

## ARC-250T amp Welding Machine

### Powerful and Portable

Welds: mild steel, carbon steel, alloy steel, copper and its alloy etc.

### 1.Features

- \* Latest IGBT inverter technology
- \* Excellent arc stability with all electrodes
- \* Thermal overload protection
- \* IP 23 rating for environmental/ safety protection
- \* Tolerant to variable power supplies



### Accessories

Quick plug

35-50

Torch

300A electrode holder/3m/35mm<sup>2</sup>

Earth Cable

3m/35mm<sup>2</sup>

Clamp

300A

### 2.Technical Data

Item No.	Rated Input Voltage V	Rated Input Power KVA	Rated Output Current A	Duty Cycle	Dimension L*W*H CM
Three phase/50~60 Hz					
ARC-250T	380/415	9.5	250	60%	48*21-41

### Overview

Those machines are inverter-based welding machines produced using the latest in IGBT technology. Low cost and portable those machines are reliable, robust and stacked with features that you can expect from a quality welder.



### 3. Caution

#### 3.1 Working environment

- 3.1.1 The environment in which this welding equipment is installed must be free of grinding dust, corrosive chemicals, flammable gas or materials etc, and at no more than maximum of 80% humidity.
- 3.1.2 When using the machine outdoors protect the machine from direct sun light, rain water and snow etc; the temperature of working environment should be maintained within  $-10^{\circ}\text{C}$  to  $+50^{\circ}\text{C}$ .
- 3.1.3 Keep this equipment 30 cm distant from the wall.
- 3.1.4 Ensure the working environment is well ventilated.

#### 3.2 Safety tips

##### 3.2.1 Ventilation

This equipment is small sized, compact in structure, and of excellent performance in amperage output.

The fan is used to dissipate heat generated by this equipment during the welding operation.

**Important:** Maintain good ventilation of the louvers of this equipment. The minimum distance between this equipment and any other objects in or near the working area should be 30 cm. Good ventilation is of critical importance of the normal performance and service life of this equipment.

##### 3.2.2 Thermal overload protection

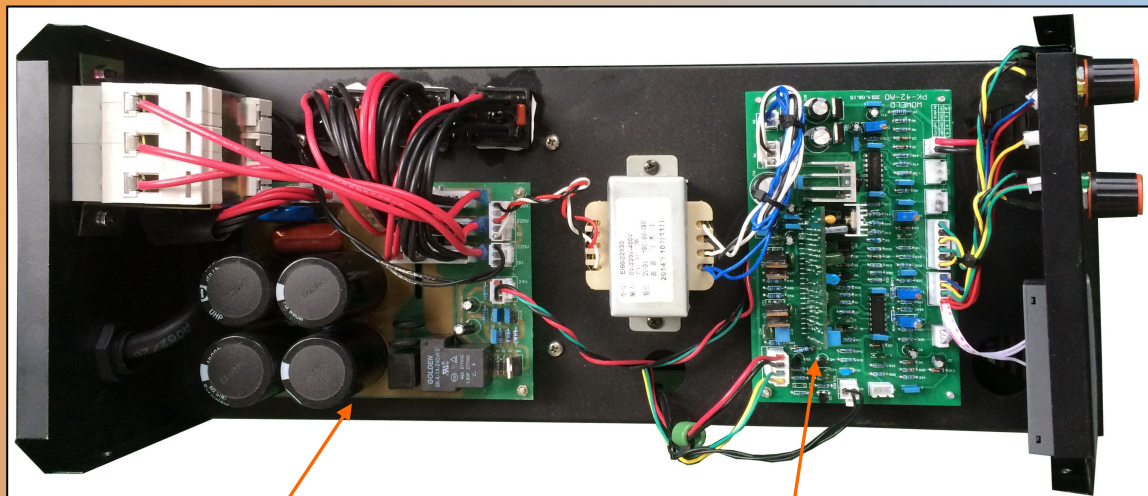
Should the machine be used to an excessive level, or in high temperature environment, poorly ventilated area or if the fan malfunctions the Thermal Overload Switch will be activated and the machine will cease to operate. Under this circumstance, leave the machine switched on to keep the built-in fan working to bring down the temperature inside the equipment. The machine will be ready for use again when the internal temperature reaches safe level.

- 3.2.3 Do not come into contact with the output terminals while the machine is in operation. An electric shock may possibly occur.

#### 3.3 Trouble Shooting

ONLY qualified technicians are authorized to undertake the repair of this welding equipment. For your safety and to avoid electrical shock, please observe all safety notes and precautions details.

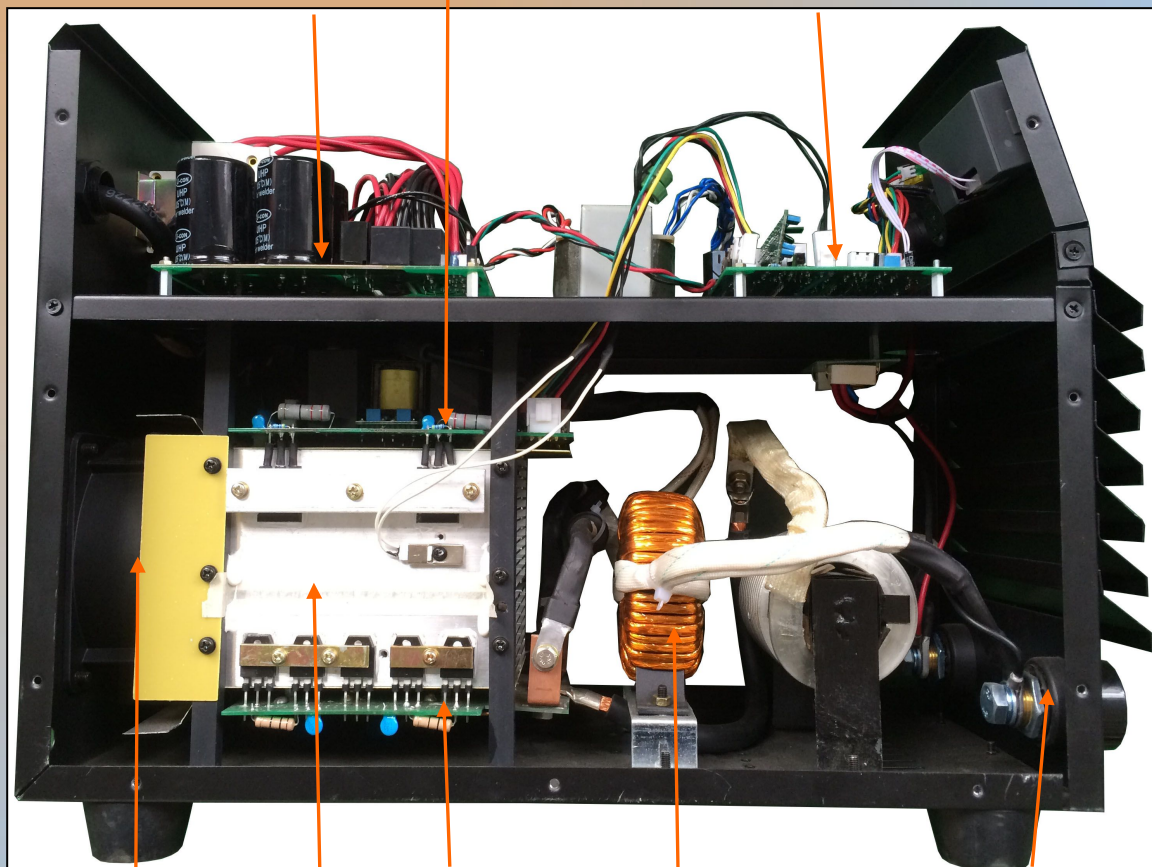
#### 4.Spare parts identification



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#### Part Number Description

1 Capacitor PCB board

2 Inverter PCB board

3 Control Board

4 Fan DC24V

5 Heatsink

6 Rectifier PCB board

7 Main transformer

8 "+" terminal



### 5.Install procedure

- 1.Welding machine should be installed in a stable position and with good ventilation. Avoid direct sun outdoors. Avoid transport in invert or side position.
- 2.Connect electrode holder, earth cable, according to connection diagram.
- 3.Set welding current according to Table
- 4.Commission the machine after the machine is installed and tested.

### 6.Operation

- 1.Check the connection of work piece, earth cable, electrode holder, make sure they are firm and reliable.
- 2.Switch on the power source.
- 3.Hold the electrode holder, touch the work piece, after arc is ignited, move the holder along seam evenly. Fine tune the welding parameter to obtain exquisite welding seam. Untouched the holder to finish a welding cycle.
- 4.After finish operation, turn off welding power source and wall switch.

### 7.Maintenance

**DISCONNECT POWER INPUT AND SWITCH OFF THE MAIN POWER SWITCH BEFORE START OF MAINTENANCE.**

Regular Check and Inspection	6 Month Routine Maintenance
<ul style="list-style-type: none"> <li>• Replace unreadable labels</li> <li>• Check the function of all switches.</li> <li>• Check if the fan rotates properly and if there is air venting out from back of the machine</li> <li>• Pay Attention to the abnormal vibration, noise, smell and gas leakage during operation</li> <li>• Check If the welding cables are over heated?</li> <li>• Check If the cable connections are over heated?</li> <li>• Check If the cable is connected firmly and properly, if it is broken and cause bad insulation?</li> </ul>	<ul style="list-style-type: none"> <li>• Blow out with dry clean pressure air or vacuum inside the machine.</li> <li>• Check the electric connection of input/output bar to avoid bad contact caused by loose or rusted screw.</li> </ul>

### 8.Warranty

We offer the warranty periods of 13 months from the BL date for machines ONLY!

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