USER MANUAL

WELDING RECTIFIER Inverter
DIGITIG 200AC / DC MULTIPRO

Sherman®
digitec—
1. GENERAL

Commissioning and operation of the device can be made only after a careful reading of this handbook.

Due to the continuous development of technical equipment, some of its functions can be modified and operation may differ in detail from the description in the manual. This is not a device error, but the result of continuous progress and modification work unit.

Damage from improper handling results in a loss of warranty. Any alteration of the rectifier are prohibited and void the warranty.

2. SAFETY

Staff operating the device should have the necessary qualifications entitling them to carry out welding work:

- should have the competence in the field of electric welder MMA welding and gas-shielded,
- know the rules of safety during the operation of the power they are welding equipment and auxiliary equipment powered by electricity,
- know the safety rules when handling and installation of the cylinder of compressed gas (argon)
- know the contents of this manual and use the device for its intended purpose.

**WARNING**

Welding may endanger the safety of the operator and other persons in the vicinity. Therefore, when welding special precautions must be taken. Prior to welding, refer to the applicable health and safety regulations in the workplace. During electric welding MMA and TIG has the following hazards:

- ELECTRIC SHOCK
- ARC NEGATIVE IMPACT ON HUMAN EYES AND SKIN
- PAIRS AND GAS POISONING
- BURNS
- EXPLOSION AND FIRE HAZARDS
- NOISE

**Prevention of electric shock:**

- a device connected to a technically efficient electrical system to the proper security and effectiveness of neutral (additional fire protection); Check and properly connect to the network and other devices in the workplace welder,
- current leads off with the mounted unit,
- It does not simultaneously touch the non-insulated part of the electrode holder, the electrode and the workpiece in the device housing,
- Do not use the handles and load wires with damaged insulation,
- under special hazard of electric shock (work in environments with high humidity and closed tanks) to work with the helper supporting the work of the welder and watchful over the safety, use gloves and clothing with good insulation properties,
- if you notice any irregularities, please contact the competent people to remove them,
- It is forbidden to operate the device with the covers removed.

**Preventing negative effects of electric arc on human skin and eyes:**

- Use protective clothing (gloves, lab coat, shoes, leather)
- Use protective shields or helmets with properly matched filter,
- Use protective curtains of non-combustible materials, and properly selected colors wall absorbing the harmful radiation.
Poisoning prevention vapors and gases evolved at the time of welding of coatings for welding electrodes and evaporation of metals:

- Use ventilation and exhaust installed in limited air exchange.
- Blow fresh air when working in a confined space (tanks)
- Use masks and respirators.

Preventing burns:
- Wear suitable protective clothing and footwear to protect from burns from arc radiation and spatter,
- Avoid contamination of clothing lubricants and oils that may lead to its inflammation.

Explosion prevention and fire:
- Do not operate the machine and welding in areas at risk of explosion or fire,
- Welding station should be equipped with fire-fighting equipment,
- Welding station should be located a safe distance from flammable materials.

Preventing negative effects of noise:
- Wear earplugs or other protection against noise,
- Warn people about the danger nearby.

⚠️ WARNING!

Do not use the power source for thawing frozen pipes.

Before starting the unit:
- Check the condition of electrical and mechanical connections. It is forbidden to use handles and load wires with damaged insulation. Inadequate insulation handles and cables current danger of electric shock,
- Ensure proper operating conditions, ie. To ensure proper temperature, moisture and ventilation in the workplace. Outdoors closed to protect from rain,
- Place the charger in a place that allows its easy handling. Persons operating welder should:
  - have the power to electric welding electrode welding and TIG,
  - know and comply with applicable health and safety regulations when performing welding work,
  - use proper, specialized protective equipment: gloves, apron, rubber boots, shield or welding helmet with a suitably selected filter
- know the contents of this manual welder and operated in accordance with its intended purpose. Repair work may only be carried out after removing the plug from the wall socket.

When the device is connected to the network is not allowed to touch the bare hand or by any wet clothing elements forming the welding current circuit.
It is forbidden to remove the outer casing when the device is turned on to the network. Any alteration of the rectifier on their own are prohibited and may constitute a deterioration in security conditions.

All maintenance and repair may only be performed by authorized persons with the conditions applicable to the safety of electrical equipment. Do not operate the welder in areas at risk of explosion or fire! Welding station should be equipped with fire-fighting equipment. After working the machine power cord must be disconnected from the network.

The above risks and the general safety rules is not exhaustive safety of the welder, since it does not take into account the specifics of the workplace. They are an important complement to bench safety instructions and training and briefings given by supervisory staff.
3. GENERAL DESCRIPTION

DIGITIG 200AC / DC MULTIPRO is used for manual welding, and the DC alternating structural steel coated electrodes (MMA method) and quality steels and non-ferrous metals tungsten inert gas (TIG). In the design and construction of equipment we used the latest advances in technology PWM (pulse width modulation) and IGBTs (insulated gate bipolar transistors with gate) so that the welder is characterized by small size and low weight.

During MMA welding function is available ARC FORCE. During TIG welding it is possible to control the rise and fall of current, and przedwypluwy powypluwy gas and the pulse parameters and the AC current. The device has a memory of 10 sets of parameter settings for TIG HF and MMA.

4. SPECIFICATIONS

4.1 welder

<table>
<thead>
<tr>
<th>power supply</th>
<th>AC 230V ± 10% 50Hz</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum power consumption</td>
<td>MMA 5.7 kVA TIG 4.1 kVA</td>
</tr>
<tr>
<td>Rated welding current / cycle</td>
<td>MMA: 180 A / 60% TIG 200 A / 60%</td>
</tr>
<tr>
<td>Rated voltage of no-load condition</td>
<td>67 V</td>
</tr>
<tr>
<td>Maximum current consumption</td>
<td>MMA: 26.6 A, 19.6 A TIG</td>
</tr>
<tr>
<td>network security</td>
<td>25 And</td>
</tr>
<tr>
<td>Weight (without accessories)</td>
<td>17 kg</td>
</tr>
<tr>
<td>dimensions</td>
<td>480 x 200 x 330 mm</td>
</tr>
<tr>
<td>Level of security</td>
<td>IP23</td>
</tr>
</tbody>
</table>

4.1.1 range parameter adjustment

<table>
<thead>
<tr>
<th>ARC FORCE</th>
<th>0 - 100 A</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pre-gas</td>
<td>0.1 - 15 s</td>
</tr>
<tr>
<td>Post-gas</td>
<td>0.1 - 15 s</td>
</tr>
<tr>
<td>current Ramp</td>
<td>0 - 15 s</td>
</tr>
<tr>
<td>drooping current</td>
<td>0 - 15 s</td>
</tr>
<tr>
<td>initial current</td>
<td>5 - 200 A</td>
</tr>
<tr>
<td>welding current</td>
<td>MMA: 20-180 A TIG 5-200 A</td>
</tr>
<tr>
<td>The current base</td>
<td>10 - 90% of the welding current</td>
</tr>
<tr>
<td>current crater</td>
<td>5 - 200 A</td>
</tr>
<tr>
<td>pulse rate</td>
<td>0.5 - 999 Hz</td>
</tr>
<tr>
<td>pulse width</td>
<td>10 - 90%</td>
</tr>
<tr>
<td>The frequency of the AC</td>
<td>1 - 250 Hz</td>
</tr>
<tr>
<td>AC balance</td>
<td>15 - 50%</td>
</tr>
</tbody>
</table>

4.2 TIG

<table>
<thead>
<tr>
<th>handle type</th>
<th>T-26</th>
</tr>
</thead>
<tbody>
<tr>
<td>The maximum current carrying capacity</td>
<td>200 A</td>
</tr>
<tr>
<td>gas flow</td>
<td>10-20 l / min</td>
</tr>
<tr>
<td>arc ignition</td>
<td>Contactless (HF)</td>
</tr>
<tr>
<td>Length</td>
<td>4 m</td>
</tr>
</tbody>
</table>

Duty cycle

Duty cycle is based on a period of 10 minutes. Duty cycle of 60% means that after 6 minutes of operation of the device is required for 4-minute break. Duty cycle of 100% means that the machine can operate continuously without interruption.

Attention! Heating test was carried out in the ambient air temperature. Duty cycle at 40 °C was determined by simulation.
5. CONSTRUCTION AND OPERATION

The basis for the construction of the power conversion electronics welders are made in IGBT technology for working in the frequency range above 200 kHz. The principle consists of a single-phase rectified voltage to the power supply voltage, conversion of the resulting DC voltage to a square wave high frequency voltage transformation in the range required by the welding process and re-erection of the resulting voltage on the DC voltage. The welding device is equipped with a compensation system power supply, allowing them to operate with voltage fluctuations in the mains to 10%.

6. CONNECTION TO THE MAINS

1. A device to be used only in a single-phase, three-wire, with earthed neutral.

2. The inverter units DIGITIG 200AC / DC MULTIPRO are adapted to cooperate with 230V 50Hz fused 25 A time-delayed action. Power supply should be stable, with no voltage drops.

3. The device is equipped with a power cord and a plug. Before connecting, make sure the power switch (7) is in the OFF position (off).

7. PREPARING THE APPLIANCE FOR OPERATION

For storage or transport devices in freezing temperatures before the start of work to bring the device to an appropriate temperature !!!

7.1 MMA

Welding the wire ends to terminals (1) and (5) located on the front panel so that the electrode holder was appropriate for the electrode pole. The polarity of the wiring depends on the type of welding electrodes used and is given on the electrode packaging. Ground cable terminal must be carefully mounted on a welded material. Plug the device into a power outlet 230V 50Hz.
7.2 TIG

Current terminal holder should be connected to the negative pole (1), plug control handle carefully screwed into the socket (3) and the gas connection socket connectors (2). Gas conduit from the regulator, lead and attach to the gas nozzle (9) located on the rear wall of the housing. The positive pole of the source (5) connected to the work piece by means of a wire with a clamp. Plug the device into a power outlet 230V 50Hz.
8. FUNCTIONAL DESCRIPTION switches and DIAL

8.1 Front and rear panel

1. Power negative polarity
2. Protective gas connection
3. Control handle socket TIG
4. Remote control jack
5. Slot positive polarity

6. Ground Terminal
7. The main switch
8. Power Cord
9. The connection of protective gas

8.2 Control Panel
A - button mode selection source (two-stroke engine / czterotakt)

Button active only TIG welding. Mode selection is signaled by lighting up symbol 2T dwutaktu mode or the corresponding diode 4T czterotaktu mode. In dwutaktu mode, pressing the switch in the handle grip will turn the ionizer and arc ignition. Welding is carried out with a finger on the switch. Releasing the switch will stop the welding. In czterotaktu mode, pressing the switch in the handle grip will turn the ionizer arc starts and then release the switch and lead to the slow welding switch. Pressing the switch will stop the welding.

B - On / off switch pulse

Button active only TIG welding. Mode selection is signaled by lighting up the symbol - welding with pulse, - welding without pulse.

C - selection button welding methods

The button is used to select the welding method. The choice of method is signaled by lighting up the symbol:

- welding with covered electrode (MMA) LIFT - welding the tungsten electrode in inert gas protection from arc ignition by friction (Lift TIG) H. F - tungsten welding electrode gas-shielded arc pilot (HF TIG).

D - The adjustment knob

Knob is used to change the welding parameters.

Briefly pressing the knob causes the transition between the adjustable parameters. Currently adjustable parameter is indicated by illumination of the corresponding LEDs and the display parameters (I) shows the actual parameter value. Rotate the knob to the left to decrease, and turning to the right to increase the parameter value. Pressing the knob will store the parameter value and move to the next parameter.
E - Memory settings

The device has a memory of the last setting, ie after switching off and then return to the last set parameters. You can also store a total of 20 sets of settings for TIG HF and MMA.

To recall previously saved set of settings, press the button until you see the corresponding number set in the display memory (H). If the call connection set we change any of the parameters, the device will exit the memory - the display memory (H) will be extinguished and the LED line USER. The changed parameters are stored automatically after 30 seconds in the cache. After the device is turned off and restarted, they will be restored and the display memory will appear dash.

To save the current settings, press the button and hold two seconds. lights diode USER and the number on the display memory (H) flashes. Turn the knob will change set number. Pressing the button again within 10 seconds will save the current setting the currently selected number. If the 10 seconds will not happen again, the machine will return to the main menu.

If the device is turned off, the memory is loaded set of parameters after restart automatically loaded last used will be set, and the number will appear on the display. If the memory is not loaded any set of parameters and the device is turned off, the next time you turn on the most recently used will be restored and the display parameters (H) appears in the dash.

F - selection button type of welding current (AC / DC)

Pressing the button changes the type of welding current. Choosing the type of current is confirmed lighting up the symbol. AC - alternating current, DC - DC

G - selection button waveform AC

Button allows a choice of the waveform during the TIG welding, or TIG HF Lift:

- sine wave: Classical wave, similar to the welding transformer, favored by older welders.
- square wave: Universal, the most widely used welding waveform for each material. Generates more heat in the weld zone, a greater penetration than the other forms.
- trapezoidal wave: The softer arc with liquid lake and good wetting of the material. Better control of arc than the sine wave.
- Triangular wave: Preferred especially when welding thin materials.
H - Display memory parameter set

The display shows the number of the parameter set that was loaded or under the current set will be saved.

I - display of welding parameters

The display shows the parameters during setup and during welding. The illumination of the corresponding LED on the side of the display indicates a unit parameter.

The display also includes additional LEDs:

- **REMOTE** - LED indicating that the unit is in remote control mode. LED lights up automatically when you connect the remote control to the jack (4)
- **OC** - LED indicates invalid parameters welding current or malfunction. On additionally appears the error code "E00"
- **OT** - Protection against overheating - the power source is equipped with thermal, a circuit breaker. When the temperature is too high welding machines, safety disconnects the welding current, LED OT lights up and the display shows the error code "E00". After falling temperature will automatically reset the circuit breaker.

The display can also indicate other error codes: Invalid parameters E01 E02 mains internal driver error

Incorrect parameters E03 mains and internal driver error

9. PARAMETERS

9.1 MMA

After selecting the MMA it is possible to control the welding current and the function of ARC FORCE. During the welding current LED lights **Current** and adjustment of the ARC FORCE is possible after the ignition of the LEDs **Arc Force**.
ARC FORCE

ARC FORCE allows the arc. Shortening the length of the arc is accompanied by an increase in the welding current, which results in stabilizing the arc. Decreasing the value will give a soft arc and a smaller depth of penetration, while increasing the value results in deeper penetration and the possibility of short-arc welding. At a set high value ARC FORCE function you can be welded while maintaining the minimum arc length and a high speed electrode melting range: 0 - 100A

9.2 TIG

Selection button welding method (C), choose HF TIG welding or TIG Lift. Button to choose the type of current (F) to select current (DC) or alternating (AC). Switch pulse (B) on or off pulse. Press (G) to select the waveform. Set the welding parameters:

**Prąd początkowy** Narastanie prądu Prąd spawania Balans AC Opadanie prądu Powypływ gazu

**Current** Slope Up Start Base Current Slope Down IStop

**Przedwypływ gazu** Szerokość pulsu Częstotliwość pulsu Prąd podstawy Częstotliwość AC Prąd krateru

**Time the gas pre** - the time from pressing the button on the handle of the gun and opening the gas valve until the arc ignition. It should normally be no longer than 0.5 seconds, to provide shielding gas to the outlet nozzle of the burner in order to shield the welding start site and the tungsten electrode. In case of a longer supply pipe gas cylinder przedwypływu time should be longer.

Range: 0.1 - 15s.

**Initial current (And Start)** - current appearing in the circuit by pressing the button in the handle grip. The higher initial current, the easier ignite the arc. However, when welding thin sheet too high value of the initial current can lead to a sheet of burning. In some modes, the welding current does not grow in order to heat the work piece. Range: 5 - 200A.

**Welding current (Current) Adjustment**

range: 5 - 200A.

**Pulse width (PULSE Duty)** - pulse duration, allows you to adjust the depth of penetration. The increase in width increase the depth of penetration, reduction reduces the amount of heat entering the material, reducing the risk of burnout of thinner plates and smaller components.

Lower values of the pulse width must be used for higher currents. The greater the pulse width must be applied to small currents, a width of more than 50% should be used for currents lower than 100A.

Range: 10 - 90%.

**Current base (Current Base)** - responsible for maintaining current welding process, the lower the value of the current pulse. It helps control the quantity of heat input to the material. Base current control is only possible when welding with pulsing range: 10 - 90% of the welding current.
Fall time of the current (Slope Down) - falling time of the welding current value set to zero and the current value of the crater. Range: 0 - 15s.

Crater current (And Stop) - current modes used in some welding when the arc is not extinguished immediately after the descent phase of the welding current. It allows you to fill the crater and the end of the weld. Range: 5 - 200A.

Ramp Time (Up Slope) - Welding current rise time of the initial current to the set welding current. Range: 0 - 15s.

Pulse rate (Pulse Frequency) - the frequency with which the value of a pulse of current between the welding current and the current base.

Frequency AC current (AC Frequency) - a useful feature when welding aluminum. The higher the frequency, the better weld quality and improved arc focus adjustment range 1 - 250Hz, we recommend setting the standard 100Hz.

Balance AC (AC Balance) - The ratio of the duration of the positive phase to a negative power. Reducing the balance yields a greater amount of heat in the material to give a narrower and deeper weld penetration while reducing the thermal load of the tungsten electrode. Increasing the balance will introduce less heat to the material to provide improved cleaning, wide and shallow weld penetration but heavy burden tungsten electrode. Range: 15 - 50% is recommended to set the standard of 25%.

Time powypływu gas - the time of extinction of the arc to close the gas valve in order to shield the solidifying weld pool from air and for cooling the tungsten electrode. Too short time powypływu may result in oxidation of the weld. When welding in TIG mode, the AC (alternating current) time should be longer. Range: 0.1 - 15s.

10. WELDING

10.1 welding with covered electrode (MMA)

10.1.1 Initiation arc

Initiation arc welding coated electrode is to touch the electrode to the workpiece, and short rubbed isolation. For initiation of the arc electrodes, wherein the sheath when solidified, creates a non-conductive slag to be pre-clean the tip of the electrode by repeatedly impact against a hard surface until the metal in contact with the work piece.

10.1.2 Keeping welding process

Welding method selection button to select the method of MMA. In this mode, you can adjust the welding current and Arc Force adjustment function.
Welding current control is possible immediately after power-on. Turning the knob changes the welding current.

10.2. Welding gas-shielded (TIG).

10.2.1 arc initiation and conduct of TIG welding HF

Device DIGITIG 200AC / DC MULTIPRO equipped with the ionizer enabling non-contact arc ignition.

To ignite the arc mode dwutaktu must approach the electrode to the workpiece at the distance of 2 millimeters and press the button in the handle of the burner to turn on the ionizer. Upon successful initiation of the arc
welding the lead button is pressed. Releasing the button on the handle causes the start of the current phase of descent and ending the welding process.

To ignite the arc mode czterotaktu must approach the electrode to the workpiece at the distance of 2 millimeters and press the button on the handle of the torch to turn the ionizer. After the correct arc is lit button can be released and welding lead to the slow button. To complete the welding press again and release the button on the handle.

10.2.2 arc initiation and conduct of TIG welding Lift

To ignite the arc dwutaktu mode, press the button in the handle grip to turn the gas flow. Touch electrode material welded short rub and tear. After the correct initiation of arc welding lead the button pressed. Releasing the button on the handle causes the start of the current phase of descent and ending the welding process.

To ignite the arc czterotaktu mode, press the button in the handle grip to turn the gas flow. Touch electrode material welded short rub and tear. After the correct arc is lit button can be released and welding lead to the slow button. To complete the welding press again and release the button on the handle.

10.2.3 TIG welding in 2T:

- 0: Press and hold the handle. Starts the flow of protective gas;
- 0 – t1: Pre-gas;
- t1 – t2: The arc, the welding current increases from the minimum value to the set value welding current. If the pulsator is activated, the current is modulated.
- t2 – t3: During the welding of the handle should remain depressed;
  Note: If you turn on the pulsator, welding current flashes, if the pulsator is off, the welding current is constant
- t3: Release the holder, welding current begins to fall. If you turn on the pulsator, falling current is modulated;
- t3 – t4: The welding current drops to a minimum value, the arc is extinguished;
- t4 – t5: Post-gas.
- t5: The solenoid valve closes the gas flow, the completion of welding.
10.2.4 TIG mode 4T:

- **0**: Press and hold the handle. Starts the flow of protective gas;
- **0 – t1**: Time gas pre. Can be adjusted in the range of 0 – 1.0 sec;
- **t1**: Arc ignition, is determined at start current;
- **t2**: Release the handle starts to increase current set value of welding current. If you enable the pulsator, the current is modulated;
- **t2 – t3**: Ramp Time;
- **t3 – t4**: The welding process;
  
  Note: If you turn on the pulsator, welding current flashes, if the pulsator is off, the welding current is constant;
- **t4**: Press the handle. The welding current begins to fall to the current value of the crater. If you turn on the pulsator, falling current is modulated;
- **t4 – t5**: Current fall time;
- **t5 – t6**: Current crater;
- **t6**: Release the handle. Arc is extinguished, the shielding gas flows;
- **t7**: The solenoid valve closes the gas flow, the completion of welding.

11. Before calling service,

In the event of malfunction of the unit, before sending welding for service, check the list of basic failures and try to remove them yourself.

Repair work may only be carried out after removing the plug from the wall socket.

Attention! The device is not sealed, and the user can remove the cover of the welding device in order to remove minor breakdowns. symptoms

<table>
<thead>
<tr>
<th>Remedy</th>
<th></th>
</tr>
</thead>
</table>
| The control panel is not lit, the fan does not work, no output | 1. Make sure the switch is in the ON position  
2. Check the security on the network connection and  
3. Remove the cover and check the connection of all electrical plug inside the device |
| The control panel lights up, the fan does not work, no output voltage. | 1. Verify that the device has not been connected to the higher voltage. If so, connect to 230V and turn again  
2. The supply voltage is unstable and turns on the overvoltage protection. Turn off device for 2-3 minutes and then back  
3. Short on and off switch may have been activated overvoltage protection. Turn off device for 2-3 minutes and then back  
4. There was other damage requiring repair by an authorized service |
| The control panel lights up, the fan is working, problems with arc is started | 1. Check TIG replace wear parts, if they are used |
The control panel lights up, the fan is running, no strikes arc welder
1. Check the correct terminals and the electrical conductivity of the electrode wire and the mass
2. Check the connection of TIG torch to the device, pay attention to whether the socket pins are not broken or jam
3. Unscrew the TIG torch handle and check that the switch in the handle is OK

The control panel lights up, the fan is running, the OC LED is on display message “E00”
1. The device is overheated. Wait a few minutes. After the indicator goes out to continue welding.

Unsatisfactory quality of the weld MMA electrode sticks to the work piece
1. Check the polarity of the welding wire
2. Check that the electrode is not wet. Replace the electrode.
3. The welder is supplied from the generator or by a long extension cord diameter is too small cable. Connect directly to the mains

Unsatisfactory quality of the weld TIG welding
1. Replace consumables. Change the tungsten electrode or the gas cylinder for higher quality materials
2. Check that the shielding gas flowing at the proper intensity
3. Check the gas hose, improve the connection hose with quick connectors, and status
4. Check regulator przybutlowy.

List of error codes:

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>E00</td>
<td>Overheating or incorrect parameters welding current</td>
</tr>
<tr>
<td>E01</td>
<td>Invalid parameters mains</td>
</tr>
<tr>
<td>E02</td>
<td>Internal driver error</td>
</tr>
<tr>
<td>E03</td>
<td>Incorrect parameters of the power supply and internal controller error</td>
</tr>
</tbody>
</table>

12. OPERATION MANUAL

Operation of the device DIGITIG 200AC / DC MULTIPRO should take place in an atmosphere free of corrosive components and dusty. Do not place the device in dusty, near the working grinders, etc. Dust and pollution control boards metallic filings, wires and connections inside the unit may cause an electrical short, and consequently damage to the welding machine.

Avoid use in environments with high humidity, especially in situations of occurrence of dew on the metal parts.

If there is dew on the metal parts, for example. After entering the cold equipment into a warm room, wait until the dew disappears. It is recommended that in the event of welding operation outdoor place it under a roof to protect against adverse weather conditions.

Device DIGITIG 200AC / DC MULTIPRO should be operated under the following conditions:
- changes in the effective value of the supply voltage is not greater than 10%
- ambient temperature of from -10 °C to +40 °C
- Atmospheric pressure 860 to 1060 hPa
- relative humidity of the atmosphere is not more than 80%
- height above sea level to 1000m

You k with consumable parts TIG torch T 26:

<table>
<thead>
<tr>
<th>No.</th>
<th>Name</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Tungsten electrode</td>
</tr>
<tr>
<td>2</td>
<td>Compression sleeve T-26</td>
</tr>
<tr>
<td>3</td>
<td>The connector current T-26</td>
</tr>
<tr>
<td>4</td>
<td>Gas nozzle T-26</td>
</tr>
</tbody>
</table>

For a full list of consumables and spare parts is available on the website and in the company www.tecweld.pl TECWELD. There is a possibility of direct purchase of these parts.
13. MAINTENANCE INSTRUCTIONS

As part of the everyday operation of the welder must be kept clean, check the connection status and the status of external electrical wires and cables. Regularly replace consumables.

Periodically clean the inside of the device by purging with compressed air to remove dust and chips from metallic plates, and the control wires and electrical connections. Not less than once every six months should be a general review of the status and electrical connections, in particular:

- state of shock protection
- the insulation
- the state security
- the operation of the cooling system

Damage resulting from the welding operation in unsuitable conditions and failure of recommendations for maintenance are not covered by warranty repairs.

14. INSTRUCTION STORAGE AND TRANSPORT

The device should be stored at -10 °C to + 40 °C and relative humidity 80% free of corrosive fumes and dusts. Transportation of packaged devices should be covered means of transport. For transport the packaged unit must be secured against slipping and ensure the correct position.

15. COMPLETE SPECIFICATION

1. Source DIGITIG 200AC / DC MULTIPRO 1 piece.
2. Holder for TIG welding 1 piece.
3. Electrode wire 1 piece.
4. Earth cable with a clamp 1 piece.
6. package 1 piece.

16. ELECTRIC SCHEME
17. GUARANTEE

Guarantee granted for a period of 12 months for business entities or consumers for 24 months from the date of sale.

The guarantee will be respected by the advertiser after the presentation of proof of purchase (invoice or receipt) and warranty card inscribed with the product name, serial number, date of sale and point of sale bearing the stamp.

In the case of warranty repair should contact TECWELD, which will arrange the reception device by courier.

Shipments sent at the expense of TECWELD through other shipping companies will not be accepted!

Welder should be provided with the welding torch. Complaints device without the torch will not be considered.

The device transmitted to the complaint must be packed in the original carton, and protected by Styrofoam original fittings. TECWELD company is not liable for damage caused by a welder during transport.

If you wish to discard this product, do not throw it with general household waste. According to the WEEE Directive (Directive 2002/96 / EC) in force in the European Union for used electrical and electronic equipment must be used methods of utilization.

In Poland, in accordance with the provisions of the Act of July 1, 2005. Waste electrical and electronic equipment is prohibited to place together with other wastes of used equipment marked with crossed out wheeled bin symbol.

The user who wishes to discard this product, it is obliged to return waste electrical and electronic equipment to a used equipment collection point. Collection points are conducted, among others, by wholesalers and retailers of equipment and the municipal organizational units engaged in waste collection.

These legal obligations have been introduced to reduce the amount of waste generated from waste electrical and electronic equipment and to ensure an adequate level of collection, recovery and recycling of used equipment. Proper implementation of these duties is important especially when the waste equipment contains hazardous components which have a particularly negative impact on the environment and human health.

TECWELD Peter Polak
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DECLARATION OF CONFORMITY 01 /
DIGITIG200ACDCMULTIPRO / 2018

Manufacturer's authorized representative:
TECWELD Peter Polak
41-943 Piekary Slaskie Street.
Emerald 21/3/6

branch:
41-909 Bytom ul. 3
Cross POLAND

Declare that the said product:

inverter welder

Trade name: DIGITIG 200AC / DC MULTIPRO
Type: TIG 200P AC / DC

Manufacturer's trademark:

beside which this declaration relates complies with the following directives of the European Union and
national provisions implementing the Directive:

LVD Low Voltage Directive 2006/95 / EC
II RoHS Directive 2011/65 / EU

and is compliant with the following standards:

BS EN 60974-1: 2013-04 Arc welding equipment - Part 1: Welding power sources,
BS EN 60974-10: 2010 Arc welding equipment - Part 10: Requirements
electromagnetic compatibility (EMC)
BS EN 50581: 2013-03 Technical documentation assessment of electrical and electronic products
taking into account the restriction of the use of hazardous substances.

Year affix the CE mark on the device: 2017

Bytom, dn. 06/01/2018

(Signature of authorized person)