

weldtech

WT140FC

INVERTER MIG WELDER

WORKSHOP SERIES



IGBT
INVERTER
TECHNOLOGY

OPERATING INSTRUCTIONS

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The Weldtech range from Euroquip uses latest technology design and engineering to produce welding products that combine market leading value and features with durability. Designed for discerning operators who seek professional results and product quality without the price tag of a full professional setup. Design emphasis is placed on simple, functional design and operation. Weldtech product is subject to stringent quality control and designed and manufactured to NZ & Australian standards.

Common use of Weldtech products include:

- Light Engineering
- Automotive
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Euroquip is a market leading provider of innovative power equipment solutions to a wide range of industries across New Zealand and Australia. Key product categories are; welding equipment, air compressors, power generators and cleaning equipment.

Euroquip's slogan is 'empowering industries', find out more about the advantage Euroquip brings at **www.euroquip.co.nz**.

Providing exceptional product support is a key component of Euroquip's market leading customer advantage focus. As part of this program, it is required for all products to be registered with Euroquip to qualify for product support. Products not registered with Euroquip are supported by a base 12 month warranty only. Spare parts and technical support will not be available for an unregistered product outside of this base warranty period. If a Euroquip dealer has not already registered your product, please register it online at www.euroquip.co.nz. To request a physical registration form, please contact Euroquip customer service on 0800 387 678.

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weldtech

IGBT
INVERTER
TECHNOLOGY

5.6kg
Super
Lightweight

10A
230V
Input Power
Requirement

Earth Clamp
Included

WT140FC

WORKSHOP SERIES

140A INVERTER MIG WELDER

Cutting edge Inverter IGBT Technology helps you weld like a pro on home, workshop and on-site projects

- Latest inverter technology for silky smooth welding performance
- Compact, lightweight design - only 5.6kg!
- 140A welding power for up to 4mm steel thickness
- Gasless welding machine - for improved convenience
- LED Display for instant feedback of amperage and voltage
- Suits 0.8mm flux cored MIG wire
- Includes 17256 MIG torch, earth lead & clamp, chipping hammer & hand-held welding mask



Dimensions: (L x W x H)	345x145x265
Weight:	5.6Kg
Input Power:	230V AC 50/60Hz 10A
Max. Input Current:	25A
Generator Capacity:	7.6KVA

MIG Current Output	40-140A
MIG Duty Cycle:	120A @ 60%
Wire Size	0.8mm Flux-cored
Spool Size	Mini-spool 1kg
Drive Rollers	0.8/0.9mm knurled

**INCLUDES
DIRECT CONNECT
MIG Torch**

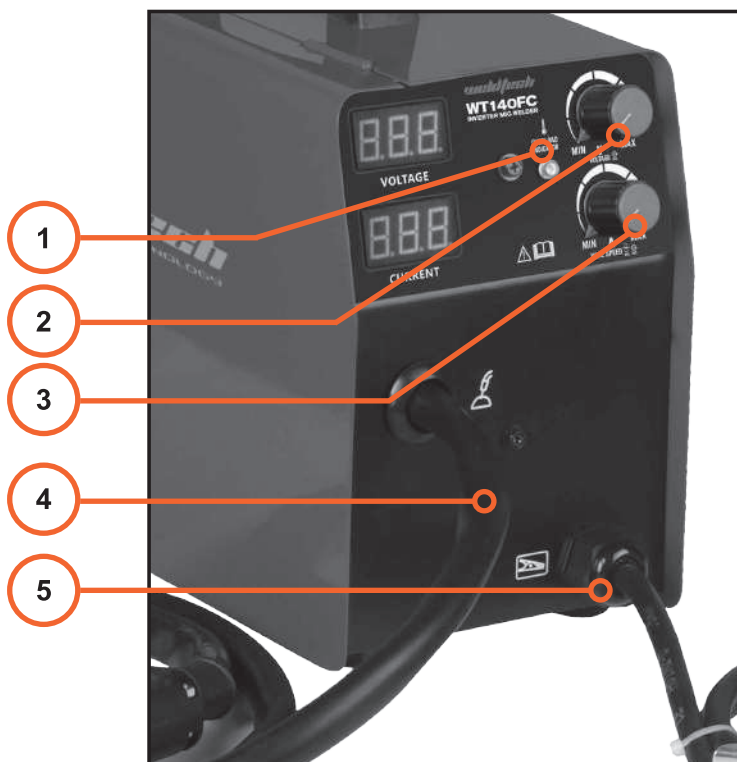
With 10A Plug - Perfect for home or workshop power supply!

140A | WELDS 4MM STEEL | 18 MONTH WARRANTY

WT140FC Welding Machine

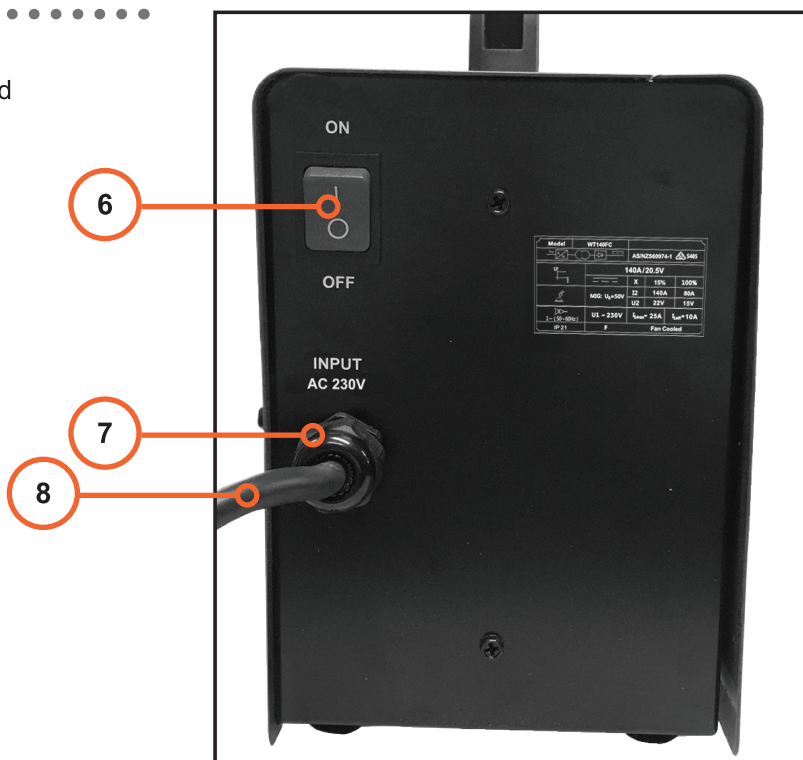
FRONT PANEL

1. Overload Error Indicator Light
2. Welding Voltage Control Knob
3. Wire Speed Control Knob
4. Welding Earth Lead
5. MIG Torch Output



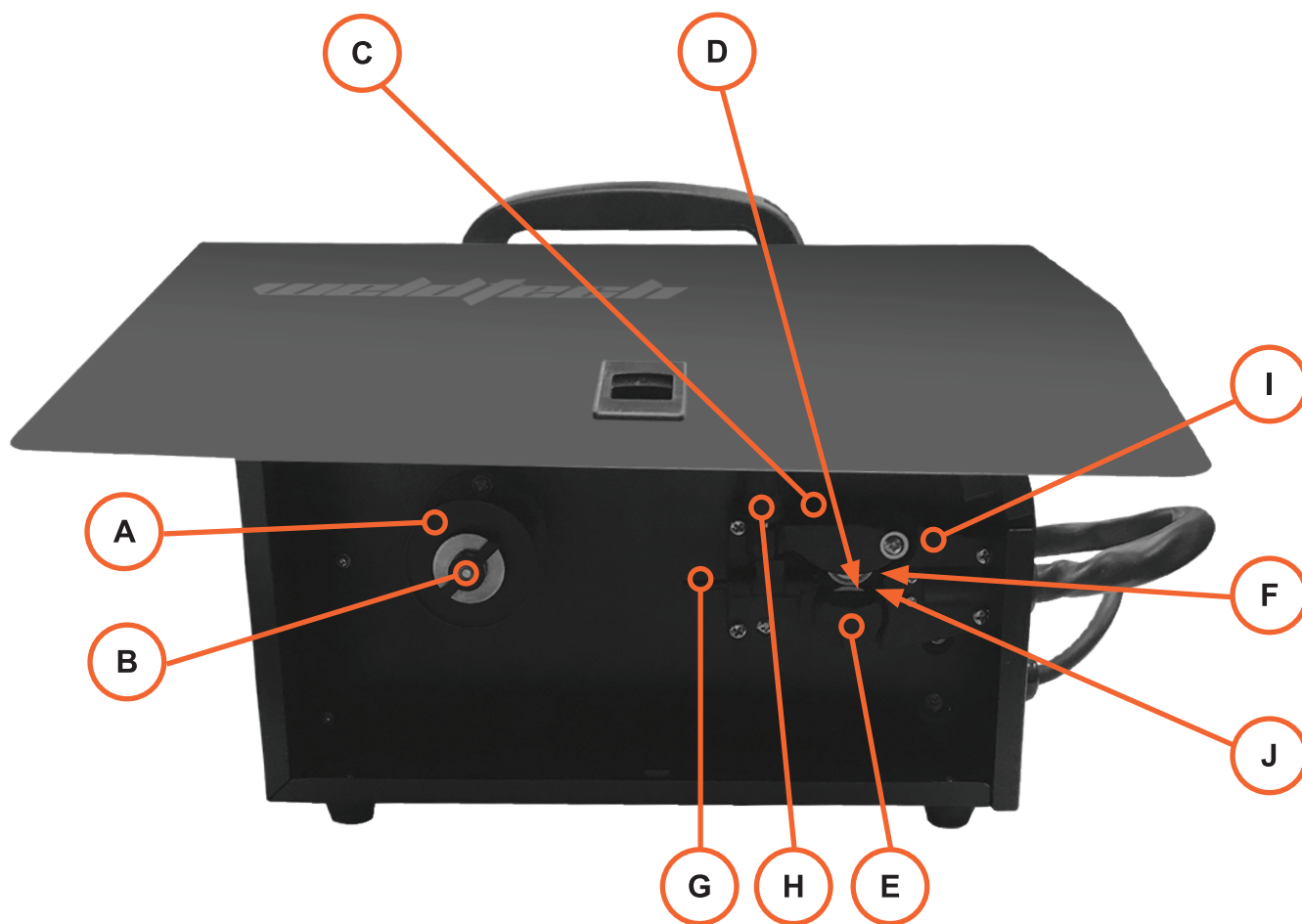
REAR PANEL

6. Mains Power Switch
7. 230V AC Mains Power Cord
8. 10 Amp Input Plug



SIDE PANEL (DOOR OPEN)

-
- A. Spool Hub **NOTE: This unit is suitable for Gasless MIG Wire <1Kg in weight**
 - B. Spool Hub Nut
 - C. Wire Drive Assembly
 - D. Drive Roller
 - E. Drive Roller Cover
 - F. Idle Roller
 - G. Guide Tube
 - H. Wire Feed Tensioning Knob
 - I. Wire Tensioning Arm
 - J. Inlet Tube

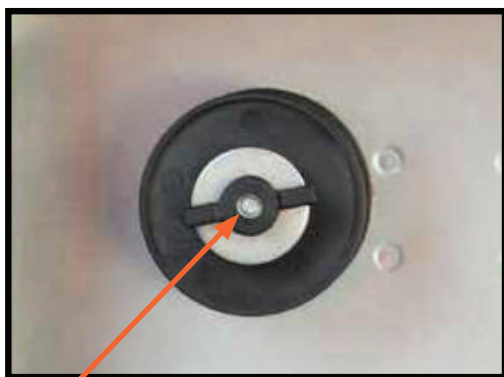


WT140FC Welding Machine

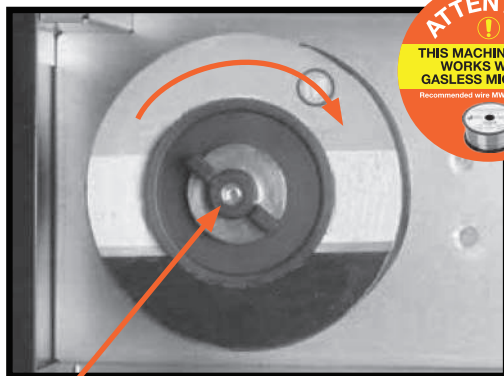
MACHINE SET UP GASLESS MIG WELDING



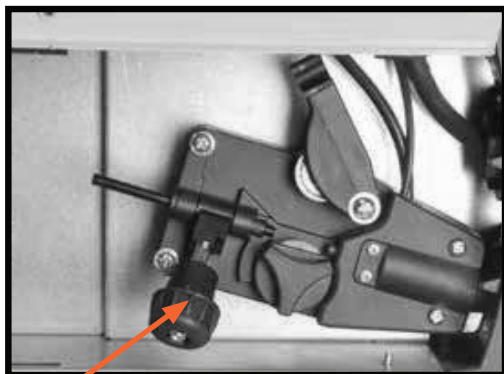
- 1 Open the side door of the machine.



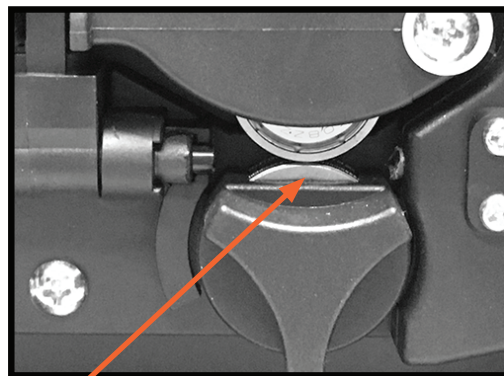
- 2 Remove the Spool Hub Nut and place spool of wire on Spool Hub.



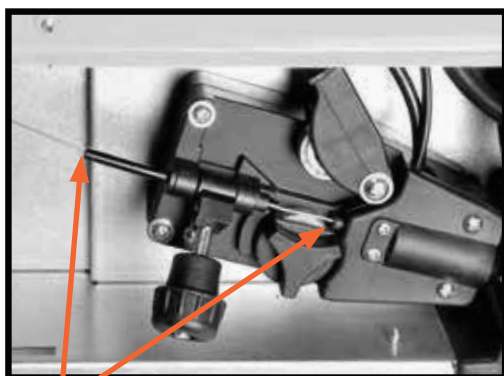
- 3 Replace Spool Hub Nut and adjust firmly - without too much pressure. **Note:** Wire to roll from over top of spool into wire feeder



- 4 Release the Wire Feed Tensioning Knob by pulling it down.

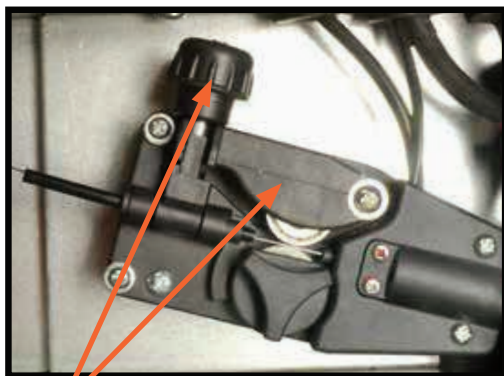


- 5 Remove the Drive Roller Cover. Check the Drive roller is matched to the wire size for the job **Note: Correct wire size on roller is stated (0.8mm).** Then replace the Drive Roller Cover, before feeding the wire



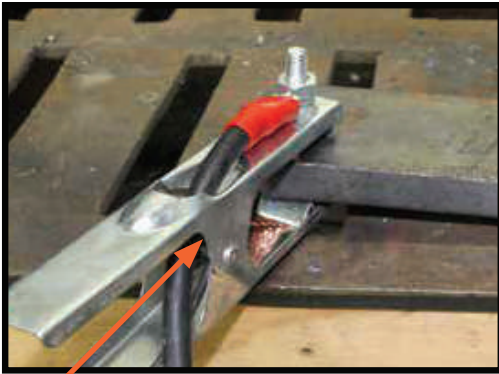
- 6 Take the end of the wire and feed it into the guide tube over the drive roller groove until it passes into the Inlet Tube, approx 100mm

Ensure you hold the spool and check tension to stop wire spool unraveling

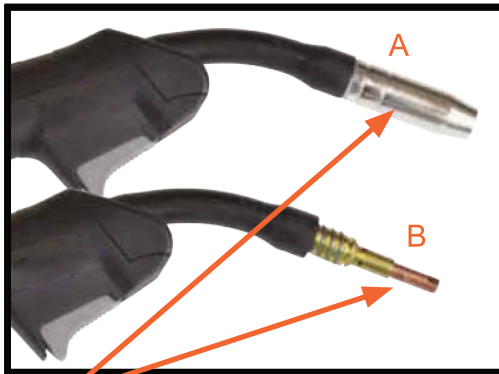


- 7 Put down Wire Tensioning Arm so it locks into position, and turn the Wire Feed Tensioning Knob to gently tighten.

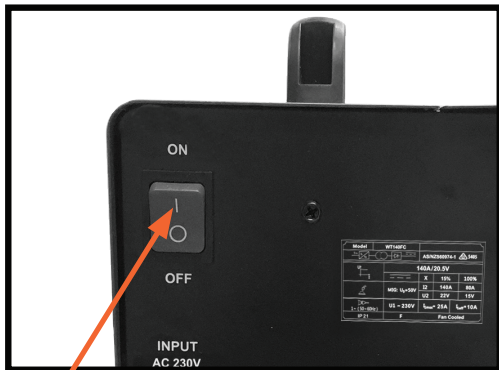
Note: Pictures may vary from your machine model 7



8 Connect earth clamp to the work piece ensuring that the clamp makes good contact with bare metal.



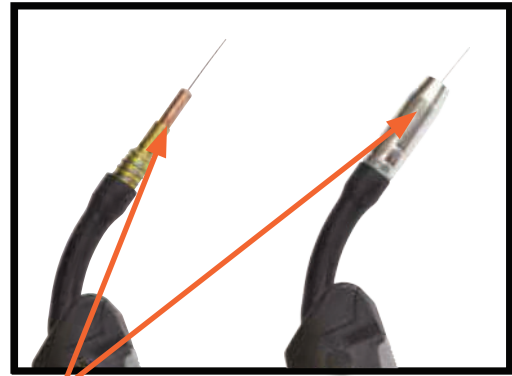
9 Remove nozzle (A) and tip (B) from torch.



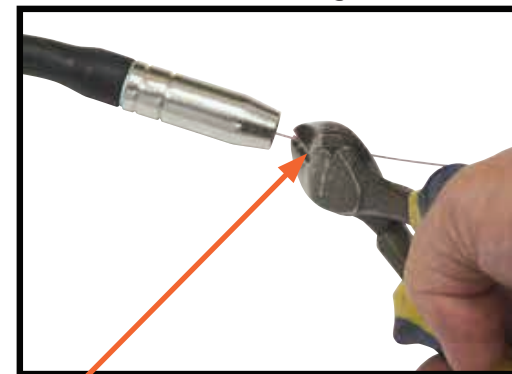
10 Plug machine into 230V and switch to the ON position on the back of machine.



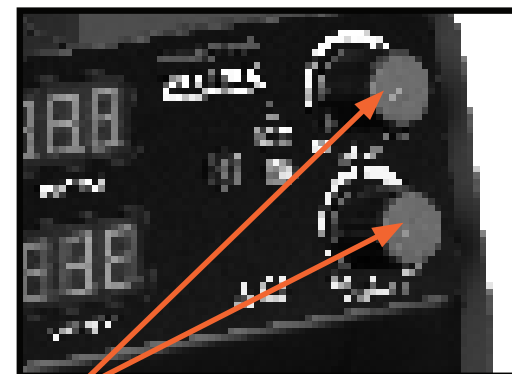
11 Press the trigger. This will feed the wire through the torch. Release button when wire appears at the end of the torch. **NOTE: Make sure your torch is laid out straight**



12 Re install tip over the wire and tighten, Do NOT over tighten, or you may damage the tip holder and re-attach nozzle to torch. **NOTE: Make sure your torch is laid out straight**



13 Trim wire to the end of the nozzle.



14 Set The welding Voltage and Wire Speed according to chart

Note: Pictures may vary from your machine model

DUTY CYCLE:

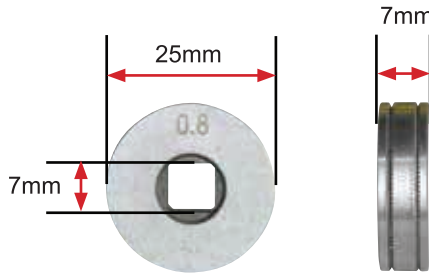
Special note:
If this welders duty cycle is exceeded the welder will enter “thermal overload” which will automatically stop the welding output in order to protect, both the user and the welder. You will know the welder has gone into thermal overload when the overload error indicator light is illuminated. The welder will then cool itself down, and once the overload error indicator light is no longer illuminated, welding can then re-commence.
Please note. Exceeding the machine’s duty cycle, cannot be considered grounds for warranty or return.
The term duty cycle indicates the percentage welding time available at the output current for each 10 min period over 4 hours,
The specification plate on the machine list three given ratings at a given current and voltage.

For example this means when the machine is set at a current of 140 Amps it can weld for one and a half Minutes in a Ten minute period.
The power source is protected by a built in temperature protection device,
This will activate if the machine is operated in excess of its amperage and duty cycle rating.

MACHINE DRIVE ROLLER SIZE (NOTE: MACHINE WILL RUN UP TO 0.8MM WIRE)

Knurled Drive Roller For Gasless Wire

DESCRIPTION
Drive Roller 0.6/0.8mm Knurled



25mm

7mm

7mm

0.8

ATTENTION

THIS MACHINE ONLY WORKS WITH GASLESS MIG WIRE

Recommended wire MWM308FC-1KG

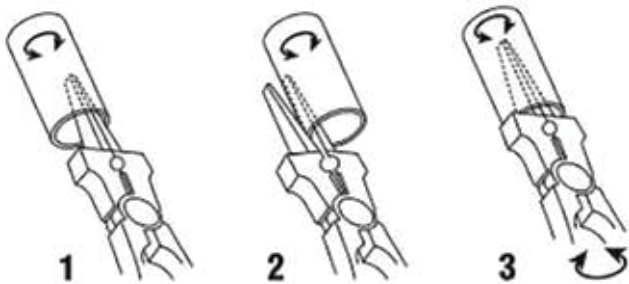
Proper MIG Torch inspection

Prior to welding, ensure all connections are tight and that consumables and equipment are in good condition and free from damage. Start with the front of the gun and work your way back to the feeder. A tight neck connection is essential to carry the electrical current from the welding cable to the front-end consumables. Also, be sure to visually inspect the handle and trigger to check there are no missing screws or damage. The cable should be free of cuts, kinks and damage along the outer cover. Cuts in the cable can expose the internal copper wiring and create a potential safety hazard to the welding operator. In addition, these issues can lead to electrical resistance that causes heat buildup — and ultimately cable failure.

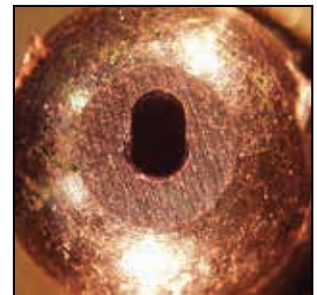
Consumables

MIG gun front-end consumables are exposed to heat and spatter and therefore often require frequent replacement. However, performing some simple maintenance can help extend consumable life and improve gun performance and weld quality. The gas diffuser provides gas flow to the weld pool and also connects to the neck and carries the electrical current to the contact tip. Make sure all connections are tight, and check the diffuser's O-rings for cracks, cuts or damage. The nozzle's main role is to focus the shielding gas around the weld pool. Watch for spatter buildup in the nozzle, which can obstruct gas flow and lead to problems due to inadequate shielding coverage. Use MIG pliers to clean spatter from the nozzle. The contact tip is the last point of contact between the welding equipment and the welding wire. Keyholing of the contact tip is a concern to watch for with this consumable. This occurs when the wire passing through the tip wears an oblong-shaped slot into the diameter of the tip. Keyholing can put the wire out of center and cause problems such as an erratic arc. If you are experiencing wire feeding issues, try changing the contact tip or switching to a larger-size contact tip. Tips that look worn should be replaced.

Spatter removal from inside and outside the nozzle using MIG pliers



Build up of spatter can cause damage to nozzle and tip



Keyholing of the contact tip

Final thoughts

Taking the time for preventative maintenance can pay off in less downtime in the long run. Along with that, always remember to properly store your MIG gun consumables to help you achieve the best results and extend the life of your equipment. When not in use, the MIG gun should be stored in a coiled position, either hanging or lying flat, such as on a shelf. Do not leave MIG gun on the floor of the shop.

Care & Maintenance

Keep your Welding Machine in Top Condition

The WT140FC does not require any special maintenance, however the user should take care of the machine as follows:

- Regularly clean the ventilation slots.
- Keep the casing clean.
- Check all cables before use.
- Check electrode holders, work lead/clamps and welding torches before use.
- Replace worn electrode holders and earth clamps, which do not provide a good connection.
- Replace worn torch consumable parts in a timely manner.
- Replace worn wire drive components in a timely manner.
- Use a soft cloth or brush to clean electrical components. Do not use liquid cleaning products, water or especially solvents.
- Do not use compressed air to clean electrical components as this can force dirt and dust further into components, causing electrical short circuits.
- Check for damaged parts. Do not use the welder with damaged parts.

If damaged, before further use, the welder must be carefully checked by a qualified person to determine that it will operate properly. Check for breakage of parts, mountings and other conditions that may affect its operation.

Have your welder repaired by an expert. An authorised service centre should properly repair a damaged part.

This appliance is manufactured in accordance with relevant safety standards. Only experts must carry out repairing of electrical appliances, otherwise considerable danger for the user may result. Use only genuine replacement parts. Do not use modified or non-genuine parts.

Storing the Welder

When not in use the welder should be stored in the dry and frost-free environment.



WARNING! Before performing cleaning/maintenance, replacing cables / connections, make sure the welding machine is switched off and disconnected from the power supply.



MIG Basic Welding Guide

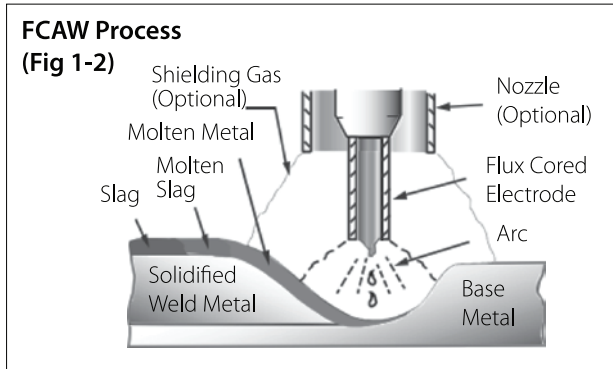
Mig Basic Welding Techniques

Two different welding processes are covered in this section (GMAW and FCAW), with the intention of providing the very basic concepts in MIG welding, where a welding gun is hand held, and the electrode (welding wire) is fed into a weld puddle, and the arc is shielded by a gas (GMAW) or flux cored wire (FCAW).

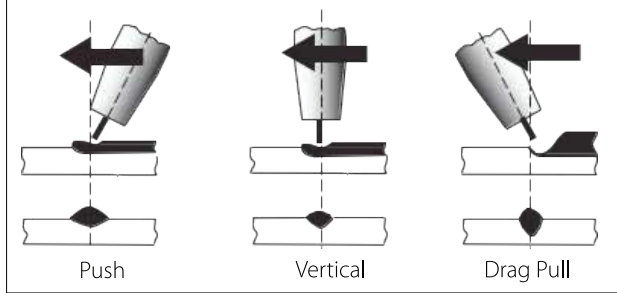
Flux Cored Arc Welding (FCAW)

This is an electric arc welding process which fuses together the parts to be welded by heating them with an arc between a continuous flux filled electrode wire and the work. Shielding is obtained through decomposition of the flux within the tubular wire. Additional shielding may or may not be obtained from an externally supplied gas or gas mixture. The process is normally applied semi automatically; however the process may be applied automatically or by machine.

It is commonly used to weld large diameter electrodes in the flat and horizontal position and small electrode diameters in all positions. The process is used to a lesser degree for welding stainless steel and for overlay work.



Position of MIG Torch (Fig 1-3)



The angle of MIG torch to the weld has an effect on the width of the weld.

The welding gun should be held at an angle to the weld joint. (See Secondary Adjustment Variables below).

Hold the gun so that the welding seam is viewed at all times. Always wear the welding helmet with proper filter lenses and use the proper safety equipment.

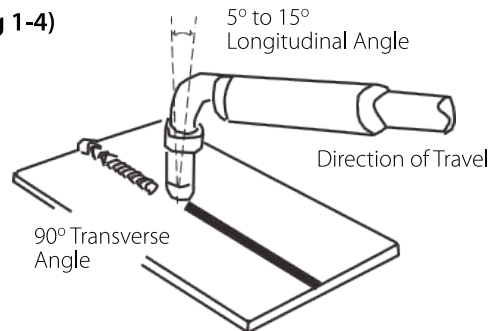


CAUTION!

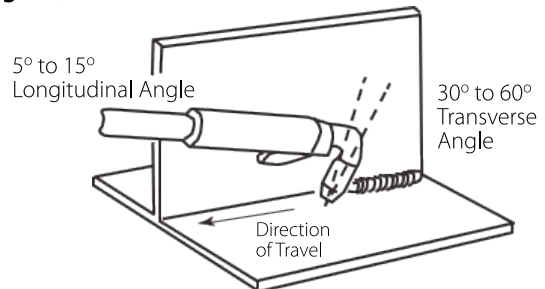
Do not pull the welding gun back when the arc is established. This will create excessive wire extension (stick-out) and make a very poor weld.

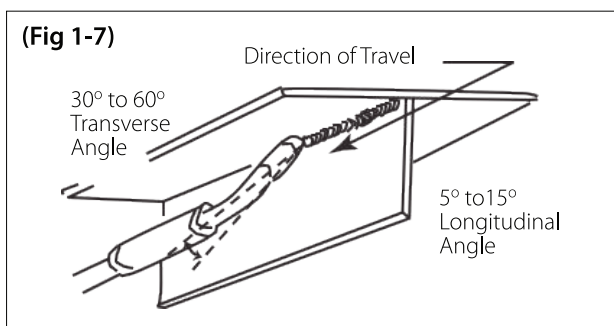
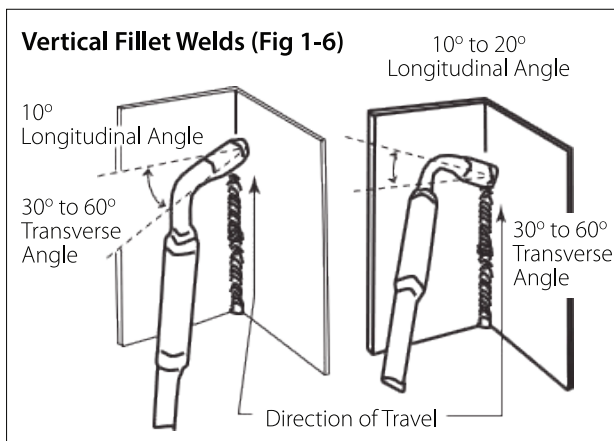
The electrode wire is not energized until the gun trigger switch is depressed. The wire may therefore be placed on the seam or joint prior to lowering the helmet.

(Fig 1-4)



(Fig 1-5)





Distance from the MIG Torch Nozzle to the Work Piece

The electrode wire stick out from the MIG Torch nozzle should be between 10mm to 20mm. This distance may vary depending on the type of joint that is being welded.

Travel Speed

The speed at which the molten pool travels influences the width of the weld and penetration of the welding run.

MIG Welding (GMAW) Variables

Most of the welding done by all processes is on carbon steel. The items below describe the welding variables in short-arc welding of 24gauge (0.024", 0.6mm) to ¼" (6.4mm) mild sheet or plate. The applied techniques and end results in the GMAW process are controlled by these variables.

Preselected Variables

Preselected variables depend upon the type of material being welded, the thickness of the material, the welding position, the deposition rate and the mechanical properties.

These variables are:

- Type of electrode wire
- of Size electrode wire
- Type of gas
- Gas flow rate

Primary Adjustable Variables

These control the process after preselected variables have been found. They control the penetration, bead width, bead height, arc stability, deposition rate and weld soundness.

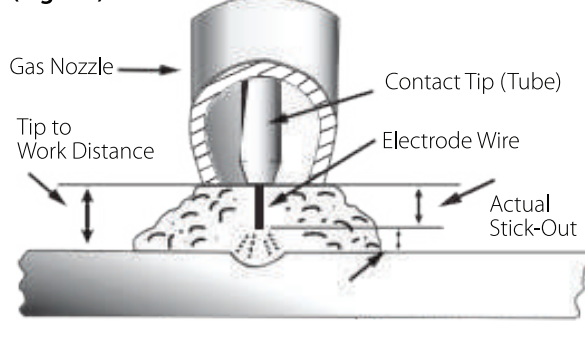
- They are:
- Arc Voltage
 - Welding current (wire feed speed)
 - Travel speed

Secondary Adjustable Variables

These variables cause changes in primary adjustable variables which in turn cause the desired change in the bead formation. They are:

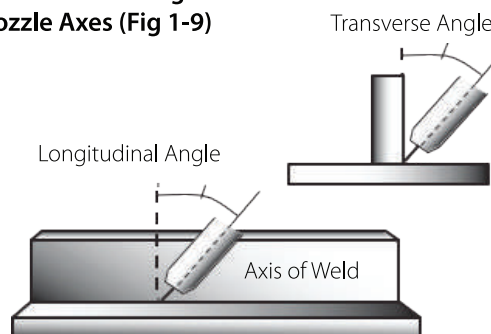
- 1. Stick-Out** (distance between the end of the contact tube (tip) and the end of the electrode wire). Maintain at about 10mm stick-out
- 2. Wire Feed Speed.** Increase in wire feed speed increases weld current. Decrease in wire feed speed decreases weld current.

Electrode Stick-Out (Fig 1-8)

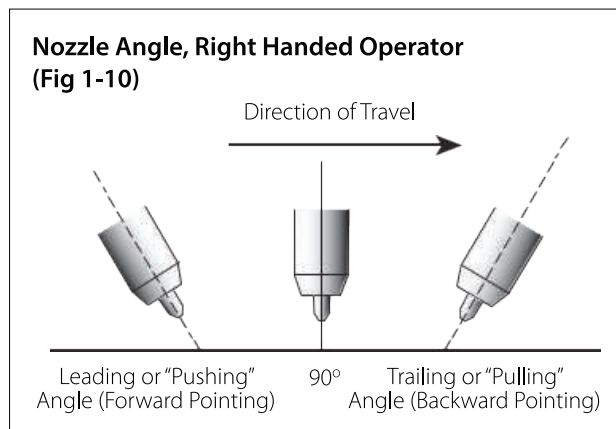


- 3. Nozzle Angle.** This refers to the position of the welding gun in relation to the joint. The transverse angle is usually one half the included angle between plates forming the joint. The longitudinal angle is the angle between the centre line of the welding gun and a line perpendicular to the axis of the weld. The longitudinal angle is generally called the Nozzle Angle and can be either trailing (pulling) or lead-

Transverse & Longitudinal Nozzle Axes (Fig 1-9)



ing (pushing). Whether the operator is left handed or right handed has to be considered to realize the effects of each angle in relation to the direction of travel.



Establishing the Arc and Making Weld Beads

Before attempting to weld on a finished piece of work, it is recommended that practice welds be made on a sample metal of the same material as that of the finished piece.

The easiest welding procedure for the beginner to experiment with MIG welding is the flat position. The equipment is capable of flat, vertical and overhead positions.

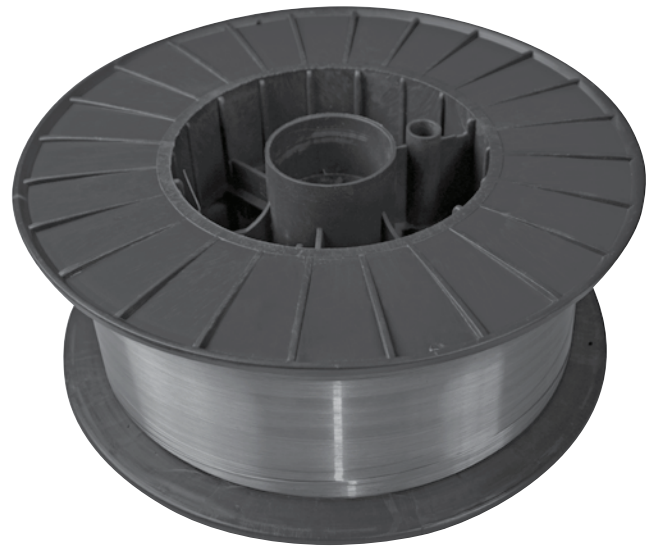
For practicing MIG welding, secure some pieces of 16 or 18 gauge (1.5mm or 2.0mm) mild steel plate (150 x 150mm). Use (0.8mm) flux cored gasless wire or a solid wire with shielding gas.

Setting of the Power Source

Power source and Current (Wire Speed) setting requires some practice by the operator, as the welding plant has two control settings that have to balance. These are the Current (Wire Speed) control and the welding Voltage Control.

The welding current is determined by the Current (Wire Speed) control, the current will increase with increased Current (Wire Speed), resulting in a shorter arc. Less Current (Wire Speed) will reduce the current and lengthen the arc. Increasing the welding voltage hardly alters the current level, but lengthens the arc. By decreasing the voltage, a shorter arc is obtained with a little change in current level.

When changing to a different electrode wire diameter, different control settings are required. A thinner electrode wire needs more Current (Wire Speed) to achieve the same current level.



A satisfactory weld cannot be obtained if the Current (Wire Speed) and Voltage settings are not adjusted to suit the electrode wire diameter and the dimensions of the work piece.

If the Current (Wire Speed) is too high for the welding voltage, "stubbing" will occur as the wire dips into the molten pool and does not melt. Welding in these conditions normally produces a poor weld due to lack of fusion. If, however, the welding voltage is too high, large drops will form on the end of the wire, causing spatter. The correct setting of voltage and Current (Wire Speed) can be seen in the shape of the weld deposit and heard by a smooth regular arc sound.

Electrode Wire Size Selection

The choice of Electrode wire size and shielding gas used depends on the following:

- Thickness of the metal to be welded
- Type of joint
- Capacity of the wire feed unit and power source
- The amount of penetration required
- The deposition rate required
- The bead profile desired
- The position of welding
- Cost of the wire

MIG Welding Troubleshooting

The general approach to fix Gas Metal Arc Welding (GMAW) problems is to start at the wire spool then work through to the MIG torch. There are two main areas where problems occur with GMAW, Porosity and Inconsistent wire feed.

When there is a gas problem the result is usually porosity within the weld metal. Porosity always stems from some contaminant within the molten weld pool which is in the process of escaping during solidification of the molten metal.

Contaminants range from no gas around the welding arc to dirt on the workpiece surface. Porosity can be reduced by checking the following points.

Troubleshooting - Porosity	
Fault	Cause
Welding in a windy environment.	Shield the weld area from the wind or increase the gas flow.
Welding dirty, oily, painted, oxidised or greasy plate.	Clean contaminates off the work piece.
Distance between the MIG torch nozzle and the work piece.	Keep the distance between the MIG torch nozzle and the work piece to a minimum.
Maintain the MIG torch in good working order.	Ensure that the gas holes are not blocked and gas is exiting out of the torch nozzle.
	Do not restrict gas flow by allowing spatter to build up inside the torch nozzle.
	Check that the MIG torch O-rings are not damaged.



WARNING!

Disengage the feed roll when testing for gas flow by ear.

Wire feeding problems can be reduced by checking the following points.

Troubleshooting - Wire Feed	
Fault	Cause
Feed roller driven by motor in the cabinet slipping.	Wire spool brake is too tight.
Wire spool unwound and tangled.	Wire spool brake is too loose.
Worn or incorrect feed roller size	Use a feed roller matched to the size you are welding.
	Replace feed roller if worn.
Wire rubbed against the misaligned guides affecting the wire feed.	Misalignment of inlet/outlet guides.
Liner blocked with swarf.	Increased amounts of swarf are produced by the wire passing through the feed roller when excessive pressure is applied to the pressure roller adjuster.
	Swarf can also be produced by the wire passing through an incorrect feed roller groove shape or size.
	Swarf is fed into the conduit liner where it accumulates thus reducing wire feed.
Incorrect or worn contact tip.	The contact tip transfers the weld current to the electrode wire. If the hole in the contact tip is too large then arcing may occur inside the contact tip resulting in the wire jamming in the contact tip.
	When using soft wire such as aluminium it may become jammed in the contact tip due to expansion of the wire when heated. A contact tip designed for soft wires should be used.
Poor work lead contact to work piece.	If the work lead has a poor electrical contact to the work piece then the connection point will heat up and result in a reduction of power at the arc.
Bent liner.	This will cause friction between the wire and the liner thus reducing wire feed.



Other weld problems can be reduced by checking the following points.

Troubleshooting - MIG Weld Quality		
Fault	Cause	Remedy
Undercut.	Welding arc voltage too high.	Decrease voltage or increase the wire feed speed.
	Incorrect torch angle.	Adjust angle.
	Excessive heat input.	Increase the torch travel speed and/or decrease welding current by decreasing the voltage or decreasing the wire feed speed.
Lack of penetration.	Welding current too low.	Increase welding current by increasing wire feed speed and increasing voltage.
	Joint preparation too narrow or gap too tight.	Increase joint angle or gap.
	Shielding gas incorrect.	Change to a gas which gives higher penetration.
Lack of fusion.	Voltage too low.	Increase voltage.
Excessive spatter.	Voltage too high.	Decrease voltage or increase the Current (Wire Speed) control.
	Voltage too low.	Increase the voltage or decrease Current (Wire Speed).
Irregular weld shape.	Incorrect voltage and current settings. Convex, voltage too low. Concave, voltage too high.	Adjust voltage and current by adjusting the voltage control and the Current (Wire Speed) control.
	Wire is wandering.	Replace contact tip.
	Incorrect shielding gas.	Check shielding gas.
	Insufficient or excessive heat input.	Adjust the Current (Wire Speed) control or the voltage control.
Weld cracking.	Weld bead is too small.	Decrease travel speed.
	Weld penetration narrow and deep.	Reduce current and voltage and increase MIG torch travel speed or select a lower penetration shielding gas.
	Excessive weld stresses.	Increase weld metal strength or revise design.
	Excessive voltage.	Decrease voltage.
	Cooling rate too fast.	Slow the cooling rate by preheating part to be welded or cool slowly.
Cold weld puddle.	Loose welding cable connection.	Check all welding cable connections.
	Low power supply voltage.	Contact supply authority.
Arc does not have a crisp sound that short arc exhibits when the wire feed speed and voltage are adjusted correctly.	The MIG torch has been connected to the wrong voltage polarity on the front panel.	Connect the MIG torch to the positive (+) welding terminal for solid wires and gas shielded flux cored wires. Refer to the electrode wire manufacturer for the correct polarity.



WARNING

The device and packaging material are not toys! Children must not be allowed to play with the machine and its accessories. Plastic parts and packaging are choking risks for children.

- Open the packaging and remove the welder carefully.
- Check that the delivery is complete.
- If possible, store the packaging until the warranty period has expired.

PERSONAL PROTECTIVE EQUIPMENT (PPE)



GLOVES AND PROTECTIVE CLOTHING

Use protective gloves and fire resistant protective clothing when welding.
Avoid exposing skin to ultraviolet rays produced by the arc.



WELDING HELMET

Under no circumstances should the welder be operated unless the operator is wearing a welding helmet to protect the eyes and face. There is serious risk of eye damage if a helmet is not used. The sparks and metal projectiles can cause serious damage to the eyes and face. The light radiation produced by the arc can cause damage to eyesight, and burns to skin. Never remove the welding helmet whilst welding.



SAFETY GLASSES

After welding use appropriate safety glasses when brushing, chipping or grinding the slag from the weld.



OTHER PERSONS

Ensure that other persons are screened from the welding arc and are at least 15 metres away from the work piece. Always ensure that the welding arc is screened from onlookers, or people just passing by. Use screens if necessary, or non-reflecting welding curtain. Do not let children or animals have access to the welding equipment or to the work area.



SWITCHING OFF

When the operator has finished welding they must switch the welder off.
DO NOT put the electrode holder down with the welder switched ON.
When leaving the welder unattended, move the ON/OFF switch to the OFF position and disconnect the welder from the electrical mains supply.
Do not leave hot material unattended after welding.



FUMES & GASES ARE DANGEROUS

Smoke and gas generated whilst welding or cutting can be harmful to people's health. Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Do not breathe the smoke and gas generated whilst welding or cutting, keep your head out of the fumes
- Keep the working area well ventilated, use fume extraction or ventilation to remove welding fumes and gases.
- In confined or heavy fume environments always wear an approved air-supplied respirator. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not weld in locations near de-greasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapours to form highly toxic and irritating gases.
- Materials such as galvanized, lead, or cadmium plated steel, containing elements that can give off toxic fumes when welded. Do not weld these materials unless the area is very well ventilated, and or wearing an air supplied respirator.



MACHINE CARE / SAFETY

Keep the welding cables, earth clamp and electrode holder in good condition. Failure to do this can result in poor welding quality, which could be dangerous in structural situations.

Prior to use, check for breakage of parts and any other conditions that may affect operation of the welder.

Any part of the welder that is damaged should be carefully checked to determine whether it will perform its intended function whilst being safe for the operator. Any part that is damaged should be properly repaired, or replaced by an authorised service centre.

IMPROPER USE

It is hazardous to use the welding machine for any work other than that for which it was designed e.g. do not use welder for thawing pipes.

HANDLING

Ensure the handle is correctly fitted. As welding machines can be heavy, always use safe lifting practices when lifting.

POSITION AND HANDLING

To reduce risk of the machine being unstable / danger of overturning, position the welding machine on a horizontal surface that is able to support the machine weight. Operators **MUST NOT BE ALLOWED** to weld in raised positions unless safety platforms are used.



SAFETY INSTRUCTIONS

WARNING

The user of this welder is responsible for their own safety and the safety of others. It is important to read, understand and respect the contents of this user guide. When using this welder, basic safety precautions, including those in the following sections must be followed to reduce the risk of fire, electric shock and personal injury. Ensure that you have read and understood all of these instructions before using this welder.

Persons who are not familiar with this user guide should not use this welder. Keep this booklet in a safe place for future reference.

TRAINING

The operator should be properly trained to use the welding machine safely and should be informed about the risks relating to arc welding procedures. This user guide does not attempt to cover welding technique. Training should be sought from qualified / experienced personnel on this aspect, especially for any welds requiring a high level of integrity for safety.

SERIOUS FIRE RISK

The welding process produces sparks, droplets of fused metal, metal projectiles and fumes.

This constitutes a serious fire risk. Ensure that the area in which welding will be undertaken is clear of all inflammable materials. It is also advisable to have a fire extinguisher, and a welding blanket on hand to protect work surfaces.



WORK AREA



Ensure a clear, well lit work area with unrestricted movement for the operator.



The work area should be well ventilated, as welding emits fumes which can be dangerous.



Always maintain easy access to the ON/OFF switch of the welder, and the electrical mains supply.



Do not expose the welder to rain and do not operate in damp or wet locations

Where welding must be undertaken in environments with increased risk of electric shock, confined spaces or in the presence of flammable or explosive materials, it is important that the environment be evaluated in advance by an “expert supervisor”. It is also recommended that welding in these circumstances be carried out in the presence of persons trained to intervene in emergencies.

AVOID ELECTRICAL CONTACT

Use adequate electrical insulation with regard to the electrode, the work piece and any accessible earthed metal parts in the vicinity. Avoid direct contact with the welding circuit. The no load voltage between the earth clamp and the electrode can be dangerous under certain circumstances.

Note: For additional protection from electric shock. It is recommended that this welder be used in conjunction with a residual current device (RCD) with rated residual current of 30MA or less.

In general the use of extension leads should be avoided. If used however, ensure that the extension lead is used with the welder is of a suitable current rating and heavy duty in nature that **MUST** have an earth connection. If using the welder outdoors, ensure that the extension lead is suitable for outdoor use. Always keep extension leads away from the welding zone, moisture and any hot materials.

WELDING SURFACES

Do not weld containers or pipes that hold, or have held, flammable liquids or combustible gases or pressure. Do not weld on coated, painted or varnished surfaces as the coatings may ignite, or can give off dangerous fumes.

WORK PIECE

When welding, the work piece will remain at high temperature for a relatively long period. The operator must not touch the weld or the work piece unless wearing welding gloves. Always use pliers or tongs. Never touch the welded material with bare hands until it has completely cooled.

VOLTAGE BETWEEN ELECTRODE HOLDERS OR TORCHES

Working with more than one welding machine on a single work piece, or on work pieces that are connected, may generate a dangerous accumulation of no-load voltage between two different electrode holders or torches, the value of which may reach double the allowed limit.



MAINTENANCE

WARNING

Before starting any cleaning, or maintenance procedures on the welding machine, make sure that it is switched OFF and disconnected from the mains supply.

There are no user serviceable parts inside the welder. Refer to a qualified service personnel if any internal maintenance is required. After use, wipe the welder down with a clean soft dry cloth.

Regular inspection of the supply cord is required and if damaged is suspected, it must be immediately replaced by the manufacturer, its service agent or similarly qualified persons in order to avoid a hazard

STORAGE/ TRANSPORT

Store the welder and accessories out of children's reach in a dry place. If possible store the welder in the original packaging. The appliance must unconditionally be secured against falling or rolling over during transport.



DISPOSAL

DISPOSING OF THE PACKAGING

Recycling packaging reduces the need for landfill and raw materials. Reuse of the recycled material decreases pollution in the environment. Please recycle packaging where facilities exist. Check with your local council authority for recycling advice.

DISPOSING OF THE WELDER

Welders that are no longer usable should not be disposed of with household waste but in an environmentally friendly way. Please recycle where facilities exist. Check with your local council authority for recycling advice.

Warranty

As part of an on-going commitment to excellence in product support, Euroquip offers a comprehensive product warranty program.

Registered warranty period for the WT140FC:

Commercial Use: 18 Months

Domestic Use: 18 Months

Warranty covers failure caused by manufacturing and material defects in the product, during the warranty period specified. The warranty period begins when the product is purchased by the end user. Warranty is not transferrable and is only claimable by the original purchaser.

Warranty does not cover parts that are subject to wear and tear from usage.

Warranty covers failure of a product caused by defective materials and/or manufacturing for the period given and the usage specified by Euroquip. The warranty period begins when the product is purchased by the end user. Warranty is not transferrable and is only claimable by the original purchaser.

Warranty also does not cover failure caused by the untimely replacement or service of the above wearing parts. Evidence must be provided that the product has been maintained and serviced suitably for a claim to be considered under warranty.

Failure caused by incorrect operation of the product, lack of proper care and maintenance of the product, external damage, external circumstances such as contaminated fuel or poor water supply, modifications to the product, attempted repair/ service by a party other than an Approved Service Agent, is not covered under warranty.

Warranty does not cover pre delivery service and ad-

justment, or failure that may occur as a result of lack of/ incorrect pre delivery service and adjustment.

Warranty does not cover any incidental, indirect or consequential loss, damage or expense that may result from any defect, failure or malfunction of a product.

Should any issue be found to be a combination of a warranty failure and a non-warranty issue, the repair cost component to rectify and repair the non-warranty failure is the customers' full responsibility.

The decision that an issue with a product qualifies as a warranty claim is made at the sole jurisdiction of Euroquip.

No costs incurred will be considered under warranty if repairs are carried out by a party other than a Euroquip Approved Service Agent, unless with prior consent in writing from Euroquip.

It is the responsibility of the purchaser to deliver a product under warranty to the nearest relevant service agent or product reseller. Warranty does not cover call outs, mileage and freight costs.

If a product is repaired under warranty, parts and labour required for the repair will be supplied at no charge. Warranty assessment and repair will be scheduled and executed according to the normal work flow at the service location and depending on the availability of suitable replacement parts.

This warranty policy is an additional benefit and does not affect the legal rights of any end user, reseller or service agent.



Congratulations on your new WELDTECH product. We are proud to have you as our customer and will strive to provide you with the best service and reliability in the industry. This product is backed by our extensive warranty and service network. To locate your nearest distributor or service agency visit www.weldtech.net.nz, or email us at customerservice@euroquip.co.nz

www.weldtech.net.nz