

SEALEY

140A FLUX CORED GASLESS MIG INVERTER WELDER

MODEL NO: **MIG140i**

Thank you for purchasing a Sealey product. Manufactured to a high standard, this product will, if used according to these instructions, and properly maintained, give you years of trouble free performance.

IMPORTANT: PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS & CAUTIONS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY.



Refer to instructions



Wear eye protection



Wear protective gloves



Wear safety footwear



Wear protective clothing



Arc rays can burn eyes and injure skin.



Electric shock from welding electrodes can kill.



Hot surfaces



Breathing welding fumes can be hazardous to your health.



Electromagnetic fields can cause pacemaker malfunction.



Welding sparks can cause explosions or fire.



Warning! Keep away from rain



Warning! Electricity Shock hazard

1.1. ELECTRICAL SAFETY

- ☐ **WARNING!** It is the user's responsibility to check the following:
 - ✓ Check all electrical equipment and appliances to ensure that they are safe before using.
 - ✓ Inspect power supply leads, plugs and all electrical connections for wear and damage.
 - ✓ Ensure that the insulation on all cables and on the appliance is safe before connecting it to the power supply.
 - ✗ **DO NOT** use worn or damaged cables, plugs or connectors.
 - ✓ Ensure that any faulty item is repaired or replaced immediately by a Sealey qualified technician.
 - ✓ If the cable or plug is damaged during use, switch off the electricity supply and remove from use.
 - ✓ Sealey recommend that an RCD (Residual Current Device) is used with all electrical products.
- Important:** Ensure that the voltage rating on the appliance suits the mains power supply.
- ✗ **DO NOT** pull or carry the appliance by the power cable.
- ✗ **DO NOT** pull the plug from the socket by the cable.
- 1.2. This is a single phase machine and must be run from a minimum of 16Amp supply.
- 1.3. **To achieve maximum output these models will require a 32 Amp fused supply. We recommend you discuss the installation of an industrial round pin plug and socket with your electrician.**
- 1.4. When a cable extension reel is used it should be fully unwound before connection. A cable reel with an RCD fitted is recommended since any product which is plugged into the cable reel will be protected. The cross-section of the cable on the cable reel must be suitable for the unit and never lower than the cross-section of the mains cable supplied with the unit.

1.5. GENERAL SAFETY

- ▲ **DANGER! Unplug the welder from the mains power supply before performing maintenance or service.**
- ✗ **WARNING! DO NOT** place the welding power source on a tilted plane as this may lead to the unit toppling over.
- ✗ Welding power sources are not suitable for use in rain or snow.
- ✗ The output is rated at an ambient temperature of 20°C and the welding time may be reduced at higher temperatures.
- ✗ Risk of electric shock: Electric shock from welding electrode can kill. **DO NOT** weld in the rain or snow. Wear dry insulating gloves. **DO NOT** touch electrode with bare hands. **DO NOT** wear wet or damaged gloves. Protect yourself from electric shock by insulating yourself from workpiece. **DO NOT** open the equipment enclosure.
- ✗ Risk induced by welding fumes: Breathing welding fumes can be hazardous to your health. Keep your head out of the fumes. Use equipment in an open area. Use ventilating fan to remove fumes.
- ✗ Risk induced by welding sparks: Welding sparks can cause explosion or fire. Keep flammables away from welding. **DO NOT** weld near flammables. Welding sparks can cause fires. Have a fire extinguisher nearby and have a watch person ready to use it. **DO NOT** weld on drums or any closed containers.
- ✓ Risk induced by the arc: Arc rays can burn eyes and injure skin. Wear hat and safety glasses. Use ear protection and button shirt collar.
- ✓ Use welding helmet with correct shade of filter. Wear complete body protection.
- ✓ Risk induced by electromagnetic fields: Welding current produces electromagnetic field. **DO NOT** use with medical implants. Never coil welding cables around your body. Route the welding cables together.
- ✓ Keep the welder and cables in good condition. Take immediate action to repair or replace damaged parts.
- ✓ *Use genuine parts and accessories only. Unapproved parts may be dangerous and will invalidate the warranty.*
- ✓ Use an air hose to regularly blow out any dirt from the liner and keep the welder clean for best and safest performance.
- ✓ Check and spray the gas cup and contact tip regularly with anti-spatter spray which is available from your Sealey stockist.
- ✓ Locate the welder in a suitable work area. Ensure that the area has adequate ventilation as welding fumes are harmful.
- ✓ Keep work area clean, tidy and free from unrelated materials. Also ensure that the work area has adequate lighting and that a fire extinguisher is at hand.

- ❑ **WARNING! Use welding head shield to protect eyes and avoid exposing skin to ultraviolet rays given off by electric arc. Wear safety welding gauntlets.**
 - ✓ Remove ill fitting clothing, remove ties, watches, rings and other loose jewellery and contain long hair.
 - ✓ Ensure that the workpiece is correctly secured before operating the welder.
 - ✓ Avoid unintentional contact with workpiece. Accidental or uncontrolled use of the torch may be dangerous and will wear the nozzle.
 - ✓ Keep unauthorised persons away from the work area. Any persons working within the area must wear protective head shield and gloves.
 - ✓ Operators must receive adequate training before using the welder.
 - ✓ Stand correctly, keeping a good footing and balance, and ensure that the floor is not slippery. Wear non-slip shoes.
 - ✓ Turn voltage switch to OFF when not in use.
 - ✗ **DO NOT** operate the welder if it or its cables are damaged and **DO NOT** attempt to fit any unapproved torch or other parts to the welder unit.
 - ✗ **DO NOT** get welder wet or use in damp or wet locations or areas where there is condensation.
 - ▲ **DANGER! DO NOT weld near flammable materials, solids, liquids, or gases, and DO NOT weld containers or pipes which have held flammable materials or gases, liquids or solids. Avoid operating on materials cleaned with chlorinated solvents or near such solvents. DO NOT use power source for pipe thawing.**
 - ✗ **DO NOT** stand welder on a metal workbench, car bodywork or similar object.
 - ✗ **DO NOT** touch any live metal parts of the torch or electrode while the machine is switched on.
 - ✗ **DO NOT** pull the welder by the cable or the torch and **DO NOT** bend or strain cables. Protect cables from sharp or abrasive items and **DO NOT** stand on them. Protect from heat. Long lengths of slack must be gathered and neatly coiled. **DO NOT** place cables where they could endanger other people.
 - ✗ **DO NOT** touch the torch or workpiece immediately after welding as they will be very hot. Allow to cool.
 - ✗ **DO NOT** operate welder while under the influence of drugs, alcohol or intoxicating medication, or if tired.
 - ✓ When not in use store the welder in a safe, dry, childproof area.
- IMPORTANT:** These instructions contain the information you require to prepare your machine for welding, together with a maintenance and a troubleshooting section. The instructions are not intended to teach you how to weld. If you have no experience, we recommend that you seek training from an expert source. MIG welding is relatively easy, but does require a steady hand and supervised practice on scrap metal, as it is only with continued practice that you will achieve the desired results.

1. INTRODUCTION

IGBT Inverter gasless MIG welder suitable for flux cored welding up to 140A. Ultra-compact and lightweight unit supplied with a carry strap making this unit highly portable and suitable for workshops, garages, bodyshop's and mobile technicians. Featuring hot start, anti-stick, forced air cooling and thermal cut out protection. Supplied with fixed non-live MIG torch, 1.4m earth cable/clamp and 0.8mm 0.45kg reel of flux cored wire. Unit can MIG weld using up to 1kg Ø0.8 and Ø0.9mm flux cored MIG wire only.

2. SPECIFICATION

Model No:	Mig140i
Welding Current:	20-140A
Duty Cycle:	100% @ 44A, 60% @ 109A, 10% @ 140A
Absorbed Power:	3.8kw
Wire Capacity:	1kg 0.8/0.9mm Flux Cored Mig Wire
Supply:	230V
Plug Type:	Bare Wire
Power Supply Cable Length:	2m
IP Rating:	IP21S
Mig Torch:	Non-live
Weight:	5.26kg
The class of insulation	H
The pollution degree	3
Efficiency of the product	80.1%
EMC classification	A
Static characteristic	Drooping



Note: To achieve maximum power a 32A supply will be required.

3. FEATURES (SEE ABOVE RIGHT)

4. ASSEMBLY REFER TO FIG.1

4.1. FITTING A REEL OF WIRE

- 4.1.1. Lift door.
- 4.1.2. Undo spindle knob anticlockwise. Fit wire reel so it will feed from bottom.
- 4.1.3. Unscrew wire lock screw to release pressure roller.
- 4.1.4. Select correct wire feed roller for wire size.
- 4.1.5. Straighten end of wire and gently push into wire guide.
- 4.1.6. Move the pressure roller moulding back round onto the grooved drive wheel and swing down the wire lock screw to lock it in place.
- 4.1.7. See section 4.2 below regarding wire tension.

4.1.8. Feeding the wire through to the torch. (See fig.2)

4.1.9. Remove gas cup (a) and contact tip (b) from end of torch as follows:

- a) Take torch in left hand with the torch tip facing to the right.
- b) Grasp gas cup firmly in your right hand.
- c) Turn gas cup clockwise only and pull cup out to the right.

❑ **WARNING! DO NOT** turn gas cup anti-clockwise, as this will damage internal spring.

- d) Unscrew the copper contact tip (fig.2.b) (right hand thread) to remove.

4.1.10. Check welder is switched OFF and that the earth clamp is away from the torch tip. Connect the welder to the mains power supply and set the voltage switch to MIN.

4.1.11. Increase the wire speed knob to position 5 or 6. Keeping the torch cable as straight as possible, press the torch switch. The wire will feed through the torch.

4.1.12. When wire has fed through, switch welder off, **unplug from mains.**

- a) Take torch in left hand, slide the contact tip over the wire and screw it back into place.
- b) Grasp gas cup in right hand, push onto torch head and turn clockwise only.

❑ **WARNING! DO NOT** turn gas cup anti-clockwise, as this will damage internal spring.

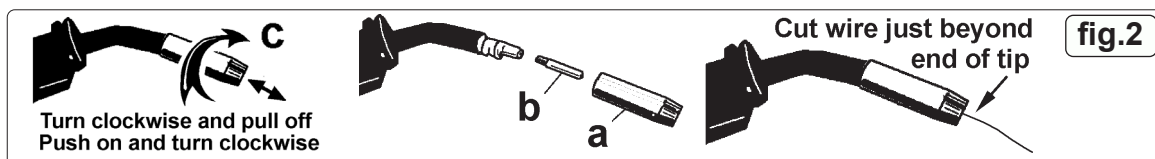
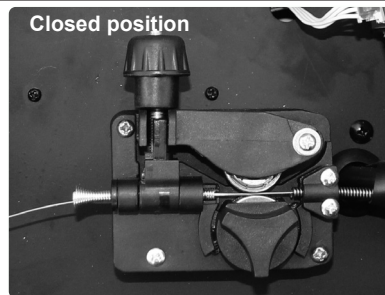
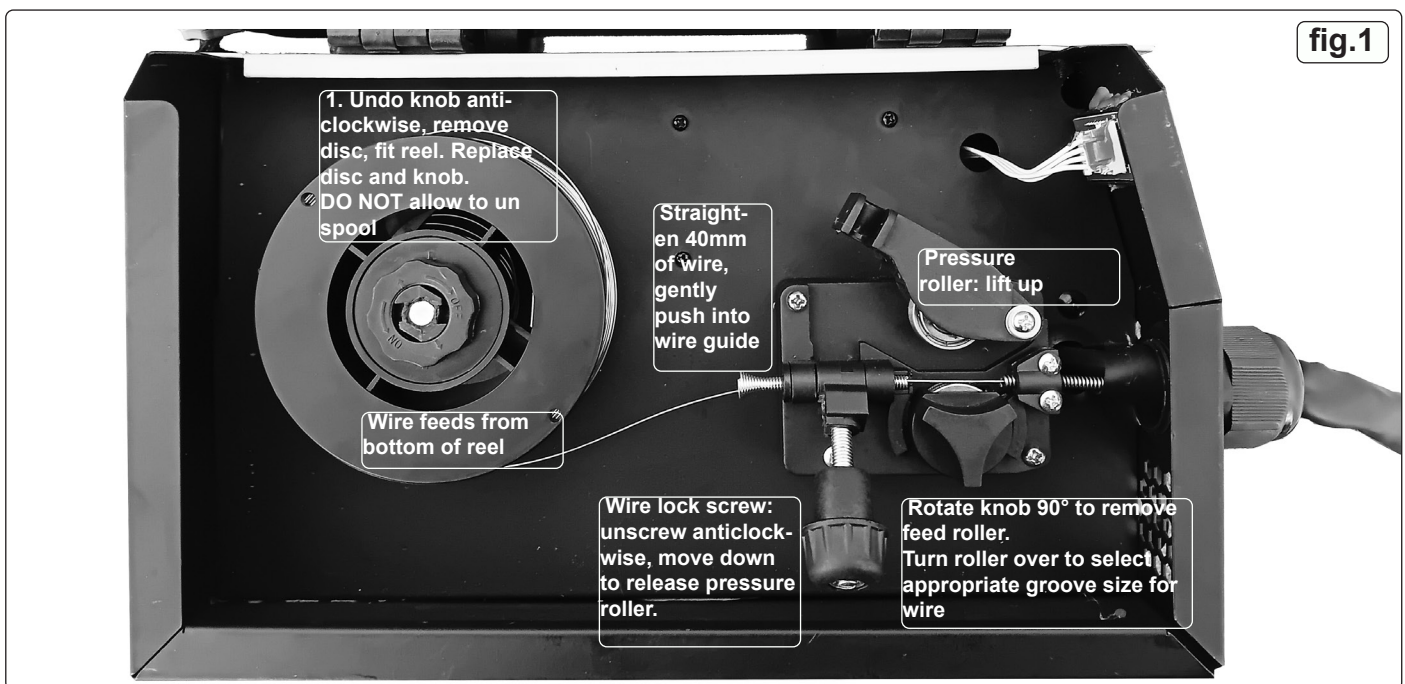
- c) Cut wire so that it is just protruding from the cup.

4.2. SETTING WIRE TENSION

IMPORTANT: You must set the correct tension, too little or too much tension will cause problematic wire feed and result in a poor weld.

4.2.1. Correct tension between the rollers is checked by slowing down the wire between gloved fingers. If the pressure roller skids the tension is correct. Try to use the lowest tension possible as too high a tension will deform the wire.

4.3. When you have completed welding allow the welder to cool before storing in a safe, dry place. Note: Damaged torches and cables are not covered under warranty.



5. WELDING PRINCIPLES

IMPORTANT: These instructions are not intended to teach you how to weld.

If you have no experience, we recommend that you seek training from an expert source. MIG welding is relatively easy, but does require a steady hand and supervised practice on scrap metal, as it is only with continued practice that you will achieve the desired results.

5.1. MIG WELDING

- 5.1.1. Welding wire is automatically fed through an insulated liner to the tip of the torch. The torch consists of a switch, liner, and control cable. The switch activates the wire feed roller. Releasing the switch stops wire feed. The weld current is transferred to the electrode (the wire) from the contact tip at the torch end. The current to the electrode is set using the knob on the control panel.

Wire speed must be adjusted according to current output using the knob the control panel. The higher the current the faster the wire speed.

5.2. PREPARATION FOR WELDING

IMPORTANT! BEFORE YOU COMMENCE, MAKE SURE THE MACHINE IS SWITCHED OFF AT THE MAINS. IF WELDING A CAR, DISCONNECT THE BATTERY OR FIT AN ELECTRONIC CIRCUIT PROTECTOR. ENSURE THAT YOU READ, UNDERSTAND AND APPLY THE SAFETY INSTRUCTIONS IN SECTION 1.

- 5.2.1. To ensure a complete circuit, the negative lead must be securely attached to the workpiece close to the weld area. Best connection is obtained by grinding the point of contact on the workpiece before connecting the clamp.

- 5.2.2. The weld area must be free of paint, rust, grease, etc.




5.3. THERMAL PROTECTION

- 5.3.1. Should the welder become overheated due to prolonged use beyond the stated duty cycle the thermal protection will cause the welder to cut out and the orange light on the front panel will illuminate. Wait for fifteen minutes for the welder to cool down at which time it will reconnect automatically (see Features diagram).

6. RATINGS PLATE

On the front panel of the welder is the ratings plate, giving the following data:

- 1 - The BS/EU standard relating to the safety and construction of arc welding and associated equipment.
- 2 - Single phase transformer.
- 3 - Symbol indicates welding with a continuous flow of welding wire.
- 4 - Symbol for Single-phase AC supply.
- 5 - Rating of internal protection provided by casing.
- 6 - Output U_0 Rated minimum and maximum no load voltage.
- I_2 , U_2 Current and corresponding voltage.
- X Welding ratio based on a 10 minute cycle.
- 20% indicates 2 minutes welding and 8 minutes rest,
- 100% would indicate continuous welding.
- 7 - Mains Supply U_1 Rated supply voltage and frequency.
- I_{1max} Maximum current.
- I_{1eff} Maximum effective current.
- 8 - Welding current range.
- 9 - Serial Number. Specifically identifies each welder.

INVERTER WELDING MACHINE					UK CA CE	
MODEL NO: MIG140i				EN 60974-1:2012		
				B/N: 9		
				40A/16V - 140A/21V		
X				20%	60%	100%
$I_2(A)$				140	82	63
$U_2(V)$				21	18.1	17.2
				1-50/60Hz		
$U_1=230V$				$I_{1max}=20.6A$		$I_{1eff}=13.5A$
IP21S				Made in China		
Jack Sealey Ltd IP32 7AR UK				Jack Sealey (EU) Ltd A81 PK68 IE		

7. MAINTENANCE

▲ **DANGER! Unplug the welder from the mains power supply before performing maintenance or service.**

7.1. WIRE FEED UNIT

- 7.1.1. Check the wire feed unit at regular intervals. The feed roller wire guide plays an important part in obtaining consistent results. Poor wire feed affects the weld. Clean the rollers weekly, especially the feed roller groove, removing all dust deposits.

7.2. TORCH

- 7.2.1. Protect the torch cable assembly from mechanical wear. Clean the liner from the machine forwards by using compressed air. If the liner is blocked torch must be replaced.

7.3. TURNING FEED ROLLER IMPORTANT: TURN THE FEED ROLLER TO SUIT THE WIRE SIZE, FIG.1.

- 7.3.1. There are two grooves on the feed roller, 0.8mm and 1mm. Always have the groove that is being used on the outside of the roller (nearest to you). To turn the feed roller first loosen the wire tension knob and move it into its up position then move the tensioning roller assembly to its down position. Take hold of the triangular knob on the roller retainer and rotate it 90° anticlockwise to release it as shown in fig.1. Now pull the roller retainer off the drive spindle to reveal the roller.
- 7.3.2. Flip it over and put it back on the drive spindle. The groove size you require should now be visible on the face of the roller. Push the roller retainer back onto the drive spindle with the opening facing right. Ensure that the flanges at the base of the retainer, seat fully into the circular recess in the main moulding and then rotate the retainer through 90° to lock it in place.

7.4. CONTACT TIP (to remove tip see Section 4.)

- 7.4.1. The contact tip is a consumable item and must be replaced when the bore becomes enlarged or oval. The contact tip MUST be kept free from spatter.

7.5. GAS CUP

- 7.5.1. The gas cup must also be kept clean and free from spatter. Build-up of spatter inside the gas cup can cause a short circuit at the contact tip which will result in expensive machine repairs. To keep the contact tip free from spatter, we recommend the use of anti-spatter spray (MIG/722308) available from your Sealey stockist.
- 7.5.2. (MIG/722308) available from your Sealey stockist.

8. TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	REMEDY
Weld current interrupted	Overheating protection activated due to overload	Protection automatically resets when transformer has cooled (approx. 15 min)
No weld current	Rectifier blown	Replace rectifier
No weld current	Bad connection between clamp and workpiece	Clean or grind contact surface and weld area
	Break in earth lead	Repair or replace earth lead
	Break in torch lead	Repair or replace
Feed motor not working	Gear damaged or worn	Replace gears
	Motor defective	Replace motor (Contact service agent)
Wire does not feed, Feed roller rotates.	Pressure roller improperly adjusted	Adjust tension
	Dirt, copper, dust, etc. have collected in torch liner	Clean the liner from the machine forward. Use compressed air.
	Gas cup (nozzle) or tip defective	Replace gas cup (nozzle) and/or tip. Check roller tension
	Deformed wire	Adjust roller tension
Wire feeds unevenly	Dirt, etc., in liner	Clean the liner from the machine forward using compressed air
	Gas cup (nozzle) or tip defective	Replace gas cup (nozzle) and/or tip
	Gas cup (nozzle) spattered	Clean or replace gas cup (nozzle)
	Feed roller groove clogged	Clean feed roller
	Feed roller groove deformed	Replace feed roller
	Pressure roller tension incorrect	Adjust tension
Unstable arc	Incorrect settings	Check settings
	Impurities in weld area	Clean and/or grind workpiece
	Worn or defective gas cup (nozzle)	Replace gas cup (nozzle)
Porous weld	Rusty/dirty joints	Clean or grind the workpiece
	Torch too far from, or at wrong angle to, workpiece	Gas cup to workpiece should be 8-10mm. Torch angle approx 75°
Wire sticking in gas cup (nozzle)	Worn or defective gas cup (nozzle)	Replace gas cup (nozzle)
	Wire deformed	Check roller tension
	Wire speed too slow	Increase wire speed
Irregular weld head	Torch incorrectly held	Use correct torch angle
	Wire weaving in weld pool	Check roller tension and adjust
Weld bead too narrow and raised	Weld current too low	Increase power and wire speed
	Weld speed too fast	Move torch slower and weave a little more
Weld bead too wide	Weld current too high	Increase power and wire speed
	Weld speed too slow	Move torch faster and weave less
Poor penetration	Weld current too low	Increase current and wire speed
	Arc too long	Bring torch closer to workpiece
Excessive penetration	Weld current too high	Decrease current and wire speed
	Weld current too slow	Decrease current and wire speed
	Incorrect distance of torch to workpiece	Torch distance should be 8-10mm



ENVIRONMENT PROTECTION

Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.



REGISTER YOUR
PURCHASE HERE



WEEE REGULATIONS

Dispose of this product at the end of its working life in compliance with the EU Directive on Waste Electrical and Electronic Equipment (WEEE). When the product is no longer required, it must be disposed of in an environmentally protective way. Contact your local solid waste authority for recycling information.

Note: It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice. Please note that other versions of this product are available. If you require documentation for alternative versions, please email or call our technical team on technical@sealey.co.uk or 01284 757505.

Important: No Liability is accepted for incorrect use of this product.

Warranty: Guarantee is 12 months from purchase date, proof of which is required for any claim.

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