

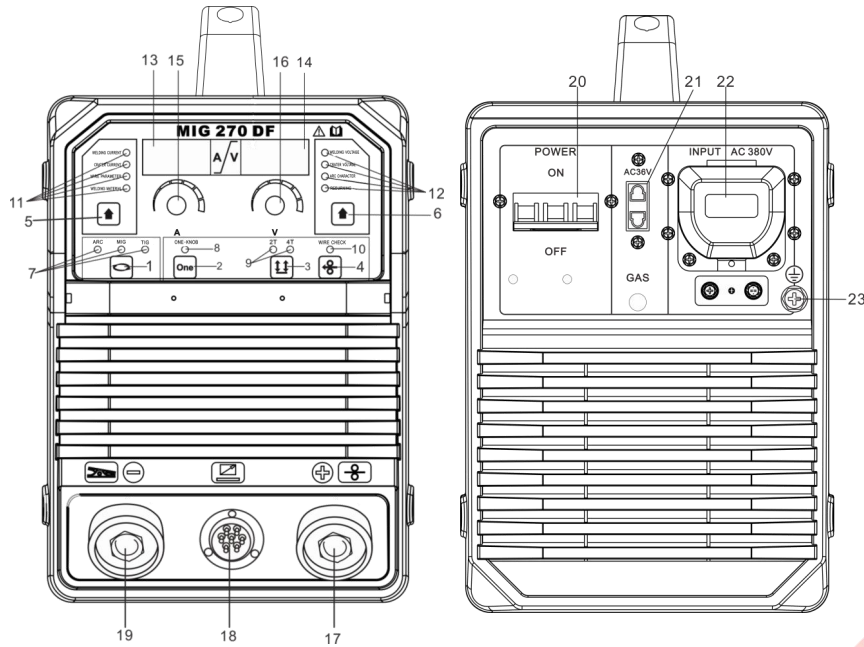


## MIG270DF

### Top Features

- ❖ High current range of 270 amps provides the ability to weld over 1.0 mm plate
- ❖ MMA function ensures the power to weld 3.2 electrodes
- ❖ Multi-function: MIG/MAG and MMA process
- ❖ Convenient digital operational interface. Automatically matching welding parameter
- ❖ Perfect match for 1.0/0.8/0.6 mm solid wire and 3.2mm electrodes
- ❖ Overheat, over-current and over-voltage detection, anti-shock and anti-sticking functions
- ❖ IP21S classification to ensure reliability in harsh and demanding environmental conditions

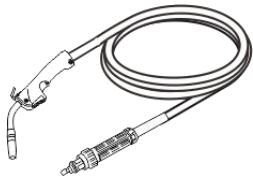
Technical	Parameters	Technical	Parameters
Input Power	380V(±15%)/3Ph/50HZ/60HZ	Wire diameter (mm)	0.6/0.8/1.0
Rated input current (A)	18.2	Insulation grade	F
Rated Output Current /Voltage/Duty Cycle	50-270A/35V/60%	Housing protection grade	IP21S
MMA Output Current	30-240A	Applicable thickness (mm)	Over 1.0
Power factor	≥0.9	Output cable (mm <sup>2</sup> )	Over 25
Efficiency (%)	≥85	Net Weight (kg)	15.3
Wire feed speed (m / min)	3-24	Dimensions H×W×D (mm)	433 x 219 x 354
Post flow time(S)	1.0±0.5		



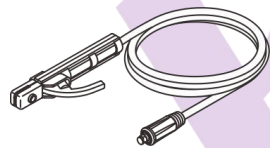
### Function description

1	ARC/MIG/TIG function switch button	13	Ammeter
2	Synergic unified function button	14	Voltmeter
3	2T/4T Status switch button	15	Current adjustment knob
4	Wire checking function button	16	Voltage adjustment knob
5	Welding current/ARC current/electrode diameter/electrode material selection button	17	Positive output
6	Welding voltage / arc voltage / arc force / back burn time/remote control selection button	18	Wire feeder control wire six-hole socket
7	ARC/MIG/TIG indicator	19	Negative output
8	Synergic unified indicator	20	
9	2T/4T indicator	21	AC 36V Gas meter power supply
10	Wire checking indicator	22	Input power line terminal block
11	Welding current/ARC current/electrode diameter/electrode material indicator	23	Grounding bolt
12	Welding voltage / arc voltage / arc force / back burn time/remote control indicator		

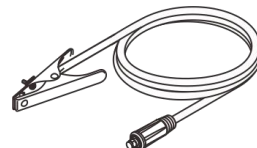
### ACCESSORY DRAWING



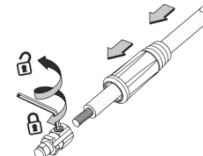
MIG Torch



Electrode holder with cable



Earth clamp with cable



Connector assembly way

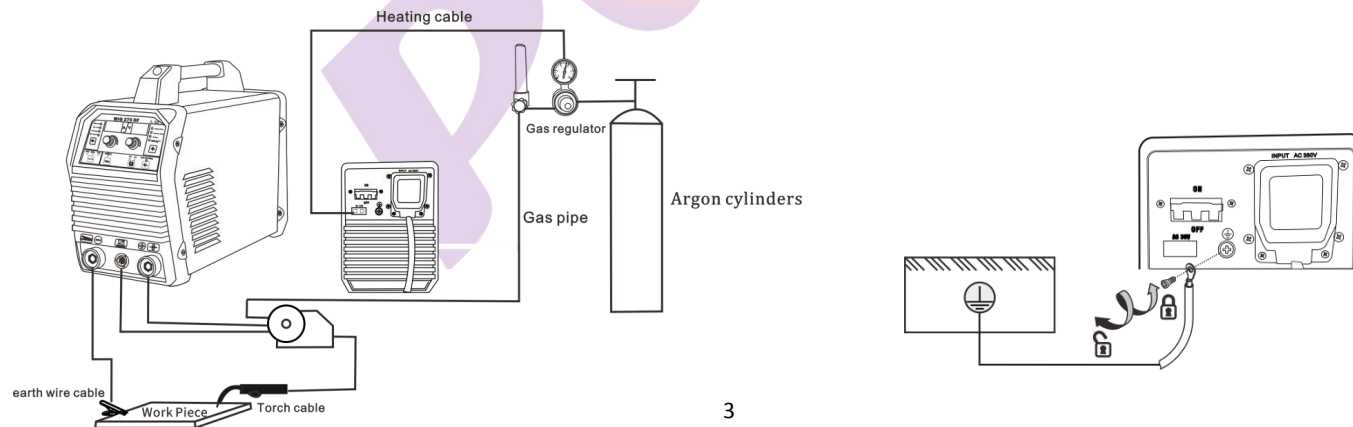


Internal hexagonal wrench

## INSTALLATION INSTRUCTION

If the connecting cable is too long, it will have a great influence on the arcing performance as well as the stability of the welding performance. Therefore, please use the recommended length. If you want to reduce the voltage drop, please use a cable with a larger cross section.

- 1) The gas cylinder equipped with the carbon dioxide gas pressure reducing flow meter is closely connected with the gas inlet of the carbon dioxide inlet at the back of the machine.
- 2) Plug the ground wire quick plug into the corresponding quick socket on the front panel.
- 3) The wire spool equipped with the welding wire is mounted on the frame shaft of the wire feeder, and the hole position of the wire wire plate is aligned with the fixing bolt on the frame shaft.
- 4) Depending on the diameter of the wire used, choose a different wire feed slot.
- 5) Loosen the nut of the pressure roller, feed the welding wire into the wire feeder groove through the wire guide tube, adjust the pressure wire to press the welding wire to ensure that the welding wire does not slide, but the pressure should not be too large, to prevent the wire from being deformed and affecting the wire feeding.
- 6) The wire spool should be rotated clockwise to release the wire. In order to prevent the wire from loosening, the new wire disk head is often placed in the fixing hole on the side of the wire disk. In order to prevent the bent wire from being stuck during normal use, cut off this part of the wire.
- 7) The torch is inserted into the output socket of the front panel and tightened, and the wire is inserted into the gun body. Ground the cables with section area no less than 6mm<sup>2</sup> to the housing, the way is connecting screw in the back of the power source to ground device;



## *FUNCTION DETAIL DESCRIPTION*

### **1.Function button description**

#### 1)ARC/MIG/TIG mode switch button

The working mode of the welder can be switched. When the button is pressed multiple times, the working mode of the welder can be cyclically switched, and the corresponding status indicator can indicate the current working mode of the welder.

#### 2)Synergic unified function button

①In the MIG mode, the welding parameters can be automatically matched. At this time, the welding voltage can be fine-tuned. Press button 6 to restore the default matching value.

②Press the button again, the Synergic unified status indicator is off. At this time, the welder is in a non-synergic uniform state, and the welding voltage, welding current, arc force and other parameters need to be manually matched.

#### 3)2T/4T switch button

①Press and hold the torch switch welder in the 2T state, and release the torch switch welder to stop working, generally used for short seam welding and spot welding.

②Pressing the torch switch welder in the 4T state, the welding current and welding voltage are not controlled, and the torch switch is released to continue welding. The welding current welding voltage is controlled, and the torch switch welder is pressed again to continue welding. The arc current and the arc voltage are controlled, and the torch switch is released again, and the welding machine stops welding. It is suitable for long-slit long-distance welding, and the corresponding indicator lights when the state is switched.

#### 4)Wire checking function button

In the MIG state, when the wire check function button is pressed, the wire feeder is in the state of wire detection, the wire is fed quickly, the corresponding status indicator lights up, and when the button is released, the wire is stopped.

#### 5)Welding current/ARC current/electrode diameter/electrode material selection button

Pressing the button multiple times in the non-welding state selects the current adjustable parameter, the corresponding indicator light is on, the current adjustment knob can adjust the parameter value, the preset value of the parameter is displayed in the ammeter, and the current meter is displayed in the welding state and the actual output current of the welder.

6)Welding voltage / arc voltage / arc force / back burn time/remote control selection button

Press the button several times in the non-welding state to select the current adjustable parameter, and the corresponding indicator is on.

Voltage adjustment knob Adjust the parameter value and the set value of the parameter is displayed in the voltmeter. The voltmeter in the welding state shows the actual output voltage of the welder.

## 2.Adjustment knob

1)Current adjustment knob: used to adjust welding parameters such as welding current / arc current / wire diameter / wire material selection.

2)Voltage adjustment knob : used to adjust welding parameters such as welding voltage/arc voltage/arc force/back burn time/remote control selection.

## 3.Parameter Description

1)Welding current: the current output when the welder is normally welded.

2)arc current: the welding machine stops the output current before welding and adjusts with the arcing voltage.

3)wire diameter: different wire diameters of 0.6mm, 0.8mm and 1.0mm can be selected.

4)wire material: different materials can be used for welding work.

5)Welding voltage: the output voltage of the welder during normal welding.

6)Arc voltage: the welding machine stops the output voltage before welding and adjusts it together with the arcing current.

7)Arc force: the welding arc characteristics are appropriately adjusted as the welding output current increases, which can reduce the welding spatter.

8)Back burn time: the burn-back time is adjustable from 10-99.9ms.

9)Remote control: the MIG270DF model is turned on by default in the remote control state. If it is in the near control state (the wire feeder adjustment knob is not adjustable), it can be pressed multiple times in the non-uniform state, "welding voltage/arc voltage/arc force/returning/ Remote control" button to the welding voltmeter shows y.on switch to remote control. When the welding voltmeter shows y.off, it switches to the near-control state.