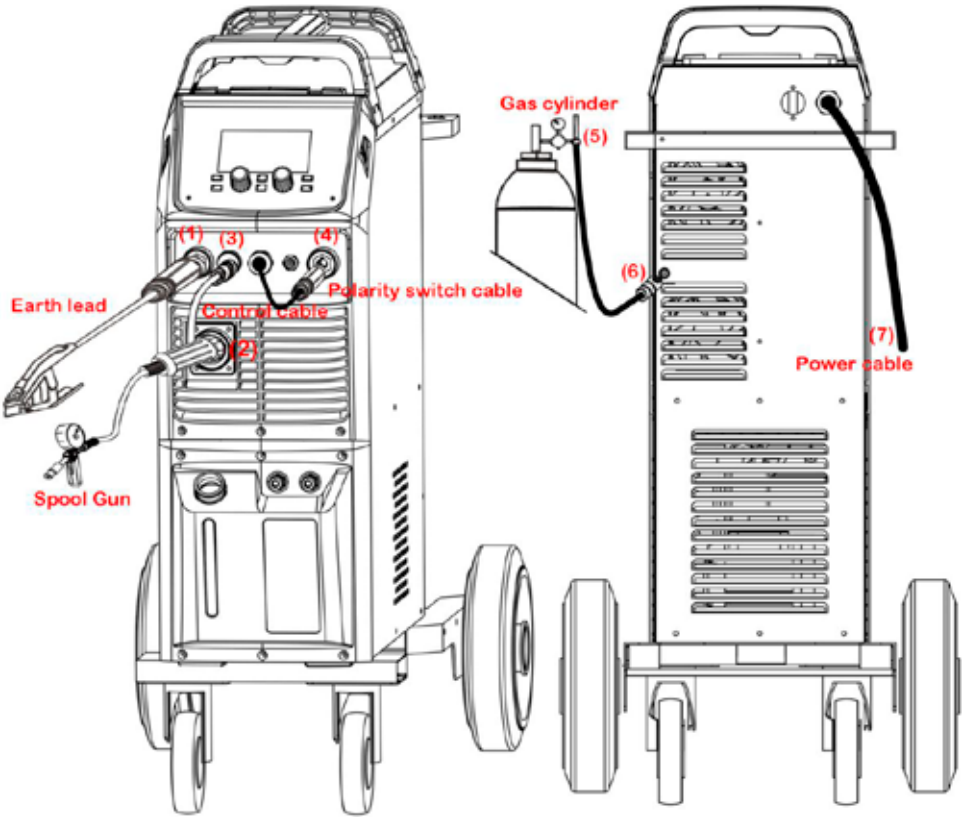
1. Insert the earth cable plug into the Negative socket on the front of the machine and tighten it.
2. Connect the Spool Welding gun to the MIG torch connection socket on the front panel of the wire feeder, and tighten it.

IMPORTANT: When connecting the torch be sure to tighten the connection. A loose connection can result in the connector arcing and damaging the machine and welding gun connector.

3. Connect the Spool Welding gun control cable to the multipin receptacle on the front panel of the wire feeder.
4. Connect the gas line to gas connector on the rear panel of wire feeder.
5. Connect the control cable of wire feeder with the aero socket on the rear panel of welding machine.
6. Connect the cable of wire feeder with the positive output of welding machine.
7. Connect the gas regulator to the Gas Cylinder and connect the gas line to the Gas Regulator.
8. Connect the power cable of welding machine with the output switch in electric box on site.
9. Remove the spool cover by pressing button and lifting off the cover.
10. Place a spool of wire inside the spool holder on post.
11. Feed the wire through the drive rolls and into the inlet guide tube. Tighten the wire tension swing arm.
12. Pull the trigger to drive the wire down the neck until it exits the contact tip.
13. Select MIG Manual welding mode by pressing the welding mode button and enter the function interface to set “SPOOL Welding gun” to “ON” by pressing function button. Then set welding parameters using the knobs and buttons.
14. Carefully open the gas cylinder valve, set the required gas flow rate on the regulator.

2.4 Installation for Spool Welding Gun (for compact models)



1. Insert the earth cable plug into the negative (--) socket on the front of the machine and twist to tighten.
2. Plug the Spool Gun into the euro connect socket on the front panel and tighten.

IMPORTANT: When connecting the torch be sure to tighten the adaptor nut completely tight. A loose connection can result in arcing between the gun and machine connector and that causes serious damage to both the torch and machine connections.

3. Connect the Spool Gun control cable to the 9 pin receptacle on the front panel.
4. Insert the polarity switching cable plug into the positive socket on the front of the machine and tighten it.
5. Connect the gas regulator to the gas cylinder and connect the gas line to the regulator.

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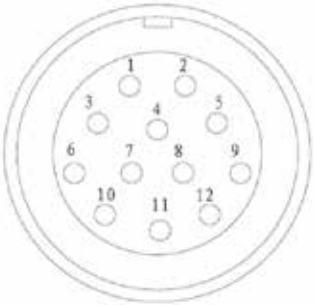
6. Connect the gas line to gas connector on the rear panel.
7. Connect the power cord of welding machine with the outlet on electrical box.
8. Remove the spool cover by pressing button and lifting off the cover.
9. Place a spool of wire inside the spool holder on post.
10. Feed the wire through the drive rolls and into the inlet guide tube. Tighten the wire tension swing arm.
11. Pull the trigger to drive the wire down the neck until it exits the contact tip.
12. Select MIG Manual welding mode by pressing the welding mode button and enter the function interface to set "SPOOL GUN" to "ON" by pressing function button. Then set welding parameters using the knobs and buttons.
13. Carefully open the gas cylinder valve, set the required gas flow rate on the regulator.

Spool Gun Control



1 - NEGATIVE MOTOR
2 - POSITIVE MOTOR
3 - Zero Ohm (minimum) connection to 10K Ohm potentiometer
4 - Potentiometer
5 - 10K Ohm connection (maximum) with 10K Ohm potentiometer
6 - not connected
7 - not connected
8 - not connected
9 - not connected
10 - not connected
11 - not connected
12 - not connected

Socket Pin	Function
1	Spool gun motor
2	Not connected
3	Not connected
4	Spool gun motor
5	10k ohm (maximum) connection to 10k ohm remote control potentiometer.
6	Zero ohm (minimum) connection to 10k ohm remote control potentiometer.
7	Wiper arm connection to 10k ohm remote control potentiometer.
8	Not connected
9	Not connected

2.5 Set Up Installation for Pull MIG Gun

1. Insert the earth cable plug into the negative ((--) socket on the front of the machine and twist to tighten.
2. Plug the Pull MIG Gun into the euro connect socket on the front panel and tighten.

IMPORTANT: When connecting the torch be sure to tighten the adaptor nut completely tight. A loose connection can result in arcing between the gun and machine connector and that causes serious damage to both the torch and machine connections.

3. Connect the Pull MIG Gun control cable to the 9 pin r eceptacle on the front panel.
4. Connect the gas regulator to the gas cylinder and connect the gas line to the regulator.
5. Connect the gas line to gas connector on the rear panel.
6. Open the gas cylinder valve, set regulator. Check for Leaks!
7. Connect the power c ord of welding machine with the outlet on electrical box.
8. Place wire onto spool holder (spool retaining nut is left hand thread) feed wire through the inlet guide tube on to the drive roller.
9. Carefully feed the wire over the drive roller into the outlet guide tube, feed through about ½" (150mm) into the torch receptacle.
10. Align the wire into the groove of the drive roller and cl ose the top roller tension arms making sure the wire is in the groove of the bottom drive roller, lock the tension arms into place with pressure knobs and tighten by turning clockwise.
11. Select MIG (Dual) Pulse or MIG SYN welding mode and enter the function interface to set PULL PUSH to O N by pressing function button . And adjust welding current, voltage and other parameters by buttons and knobs.
12. Press and hold the manual wire button to feed the wire through to Pull MIG gun.
13. Change the wire tension swing arm to adjust the drive roller tightness
14. Pull the trigger to drive the wire down the neck until it exits the contact tip

2.5 Welding parameters

Process reference for CO2 butt welding of low carbon steel solid welding wire

Material thickness (mm)	Root gap G (mm)	Wire diameter (mm)	Welding current (A)	Welding voltage (V)	Welding speed (cm/min)	Gas-flow rate (L/min)
0.8	0	0.8	60~70	16~16.5	50~60	10
1.0	0	0.8	75~85	17~17.5	50~60	10~15
1.2	0	0.8	80~90	17~18	50~60	10~15
2.0	0~0.5	1.0/1.2	110~120	19~19.5	45~50	10~15
3.2	0~1.5	1.2	130~150	20~23	30~40	10~20
4.5	0~1.5	1.2	150~180	21~23	30~35	10~20
6	0	1.2	270~300	27~30	60~70	10~20
6	1.2~1.5	1.2	230~260	24~26	40~50	15~20
8	0~1.2	1.2	300~350	30~35	30~40	15~20
8	0~0.8	1.6	380~420	37~38	40~50	15~20
12	0~1.2	1.6	420~480	38~41	50~60	15~20

Process reference for CO2 corner welding of low carbon steel solid welding wire

Material thickness (mm)	Wire diameter (mm)	Welding current (A)	Welding voltage (V)	Welding speed (cm/min)	Gas-flow rate (L/min)
1.0	0.8	70~80	17~18	50~60	10~15
1.2	1.0	85~90	18~19	50~60	10~15
1.6	1.0/1.2	100~110	18~19.5	50~60	10~15
1.6	1.2	120~130	19~20	40~50	10~20
2.0	1.0/1.2	115~125	19.5~20	50~60	10~15
3.2	1.0/1.2	150~170	21~22	45~50	15~20
3.2	1.2	200~250	24~26	45~60	10~20
4.5	1.0/1.2	180~200	23~24	40~45	15~20
4.5	1.2	200~250	24~26	40~50	15~20
6	1.2	220~250	25~27	35~45	15~20
6	1.2	270~300	28~31	60~70	15~20
8	1.2	270~300	28~31	60~70	15~20
8	1.2	260~300	26~32	25~35	15~20
8	1.6	300~330	25~26	30~35	15~20
12	1.2	260~300	26~32	25~35	15~20
12	1.6	300~330	25~26	30~35	15~20
16	1.6	340~350	27~28	35~40	15~20
19	1.6	360~370	27~28	30~35	15~20

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2.6 Operation environment

- Height above sea level ≤1000 M.
- Operation temperature range: -10~40°C.
- Air relative humidity is below 90% (20°C).
- Preferable site the machine some angles above the floor level, the maximum angle does not exceed 15°C.
- Protect the machine against heavy rain and against direct sunshine.
- The content of dust, acid, corrosive gas in the surrounding air or substance cannot exceed normal standard.
- Take care that there is sufficient ventilation during welding. There must be at least 30cm free distance between the machine and wall.

2.7 Operation Notices

- Read Section "1"' carefully before starting to use this equipment.
- Connect the ground wire with the machine directly.
- Ensure that the input is three-phase: 50/60Hz, 400V ±10%.
- Before operation, none concerned people should not be around the working area and especially children. Do not watch the arc in unprotected eyes.
- Ensure good ventilation of the machine to improve Duty Cycle.
- Turn off the engine when the operation finished for energy consumption efficiency.
- When power switch shuts off protectively because of failure. Don't restart it until problem is resolved. Otherwise, the range of problem will be extended.
- In case of problems, contact your local dealer if no authorized maintenance staff is available!

Precautions

Workspace

1. Welding equipment free of dust, corrosive gas, non-flammable materials, up to 90% humidity for use!
2. Avoid welding outdoors unless protected from direct sunlight, rain, snow, work area temperature must be between -10 °C and +40°C.
3. Wall to position the device at least 30 inches away.
4. Well-ventilated area to perform welding.

Safety requirements

Welding provides protection against overvoltage / overcurrent / overheating. If any of the above events occurs, the machine stops automatically. However, over- stress damage to the machine , keep the following guidelines :

1. Ventilation . When welding a strong current going through the machine , so the machine is not enough natural ventilation for cooling . The need to ensure adequate cooling, so the distance between the plane and any object around it at least 30 cm . Good ventilation is important to normal function and service life of the machine.
2. Continuously , the welding current does not exceed the maximum allowable value. Current overload may shorten its life or damage to the machine .
3. Surge banned ! Observance of tension range follow the main parameter table . Welding machine automatically compensates for voltage , allowing the voltage within permissible limits of law. If input voltages exceed the specified value , damaged parts of the machine .
4. The machine must be grounded! If you are operating in a standard, grounded AC pipeline in the event of grounding is provided automatically . If you have a generator or foreign , unfamiliar , non-grounded power supply using the machine , the machine is required for grounding connection point earth to protect against electric shock .
5. Suddenly stopping may be during welding when an overload occurs or the machine overheats . In this case, do not restart the computer , do not try to work with it right away, but do not turn off the power switch , so you can leave in accordance with the built-in fan to cool the welding machines .

WARNING!

If the welding equipment is used with the welding parameters above 180 amperes, the standard 230V electrical socket and plug for 16 amp circuit breaker is not sufficient for the required current consumption, it is necessary to use the welding equipment with 20A, 25A or even to the 32A industrial fuses! In this case, both the plug and the plug socket fork have to be replaced to 32A single phase fuse socket in compliance with all applicable rules. This work may only be carried out by specialists!

Maintenance

1. Remove power unit before maintenance or repair!
2. Ensure that proper grounding!
3. Make sure that the internal gas and electricity connections are perfect and tighten, adjust if necessary, if there is oxidation, remove it with sandpaper and then reconnect the cable.
4. Hands, hair, loose clothing should be kept away under electric parts, such as wires, fan.
5. Regularly dust from the machine clean, dry compressed air, a lot of smoke and polluted air to clean the machine every day!
6. The gas pressure is correct not to damage components of the machine.
7. If water would be, for example. rain, dry it in the machine and check the insulation properly! Only if everything is all right, go after the welding!

8 When not in use for a long time, in the original packaging in a dry place.

EN

CERTIFICATE OF EUROPEAN STANDARD

Manufacturer:
IWELD Ltd.
2314 Halásztelek
II. Rákóczi Ferenc street 90/B
Tel: +36 24 532-625
info@iweld.hu
www.iweld.hu

Item:
MIG 5200 DOUBLE PULSE
MIG 4200 DOUBLE PULSE
MIG 3200 DOUBLE PULSE
MIG 2800 DOUBLE PULSE
MIG 2800 DOUBLE PULSE T
Double Pulse MIG/MAG Welding Power Source

Applied Rules (1):
EN 60204-1:2005
EN 60974-10:2014,
EN 60974-1:2018

(1) References to laws, rules and regulations are to be understood as related to laws, rules and regulations in force at present.
Manufacturer declares that the above specified product is complying with all of the above specified rules and it also complying with the essential requirements as specified by the Directives 2014/35/EU, 2014/30/EU, 2006/42/EU and 2011/65/EU

Serial No.:

CE

Halásztelek (Hungary), 14/03/20

Managing Director:
András Bódi

ÁLTALÁNOS GARANCIÁLIS FELTÉTELEK A JÓTÁLLÁSI ÉS SZAVATOSSÁGI IGÉNYEK ESETÉN

1. 12 hónap kötelező jótállás

A jótállás időtartama 12 hónap. A jótállási határidő a fogyasztási cikk fogyasztó részére történő átadása, vagy ha az üzembe helyezést a vállalkozás vagy annak megbízottja végzi, az üzembe helyezés napjával kezdődik.

Nem tartozik jótállás alá a hiba, ha annak oka a termék fogyasztó részére való átadását követően lépett fel, így például, ha a hibát

- szakszerűtlen üzembe helyezés (kivéve, ha az üzembe helyezést a vállalkozás, vagy annak megbízottja végezte el, illetve ha a szakszerűtlen üzembe helyezés a használati-kezelési útmutató hibájára vezethető vissza)
- rendeltetés-ellenes használat, a használati-kezelési útmutatóban foglaltak figyelmen kívül hagyása,
- helytelen tárolás, helytelen kezelés, rongálás,
- elemi kár, természeti csapás okozta.

Jótállás keretébe tartozó hiba esetén a fogyasztó - elsősorban – választása szerint – kijavítást vagy kicserélést követelhet, kivéve, ha a választott jótállási igény teljesítése lehetetlen, vagy ha az a vállalkozásnak a másik jótállási igény teljesítésével összehasonlítva aránytalan többletköltséget eredményezne, figyelembe véve a szolgáltatás hibátlan állapotban képviselt értékét, a szerződésszegés súlyát és a jótállási igény teljesítésével a fogyasztónak okozott érdeksérelmet.

- ha a vállalkozás a kijavítást vagy a kicserélést nem vállalta, e kötelezettségének megfelelő határidőn belül, a fogyasztó érdekeit kímélve nem tud eleget tenni, vagy ha a fogyasztónak a kijavításhoz vagy a kicseréléshez fűződő érdeke megszűnt, a fogyasztó elállhat a szerződéstől. Jelentéktelen hiba miatt elállásnak nincs helye.

A fogyasztó a választott jogáról másikra térhet át. Az áttéréssel okozott költséget köteles a vállalkozásnak megfizetni, kivéve, ha az áttérésre a vállalkozás adott okot, vagy az áttérés egyébként indokolt volt.

A kijavítást vagy kicserélést – a termék tulajdonságaira és a fogyasztó által elvárható rendeltetésére figyelemmel – megfelelő határidőn belül, a fogyasztó érdekeit kímélve kell elvégezni. A vállalkozásnak törekednie kell arra, hogy a kijavítást vagy kicserélést legfeljebb tizenöt napon belül elvégezze.

A kijavítás során a termékbe csak új alkatrész kerülhet beépítésre.

Nem számít bele a jótállási időbe a kijavítási időnek az a része, amely alatt a fogyasztó a terméket nem tudja rendeltetésszerűen használni. A jótállási idő a terméknek vagy a termék részének kicserélése (kijavítása) esetén a kicserélt (kijavított) termékre (termékrészre), valamint a kijavítás következményeként jelentkező hiba tekintetében újból kezdődik.

A jótállási kötelezettség teljesítésével kapcsolatos költségek a vállalkozást terhelik.

A jótállás nem érinti a fogyasztó jogszabályból eredő – így különösen kellék- és termékszavatossági, illetve kártérítési – jogainak érvényesítését.

Fogyasztói jogvita esetén a fogyasztó a megyei (fővárosi) kereskedelmi és iparkamarák mellett működő békéltető testület eljárását is kezdeményezheti. A jótállási igény a jótállási jeggyel érvényesíthető. Jótállási jegy fogyasztó rendelkezésére bocsátásának elmaradása esetén a szerződés megkötését bizonyítottnak kell tekinteni, ha az ellenérték megfizetését igazoló bizonylatot - az általános forgalmi adóról szóló törvény alapján kibocsátott számlát vagy nyugtát - a fogyasztó bemutatja. Ebben az esetben a jótállásból eredő jogok az ellenérték megfizetését igazoló bizonylattal érvényesíthetőek.

A fogyasztó jótállási igényét a vállalkozásnál érvényesítheti.

2. Kiterjesztett garancia

Az IWELD Kft. a Forgalmazókkal együttműködve, az 1 éves kellékszavatossági kötelezettségét +1 évvel kiterjeszti (2 évre) a következőkben felsorolt hegesztőgépekre az alábbi feltételekkel:

minden GORILLA® hegesztőgép, ARC 160 MINI, HEAVY DUTY 250 IGBT, HEAVY DUTY 315 IGBT

A garanciavállalás során a Polgári Törvénykönyv 6:159. § (hibás teljesítési vélelem) nem alkalmazható, és a kiterjesztett garanciavállalás a Polgári Törvénykönyv 6:159. § - 6:167. § meghatározott kellékszavatossági jellegű felelősségvállalást jelent az alábbi feltételekkel.

A kiterjesztett garancia feltételei fent felsorolt hegesztőgépek esetében:

- Származás igazolása (eredeti számla, tulajdonos változás esetén adás-vételi szerződés) A végfelhasználónak meg kell őrizni a kiterjesztett garancia ideje alatt végig a vásárlást igazoló számlát!
- Kitöltött garancia jegy
- Maximum 12 havonta szakszerviz által elvégzett karbantartás, ami az átvizsgáláson és érintésvédelmi ellenőrzésen túl a teljes burkolat eltávolítása utáni szakszerű takarításból kell, hogy álljon!
- Karbantartást igazoló számlák és karbantartási jegyzőkönyv

A számláknak és egyéb dokumentumoknak mindenképpen tartalmaznia kell a berendezés típusát (típusszám, modell) és szériaszámát (Serial no.)!

A kiterjesztett garancia tartalma:

A kiterjesztett garanciát alkatrész, tényleges javítás, vagy csere formájában biztosítjuk. Amennyiben a javítás nem lehetséges, úgy a hibás eszköz cseréjét biztosítjuk.

A kiterjesztett garancia sem tartalmazza a berendezés postázását, országon belüli szállítását! A termék forgalmazója, szüksége estén, (kötelezettség nélkül) segítséget nyújt a berendezés szakszervizbe való eljuttatásában!

A kiterjesztett garanciális javításokat saját szakszervizünkben a cég telephelyén végezzük:

IWELD Kft. 2314 Halásztelek II. Rákóczi Ferenc út 90/B

Tel.: +36 24 532 625

szerviz@iweld.hu

H

JÓTÁLLÁSI JEGY

Forgalmazó:

IWELD KFT.
2314 Halásztelek
II. Rákóczi Ferenc út 90/B
Szerviz: Tel: +36 24 532 706
mobil: +36 70 335 5300

Sorszám:

..... típusú..... gyári számú .....
termékre a vásárlástól számított 12 hónapig kötelező jótállást vállalunk a jogszabály szerint. A jótállás lejárta után 3 évig biztosítjuk az alkatrész utánpótlást.
Vásárláskor kérje a termék próbáját!

Eladó tölti ki:

A vásárló neve: .....

Lakhelye: .....

.....

Vásárlás napja: ..... ÉV ..... HÓ ..... NAP

Eladó bélyegzője és aláírása:

Jótállási szelvények a kötelező jótállási időre

Bejelentés időpontja: .....

Hiba megszüntetésének időpontja: .....

Bejelentett hiba: .....

A jótállás új határideje: .....

A szerviz neve: ..... Munkaszám: .....

..... ÉV ..... HÓ ..... NAP

.....
aláírás

Figyelem!
A garancia jegyet vásárláskor érvényesíteni kell a készülék gyári számának feltüntetésével! A garancia kizárólag azonos napon, kiállított gyári számmal ellátott számlával együtt érvényes, ezért a számlát őrizze meg!

RO

Certificat de garanție

Distribuitor:
IWELD KFT.
2314 Halásztelek
Str. II.Rákóczi Ferenc 90/B
Ungaria
Service: Tel: +36 24 532 706
mobil: +36 70 335 5300

Număr:

..... tipul.....număr de serie .....
necesare sunt garantate timp de 12 luni de la data de produse de cumpărare, în conformitate cu legea. La trei ani după expirarea garantiei oferim piese de aprovizionare.
La cumpărături încercați produsul!

Completat de către Vânzător:

Numele clientului: .....

Adresa: .....

.....

Data de cumpărare: ..... An..... Lună ..... Zi

Ştampila şi semnătura vânzătorului:

Secțiuni de garanție a perioadei de garanție

Data raportului: .....

Data încetării: .....

Descriere defect: .....

Noul termen de garanție:.....

Numele serviciului: ..... Cod de locuri de muncă:.....

..... An..... Lună ..... Zi

.....
semnătura

Data raportului: .....

Data încetării: .....

Descriere defect: .....

Noul termen de garanție:.....

Numele serviciului: ..... Cod de locuri de muncă:.....

..... An..... Lună ..... Zi

.....
semnătura

Atenție!
Garanția trebuie să fie validate la timp de cumpărare a biletului fabrica numărul! Garantie numai pe aceeaşi zi, cu o factură poartă numărul de eliberat este valabil pentru o fabrica, deci proiectul de lege să-l păstrați!

SK

ZÁRUČNÝ LIST

Distribútor:

IWELD KFT.
2314 Halásztelek
II. Rákóczi Ferenc út 90/B
Service: Tel: +36 24 532 706
mobil: +36 70 335 5300

Poradové číslo:

Výrobok: ..... Typ: ..... Výrobné číslo: .....

Na tento výrobok platí záruka 12 mesiacov od kúpy podľa platnej legislatívy. Na uplatnenie záruky je nutné predložiť originálny nákupný doklad! Po uplynutí záručnej doby 3 roky Vám zabezpečíme prísun náhradných dielov.
Pri kúpe tovaru požiadajte o rozbalenie a kontrolu výrobku!

Vyplní predajca:

Meno kupujúceho: .....

Bydlisko: .....

Dátum zakúpenia: deň: ..... mesiac: ..... rok: .....

Pečiatka a podpis predajcu:

ZÁRUČNÉ KUPÓNY

Dátum nahlásenia: .....

Dátum odstránenia vady: .....

Nahlásená vada:.....

Nová záručná doba: .....

Návoz servisu: .....Číslo práce: .....

Deň: ..... mesiac: ..... rok: .....

.....

Podpis

Dátum nahlásenia: .....

Dátum odstránenia vady: .....

Nahlásená vada:.....

Nová záručná doba: .....

Návoz servisu: .....Číslo práce: .....

Deň: ..... mesiac: ..... rok: .....

.....

Podpis