# TitanCut 100
## Operating Manual

Operating manual EN

Brugsanvisning DA

Gebrauchsanweisung DE

Manual de instrucciones ES

Käyttöohje FI

Manuel d'utilisation FR

Manuale d'uso IT

Gebruiksaanwijzing NL

Bruksanvisning NO

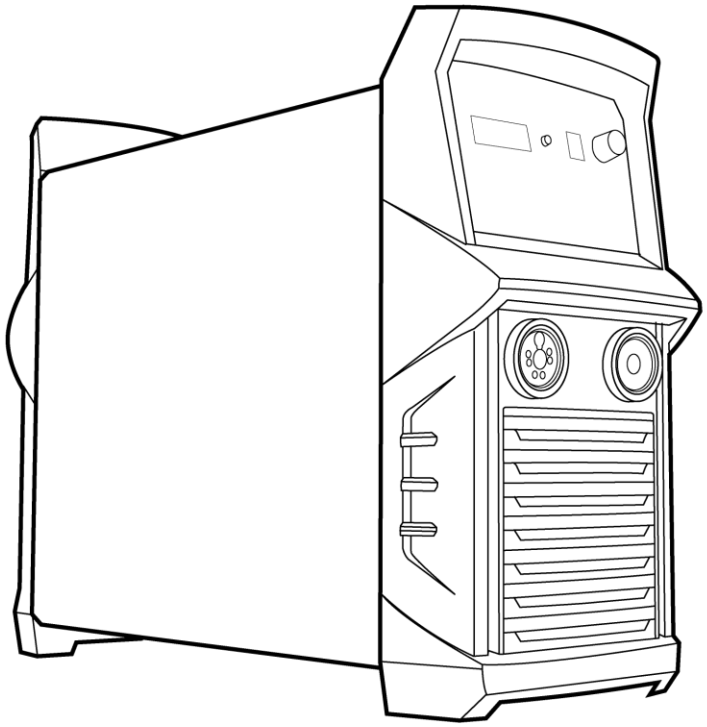
Instrukcja obsługi PL

Manual de utilização PT

Инструкции по эксплуатации RU

Bruksanvisning SV

操作手册 CN



## English

**TitanCut 100 Plasma Cutter**

**Model No.** TCUT100 **Issue.** A 12/16

## Welcome:

**Thank you for your purchase of your new Weldtronic product.** The Weldtronic product range provides you with quality and reliability.

This product is supported by our extensive service network. In the unlikely event of a problem occurring please call your local distributor.

Please record below the details from your product as these will be required for warranty purposes and to ensure you get the correct information should you require assistance or spare parts.

**Date purchased:** _____

**From where:** _____

**Serial No:** _____

*(The serial number will be located on the equipment data plate underneath or on the rear panel)*

This Operating manual has been designed to instruct you on the correct use and operation of your Weldtronic product. Information is a guide and we assume no liability for its use.

Please take the time to read the entire manual paying particular attention to the Safety Precautions. They will help you to avoid potential hazards that may exist when working with this product.

**2 Year Warranty Statement.**

- This product is covered by a 2 Year Warranty Parts & Labour Warranty.
- This warranty does not cover freight or goods that have been interfered with.
- All goods in question must be repaired by an authorized repair agent as appointed by Weldtronic.
- Warranty does not cover abuse, misuse, accident, theft or general wear & tear.
- New product will not be supplied unless Weldtronic International P/L has inspected product returned for warranty and agrees to replace the product.
- Product will only be replaced if repair is not possible.
- Warranty will be considered void if the 15 Amp primary power Input Plug is modified or replaced to fit a domestic 10A primary power input Plug.
- Warranty will be considered void if the equipment is powered from an unsuitable engine driven generator.
- Warranty will be considered void if no proof of purchase can be provided.
- Warranty will be considered void if this product has been altered, tampered or used in any manner contrary to customary usage or application.
- Full warranty details and conditions supplied with this product are shown in the back of this manual.

# Contents

# SAFETY PRECAUTIONS – READ BEFORE USING

These general safety norms cover both arc welding machines and plasma cutting machines unless otherwise noted.
The equipment must only be used for the purpose it was designed for. Using it in any other way could result in damage or injury and in breach of the safety rules. Only suitably trained and competent persons should use the equipment. Operators should respect the safety of other persons.

**OPERATION AND MAINTENANCE OF PLASMA ARC EQUIPMENT CAN BE DANGEROUS AND HAZARDOUS TO YOUR HEALTH.**

Plasma arc cutting produces intense electric and magnetic emissions that may interfere with the proper function of cardiac pacemakers, hearing aids, or other electronic health equipment. Persons who work near plasma arc cutting applications should consult their medical health professional and the manufacturer of the health equipment to deter- mine whether a hazard exists.
To prevent possible injury, read, understand and follow all warnings, safety precautions and instructions before using the equipment.

**GASES & FUMES**

Gases and fumes produced during the plasma cutting process can be dangerous and hazardous to your health.
• Keep all fumes and gases from the breathing area. Keep your head out of the cutting fume plume.
• Use an air-supplied respirator if ventilation is not adequate to remove all fumes and gases.
• The kinds of fumes and gases from the plasma arc depend on the kind of metal being used, coatings on the metal, and the different processes. You must be very careful when cutting or cutting any metals which may contain one or more of the following:

| | | | |
|---|---|---|---|
| Antimony | Chromium | Mercury | Beryllium |
| Arsenic | Cobalt | Nickel | Lead |
| Barium | Copper | Selenium | Silver |
| Cadmium | Manganese | Vanadium | |

Always read the Material Safety Data Sheets (MSDS) that should be supplied with the material you are using.
These MSDSs will give you the information regarding the kind and amount of fumes and gases that may be dangerous to your health.
• Use special equipment, such as water or down draft cutting tables, to capture fumes and gases.
• Do not use the plasma torch in an area where combustible or explosive gases or materials are located.
• Phosgene, a toxic gas, is generated from the vapors of chlorinated solvents and cleansers. Remove all sources of these vapors.

**ELECTRIC SHOCK**

Electric Shock can injure or kill. The plasma arc process uses and produces high voltage electrical energy. This electric energy can cause severe or fatal shock to the operator or others in the workplace.

- The equipment should be installed by a qualified person and in accordance with current standards in operation. It is the user's responsibility to ensure that the equipment is connected to a suitable power supply. Consult with your utility supplier if required.

- If earth grounding of the work piece is required, ground it directly with a separate cable.
- Do not use the equipment with the covers removed.
- Do not touch live electrical parts or parts which are electrically charged.
- Turn off all equipment when not in use.
- Cables (both primary supply and welding) should be regularly checked for damage and overheating. Do not use worn, damaged, under sized or poorly jointed cables.
- Ensure that you wear the correct protective clothing, gloves, head and eye protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work ground.
- Never touch the electrode if you are in contact with the work ground, or another electrode from a different machine.
- Do not wrap cables over your body.
- Ensure that you take additional safety precautions when you are welding in electrically hazardous conditions such as damp environments, wearing wet clothing, and metal structures. Try to avoid welding in cramped or restricted positions.
- Ensure that the equipment is well maintained. Repair or replace damaged or defective parts immediately. Carry out any regular maintenance in accordance with the manufacturer's instructions.

**NOISE**

Noise can cause permanent hearing loss. Plasma arc processes can cause noise levels to exceed safe limits. You must protect your ears from loud noise to prevent permanent loss of hearing.

- Some welding and cutting operations may produce noise.
- Wear safety ear protection to protect your hearing.
- To protect your hearing from loud noise, wear protective ear plugs and/or ear muffs. Protect others in the workplace.
- Noise levels should be measured to be sure the decibels (sound) do not exceed safe levels.

**PLASMA ARC RAYS**

Plasma Arc Rays can injure your eyes and burn your skin. The plasma arc process produces very bright ultra violet and infra-red light. These arc rays will damage your eyes and burn your skin if you are not properly protected.

• To protect your eyes, always wear a cutting helmet or shield. Also always wear safety glasses with side shields, goggles or other protective eye wear.
• Wear cutting gloves and suitable clothing to protect your skin from the arc rays and sparks.
• Keep helmet and safety glasses in good condition. Replace lenses when cracked, chipped or dirty.
• Protect others in the work area from the arc rays. Use protective booths, screens or shields.

## Prevention against burns and radiation

- Arc rays from the welding process produce intense, visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin.
- Wear an approved welding helmet fitted with a proper shade of filter lens to protect your face and eyes when welding or watching
- Wear approved safety glasses with side shields under your helmet.
- Never use broken or faulty welding helmets.
- Always ensure there are adequate protective screens or barriers to protect others from flash, glare and sparks from the welding area. Ensure that there are adequate warnings that welding or cutting is taking place.

- Wear suitable protective flame resistant clothing. The sparks and spatter from welding, hot work pieces, and hot equipment can cause fires and burns
- Welding on closed containers, such as tanks, drums, or pipes, can cause them to explode.
- Accidental contact of electrode to metal objects can cause arcs, explosion, overheating, or fire.
- Check and be sure the area is safe and clear of inflammable material before carrying out any welding.

## Protection from moving parts

- When the machine is in operation, keep away from moving parts such as motors and fans. Moving parts, such as the fan, may cut fingers and hands and snag garments.
- Protections and coverings may be removed for maintenance and controls only by qualified personnel, after first disconnecting the power supply cable.
- Replace the coverings and protections and close all doors when the intervention is finished, and before starting the equipment.
- Take care to avoid getting fingers trapped when loading and feeding wire during set up and operation.
- When feeding wire be careful to avoid pointing it at other people or toward your body.
- Always ensure machine covers and protective devices are in operation.

## Precautions against fire and explosion

Fire and explosion can be caused by hot slag, sparks, or the plasma arc.

- Avoid causing fires due to sparks and hot waste or molten metal
- Ensure that appropriate fire safety devices are available near the cutting / welding area.
- Remove all flammable and combustible materials from the cutting / welding zone and surrounding areas
- Do not cut/weld fuel and lubricant containers, even if empty. These must be carefully cleaned before they can be cut/welded.
- Always allow the cut/welded material to cool before touching it or placing it in contact with combustible or flammable material.
- Do not work in atmospheres with high concentrations of combustible fumes, flammable gases and dust.
- Always check the work area half an hour after cutting to make sure that no fires have begun
- Ventilate all flammable or explosive vapors from the workplace.
- Do not cut or weld on containers that may have held combustibles.
- Provide a fire watch when working in an area where fire hazards may exist.
- Hydrogen gas may be formed and trapped under aluminum workpieces when they are cut underwater or while using a water table. DO NOT cut aluminum alloys underwater or on a water table unless the hydrogen gas can be eliminated or dissipated. Trapped hydrogen gas that is ignited will cause an explosion.

## Risks due to magnetic fields

- The magnetic fields created by high currents may affect the operation of pacemakers or electronically controlled medical equipment.
- Wearers of vital electronic equipment should consult their physician before beginning any arc welding, cutting, gouging or spot welding operations.
- Do not go near welding equipment with any sensitive electronic equipment as the magnetic fields may cause damage.

## RF Declaration

Equipment that complies with directive 2004/108/EC concerning electromagnetic compatibility (EMC) and the technical requirements of EN60974-10 is designed for use in industrial buildings and not those for domestic use where electricity is provided via the low voltage public distribution system. Difficulties may arise in assuring class A electromagnetic compatibility for systems installed in domestic locations due to conducted and radiated emissions.
In the case of electromagnetic problems, it is the responsibility of the user to resolve the situation. It may be necessary to shield the equipment and fit suitable filters on the mains supply.

## LF Declaration

Consult the data plate on the equipment for the power supply requirements.
Due to the elevated absorbance of the primary current from the power supply network, high power systems affect the quality of power provided by the network. Consequently, connection restrictions or maximum impedance requirements permitted by the network at the public network connection point must be applied to these systems.
In this case the installer or the user is responsible for ensuring the equipment can be connected, consulting the electricity provider if necessary.

## Materials and their disposal

The equipment is manufactured with materials, which do not contain any toxic or poisonous materials dangerous to the operator.
When the equipment is scrapped, it should be dismantled separating components according to the type of materials.
Do not dispose of the equipment with normal waste. The European Directive 2002/96/EC on Waste Electrical and Electronic Equipment states the electrical equipment that has reached its end of life must be collected separately and returned to an environmentally compatible recycling facility.

## Handling of Compressed gas cylinders and regulators

All cylinders and pressure regulators used in welding operations should be handled with care.
Never allow the electrode, electrode holder or any other electrically “hot” parts to touch a cylinder.
Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
Always secure the cylinder safely.
Never deface or alter any cylinder

## *EMF Information*

Considerations About Welding And The Effects Of Low Frequency Electric And Magnetic Fields Welding current, as it flows through welding cables, will cause electro-magnetic fields. There has been and still is some concern about such fields, However, after examining more than 500 studies spanning 17 years of research, a special blue ribbon committee of the National Research Council concluded that: "The body of evidence, in the committees judgment, has not demonstrated that exposure to power-frequency electric and magnetic fields is a human-health hazard." However studies are still going forth and evidence continues to be examined. Until the final conclusions of the research are reached, you may wish to minimize your exposure to electromagnetic fields when welding or cutting.

To reduce magnetic fields in the workplace, use the following procedures:

- Keep cables close together by twisting or taping them.
- Arrange cables to one side and away from the operator.
- Do not coil or drape cables around your body.
- Keep welding power source and cables as far away from operator as practical.
- Connect work clamp to work piece as close to the weld as possible.

## *Limitations of warranty declaration regarding machine use*

▲ ***The welding machine(s) described in this manual are designed exclusively for electrical arc welding with shielding gases Argon, $CO_2$ or Ar + $CO_2$ mixture(s) employing TIG technology. Using this machine for other purposes is not allowed. Using this machine in opposition with instructions can put the welder in danger. Damage can occur to the welding machine if not operated according to this manual. Failures and accidents due to such actions are not covered by warranty, nor can the producer be held responsible***

Means Warning! Watch Out! There are possible hazards with this procedure! The possible hazards are shown in the adjoining symbols.

▲ **Marks a special safety message.**

***This group of symbols means Warning! Watch Out! Possible ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards.***
***Consult symbols and related instructions below for***

## Arc Welding Hazards

▲ **The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards. Read and follow all Safety Standards.**

▲ **Only qualified persons should install, operate, maintain, and repair this unit.**

▲ **During operation, keep everybody, especially children, away.**

## ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. In semi-automatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Do not use AC output in damp areas, if movement is confined, or if there is a danger of falling.
- Use AC output ONLY if required for the welding process.
- If AC output is required, use remote output control if present on unit.
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to Safety Standards.
- Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.

- Always verify the supply ground — check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- When making input connections attach proper grounding conductor first - double-check connections.
- Frequently inspect input power cord for damage or bare wiring replace cord immediately if damaged — bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or poorly spliced cables.
- Do not drape cables over your body.
- If earth grounding of the work piece is required, ground it directly with a separate cable.
- Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.
- Use only WeII-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Clamp work cable with good metal-to-metal contact to work piece or worktable as near the weld as practical.
- Insulate work clamp when not connected to work piece to prevent contact with any metal object.
- Do not connect more than one electrode or work cable to any single weld output terminal.

▲ **SIGNIFICANT DC VOLTAGE exists after removal of input power on inverters.**

- Turn off inverter, disconnect input power, and discharge input capacitors according to instructions in Maintenance Section before touching any parts.

## FUMES AND GASES can be hazardous.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Keep your head out of the fumes. Do not breathe the fumes.
- If inside, ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.
- If ventilation is poor use an approved air-supplied respirator.
- Read the Material Safety Data Sheets (MSDSs) and the manufacturers' instructions for metals, consumables, coatings, cleaners, and degreasers.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watch-person nearby. 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 degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapours to form highly toxic and irritating gases.

- Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and if necessary, while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.

## ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

- Wear a welding helmet fitted with a proper shade of filler to protect your face and eyes when welding or watching (see Safety Standards).
- Wear approved safety glasses with side shields under your helmet.

- Use protective screens or barriers to protect others from flash and glare; warn others not to watch the arc.
- Wear protective clothing made from durable, flame-resistant material (leather and wool) and foot protection.

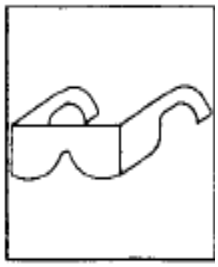
## WELDING can cause fire or explosion.

Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot work piece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or lure. Check and be sure the area is safe before doing any welding.

- Protect yourself and others from flying sparks and hot metal.
- Do not weld where flying sparks can strike flammable material.
- Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Watch for fire, and keep a fire extinguisher nearby.
- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- Do not weld on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to Safety Standards.
- Connect work cable to the work as close to the welding area as practical to prevent welding current from travelling long, possibly unknown paths and causing electric shock and fire hazards.
- Do not use welder to thaw frozen pipes.
- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.

- Wear oil-free protective garments such as leather gloves, heavy shirt, cuff less trousers, high shoes, and a cap.
- Remove any combustibles, such as butane lighter or matches, from your person before doing any welding.

**FLYING METAL can injure eyes.**



- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.

**BUILDUP OF GAS can injure or kill.**

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.

**HOT PARTS can cause severe burns.**

- Do not touch hot parts bare handed.
- Allow cooling period before working on gun or torch.

**MAGNETIC FIELDS can affect pacemakers.**

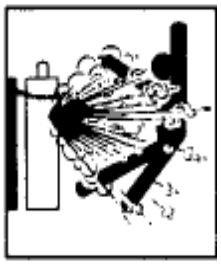
- Pacemaker wearers keep away.
- Wearers should consult their doctor before going near arc welding, gouging, or spot welding operations.

**NOISE can damage hearing.**

Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.

## CYLINDERS can explode if damaged.



Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.
- Never weld on a pressurized cylinder - explosion will result.
- Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application: maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for us

## FIRE OR EXPLOSION hazard.

- Do not install or place unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring — be sure power supply system is properly sized, rated, and protected to handle this unit.

## FALLING UNIT can cause injury.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit

## OVERUSE can cause OVERHEATING

- Allow cooling period; follow rated duty cycle
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit.

**STATIC (ESD) can damage PC boards.**

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.

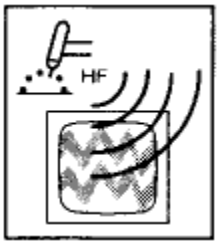
**MOVING PARTS can cause injury.**

- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.

**WELDING WIRE can cause injury.**

- Do not press gun trigger until instructed to do so.
- Do not point gun toward any part or the body, other people, or any metal when threading welding wire.

**H.F. RADIATION can cause interference.**




- High frequency (HF,) can interfere with radio, navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut. Keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.

**ARC WELDING can cause interference.**

- Electromagnetic energy can interfere with sensitive electronic equipment such as computers and computer-driven equipment such as robots.
- Be sure all equipment in the welding area is electromagnetically compatible.
- To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor.
- Locate welding operation 100 meters from any sensitive electronic equipment.
- Be sure this welding machine is installed and grounded according to this manual.
- If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area

# 1.0 Preface

## 1.1 General

Congratulations on choosing TitanCut 100 Welding Machines. Used correctly, our products can significantly increase the productivity of your welding, and provide years of economical service.

This operating manual contains important information on the use, maintenance and safety of our product. Please read the manual carefully before using the equipment for the first time.

For your own safety and that of your working environment, pay particular attention to the safety instructions in the manual.

For more information on our products, contact us, consult an authorized dealer, or visit our website.

The specifications presented in this manual are subject to change without prior notice.

### Important notes

Items in the manual that require particular attention in order to minimize damage and personal harm are indicated with the **'NOTE!'** notation. Read these sections carefully and follow their instructions.

### Disclaimer

While every effort has been made to ensure that the information contained in this guide is accurate and complete, no liability can be accepted for any errors or omissions. We reserve the right to change the specification of the product described at any time without prior notice.

## 1.2 Technical Specifications

| Type | CUT100 |
|---|---|
| Power supply | 415V±15% |
| Frequency | 50/60Hz |
| Phase | 3PH |
| Rated input(KVA) | 14.1 |
| Open circuit voltage(V) | 280 |
| Amperage range(A) | 30-100 |
| Rated Duty cycle (%) | 60 |
| Rated working voltage(V) | 92-120 |
| Efficiency | 0.85 |
| Power factor | 0.93 |
| Max cutting thickness (mm) | 35 |
| Compressed air pressure ($kg/cm^2$) | 4 ~ 6 |
| Dimension(L x W x H)(MM) | 685x295x560 |
| Post flow time(S) | 4 |

**Note: The above parameters are subject to change with the improvement of machines.**

## 1.3 Important Notes before use

▲ **Do not operate or install this equipment without thoroughly reading this manual and the safety precautions contained throughout.**

- Save this manual and keep it handy for reference.
- Disconnect mains of the semi-automatic welding machine after finishing work or before a long break.

▲ **DO NOT make any modifications to the machine. It may cause changes in the features and deterioration of technical data.**

▲ **Any adaptations to this machine are prohibited and may void the warranty.**

▲ **Warranty is void if any damage to the machine is caused by misuse.**

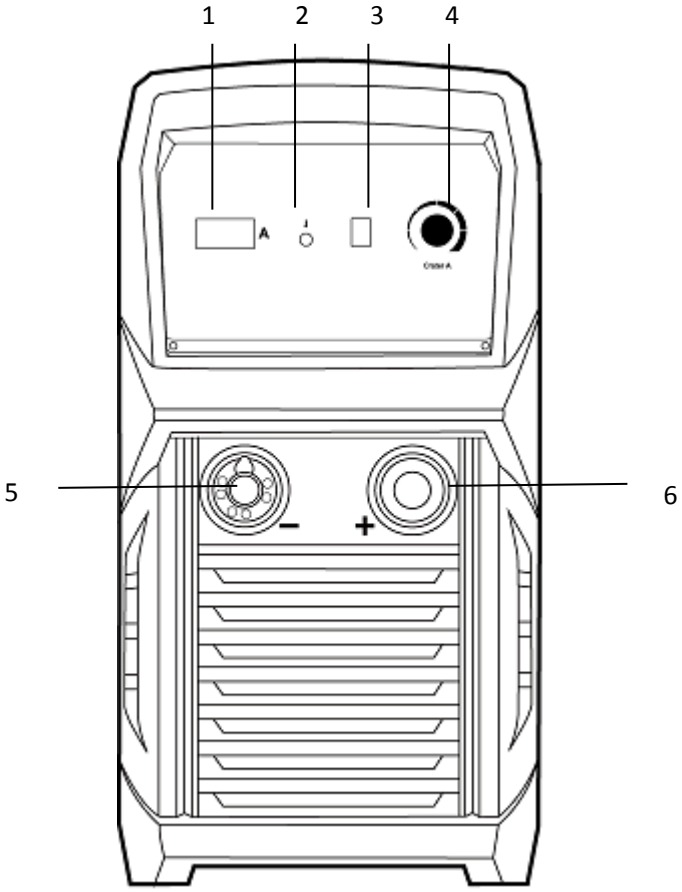
- Acceptable range of ambient temperature is from 10—40°C.
- Acceptable range of humidity is 20°C at 95% humidity.
- Specifications may change without previous notice.

# 1.3 Overview of machine

**Front View**

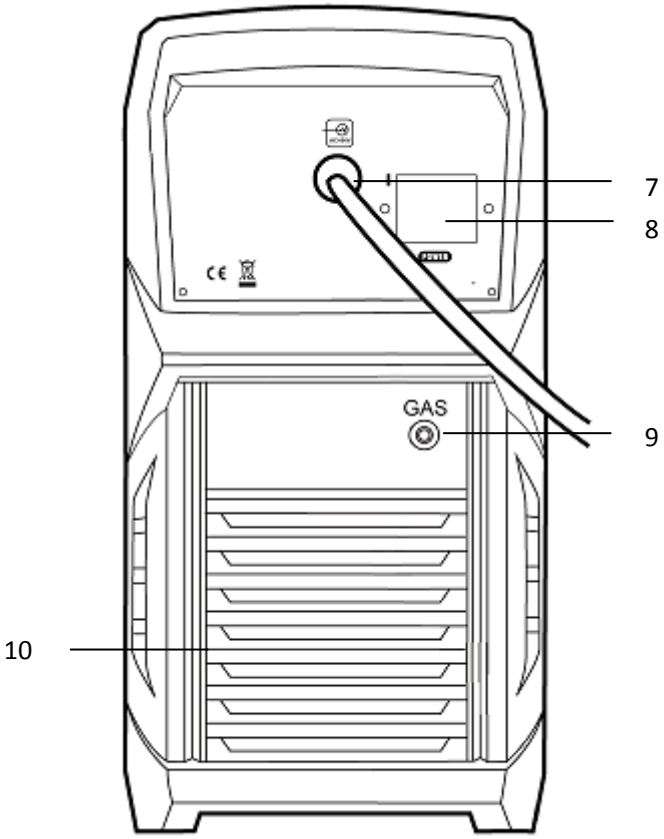
Power Source Front Panel Layout

1. Amperage Meter
2. Thermal Overload LED
3. 2T - 4T Trigger Switch
4. Current Control
5. Plasma Central Socket
6. Output –




**Rear View**

7. Primary Input Cable
8. Primary Power Switch
9. Gas input
10. FAN



# Installation

Worker and working area protection

Fumes and gases produced by welding are dangerous for your health. Ventilation in workplace must be adequate to remove all harmful fumes and gases but not too strong since it could remove the shielding gas flowing over work piece. Arc welding rays are dangerous for your eyes. The welder must always use a welding helmet with a minimum protective shade glass No. 10 for MIG Welding. All personal protective including working clothes, leather apron, gloves, etc. must always be worn when welding or handling the work piece.


## Unpacking

Check the packaging for any signs of damage. Carefully remove the machine and retain the packaging until the installation is complete.

## Positioning of the machine

Place the machine on a firm, dry and level surface. Where possible, do not allow dust or other impurities to enter the machines cooling air flow. Preferably site the machine above floor level; for example on a suitable carriage unit.

Notes for positioning the machine

- The surface inclination should not exceed 15 degrees.
- Ensure the free circulation of the cooling air. There must be at least 20 cm of free space in front of and behind the machine for cooling air to circulate.
- Protect the machine against heavy rain and direct sunshine.

**NOTE!** The machine should not be operated in the rain as the protection class of the machine, IP21S, allows for outside preserving and storage only.

**NOTE!** Never aim metallic grinding spray/sparks towards the equipment.

## Input connection

- Before connecting the machine you should ensure that the correct supply is available. Details of the machine requirements can be found on the data plate of the machine or in the technical parameters shown in the manual.
- The equipment should be connected by a suitably qualified competent person. Always ensure the equipment has a proper grounding.
- Never connect the machine to the mains supply with the panels removed.
- Before connecting the machine you should ensure that the correct supply is available. Details of the machine requirements can be found on the data plate of the machine or in the technical parameters shown in the manual.

## Gas Connection

- Connecting Gas Supply to Unit
- Connect the gas line to the inlet port of the gas filter on the rear panel.
- Check Air Quality

## Working connections

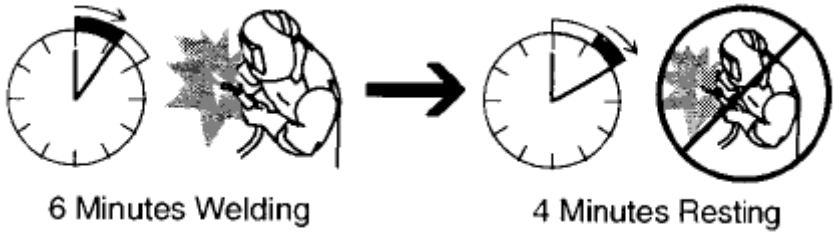
Connect cutting torch, earth cable & regulator,according to connection diagram.Gas supply can be either air or Nitrogen. A high pressure regulator must be used on either type of gas and must be capable of delivering 155 l/min at a pressure of 57 psi ( 3.9 bar) to the filter.

# 2.0 Operation

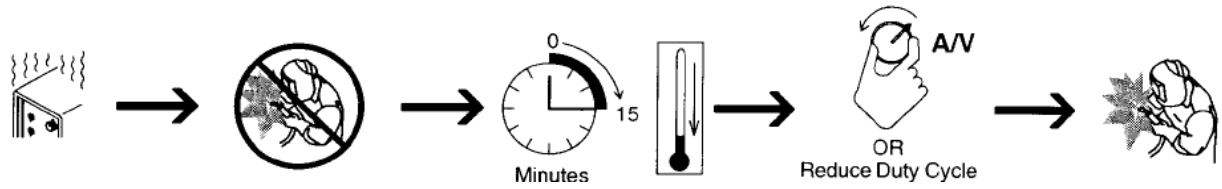
## Duty cycle and overheating

Duty Cycle is percentage of 10 minutes that unit can weld at rated load without overheating. If unit overheats, thermostat(s) opens, output stops, and cooling fan runs. Wait fifteen minutes for unit to cool. Reduce amperage or duty cycle before welding.

**60% Duty Cycle at 180A.**




**Overheating**




▲ **Welding machine must be used according to technical data from this manual. If the machine is overloaded, failures may occur that are not covered by warranty.**

## Overload control

Thermal protection is built in the machine's main transformer and Inverter Bridge. If the machine overheats, thermal fuse will prevent further use and control lamp on the front panel will light up. In this case the welder must wait until the machine's temperature drops to normal. Note the machine must be left switched on for the fan to keep running.

# 3.1 Plasma Cutting

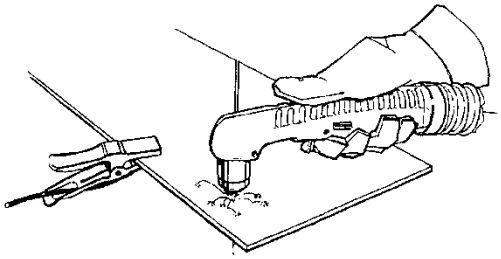
## Cutting Preparation

1. Tightly connect the power cable to electrical socket outlet
2. Connect the air pipe to the air supply equipment, the earth cable to the workpiece
3. Turn on the power switch ,the power source lamp on.
4.Now all the preparation done .

## Cutting Operation

Before starting any welding activity ensure that you have suitable eye protection and protective clothing. Also take the necessary steps to protect any persons within the area.

3-1.1 Check the connection of work piece, earth cable, cutting torch, gas cylinder, regulator and hose, make sure they are firm and reliable. **Do not attach earth cable to the portion that will fall away.**



Correct way to attach earth clamp

3-1.2 Verify that the input gas supply pressure is set to 72psi (5 Bar)

3-1.3 Pull the regulator cap out, gradually turn regulator cap to adjust gas pressure to 2.5-5 Bar and push the regulator cap back in.

3-1.4 Switch on the power source. Adjust the cutting current and after cutting delay time knob to desired setting.

3-1.5 Place the tip of the torch at the edge of the work piece makes sure the tip is vertical to the work piece. When piercing, the tip should have a angle away from yourself, after arc starts, slowly rotate the torch to upright position. This is to blow the melted metal away and is particularly important when cutting thicker material. Make sure that the torch is pointed away from you and the people near you to avoid any danger from sparks and hot metal.

**Push the safety trigger at the side of the torch first, then press the switch to start cutting.**

**CUTTING MACHINES ARE CONTACT START, THE PLASMA ARC IGNITED IMMEDIATELY AFTER START SWITCH CLOSED. ALWAYS HOLD THE HAND TORCH AWAY FROM YOUR BODY AS A PRECAUTION AGAINST ACCIDENTAL TORCH FIRING. BE AWARE OF THIS HAZARD. FAILURE TO DO SO CAN RESULT IN SERIOUS BODILY INJURY.**

3-1.6 Evenly move the torch in the desired direction, at a speed which will ensure good cut quality. When using shielded consumables, drag the torch tip directly on the work piece.

3-1.7 Hold the torch lightly on the metal or just above metal. Holding the torch firmly to the work piece causes the shield to stick and makes smooth cutting difficult. Pulling the torch through the cut is easier than push it.

3-1.8 When the cut is finished, release the torch switch to extinguish the arc.

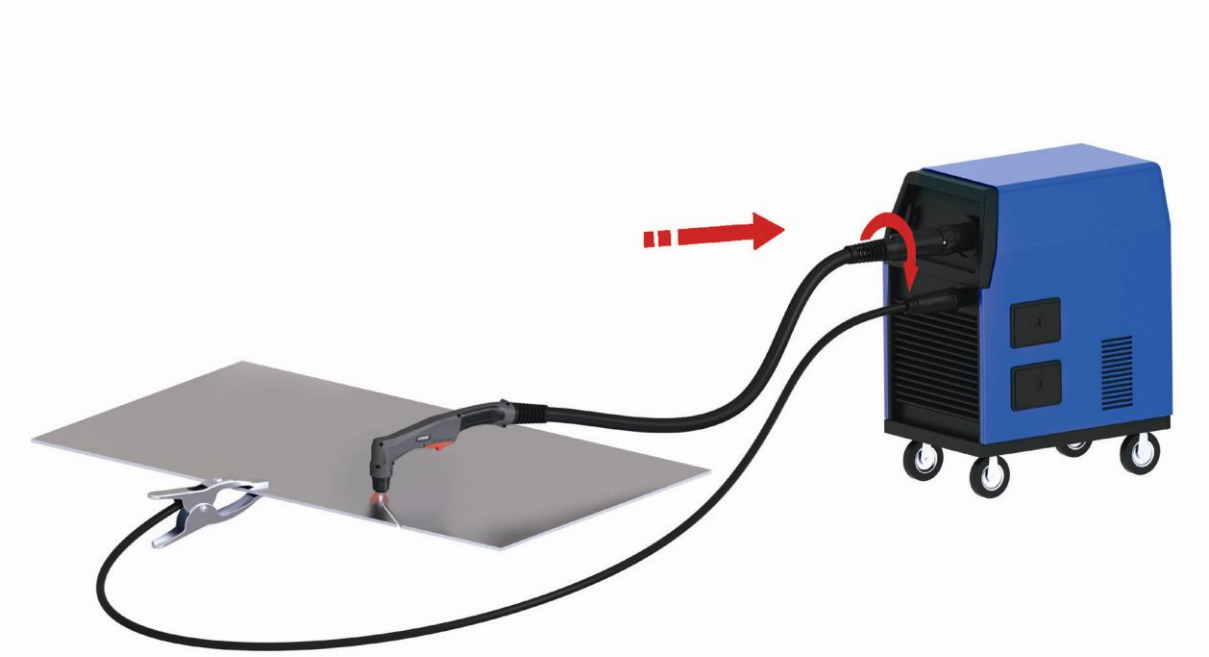
3-1.9 After finish operation, turn off the gas valve, push torch switch to clear the residual gas in the regulator. In the end, turn off welding power source and wall switch.

## Recommend cutting parameters

The settings listed below are just for initial commission of the machine. The parameters can be refined in actual cutting.

| Material | Thickness (inches) (mm) | | Current (amps) | Maximum travel speed (ipm) (mm/mln.) | |
|---|---|---|---|---|---|
| Mild steel | 26 GA | 0.5 | 25 | 638 | 16205 |
| | 10 GA | 3.4 | 40 | 151 | 3835 |
| | 1/4 | 6.4 | 60 | 132 | 3353 |
| | 3/8 | 10 | 60 | 63 | 1600 |
| | 1/2 | 12 | 60 | 42 | 1067 |
| | 5/8 | 16 | 60 | 31 | 787 |
| | 4/4 | 19 | 60 | 22 | 559 |
| Aluminum | 1/32 | 0.8 | 25 | 610 | 15494 |
| | 1/8 | 3.2 | 40 | 204 | 5182 |
| | 1/4 | 6.4 | 60 | 145 | 3683 |
| | 3/8 | 10 | 60 | 74 | 1880 |
| | 1/2 | 12 | 60 | 51 | 1295 |
| | 5/8 | 16 | 60 | 33 | 838 |
| Stainless steel | 26 GA. | 0.5 | 25 | 631 | 18027 |
| | 14 GA. | 1.9 | 40 | 221 | 5613 |
| | 1/4 | 6.4 | 60 | 110 | 2794 |
| | 3/8 | 10 | 60 | 53 | 1346 |
| | 1/2 | 12 | 60 | 35 | 889 |
| | 5/8 | 16 | 60 | 26 | 660 |

## 3.2 Plasma Torch Operation & Start Up.



Attach the work clamp securely to the workpiece. Remove rust, paint or other coatings to ensure good electical contact. Attach the work clamp as close as possible to the area being cut, to reduce exposure to electromagnetic fields (EMF).
Do not attach the work clamp to the portion that will fall away!!

# 3.2 Plasma Torch Operation & Start Up.

**Tips**

- It is easier to pull the torch through the cut than to push it.
- To cut thin material, reduce the amps until you get the best quality cut.
- For straight-line cuts, use a straight edge or a cutting buggy as a guide. To cut circles, use a template or a circle cutting attachment .
- Dependant upon the cutting method required, different torches have different front end set-ups to help improve ease of use. Please refer to the wear parts configurator section in the wear parts manual for options, or go to our web site www.parkertorchology.com.cn.
- After the torch trigger switch is released, the gas will continue to flow for at least 60 seconds to cool the torch and consumables. This helps to cool the torch and prolong the life of the consumables.

## Starting a cut

Hold the torch vertical at the edge of the workpiece.

Pull the trigger to start the pilot arc. The cutting arc will initiate when the torch parts are in the correct proximity to the workpiece. Start cutting at the edge until the arc has completely cut through the workpiece.

Then, proceed with the cut.

## Hand torch cutting technique

When cutting, make sure that sparks are exiting from the bottom of the workpiece.

If sparks are spraying up from the workpiece, you are moving the torch too fast, or without sufficient power.

Hold the torch vertically and watch the arc as it cuts along the line.

# 3.2 Plasma Torch Operation & Start Up.

## Piercing

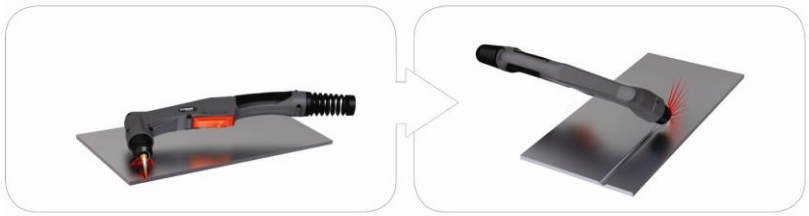
Fire the torch at an angle to the workpiece, then slowly rotate it to an upright position.

When sparks are exiting from the bottom of the workpiece, the arc has pierced through the materal.

When the pierce is complete, proceed with the cut.

## Gouging

Note: Most torches have specialized front end set ups for the process.
Hold the torch so that the nozzle is within 1/16 in (1.5 mm) from the workpiece before firing the torch.



Hold the torch at a 45° angle to the workpiece. Pull the trigger to obtain a pilot arc. Transfer the arc to the work piece.

Maintain an approximate 45° angle to the workpiece.
Feed into the gouge.

# 4.0 Trouble Shooting

There are extremely dangerous voltage and power levels present inside this unit. Do not attempt to diagnose or repair unless you have had training in power electronics measurement and troubleshooting techniques.

1. **The cutting torch fails to ignite the arc, when press on the torch switch, the TIP/GUN/GAS light on.**

- Gas pressure too high, gas test then adjust gas pressure to 4bar/60psi.

2. **The cutting torch fails to ignite the arc, when press on the torch switch, the TIP/GUN/GAS lamp splash.**

- The shield cup improper installation, turn off the power source, install and screw it down properly, then turn on the power source.

3. **The cutting torch fails to ignite the arc, when press on the torch switch, the TIP/GUN/GAS lamp on and air feed intermittently.**

- The electrode or nozzle improper installation, turn off the power source, install the electrode or nozzle, and screw shield cup down properly, then turn on the power source.

4. **The cutting torch fail to ignite the arc, when press on the torch switch, the TIP/GUN/GAS lamp on and air feed intermittently.**

- Short-circuit for burned-out and other abnormal situation, turn off the power source, change the electrode and nozzle.

5. **Power lamp and temperature lamp on.**

- Air flow blocked, check for blocked air flow around the unit and correct condition.
- Fan blocked, check and correct condition.
- Unit is overheated, let unit cool down for at least 5 minutes. Make sure the unit has not been operated beyond Duty Cycle limit.
- Faulty components in unit, return for repair or have qualified technician repair per Service Manual.

6. **Torch fails to ignite the arc when torch switch is activated**

- Faulty torch parts, inspect torch parts and replace if necessary.
- Gas pressure too high or too low, adjust to proper pressure.
- Faulty components in unit, return for repair or have qualified technician repair per Service Manual.

7. **No cutting output; Torch activated, power source on; Gas flows; Fan operates**

- Torch not properly connected to power supply, check that torch leads are properly connected to power supply.
- Work cable not connected to work piece, or connection is poor, make sure that work cable has a

proper connection to a clean, dry area of the workpiece.

- Faulty components in unit, return for repair or have qualified technician repair per Service Manual.
- Faulty Torch, return for repair or have qualified technician repair.

**8. Low cutting output**

- Incorrect setting of CURRENT (A) control, check and adjust to proper setting.
- Faulty components in unit, return for repair or have qualified technician repair.

**9. Difficult Starting**

- Worn torch parts (consumables), shut off input power. Remove and inspect torch shield cup, tip and electrode. Replace electrode or tip if worn; replace shield cup if excessive spatter adheres to it.

**10. Arc shuts off during operation; arc will not restart when torch switch is activated.**

- Power Supply is overheated (OC/OT lamp on), let unit cool down for at least 5 minutes. Make sure the unit has not been operated beyond Duty Cycle limit. Refer to Section 2 for duty cycle specifications.
- Gas pressure too low (the TIP/GUN/GAS lamp on when press on torch switch is on), check source for at least 4bar/60psi; adjust as needed.
- Torch consumables worn, check torch shield cup, tip, starter element, and electrode; replace as needed.
- Faulty components in unit:, return for repair or have qualified technician repair per Service Manual.

**11. No gas flow; the power lamp on; Fan operates**

- Gas not connected or pressure too low, check gas connections. Adjust gas pressure to proper setting.
- Faulty components in unit, return for repair or have qualified technician repair.

**12. Torch cuts but low quality**

- Current (A) control set too low, increase current setting.
- Torch is being moved too fast across workpiece, reduce cutting speed.
- Excessive oil or moisture in torch, hold torch 1/8 inch (3 mm) from clean surface while purging and observe oil or moisture buildup (do not activate torch). If there are contaminants in the gas, additional filtering may be needed.

# 5.0 Maintenance

The utilization level of the power source and its working environment should be taken into consideration in planning the frequency of maintenance of the machine. Appropriate use and preventive maintenance guarantee the trouble-free use of the equipment. This allows you to avoid interruptions in use and increases the productivity of the machine.

**6.1 Cables**

Check the condition of welding and mains cables daily. Do not use damaged cables. Also make sure that all extension cables used in the mains connection are in proper condition and compliant with regulations.

NOTE! The mains cables may be repaired and installed only by electrical contractors and installers authorized to perform such operations.

**6.2 Power source**

Before cleaning the interior of the machine, you need to remove the case by unscrewing the mounting screws at the top and sides of the machine.

NOTE! To prevent damage, wait approximately two minutes after disconnecting the mains cable before removing the machine's case. Perform the following cleaning and maintenance at least every six months:

1. Clean the interior of the machine and the fan grill's net of any dust and stains – for Example, with a soft brush and vacuum cleaner.

- Do not use pressurized air. The stain may become compressed into the grooves of the coolers.

- Do not use a pressure-washing device.

2. Check the electrical connections of the machine. Clean any oxidized connections, and tighten the loosened ones.

- Check for the right tension before you start repairing the connections.

NOTE! Remember that the machine may be repaired only by an electrical contractor or installer authorized to perform such operations.

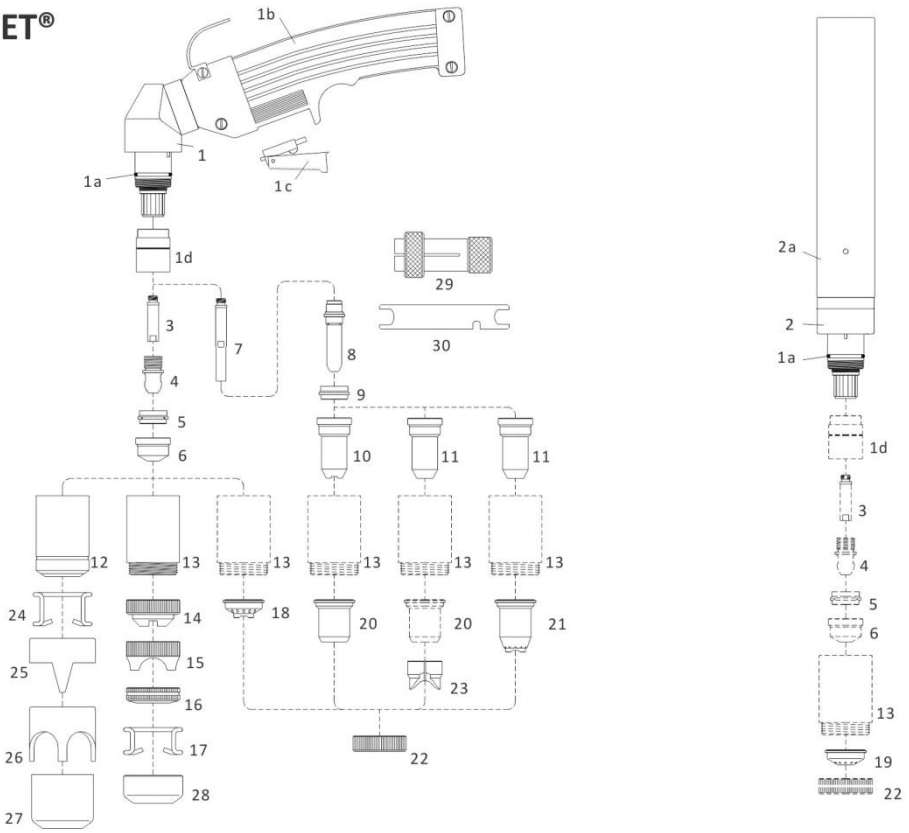
**6.3 Regular maintenance**

Authorized service agents perform regular maintenance by agreement. Tasks included in regular maintenance:

- Cleaning Equipment
- Inspection and maintenance of the welding gun.
- Checking of connectors, switches, and control knobs.
- Checking electrical connections.
- Checking the mains cable and plug
- Replacement of damaged or worn parts.
- Calibration testing, with adjustment of the functions and operational values of the machine, if necessary

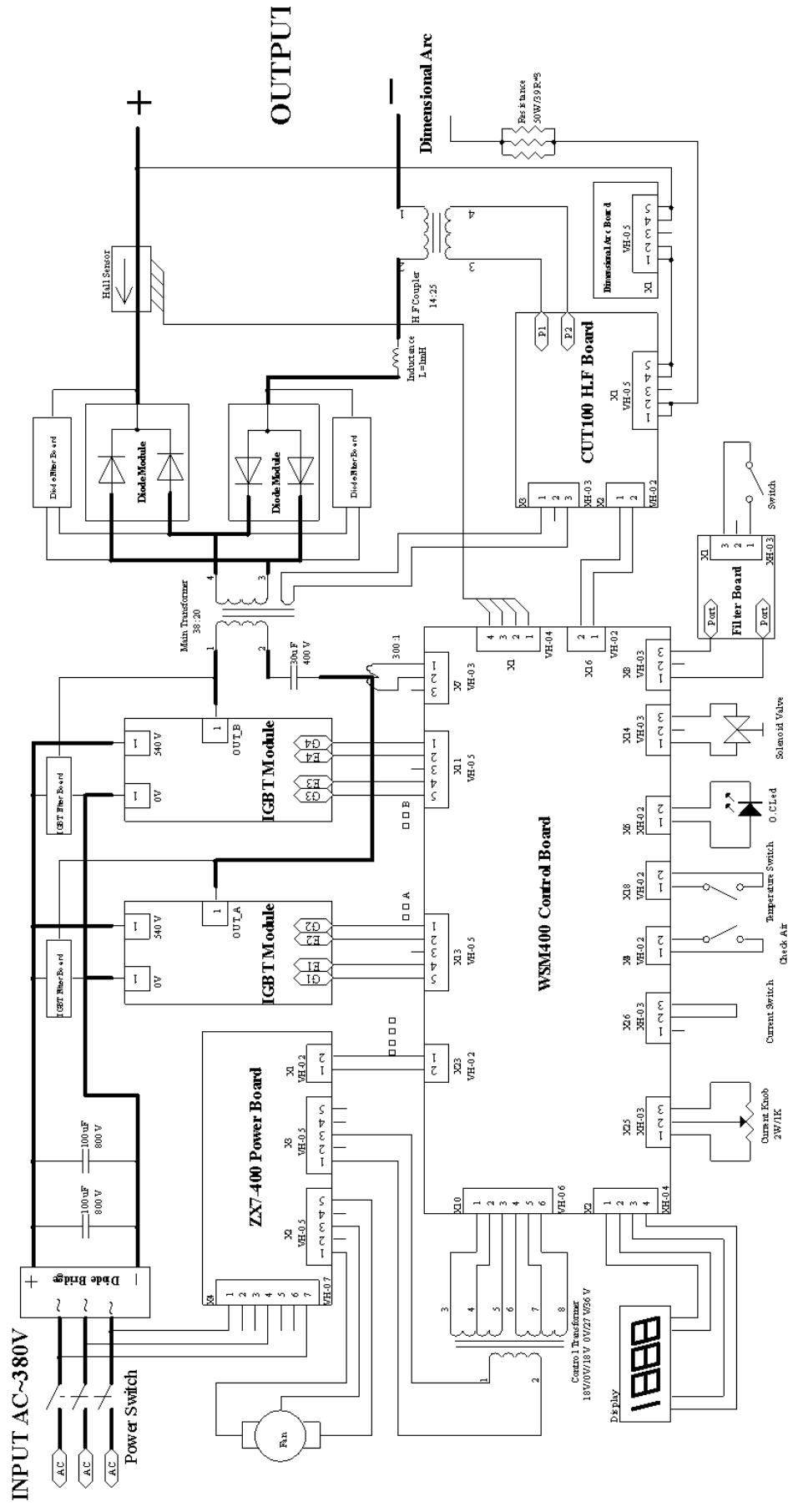
# 6.0 Torch Spare Parts & Consumables

**TRAFIMET®**
**A101®**




| No. | Ref. | Code | Description | No. | Ref. | Code | Description |
|---|---|---|---|---|---|---|---|
| | PA101 | 06250 | Hand torch 6m M14 x 1 | 11 | PD117-14 | 51149.14 | Extended tip ø 1.4 |
| | | 06251 | Hand torch 6m cent. connector | | | 51149.17 | Extended tip ø 1.7 |
| | PA102 | 06350 | Hand torch 12m M14 x 1 | | | 51149.19 | Extended tip ø 1.9 |
| | | 06351 | Hand torch 12m cent. connector | 12 | PC101/102 | 60375 | Retaining cap, long life |
| | PA103 | 06450 | Machine torch 6m M14 x 1 | 13 | PC103/131 | 60385 | Contact retaining cap |
| | PA145 | 06451 | Machine torch 6m cent. connector | | PC103/131 | 60385/V | Contact retaining cap, Max.life |
| | PA104 | 06550 | Machine torch 12m M14 x 1 | 14 | CV23 | 51940 | Spacer for contact cutting |
| | PA146 | 06551 | Machine torch 12m cent.conn. | 15 | CV39 | 51945 | Large spacer for contact cutting |
| 1 | PF101 | 06200 | Hand torch head | 16 | | 51952 | Spring holder protection nut |
| 1a | EA131 | 06000.60 | O - Ring | 17 | | 51911 | Spacer spring for code 51952 |
| 1b | | 07301 | Handgrip complete with switch | 18 | | 51950 | Spacer for contact cutting, hand |
| 1c | | 07301.20 | Switch | 19 | | 51951 | Shield cup, machine |
| 1d | | 60080 | Front insulator | 20 | CV8 | 51957 | Shield cup, hand (max. 50A) |
| 2 | PF102 | 06400 | Machine torch head | 21 | CV9 | 51958 | Spacer for contact cutting, hand |
| 2a | | 03310 | Machine handle | 22 | | 51959 | Locking nut |
| 3 | | 05004 | Diffusor | 23 | | 51974 | Spacer for extended tips High Amp. |
| 4 | PR101 | 52535 | Electrode | 24 | CV11 | 51910 | Spacer spring |
| 5 | PE101 | 60030 | Swirl ring | 25 | CV12 | 60370 | Double pointed spacer |
| 6 | PD101-11 | 51154 | Tip ø 1.1 | 26 | CV14 | 60371 | Crown spacer |
| | PD101-14 | 51155 | Tip ø 1.4 | 27 | CV13 | 60373 | Gouging spacer |
| | PD101-17 | 51156 | Tip ø 1.7 | 28 | | 51953 | Gouging spacer |
| | PD101-19 | 51157 | Tip ø 1.9 | 29 | GR60 | 60369 | Extractor for swirl ring |
| | PD101-30 | 51158 | Gouging tip ø 3.0 | 30 | | 60368 | Wrench for electrode |
| 7 | | 05005 | Extended Diffusor | | | 04220 | Cable 6m M14 x 1- Hand torch |
| 8 | PR116 | 52530 | Extended electrode | | | 04230 | Cable 12m M14 x 1 - Hand torch |
| 9 | PE103 | 60031 | Insulating spacer | | | 04222 | Cable 6m M14 x 1 - Machine torch |
| 10 | PD111 | 51149 | Extended tip ø 1.1 (max. 50A) | | | 04232 | Cable 12m M14 x 1 - Machine torch |

# 7.0 Electrical principle diagram



# 8.0 Warranty Terms & Conditions

**Weldtronic International P/L: ABN 99 149 754 263**

Weldtronic International P/L (Weldtronic) warrants to the original retail purchaser that the products supplied by us and purchased by you from an authorized Weldtronic distributor are free of material and faulty workmanship defects except for those products listed under Warranty Exclusions.

All warranty periods are from **date of purchase** from the retailer/distributor of the product. Unless otherwise stated the warranty period includes parts and labour.

If a defect in material or workmanship becomes evident during the warranty period, Weldtronic will, at its opinion, either:

- Repair the Product (or pay for the costs of repair of the product); or
- Replace the Product if repair is not possible.

In the unlikely event of such a defect, the customer should return the product to the original place of purchase, with a proof of purchase, or contact Weldtronic on 03 9702 9366 to locate a authorized service agent.
Any handling and transportation costs (and other expenses) incurred in claiming under this warranty are not covered by this warranty and will not be borne by Weldtronic.
Weldtronic will return the replacement or repaired product, if original found to be faulty, freight free to the customer.

The obligation of Weldtronic International P/L under this warranty is limited to the circumstances set out above and is subject to:

- The customer being able to provide proof of purchase of the product and the purchase price paid for the product;
- The relevant defect in materials or workmanship;
- The product not having been altered, tampered with or otherwise dealt with by any person in a manner other than as intended in respect of the relevant product; and
- The product not having been used or applied in a manner that is contrary to customary usage or application for the relevant product or contrary to any stated instructions or specification of Weldtronic International.

Our products come with a guarantee that cannot be excluded under the Australian Consumer Law. You are entitled to a replacement or refund for a major failure and for compensation for any other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of an acceptable quality and the failure does not amount to a major failure. The benefits given by this warranty are in addition to the other rights and remedies which may be available to the customer under any law in relation to goods and services to which this relates.

These terms and conditions supersede and exclude all former and other representations and arrangements relating to any warranties on these products

## Warranty Periods

We offer the following Warranty Periods **from date of purchase**;

| | | |
|---|---|---|
| **Equipment Power Sources** | | |
| TitanTIG, TitanMIG, TitanARC Inverter Series (Power Source) | 2 Years | (Clause 2) |
| TronicTig, TronicMIG, TronicPlas Inverter Series (Power Source) | 2 Years | (Clause 2) |
| EuroMIG Transformer MIG Series (Power Source) | 3 Years | (Clause 1&2) |
| TronicCool Water Coolers | 1 Year | (Clause 2) |
| Electrode Ovens | 1 Year | (Clause 2) |
| Straight Line & Pipe Cutters (Power source only) | 1 Year | (Clause 2) |
| Positioners & Rotators (power source only) | 1 Year | (Clause 2) |
| **Gas apparatus** | | |
| TronicFlame Gas & Welding Kits | 3 Months | (Clause 2&4) |
| TronicFlame Regulators | 1 Year | |
| **Automatic Welding Helmets** | | |
| Clearwelding® CWH720S Series Automatic Helmet | 1 Year | (Clause 4) |
| Clearwelding® CWH800S / 815S / 820S Series Automatic Helmet | 2 Years | (Clause 4) |
| **Welding Accessories** | | |
| MIG , TIG & Plasma Torches | 3 Months | |
| Earth & Work Leads | 3 Months | |
| Gas Hose & Interconnecting Cables | 3 Months | |

**(Clause 1)** 3 Year warranty on transformer, inductor, & Rectifier. 2 Year Warranty on PCB and all other components.

**(Clause 2)** This only covers manufacture defaults on all accessories for the first three months after date of purchase (e.g. MIG/TIG/Plasma Torches, Earth Leads, Gas hose, etc.).

**(Clause 3)** Gas Hose & Flashback arrestors are subject to and covered by the manufacturer's individual warranty.

**(Clause 4)** 1 & 2 Year warranty on ADF Lens. 3 Month warranty on Helmet shell, harness & fittings.

### Warranty, Returns & Exchanges

**(1)**Subject to the conditions of warranty set out in the warranty period, Weldtronic International P/L warrants that if any defect in any workmanship on any product has occurred then the conditions applicable to the warranty period are;

**(a)**The warranty applies on the basis of the goods being used on the equivalent of single daily eight (8) hour shift.

**(2)**The warranty shall not cover defect or damage which may be caused or partly caused by or arise through:

**(a)**Failure on the part of the buyer to properly maintain any goods.

**(b)**Failure on the part of the buyer to follow any instructions or guidelines provided by Weldtronic.

**(c)**Any use of any goods otherwise than for any application specified on a quote or order form.

**(d)**The continued use of any goods after any defect becomes apparent or would have become apparent to a reasonably prudent operator or user.

**(e)**Fair wear and tear of goods or any part thereof including but not limited to items listed in warranty exclusions.

**(f)**Misuse, neglect, accident, vandalism or damage in transit or natural disaster.

**(3)**The warranty shall cease and Weldtronic International P/L shall thereafter in no circumstances be liable under the terms of the warranty if the workmanship is repaired, altered or overhauled without Weldtronic International consent.

**(4)**In respect of all claims Weldtronic International P/L shall not be liable to compensate the buyer for any delay in either replacing or remedying the workmanship or in properly assessing the buyers claim.

**(5)**For goods not manufactured by Weldtronic International P/L, the warranty shall be the current warranty provided by the manufacturer of the goods. Weldtronic International shall not be bound by nor be responsible for any term, condition, representation or warranty other than which is given by the manufacturer of the goods.
**(6)**We understand that sometimes you may need to return a product you have purchased from Weldtronic International p/l authorized dealer, to assist you , we have set out below the Weldtronic International P/L Returns Policy that you should know.

Our Returns Policy includes the rights you have under the Australian Consumer Law and other relevant laws.
Your rights under the Australian Consumer Law;
Our goods come with guarantees that cannot be excluded under the Australian Consumer Law. You are entitled to a replacement or refund for a major failure and for compensation for any reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.
You shall inspect the goods on delivery and shall within seven (7) days of delivery notify Weldtronic International P/L of any alleged defect, shortage in quantity, damage or failure to comply with the description or quote.
You shall also afford Weldtronic International P/L the opportunity to inspect the goods within a reasonable time following delivery if you believe the goods are defective an any way.
If you fail to comply with these provisions the goods shall be presumed to be free from any defect or damage. For defective goods, which Weldtronic International P/L has agreed in writing that you are entitled to reject, Weldtronic International P/L liability is limited to either (at Weldtronic discretion) replacing the goods or repairing the goods except where you have acquired goods as a consumer within the meaning of the Trade Practices Act 1974 or the Fair Trading Acts of the relevant state or territories of Australian, and is therefore also entitled to, at the consumers discretion either a refund of the purchase price of the goods, or repair of the goods, or replacement of the goods.

**(7)**Returns will only be accepted provided that;
**(a)**You have complied with the provisions outlined above, and…
**(b)**Where the goods are unable to be repaired, the goods are returned at your cost within thirty (30) days of the delivery date, and…
**(c)**Weldtronic International P/L will not be liable for goods which have not been stored or used within the proper manner, and…
**(d)**The goods are returned in the condition in which they were delivered and with all packaging material, brochures and instruction material in as new condition as is reasonably possible in the circumstances. Failure to comply to this point may mean that a re-stocking fee is charged to compensate Weldtronic for any lost materials and labour.
**(8)**Weldtronic International P/L accepts no responsibility for products lost, damaged or mislaid whilst in transit.
**(9)**Weldtronic International P/L (at their sole discretion) accepts the return of goods for credit but this may incur a handling fee of up to twenty percent (20%) of the value of the returned goods plus any freight costs.
**(10)**Where the failure does not amount to a major failure, Weldtronic International P/L is entitled to choose between providing you with a repair, replacement or other suitable remedy.
**(11)**Your rights under the Australian Consumer Law are not limited by a defined time. However, the Australian Consumer Law does recognize the relevant time period can vary from product to product, depending on factors such as the nature if the product and price. Weldtronic International P/L adopts the same approach. As you can appreciate, the type of remedy we can offer you may also vary depending on how long it takes you to return the product to use.

**Making a Claim**
**(12)**If you wish to make a claim under this warranty you should;
**(a)**Return the product to the point of purchase either in person or on a prepaid courier; or
**(b)**Contact us by telephone on 03 9702 9366 or mail to PO 2096 Rowville VIC 3178

**(c)**When returned, the product must be accompanied with the original invoice including the purchase price and disclosing the purchase date.
**(d)**All costs of installation, cartage, freight, travelling expenses, hiring tools and insurance are paid by the Customer.
**(e)**To the extent permitted by law, our total liability for loss or damage of every kind related to the product in any way whatsoever is limited to the amount paid to the retailer by you for the product or value of the product.

**Warranty Exclusions**

**(13)**This warranty covers material and faulty workmanship defects only. This warranty does not cover damage caused by
**(a)**Normal wear and tear due to usage
**(b)**Misuse or abusive use of the instructions supplied with the product
**(c)**Failure to clean or improper cleaning of the product
**(d)**Failure to maintain the equipment such as regular services etc.
**(e)**Incorrect voltage or non-authorized electrical connections
**(f)**Improper installation
**(g)**Use if non-authorized/non-standard parts
**(h)**Abnormal product performance caused by any ancillary equipment interference or other external factors.
**(i)**Failure or breakage caused by overload, dropping or abusive treatment or use by the customer
**(j)**Repair, modifications or other work carried out on the product other than by an authorized Weldtronic service dealer.
**(14)**This warranty does not cover the following parts:
**(a)MIG , TIG & Stick (MMA) Welding Torches & Consumables such as;**
*Gas nozzles, Gas diffusers, contact tip holder, contact tip, swan necks, trigger, handle, liners, wire guide, drive roller, neck spring, connector block, insulator, gas nipple , cap, euro block, head assembly, gas block, trigger spring, cable support, neck insulator, lock nut, arc leas, welding cable, electrode holders & earth clamps, tungsten Electrodes, Collect, Back Cap, Collet body, Torch head, gaskets, gas lens & O-rings.*
**Plasma (b)Cutting Torches & Consumables such as;**
*Cutting tips, Air diffuser, Swirl ring, Electrode, retaining cap, nozzle spring, spaces, air & power cables, O-rings, guides, torch bodies, air filter*
**(c)Straight Line & Pipe Cutting consumables such as;** *Hoses, fittings, track, cutting nozzles, torch*
**(15)**This warranty does not cover for products purchased:
**(a)**From a non-authorized Weldtronic dealer (such as purchases from unauthorized retailers and purchases over the internet from unauthorized local/international sites such as EBay)
**(b)**At an auction
**(c)**From a private seller
**(d)**Unless it is a manufacturing fault, this warranty does not apply for products sold to hire companies.
These conditions may only be varied with the written approval of the directors of Weldtronic International P/L.

## REMEMBER TO RETAIN YOUR ORIGINAL INVOICE FOR PROOF OF PURCHASE.

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