

# MIG225i

## QUICK SET-UP

1. Install the 220v electrical plug with the green and yellow wire to ground and connect the other two wires to the hot wires. Hook up the proper welding gas, install welding wire and torch assemblies following the instructions in the owner's manual.

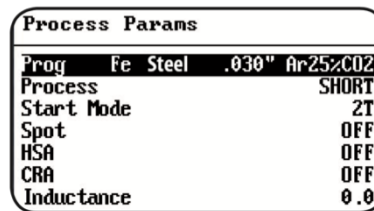
2. Turn on the welder using the on/off switch in the lower back corner of the unit. You will see a boot up display for a few seconds and then the display will change to one similar to the image on the right.



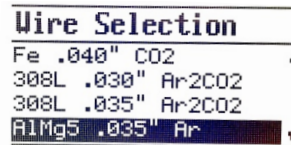
3. Turn the torch selection knob either to the right to select the aluminum push pull torch or to the left to select the steel / braze torch.



4. Push the red knob for **3 seconds or more** and the Process Parameters display will appear.



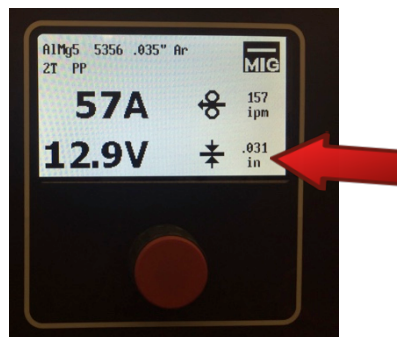
5. Push and **quickly release** the red knob and the Wire Selection display will appear.



6. Turn the red knob to scroll and highlight the kind of wire and gas you are using. Then push the red button and **quickly release**. You will be at the Process Parameters screen again but now showing the wire and gas you selected. The welder is pre-set to .035" aluminum wire for the aluminum torch and .030 steel wire for the steel torch. These spools of wire are included with the new welder.

7. Push the red knob for **2 seconds** or more and you will be back at the main screen.

8. Turn the red knob to set thickness of your material as shown in the lower right corner of the display.



**You are now ready to weld.**

Because the welder uses a synergic curve principle, the wire speed is pre-set and welding amps, and welding voltage, all change together. **Just set the metal thickness and weld.** Please see the back page for more detailed instructions.

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### Welding Gas Adjustment

Open each gas bottle. Activate each torch trigger and adjust the gas flow using the flow adjustment knob. Set the aluminum wire gas flow to about 40 CFH and steel/braze flow to about 30 CFH. (After a few seconds the gas flow shuts off and the wire speed increases). This allows you to quickly feed wire without wasting gas.

### Short / Pulse Arc Welding

Short arc welding is the default setting for steel or aluminum welding. To weld aluminum using the pulse arc mode, push the red knob for three seconds or more and the Process Parameters display will appear. To activate the pulse feature, in the Process Parameter Menu, select Process and quickly push the red knob. Scroll to pulse, quickly push the red knob, selecting the pulse mode. Push the red knob for three seconds or more and you will be back at the Main Menu with pulse mode showing in the display.

Short Arc Mode

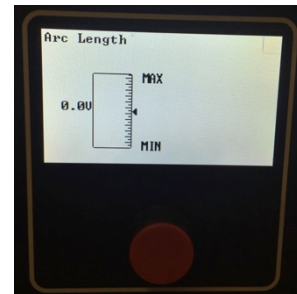
Pulse Arc Mode



**You must reset your metal thickness when switching modes.**

### Arc Length Adjustment

The arc length is preset after setting the metal thickness but you can quickly increase and decrease it so you can “fine tune” your heat setting if needed. To change the arc length quickly push the red knob in the main menu and the Arc Length setting will appear. Increasing it above “0” will increase the heat the decreasing it below “0” will decrease the heat.



### Spot Welding

To use the spot weld feature using steel welding wire, from the main menu, push the red knob for 3 seconds or more. You will now be in the Process Parameter Menu. Scroll down to spot and quickly push the red knob. Scroll down to on and quickly push the red knob. Scroll down to spot time and quickly push the red knob. Adjust the spot time as desired. Push the red knob for three seconds or more and you will be at the main menu. Install the optional spot weld nozzle and you are ready to spot weld.

**Please read the Owner’s Manual for more detailed instructions and also many more advanced welding options.**

## SYNERGIC CURVE (WIRE SELECTION):

Setting	Wire Dia	Composition	Shielding Gas	Material Thickness		Application
				MIN/MAX inch	SHORT PULSED	
E71TGS	.035	Flux Core - Steel	none	.039 - .240 1 - 6 mm		All-purpose steel welding from sheet metal to structural
Fe	.023	Steel	75% Argon 25%CO2	.024 - .118 0,6 - 3 mm	.028 - .138 0,7 - 3,5 mm	All-purpose steel welding from thin sheet to structural
Fe	.023	Steel	100% CO2	.024 - .197 0,6 - 5 mm	.031 - .197 0,8 - 5 mm	All-purpose steel welding from thin sheet to structural
Fe	.030	Steel	75% Argon 25%CO2	.031 - .130 0,8 - 3,3 mm	.031 - .197 0,8 - 5 mm	All-purpose steel welding from thin sheet to structural
Fe	.030	Steel	100% CO2	.031 - .150 0,8 - 3,8 mm	.039 - .197 1 - 5 mm	All-purpose steel welding from thin sheet to structural
Fe	.035	Steel	75% Argon 25%CO2	.024 - .157 0,6 - 4 mm	-	All-purpose steel welding from thin sheet to structural
Fe	.035	Steel	100% CO2	.024 - .236 0,6 - 6 mm	-	All-purpose steel welding from thin sheet to structural
Fe	.040	Steel	75% Argon 25%CO2	.031 - .157 0,8 - 4 mm	-	All-purpose steel welding from thin sheet to structural
Fe	.040	Steel	100% CO2	.031 - .236 0,8 - 6 mm	-	All-purpose steel welding from thin sheet to structural
308L	.030	Stainless-Steel	98% Argon 2% CO2	.031 - .157 0,8 - 4 mm	.024 - .197 0,6 - 5 mm	Steels
308L	.035	Stainless-Steel	98% Argon 2% CO2	.035 - .177 0,9 - 4,5 mm	.031 - .209 0,8 - 5,3 mm	Steels
AlMg5 5356	.035	Aluminum Magnesium 5%	100% Argon	.031 - .236 0,8 - 6 mm	.031 - .236 0,8 - 6 mm	All-purpose, automotive body panel and structural repair, pressure vessels boats and truck bodies
AlMg5 5356	.040	Aluminum Magnesium 5%	100% Argon	.035 - .197 0,9 - 5 mm	.028 - .236 0,7 - 6 mm	All-purpose, automotive body panel and structural repair, pressure vessels boats and truck bodies
AlSi12 4047	.035	Aluminum Silicon 12%	100% Argon	.039 - .276 1 - 7 mm	.024 - .236 0,6 - 6 mm	Parts
AlSi12 4047	.040	Aluminum Silicon 12%	100% Argon	.035 - .236 0,9 - 6 mm	.031 - .157 0,8 - 4 mm	Parts
CuSi3 6560	.030	Copper Silicon 3%	100% Argon	.024 - .197 0,6 - 5 mm	.031 - .142 0,8 - 3,6 mm	MIG brazing, automotive body panel and structural repair with high strength, Boron and galvanized steels
CuSi3 6560	.035	Copper Silicon 3%	100% Argon	.024 - .177 0,6 - 4,5 mm	.031 - .197 0,8 - 5 mm	MIG brazing, automotive body panel and structural repair with high strength, Boron and glvanized steels