



# MANUAL BOOK

**WM270C**

**CO2/MAG/MIG/ AUTOMATIC**

**WELDING MACHINE**



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# Prolegomenon

We do very appreciated for your selecting our products.

It can be composed the WM – 270C CO<sub>2</sub> ARC Welding system equipped with SB-10 wire feeder and welding gun. It has many characteristic such as easy Arc starting good Arc springiness adjustable arc thrusting, low splash, good welding form, easy welding operation. The CO<sub>2</sub> semi-auto Arc welding machine model WM – 270C is advanced welding machine and it can be compared with foreign products.

This operation manual can help you for the machine installation, operation and maintenance correctly and safely. Pay attention to the points as following.

- Installation of the power cord. Be grounded correctly.
- Don't put sundries under the welder. Otherwise it will affect the heat released.
- Installation for the positive and negative cable of the power output.
- Welding voltage selection
- Welding current selection

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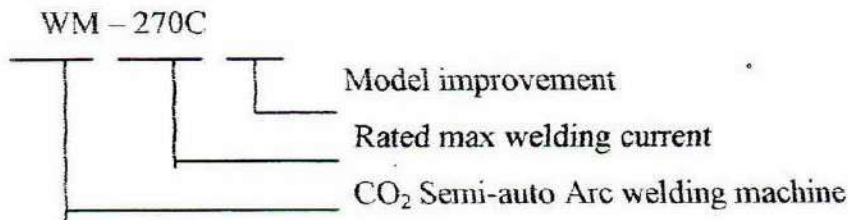
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## 1. Main characteristic and suitable range

This kind of welding power Model WM – 270C is taken foreign advanced technology to develop and manufacture. It has the perfect performance of high quality,good reliability,quick speed of welding current, steady welding process,low splash and good welding form. Anyway,it becomes the welding veery easy.

### 1.1 Structure of the WM – 270C CO<sub>2</sub> semi-auto Arc welding machine

#### a. The name of model



#### b. Composing of the product

This product is composed by three parts as following

- ❖ Power source (WM – 270C)
- ❖ welding gun

### 1.2 Suitable range of the WM – 270C

- ❖ Suitable material : low-carbon steel, stainless steel
- ❖ Thickness of the material : low-carbon steel and stainless: more than 1.5mm
- ❖ Suitable position: all positions
- ❖ Suitable wire : Ø 0.8, 1.0, 1.2 solid wire/flux core wire

### 1.3 Characteristic of WM – 270C

- ❖ Wide out-put current 40-315A : 0.8 -----40-150A  
1.0 -----50-250A  
1.2 -----80-315A
- ❖ Steady welding process, low splash, easy control, good welding form.
- ❖ Low starting of wire feed

## 2. Main technical data :

- ❖ Input Voltage 3~380; 50/60Hz
- ❖ Rated Input current 18A
- ❖ Rated Input power 6.2KVA
- ❖ No-load Voltage 38V(max)
- ❖ Voltage adjusting Range 16±3V~38±3V
- ❖ Current output Range 40~315A

❖ Suitable wire	0.8, 1.0, 1.2 (solid/flux)
❖ Duty cycle	315A/30V X=40% (Rated condition); 200A/24V X=100%
❖ Insulation class	F
❖ Protection class of shell	fan cooling
❖ Weight	82KG

### 3. Function

#### 3.1 Adjusting function for the welding voltage and welding current

WM – 270C supply the adjusting range as following,

Welding voltage :  $16V \pm 3V \sim 38V \pm 3V$  use the voltage rough control switch and Voltage fine control switch

Welding current : 40A~315A use the current adjusting knob

#### 3.2 36Vac-3A/110W power function

When you use the CO<sub>2</sub> welding machine, you may generally equip with gas heating source. So we design the power function to meet the heating for 36V-3A/110W heater. The out connection is in the back panel of WM – 270C

#### 3.3 Spot Welding

When Open the 'spot time' knob, you can select right time (pulse regulator to minimum, turning it anticlockwise to the end), then spot welding

#### 3.4 pulse welding

Open the the 'spot time' knob and the, 'pulde' knob at one time, you can achieve 'pulse welding'

3.5 The spot wire feed speed can be adjusted by the welding current knob on the front of panel.

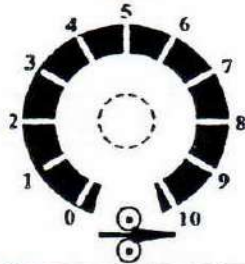
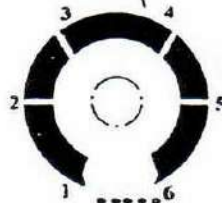
### 4. Indicating and warning on WM – 270C control panel

#### 4.1 Indicating and adjusting

**SPOT TIME**

**PULSE TIME**

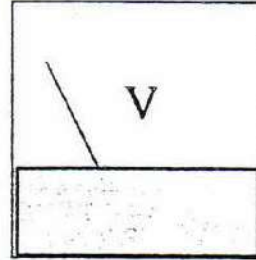
**WARNING LIGHT**



**ON**



**power switch**



**VOLTAGE**



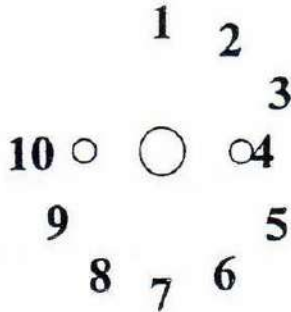
**power**



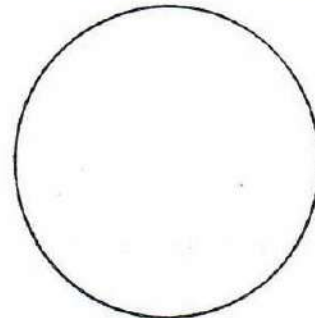
**warning**

**CURRENT**

**WM - 270C**



**Don't Switch, please  
While Welding**



**WELDING TORCH**

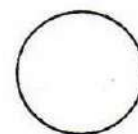
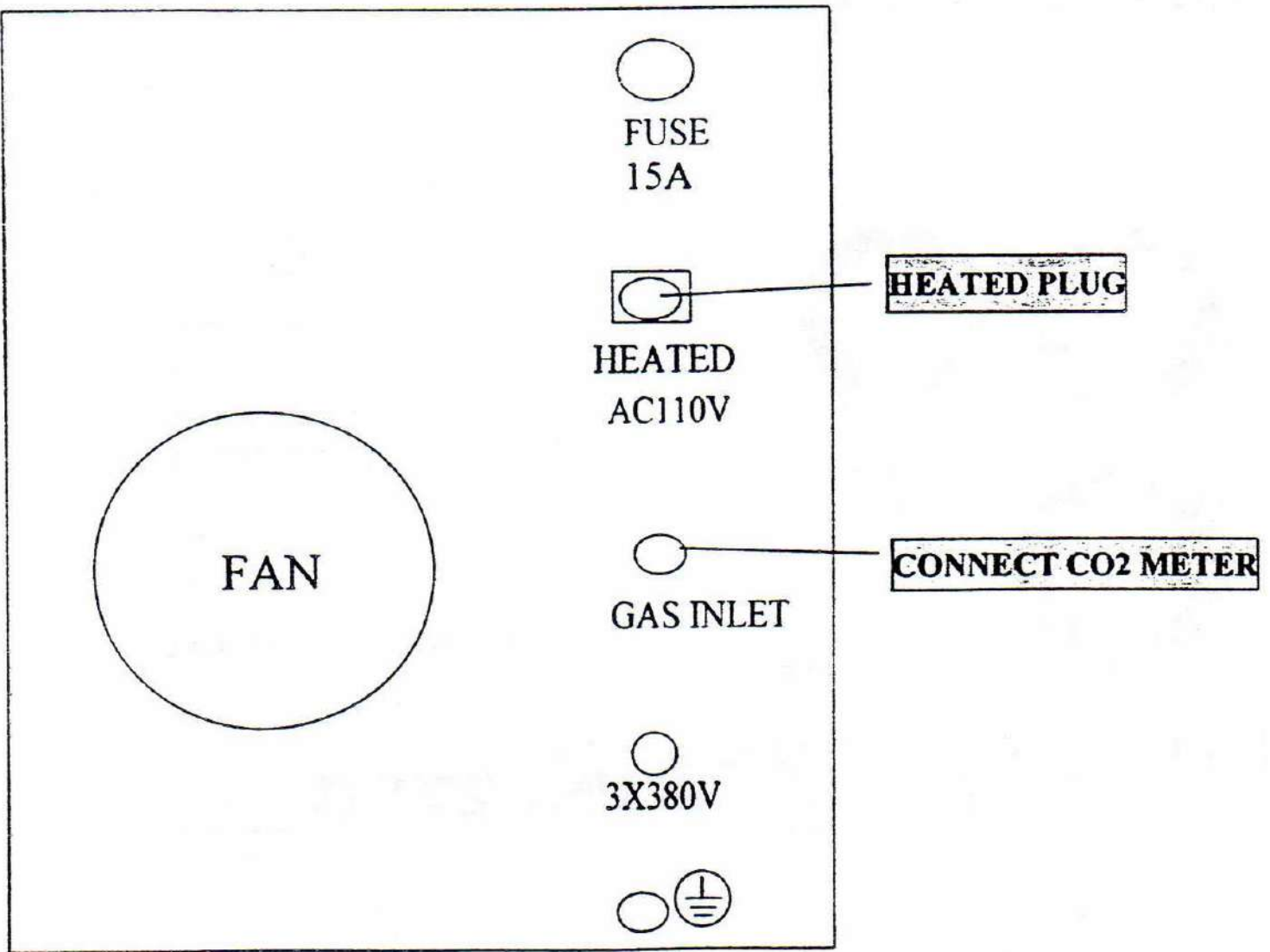
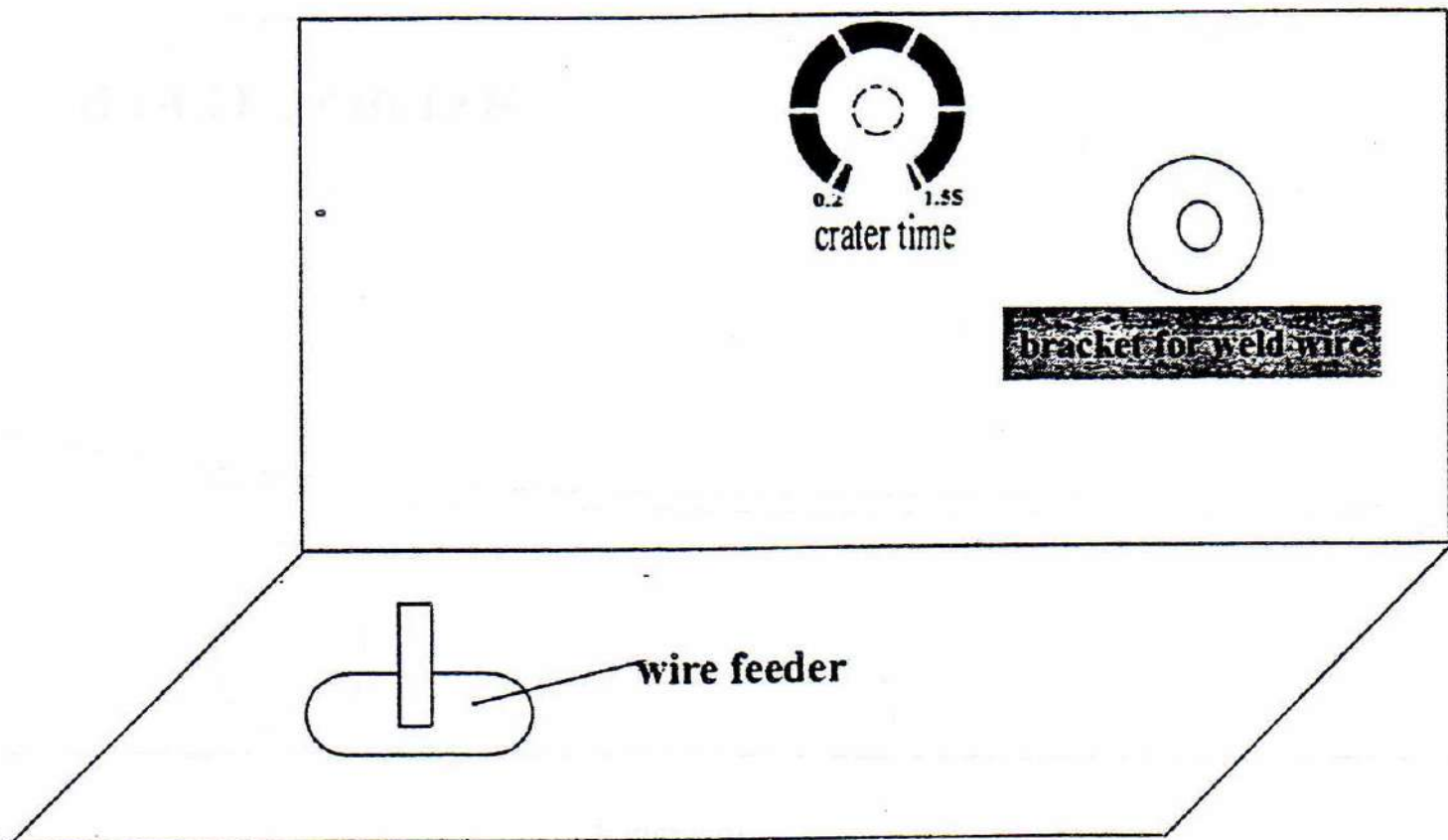


diagram 4



open the right side board ,you can see wire feeder and bracket for weld wire ,as following



#### 4.1.1 Power indicating

If the indicating light is on the control circuit connect the power already.

#### 4.2. Warning

In order to remind the operator we design the warnins as following

##### ❖ Excess temp

In the condition of more than 40°C temperature,large current is used continuously (12>200A) efficiency radiator temperature id more than 80±5°C, overheat circuit begins working. The indicating light is on, the power stop the welding automatically. The fan running continuously.If the temperature is lower,the-indicating is off,the power can work and weld can be continued automatically,Remind:Don't turn off the machine while the indicating overheat light is ON.

### 5. Safe and installation caution

Read the safe caution before installation and operation. It come down to the high voltage electricity,electric Arc and high temperature splash.So keep the safe regulation,operate the machine properly,avoid the danger of electricity and high temperature arc.

- ❖ Check if any damage ot out looking of the welder
- ❖ Confirm the capacity:more than 60A
- ❖ Power source is grounded,diagram 6
- ❖ Prohibit the combustibile goods in the welding locale.
- ❖ There is fire proof measure in the welding locale with favorable ventilated condition.
- ❖ There is smoke discharge system if the welding is operated inside the house in order to keep the safety of workers.
- ❖ The welding operator must be proffesional workers.
- ❖ The operator must be fitted with safe accessories.Such as safe shoes,gloves,cover,welding make and welding dress etc.

### 6. Explanation of installation

- ❖ Check the products according to the packing list when open the package
- ❖ Grounded protection.Attached the diagram 6

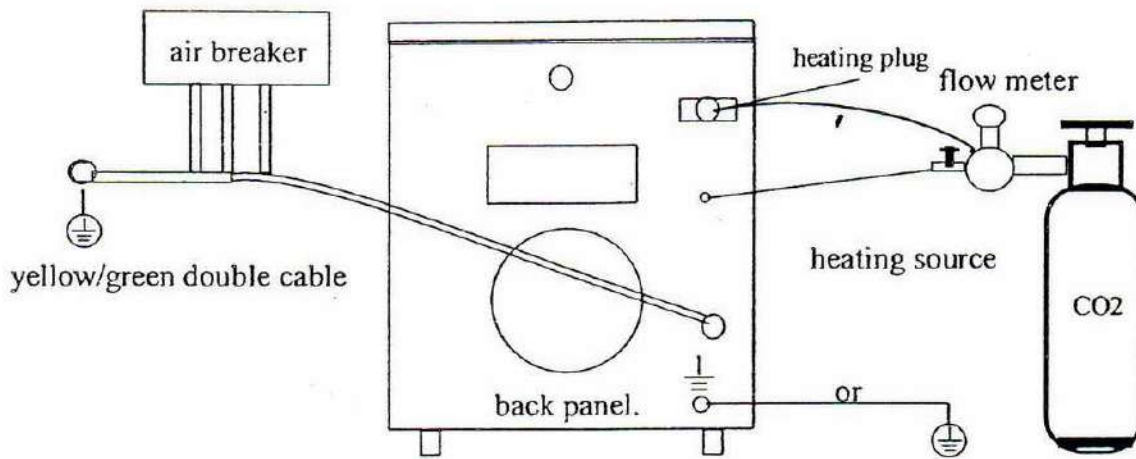


diagram 6

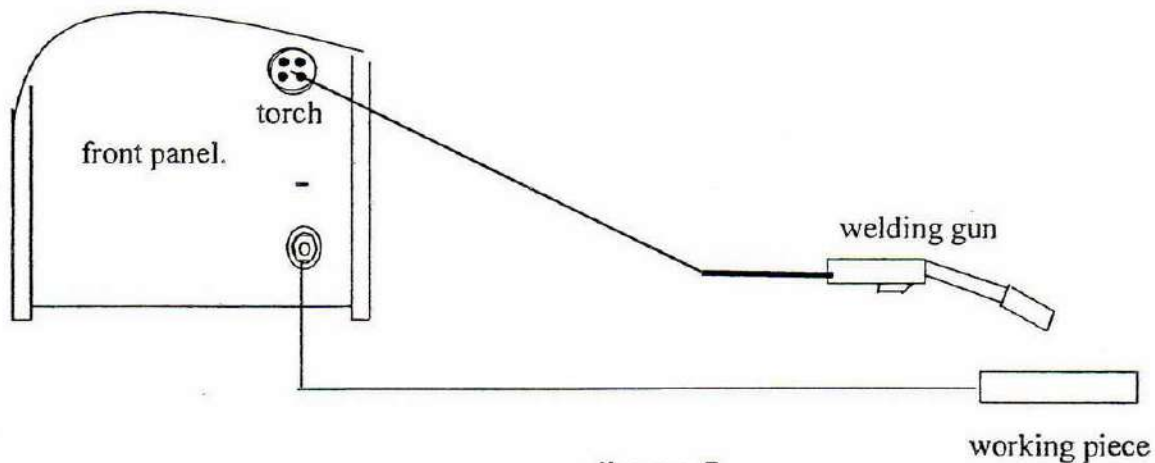


diagram 7

The power source is 380Vac/(50~60Hz) .The yellow/green double cable is grounding cable.Be sure to connect the yellow/green double cable into the grounding connection in the welding locale .Another way is selecting the M8 bolt on the back on the machine and connect the grounding as the diagram Attached the diagram 7

★ confirm the positive and negative marks and install the cable as diagram.

★ Insert the connectors inside the positive "+" and negative "-" position and roll it in 90. Do it oppositely when unloading the connectors.Keep the surface clean

★ Install the welding gun on the wire feeder and roll the welding gun in 90,then lock the bolt.

★If use the CO<sub>2</sub> heater,connected the heating power with 110V/2A power source.

★ Connect the gas pipe with the gas bottle according to the locale conditions. Check the air proof conditions to ensure the good airproof.

★ Connect the control cable of the wire feeder with the relative connector of the power



## 7. Operatings

- ❖ “ON” and “OFF” indicating switch on the front panel.
- ❖ Confirm the specification of the wire feed hose
- ❖ Confirm the specification of nib base. It affects the extended length of the wire.
- ❖ Confirm the specification of nib. It affects the electric resistance.
- ❖ Confirm the wire slot of the roller is suitable for the diameter of the wire. Different diameter

of wire select different wire slot. Otherwise it affects the wire feed result.

- ❖ Confirm the pressure of the roller to avoid slipping.  
If the pressure is not enough, the wire feed is slow speed.  
If the pressure is too much, the wire will be anamorphic.  
The wire feeder can not work properly.

- ❖ Confirm the flow of the gas and air proof.

We suggest the gas flow to be “L” more than 10D (D-diameter of wire). If the selection is not proper, it also affects the welding quality. When using the CO<sub>2</sub> gas, please confirm if the heating power works properly or not.

- ❖ Straight the hose of welding gun as much as possible. The bending radius can not be less than 200mm. Otherwise it affects the wire feeder.

### 7.1 Gas inspection

Press the switch of the gun before the wire roller is firmed, preset the gas flow through the meter to check if it is gas proof. Otherwise, it affects the welding result

### 7.2 Rip into the wire

Select the specification of the wire, materials according to the craft requirements. Firm the bolt and press the button on the front panel. The speed of ripping wire can be controlled by the welding current knob. Unload the nib if necessary and load it again after the wire is out.

## 8. Suggested welding criterion

Select good quality welding wire to get the perfect welding result and smooth welding process. Low quality wire can affect the welding quality by resistance welding process and blocking etc.

### 8.1 Selection switch for wire diameter

Please refer to the function on 1.3

### 8.2 Selection for welding voltage and current Diagram 8

Diagram 8

d(mm)	Ø0.8	Ø1.0	Ø1.2
Suitable	18~20V/80~120A*	17~18V/50~80A*	17~19V/50~100A*
		18~19V/80~100A*	19~22V/100~150A*
Welding criterion	17~18V/50~80A*	19~22V/100~160A*	22~24V/150~200A*
		22~24V/150~200A*	22~27V/200~250A*
		24~27V/200~250A*	27~32V/250~315A*

## 9. working elements

Diagram for the WM – 270C working elements. Diagram9

## 10. Maintenance

Check the safety measure be efficiency.

Get rid of the dust for the power source (FORexample,dry compressed air)

Before operating,Check the “+” “-” connectors of the power panel if they are relaxed

Check the connection between the grounding cable and plug if they are relaxed,(if relaxed,the serious heating will damaged the quick connectors)

Check the fan if it works regularly charge it if is trouble.

Check the insulation and breakage of the input power cord.

Change it in time to ensure the safety.

Check if there is any noisy for the wire feed motor.

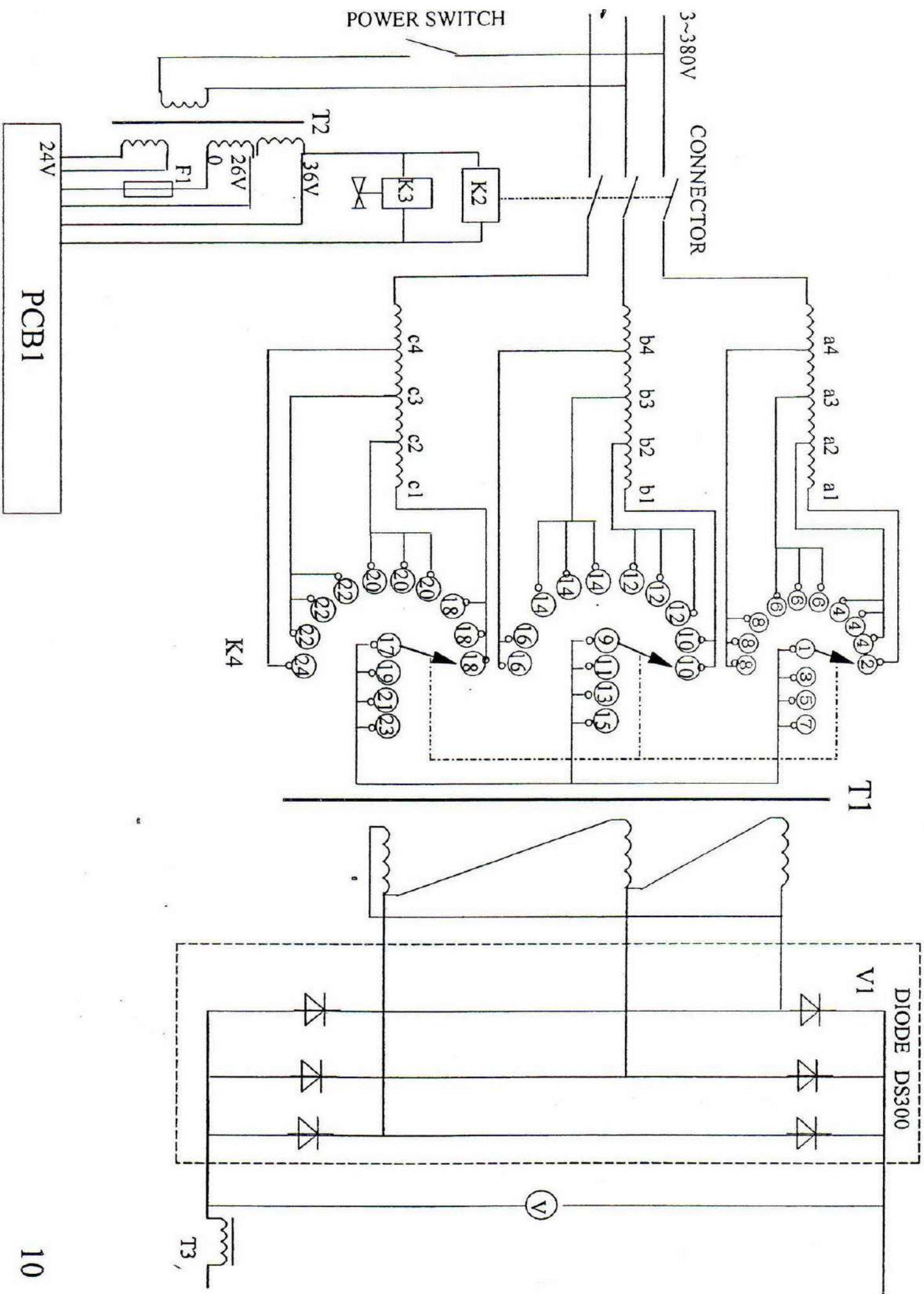
Check the abrasion of the wire feed hose.Get rid of the dust inside of the hose. (!~2 times / 40kg wire)

Check the abrasion of the nib.Change it in time (suggest 1~2 pieces nibs/40kg wire)

## 11. Troubles and Remedy

Troubles and remedy and remedy are as the form 10 as following

Troubles	Cause	Remedy
1. Fan not works properly	1. the fan line lose 2. . Fan breakage	1. connect the line 2. Change the fan



2.No indicating on The front panel	<ol style="list-style-type: none"> <li>1. phase absent of the power</li> <li>2. the fuse broken</li> <li>3.indicating light broken</li> </ol>	<ol style="list-style-type: none"> <li>1. Check the power</li> <li>2.Change the fuse 15A/250 V(back panel)</li> </ol>
3.Over heating light on	<ol style="list-style-type: none"> <li>1.aeration is not good</li> <li>2.The temperature is too high</li> <li>3.over-load use</li> <li>4.Thermostat broken</li> <li>5.Control plate broken</li> </ol>	<ol style="list-style-type: none"> <li>1. get rid of the bar 0.5m around</li> <li>2. Reduce the temperature</li> <li>3. Reduce the use loading</li> <li>4. Change the thermostat (JUC-OF)</li> <li>5.Check and change the control plate</li> </ol>
4.Wire feeder not work	<ol style="list-style-type: none"> <li>1.the fuse broken</li> <li>2.the Cables are not</li> <li>3.the wire blocked</li> <li>4.the drive circuit broken</li> <li>5.other reasons</li> </ol>	<ol style="list-style-type: none"> <li>1.Change the fuse 15A/250V (on back panel)</li> <li>2.the Cables are not connected properly</li> <li>3.Check the gun</li> <li>4.Change the control panel</li> <li>5.Contact with the manufacturer</li> </ol>
5.Welding Voltage and welding current not adjustable	<ol style="list-style-type: none"> <li>1.Voltage switch line fall down</li> <li>2.Voltage switch broken</li> <li>3.fuse broken</li> <li>4.the cables not connected properly</li> </ol>	<ol style="list-style-type: none"> <li>1.Connect the lines</li> <li>2.Change it</li> <li>3.Change the fuse 15A/250V (on back panel)</li> <li>4.Check it</li> </ol>

## 12. Enlarge the length of the welding cable

The length of the cable includes the total length of the welding circuit including the cables between the positive "+" of the power source. The cables longer, the section area thinner, it caused large voltage reducing and large voltage loss. More over, it affect the quality of the arc and the slag. So arrange the position of the welding machine properly to get the shortes cable.

The cable between the welding power and wire feeder is the shorter, the better. Otherwise is affects the maximum speed of wire feeder are the maximum welding current

On the condition of low speed (lower than 12m/min), we can enlarge the cable to 20m when use  $\varnothing$  0.8~1.0

- ❖ Straight the enlarged cable, otherwise it effects the arc stability.

