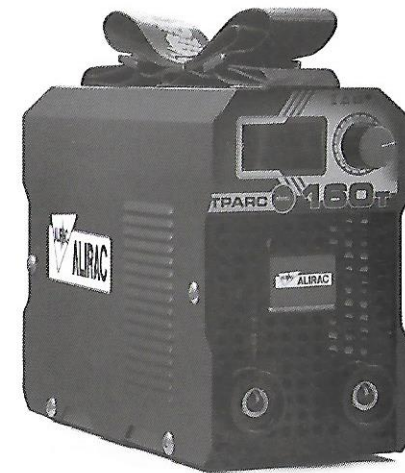


# Operator's Manual

Inverter DC MMA Welder

TPARC-160T/200T



**IMPORTANT:** This operational manual kindly show you how to install, debug, operate and maintain the welder. Read this instructions carefully and you will understand how to use it to reduce the risk of error operation.



**Warning!**

**This machine should be operated and maintained by full-time staffs or professionals.**

**You are not allowed to operate and repair it unless read this manual in advance!**

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## 1 Brief Introduction

TPARC welder uses imported IGBT and fast recovery diodes as main electric components. It is supplemented by a specially developed main PCB board. In addition, the uniform regulation of welding current has been designed to guarantee the arc reach good welding process adaptability. What's more, its perfect dynamic protection features ensure that it is safe and reliable when use. It is ideal for using low carbon steel, stainless steel, alloy steel etc.

### TPARC Features:

- Synergic MMA & Lift TIG welder.
- Lower cost operation, more portable, more compact, superior output.
- Excellent arc properties and solution droplet transfer.
- With the protections of over-heating, over-voltage, over-current.
- Plastic handle makes it easy to carry.
- Convenient quick connection for the output makes it quick, safe, simple and stable.

**NOTES: The above description may be modified without prior notice such as omissions, unclear statements about this welder.**

## 2 Safety

### 2.1 Self-Protection

- \* The user must comply with occupational safety and health rules and wear appropriate labor protective equipment. Try to avoid injury on eye and skin.
- \* It is safe to cover your head with face mask while welding, only do the observation on the arc through the window of the mask.
- \* Don't expose any part of the body at the same time to the welding positive and negative output terminals without insulated protection.

## 2.2 Cautions

- \* TPARC Inverter DC Arc welder is a kind of electronic product which makes its components more easily damaged. While replacing or modulating, the strength should not be too much in order to avoid causing damage to the device.
- \* Check the connection to see if it is correct or reliable each time before working. Besides, ensure the grounding outlet device correct.
- \* While using, as smoke is harmful to human's health, the operation must be carried out in the ventilation and exhaust facilities.
- \* Prohibit non-professionals to change or replace the welder.
- \* Since the welder owns strong electromagnetic and radio frequencies, the people with cardiac pacemakers affected by the interference electromagnetic, electrical frequency are not allowed to stay nearby.
- \* When it works, please pay attention to its rated duty cycle. Do not overload.

## 2.3 Safety Precaution for Installation and Location

- \* In some areas, where something may fall from the sky, personal safety precaution should be taken.
- \* In some areas around construction site, something like the dust, acid, corrosive gases or other substance in the air can not exceed the standard value except those generated while welding.
- \* It should be equipped in the open air where there is no direct sunlight, anti-rain, temperature range from  $-10^{\circ}\text{C}$  to  $+40^{\circ}\text{C}$  and low humidity place.
- \* 50cm space is needed to ensure good ventilation.
- \* No metal impurities are tolerant inside the welder.
- \* In some areas, there is no severe vibration.
- \* Make sure no interference will be caused to the surrounding in the welding area.
- \* Whether the power supply capacity is sufficient to allow the welder to work normally or not. And a safety protection device should be equipped in the input power.

- \* Prevent it from dumping if the welder is put in the place of over  $10^{\circ}$  incline.

## 2.4 Security Check

The following items must be checked up by the operator each time before access to the power source.

- \* Make sure the power socket is reliably grounded.
- \* Make sure the output terminals are well connected without short circuit.
- \* Make sure output and input cables are perfect with no exposure.

The welding machine must be inspected by professionals at regular time (not exceed 6 months). The contents as follow:

- \* Whether the electronic components are loosed or not and dust removal must be conducted.
- \* Whether the panel mounted on the device should be able to guarantee the normal implementation of the machine.
- \* Whether the input cables are damaged or not. If yes, safe handling must done.



**Disconnect the power source before servicing it. Contact with the manufacturer or agent immediately to acquire the service and support skills when users do not have the ability to repair it.**

## 3 Technical Description

### 3.1 Environment

- \* Working temperature:  $-10^{\circ}\text{C}$ ~ $40^{\circ}\text{C}$ .
- \* Transportation and storage:  $-25^{\circ}\text{C}$ ~ $55^{\circ}\text{C}$ .
- \* Relative air humidity:  $40^{\circ}\text{C} \leq 50\%$ ;  $20^{\circ}\text{C} \leq 90\%$ .
- \* The dust, acids, corrosive gases and substance in the ambient air must be lower

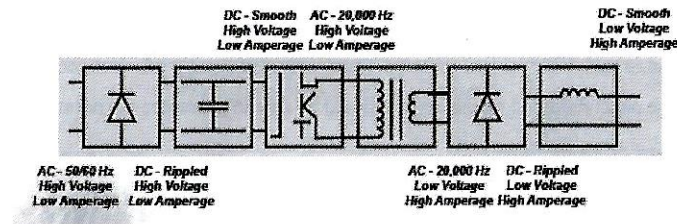
normal level except those from welding process.

- \* Altitude must be less than 1km.
- \* Keep good ventilation at a distance of 50cm around.
- \* Put it in somewhere the speed of wind not less than 1m/s.

### 3.2 Input Power

- \* Power supply waveform should be sine wave and frequency fluctuations with less than +1% of its rating.
- \* The fluctuations of input voltage must be lower than +-10% of the rated value.

### 3.3 Equipment Principle



NOTES: This is inverter technology. The main part as follow:

Rectifier → Filter → IGBT → Transformer → Rectifier → Choke

### 3.4 Equipment Structure

The TPARC Inverter DC MMA Welder uses portable cabinet structure: the upper part of front panel has been equipped with welding current adjustment knob, power indicator (green), abnormal indicator (yellow). The output terminal is fitted with quick connector both “+” and “-”. The back panel owns power switch, motor fan, input power cable. The inside body of the machine includes PCB main board, electronic components, radiator etc.

### 3.5 Parameter

Item/Model	TPARC-160T	TPARC-200T
Rated Input Voltage (V)	1ph AC230	1ph AC230
Frequency (Hz)	50	50
Rated Input Capacity (KW)	6.6	7.7
Rated Input Current (A)	30	34
Rated Duty Cycle(25°C)	60%@160A	40%@180A
No Load Voltage (V)	66	66
Output Current Range (A)	10~160	10~180
Efficiency (%)	85	85
Protection Class	IP21S	IP21S
Insulated Grade	H	H
Electrode Size (mm)	1.6-4.0	1.6-5.0
Cooling Type	fan	fan
Dimension (mm)	256*115*180	256*115*180
Net Weight (KG)	3.2	3.2

### 3.6 Standard

- \* EN 60974-1: Arc Welding Machine Standards
- \* JB / T 7824: Technical Conditions of Inverter Arc Welding Rectifier
- \* GB 4208: Protection Class (IP Code)

### 3.7 Symbol Chart

Note that only some of these symbols will appear on your model.

0	On	Hz	Hertz (cycles / sec)
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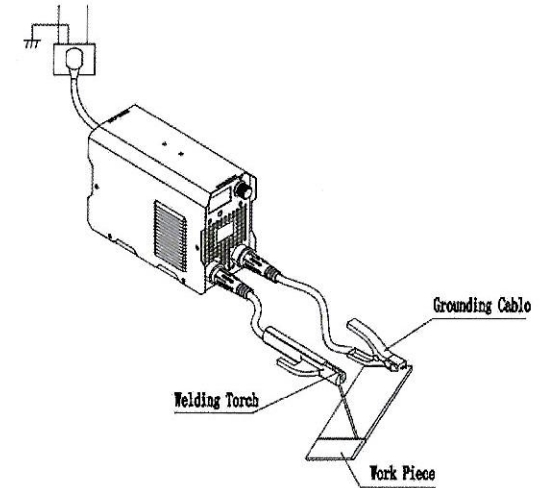
⊙	Off	f	Frequency
⚡	Dangerous Voltage	—	Negative
↷	Increase / Decrease	+	Positive
~	AC Auxiliary Power	≡	Direct Current (DC)
⊞	Fuse	⊕	Protective Earth
A	Amperage	⚡	Line
V	Voltage	1 ~	Single Phase
3 ~	Three Phase	X	Duty Cycle
⚡	SMAW	⚡	GMAW
⚡	GTAW	⚡	High Temperature
⊙	Wire Feed Function	⚡	Welding Gun

## 4 Installation

### 4.1 Connection

- \* The welder should be placed in dry and dusty surrounding where there is no corrosive chemicals, flammable, explosive gases.
- \* Avoid direct sunlight and rain. And maintain the ambient temperature ranging from -10°C to 40°C.
- \* The space of 50cm should be left around the equipment.
- \* If indoor ventilation is not good enough, the ventilation exhaust device should be installed.

### Installation Diagram



### 4.2 Power Source Connection

Access the back panel (power source cable) to the power supply which is equipped with circuit breakers and grounding line (grid), and it is strictly prohibited that ground wire is connected to the grid, otherwise bear your own consequences.

### 4.3 Electrode Polarity (see above picture)

Connect the quick plug with electrode holder to the positive terminal and then tightened them up clockwise.

### 4.4 Workpiece Connection

Connect the quick plug with earth clamp to the negative terminal on the front panel below. And then tighten them up. Access the earth clamp to the workpiece.



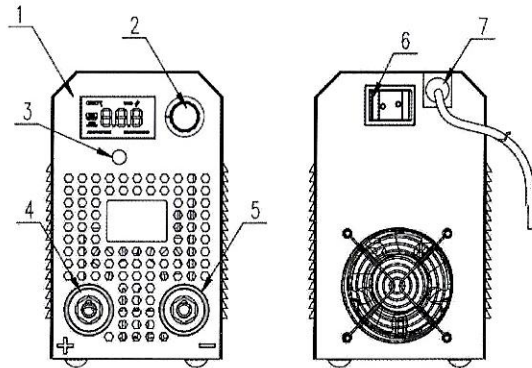
It is forbidden to connect the workpiece to the welder with iron or other poor conductors.

## 5 Operation Instruction

NOTES: The case protection class is IP21S. Finger or round bars especially

metal rod must be less than 12.5mm and it can not be inserted into the welder.

Also you can not press it heavily.



1. LCD	2. Knob	3. button	4. Positive Terminal
5. Negative Terminal	6. Power Switch	7. Power Source Cable	

**NOTES:** When the welder works for a long time, the high temperature indicator will light. This means the inside temperature has exceeded its standard. And you must turn off the power immediately for a period until it recovers.

\* You have to wear canvas overalls and face mask to prevent from arc light and heat radiation.

\* Vibration screen should be laid out to prevent others from arc light.

\* Inflammable and explosive stuffs are not allowed to pile up. All the connections must be right, reliable.

### MMA welding steps (TPARC-140T for example)



1) When turn on this welder, press and adjust the potentiometer knob select current output.

10 – Maximum output current. Press the soft button into MMA page, select “YES”



2) “Electrode” Press the soft button and clockwise rotate the knob, it is selection different dimension of electrode 0.0-1.6-2.0-2.5-3.2, when after choosing, press that your selection, each electrode dimension will output a fit default for welding.



3) Anti stick..Press the soft button to “Anti Stick” page. Clockwise rotate the knob, will display “ON”. Anticlockwise rotate the knob, will display “OFF”. Default is “ON”.



4) Hot Start. Press the soft button to “Hot Start” page. Clockwise rotate the knob with the beginning of 0 (0 means there have no hot start), and when slowly clockwise rotate the knob, the digital will grow bigger, the maximum display is “100”. ( The current of hot start ⇒real current+ 100% real current). The display “100” means that at this time, you have choosen a 100% hot start, the maximun current for the hot start is 140Amp, default is 0 Amp.



5) Arc Force. Press the soft button to “Arc Force” page. Clockwise rotate the knob with the beginning of 0 (0 means there have no arc force), and when slowly clockwise rotate the knob, the digital will grow bigger, the maximum display is “50”. (The current of arc force = real current + 50% real current). The display “50” means that at this time, you have chosen a 140Amp Arc Force, the maximum current for the arc force is 140Amp, default is 0Amp.



6) VRD. Press the soft button to “VRD” page. Clockwise rotate the knob, will display “ON”. Anticlockwise rotate the knob, will display “OFF”. Default is “ON”.



7) LIFT TIG. Press the soft button to “LIFT TIG” page. Clockwise rotate the knob, will display “YES”. Anticlockwise rotate the knob, will display “OFF”. Default is “OFF”. If setting the machine LIFT TIG ON, please connection your earth clamp in positive pole, LIFT TIG torch in negative pole.

### 5.1 Procedure

- a) Connect to the power switch light on.
- b) To press the soft button and adjust the current potentiometer to the required value of the welding.
- c) Pick up electrode holder, and point at the welding edge. Then put the electrode on the workpiece, you can start welding.

### Attention:

MMA connection: Electrode holder connect to positive pole, earth clamp connect to negative pole.

LIFT TIG connection: Earth clamp connect to positive pole, LIFT TIG torch connect to negative pole.

### 5.2 Electrode Replacement

When the electrode is left only 2~3cm away from the holder, you have to replace new one to go on working.

**NOTES:** When the electrodes combustion is in process at high heat, do not touch it with bare hands while replacing it. Besides, the electrode head down should be unified in a metal container. And the cover coating should not be caught by the holder. Scratch gently when igniting the arc, otherwise it is easy to come across the phenomenon of sticking electrode.

### 5.3 Slag Removal

After finishing work, you should remove the slag with specific knock residue tools in the way of knocking.



Warning!

The welding slag should not be removed until it is cooled down. Don't point it at the other people while knocking on the slag incase that it will do harm with pop-up slag.

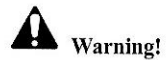
### 5.4 Maintenance

\* The major difference between inverter arc welder and traditional welder is the inverter welder has lots of advanced electronic components. What's more, it is high technology product. And this requires high skill maintenance.

\* It is very essential to do daily maintenance. You must be responsible for examination and repair. Once you do not have the ability to check it, kindly contact with manufacturer to acquire the service and support of technology.

**The following is the steps for maintaining:**

- a) Dust removal.
- b) Remove dust by professionals with dry and clean compressed air (using a compressor or Paper Tiger) regularly. Meanwhile, check inter circuit of welding machine regularly and make sure the cable is connected correctly and connectors are connected tightly. If scale and loose are found, please give a good polish to them. Then connect them again tightly. Generally, if welding machine is operating in environment where there is no heavy accumulated dust, the machine need remove dust once a year. If in the environment where is polluted with smokes and polluted air, it is needed to be removed once or even twice of each season.
- c) To maintain good contact with cable and plugs.
- d) Check up the contact conditions of cable and plug frequently, at least once a month for stationary use.



**Warning!**

**Due to high voltage in the main circuit of the welder, you need to do the safety precaution measure to prevent accidental electric shock. Don't open the shell except for the professionals. Remember to turn off the power before removing dust. And don't meddle with the connections and components when doing this work.**

**6 Basic Troubleshooting**

No.	Description	Possible Cause	Remedy
1	Abnormal indicator	Bad ventilation leads to overheating protection	Improve ventilation conditions
		High environmental temperature	Automatic recovery after decreasing
		Exceed rated duty cycle	Replace potentiometer
2	Current knob broken	Potentiometer damaged	Replace it
3	Motor fan can't work or low rotational speed	Bad power switch	Replace the switch
		Bad fan	Replace the fan
		Led broken	Check the circuit
4	No open circuit voltage	Overheating	See point 1
		Bad power switch	Replace the switch
5	Electrode holder cable is too hot; output terminals are too hot.	Capacity on electrode holder is too small	Replace larger capacity electrode holder
		Cable is too thin	Replace a proper cable



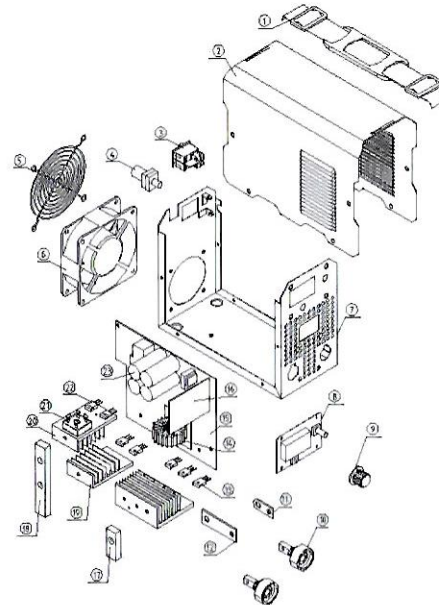
		Socket is loosen	Remove the oxide coat and re-tight it
6	Power off	Power capacity is not big enough	Enlarge the capacity
		Welding process	Contact the supplier
7	Other problems		Contact the supplier

**Warning!**

The machine has the function of prohibit switching power supply in rapid succession within a short period of time for switching on and off. The power will not open then (the indicator light is not on or the fan does not work or there is no-load voltage). Shut down the power switch and resume back to normal after a few minutes.

**7 Parts List**

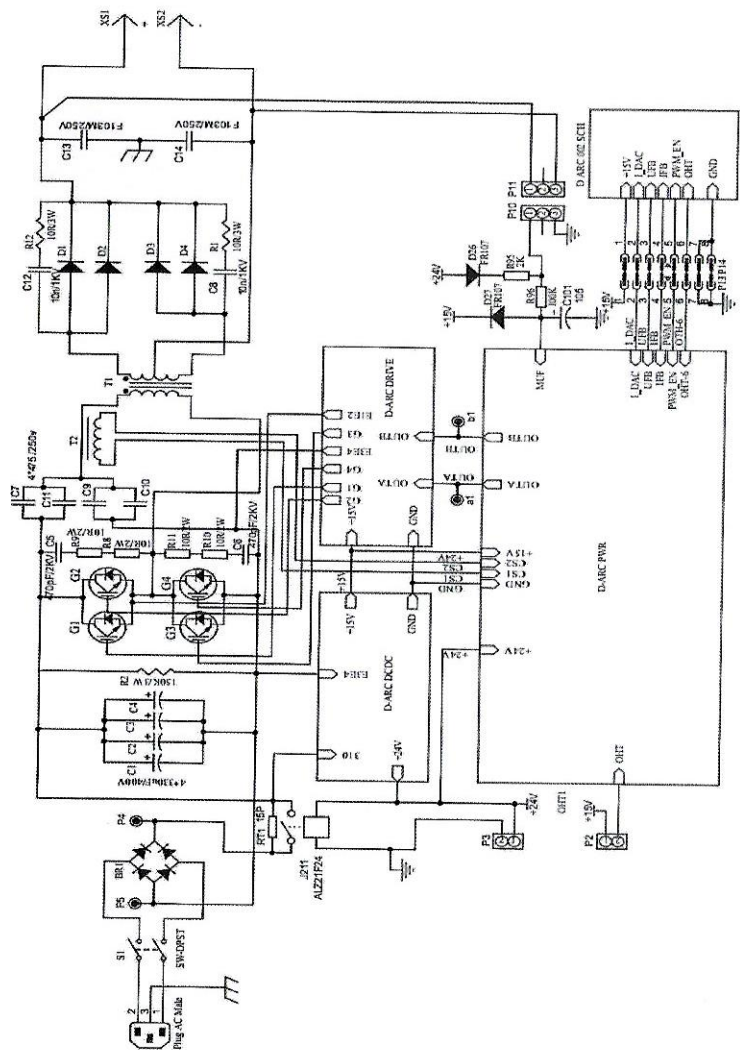
NO	Name	Qty
1	Belt	1
2	Machine cover	1
3	Power switch	1
4	Power cord	1
5	Fan screen	1
6	Fan cover	1
7	Bottom board	1
8	LCD board	1
9	Potentiometer knob	1
10	Quick connector	2
11	Connection piece	1
12	Connection piece	1
13	Fast recovery diode	4



14	Main transformer	1
15	Main circuit board	1
16	Control circuit board	1
17	Pillar1	1
18	Pillar2	1
19	Radiator1	1
20	Radiator2	-1
21	Rectifier	1
22	IGBT	4
23	Electrolytic capacitor	4

**NOTES:** The above components listed are just for your reference. If something different with the real machine, kindly follow the real one

**8 Interconnection Diagram**



**Circuit Schematic of TPARC Welder**  
(Figures for reference are subject to change without notice.)  
**9 Accessories**

No.	Description	Qty.
1	TPARC Welder	1set
2	Operator's Manual	1pc
3	Electrode Holder	1pc
4	Earth Clamp	1pc
5	Face Mask with Filter	1pc
6	Brush & Hammer	1pc

**NOTES:** All above mentioned are based on the ordering contact unless otherwise agreed by the parties.

### 10 Transportation and Storage

- \* This machine is an indoor equipment and the attacks of rain and snow should be avoided in the process of transportation and storage. While loading and unloading, more attention should be paid on the package with words of warning. Storage warehouse should be kept dry with good air circulation and no corrosive gas or dust. The temperature should be maintained from -25°C to 55°C and relative humidity must be lower than 90%.
- \* If the products are still needed to continue storing after stripping, repacking should be carried out according to original package's requirement. Remember before storage, don't forget to clean and seal it with plastic bags.
- \* Users should maintain the cartons and shock blocks in order to be properly packaged in need of long distant transportation. For the long distant transportation, it should be retrofitted with a wooden case and mark the "up" or "rain" symbols.

### 11 Quality Warranty

If the machine is used in accordance with the regulations on the operation manual, in

compliance with the rules on installation, storage, use, maintenance, safeguarding, manufacturers should provide free services for the users under the conditions of within 12 months from the date of purchase (based on the issued invoice date).