

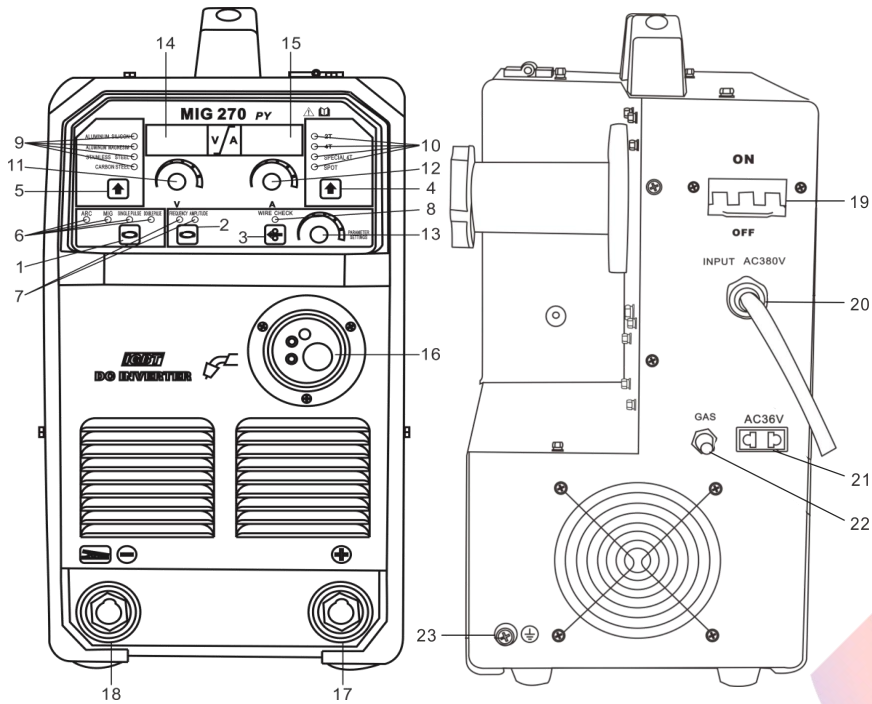


MIG270PY

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: Pulse and Double Pulse MIG/MAG, MMA process
- ❖ high performance to weld aluminum alloy, titanium alloy, etc.,
- ❖ 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

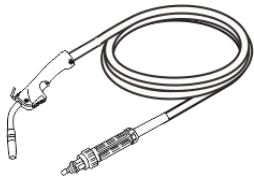
<i>Technical</i>	<i>Parameters</i>	<i>Technical</i>	<i>Parameters</i>
Input Power	380V(±15%)/3Ph/50HZ/60HZ	Wire diameter (mm)	0.6/0.8/1.0
Rated input current (A)	18.2	Insulation grade	F
Rated Output Current /Voltage/Duty Cycle	50-270A/35V/60%	Housing protection grade	IP21S
MMA Output Current	30-240A	Applicable thickness (mm)	Over 1.0
Power factor	≥0.9	Output cable (mm ²)	Over 25
Efficiency (%)	≥85	Net Weight (kg)	22.3
Wire feed speed (m / min)	3-31	Dimensions H×W×D (mm)	581 x 234x 470
Post flow time(S)	1.0±0.5		



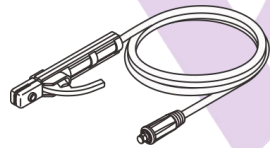
Function description

1	ARC/MIG/Single pulse / double pulse function switch button	13	Parameter setting adjustment knob
2	Frequency/amplitude state switch button	14	Voltmeter
3	Wire checking function button	15	Ammeter
4	2T/4T/Special 4T/spot welding function switch button	16	Positive output
5	Aluminum silicon / aluminum magnesium / stainless steel / carbon steel material selection button	17	Positive output
6	ARC/MIG/Single pulse / double pulse indicator	18	Negative output
7	Frequency/amplitude indicator	19	Power switch
8	Wire checking indication	20	Input power line
9	Aluminum silicon/aluminum magnesium/stainless steel/carbon steel material indicator	21	AC 36V Gas meter power supply
10	2T/4T/Special 4T/spot welding function indicator	22	Air intake
11	Voltage adjustment knob	23	Grounding bolt
12	Current adjustment knob		

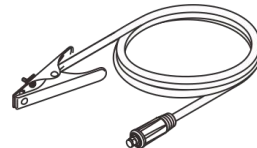
ACCESSORY DRAWING



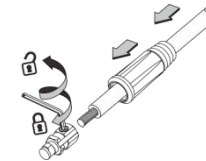
MIG Torch



Electrode holder with cable



Earth clamp with cable



Connector assembly way

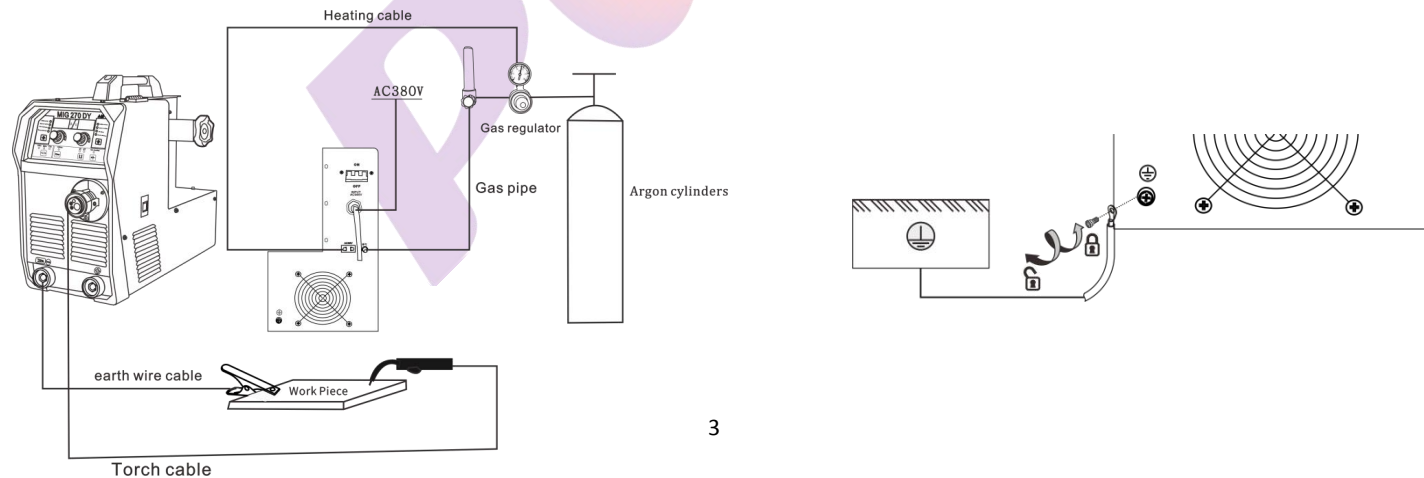


Internal hexagonal wrench

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 6mm² 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/single pulse/double pulse function 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)2T/4T/special 4T/spot welding function 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.

3)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.

4)Aluminum silicon/aluminum magnesium/stainless steel/carbon steel material selection button

Pressing the button, then you can select different welding wire material

5)Welding voltage / arc voltage / arc force / back burn time 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/arcing voltage/arc force/back burn time 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.