V2.4 24.04.23

USER MANUAL

INVERTER WELDING MACHINE
DIGITIG PULSE AC/DC 200GD

Sherman® digitec

CE

WARNING!

Before installing and starting the device, please read this manual

1. GENERAL REMARKS

The device may only be started and operated after carefully reading this Operating Instructions.

Due to the continuous technical development of the device, the external appearance and some of its functions may be subject to modifications and their operation may differ in detail from the descriptions in the instructions and on the carton. This is not a device fault, but the result of progress and continuous modification work on the device. The standard equipment of the device may also change.

Damage to the device caused by improper operation will void your warranty.
Any modifications to the rectifier are prohibited and will void the warranty.

2. SECURITY

Employees operating the device should have the necessary qualifications entitling them to perform welding work:

- should have qualifications of an electric welder in the field of welding with coated electrodes and gas shields,
- know the health and safety rules when operating electrical power equipment such as welding equipment and auxiliary equipment powered by electricity,
- know the health and safety regulations when handling cylinders and installations with compressed gas (argon),
- be familiar with the contents of this manual and use the device in accordance with its intended purpose.

WARNING

Welding can pose a safety risk to the operator and other people in the vicinity.
Therefore, special precautions must be taken when welding. Before starting to weld, familiarize yourself with the health and safety regulations applicable at the workplace.
The following hazards exist during MMA and TIG electric welding:

- **ELECTRIC SHOCK**
- **NEGATIVE IMPACT OF ARC ON HUMAN EYES AND SKIN**
- **VAPORS AND GAS POISONING**
- **BURNS**
- **EXPLOSION AND FIRE HAZARDS**
- **NOISE**

Preventing electric shock:

- connect the device to a technically efficient electrical installation with proper protection and effective zeroing (additional protection against electric shock); other devices at the welder's workstation should also be checked and correctly connected to the network,
- install power cables when the device is switched off,
- do not touch the non-insulated parts of the electrode holder, the electrode and the object at the same time welded, including the device housing,
- do not use handles and power cables with damaged insulation,
- in conditions of particular risk of electric shock (work in environments with high humidity and closed tanks) work with an assistant supporting the welder's work and ensuring safety, use clothing and gloves with good insulating properties,

- If you notice any irregularities, please contact the competent persons for assistance. their removal,
- It is prohibited to operate the device with removed covers.

Preventing the negative impact of electric arc on human eyes and skin:

- Wear protective clothing (gloves, apron, leather shoes),
- Use protective shields or visors with a properly selected filter,

• Use protective curtains made of non-flammable materials and choose the right wall colors absorbing harmful radiation.

Prevention of poisoning by vapors and gases emitted during welding from electrode coating and metal evaporation:

• Use ventilation devices and exhaust systems installed in places with limited air exchange. air,
• Blow with fresh air when working in a confined space (tanks),
• Use masks and respirators.

Burn prevention:

• Wear appropriate protective clothing and footwear to protect against burns from arc radiation and spatter,
• Avoid contaminating clothing with grease and oils that may cause ignition.

Explosion and fire prevention:

• It is prohibited to operate the device and weld in rooms with a risk of explosion or fire,
• The welding station should be equipped with fire extinguishing equipment,
• The welding station should be located at a safe distance from flammable materials.

Preventing the negative impact of noise:

• Use earplugs or other noise protection measures,
• Warn people nearby about dangers.

WARNING!

Do not use an electrical source to thaw frozen pipes.

Before starting the device, you must:

• Check the condition of electrical and mechanical connections. It is forbidden to use handles and cables current with damaged insulation. Improper insulation of handles and current cables may result in electric shock,
• Ensure proper working conditions, i.e. ensure proper temperature, humidity and ventilation in the workplace. work. Outside closed rooms, protect against atmospheric precipitation,
• Place the charger in a place where it can be easily operated.

People operating a welding machine should:

• have the qualifications for electric welding with coated electrodes and the TIG method,
• know and comply with the occupational health and safety regulations applicable to welding work,
• use appropriate, specialist protective equipment: gloves, apron, rubber boots, shield or a welding helmet with a properly selected filter,
• be familiar with the contents of this instruction manual and use the welding machine in accordance with its intended purpose.

Any repairs to the device may only be performed after disconnecting the plug from the power socket.

When the device is connected to the mains, it is not permitted to touch any elements forming the welding current circuit with bare hands or through wet clothing.
It is prohibited to remove external covers when the device is connected to the mains.
Any modifications to the rectifier on your own are prohibited and may constitute a deterioration of safety conditions.

All maintenance and repair work may only be carried out by authorised persons in compliance with the work safety conditions applicable to electrical devices.
It is prohibited to operate the welding machine in rooms at risk of explosion or fire!
The welding station should be equipped with fire extinguishing equipment.
After finishing work, the device's power cord must be disconnected from the mains.

The above-mentioned hazards and general health and safety rules do not exhaust the issue of welder's work safety, because they do not take into account the specifics of the workplace. An important supplement to them are workplace health and safety instructions and training and instruction provided by supervisory employees.

3. GENERAL DESCRIPTION

DIGITIG PULSE AC/DC 200GD is used for manual welding of structural steels with coated electrodes (MMA method) and quality steels and non-ferrous metals with a non-consumable electrode in an inert gas shield (TIG method). The latest achievements in PWM technology (pulse width modulation) and IGBT modules (insulated gate bipolar transistors) were used in the design and construction of the device, thanks to which the welder is characterized by small dimensions and low weight.

During MMA welding, VRD, ARC FORCE and HOT START functions are available. During TIG welding, it is possible to adjust the current rise and fall, gas pre-flow and post-flow, and the pulse and AC current parameters. The device has a memory for 10 sets of parameter settings.

4. TECHNICAL PARAMETERS

4.1 Welding machine

Supply voltage	AC 230V ±10% 50Hz
Maximum power consumption	MMA: 6.6kVA, TIG: 4.2kVA
Rated welding current/duty cycle	MMA: 180 A / 40% TIG 200 A / 40%
Nominal no-load voltage	20V (VRD) / 59V
Maximum current consumption	MMA: 36.5A, TIG 26.8A
Network security	25A
Weight (without accessories)	18.5kg
Dimensions	455 x 195 x 415mm
Degree of protection	IP21

4.1.1 Parameter adjustment ranges

ARC FORCE	1-100A
HOT-START	0-50A
Gas pre-flow	0.1 - 5 sec
Gas leak	0 - 15 sec
Current build-up	0 - 15 sec
Current drop	0 - 25 sec
Initial current	5-200A
Welding current	MMA: 20-180 A TIG: 10-200 A
Base Current	5 - 95% of welding current
Crater Current	10-200A
Pulse rate	0.5 - 200Hz
Pulse Width	10-90%
AC Frequency	40-200Hz
AC Balance	30 - 70%

4.2 TIG torch

Handle type	T-26
Maximum current carrying capacity	200A
Gas flow	10-20 l/min
Arc striking	Contactless (HF)
Length	4m

Work cycle
The duty cycle is based on a 10-minute period. A duty cycle of 40% means that after 4 minutes of operation, a 6-minute break is required. A duty cycle of 100% means that the device can operate continuously without interruption.

Note! Heating tests were conducted at ambient air temperature. Duty cycle at 40ºC was determined by simulation.

Degree of protection
IP determines the degree to which the device is resistant to the ingress of solid and water contaminants. IP21 means that the device is designed for use in closed rooms and is not suitable for use in the rain.

5. CONSTRUCTION AND OPERATION

The basis for the construction of the welding machine's electrical energy conversion system are electronic systems made in IGBT technology enabling operation in the frequency range above 200 kHz. The principle of operation consists in rectifying the voltage of a single-phase supply network to DC voltage, converting the obtained DC voltage to a high-frequency square waveform, transforming the voltage into the range required by the welding process and rectifying the obtained voltage to DC voltage.
The welder is equipped with a supply voltage compensation system, which allows its operation with voltage fluctuations in the supply network of up to 10%.

6. CONNECTION TO THE POWER SUPPLY

1. The device should only be used in a single-phase power supply system, three-wire, with grounded neutral point.
2. DIGITIG PULSE AC/DC 200GD inverter rectifiers are designed to work with a 230V 50Hz network protected by 25A delayed fuses. The power supply should be stable, without voltage drops.

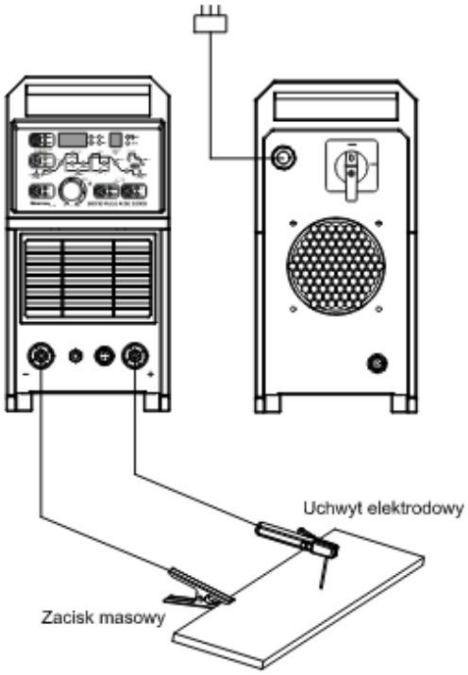
3. The device is equipped with a power cord and plug. Before connecting the power supply, make sure that the power switch (1) is in the OFF position.

7. PREPARING THE DEVICE FOR WORK

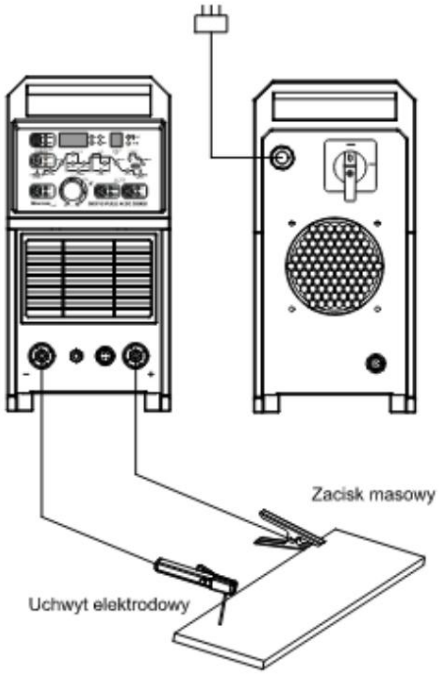
If the device is stored or transported at low temperatures, bring the device to the correct temperature before starting work!

7.1 MMA method

The ends of the welding cables should be connected to the sockets (3) and (6) located on the front panel so that the correct pole for the given electrode is on the electrode holder.
The polarity of the welding cable connection depends on the type of electrode used and is indicated on the electrode packaging (negative polarity DCEN or positive polarity DCEP). The ground cable clamp must be carefully attached to the welded material. Connect the device plug to a 230V 50Hz mains socket.



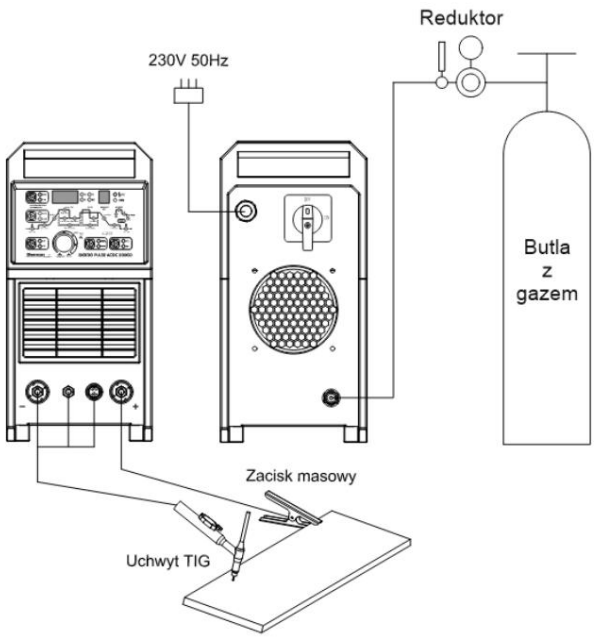
DCEP



DCEN

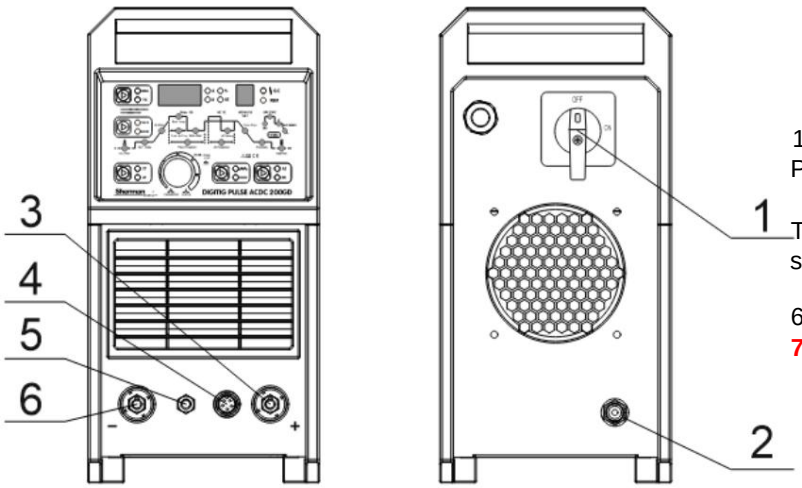
7.2 TIG method

The current terminal of the handle should be connected to the negative polarity socket (6), the control plug of the handle should be carefully screwed into the socket (4), and the gas connection to the quick connector socket (5). The gas hose from the reducer should be led and attached to the gas connector (2) located on the rear wall of the housing. The positive pole of the source (3) should be connected to the welded material using a cable with a clamp. Connect the device plug to a 230V 50Hz mains socket.



8. DESCRIPTION OF SWITCH AND KNOB FUNCTIONS

8.1 Front and rear panels

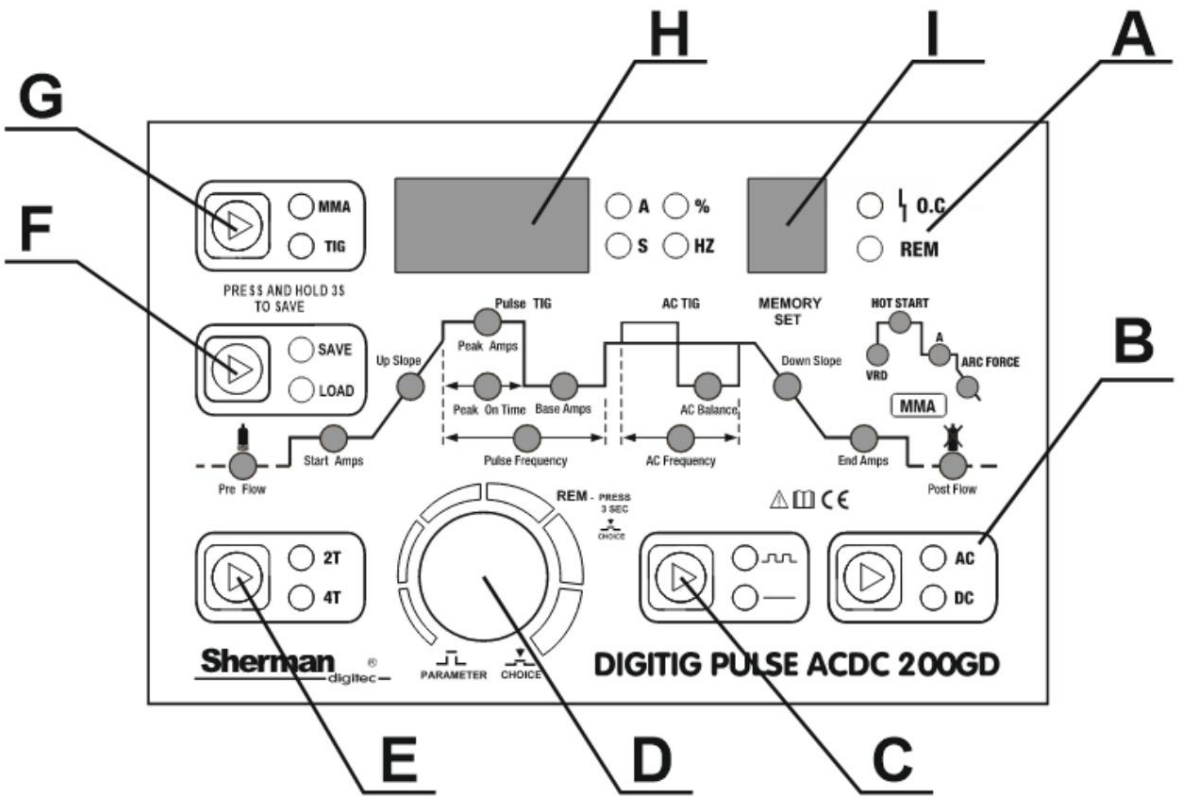


1. 1. Main switch 2. 2. Protective gas connection
3. Positive polarity socket 3. 4. TIG torch control socket 4. 5. Shielding gas socket 5. 6. Negative polarity socket

6.

7.

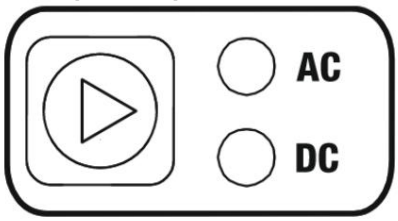
8.2 Control Panel



A - Control diodes

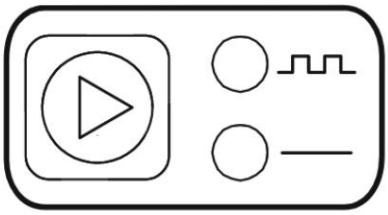
The OC diode lighting up means that the device is overheating or that the welder is not working properly. The REM diode signals that remote control is possible. To turn the remote control on or off, press the control knob (D) and hold for 3 seconds.

B – Welding current type selection button (AC / DC)



Pressing the button changes the type of welding current. The selection of the current type is confirmed by lighting up the appropriate diode. AC – alternating current, DC – direct current

C – Pulse on/off button



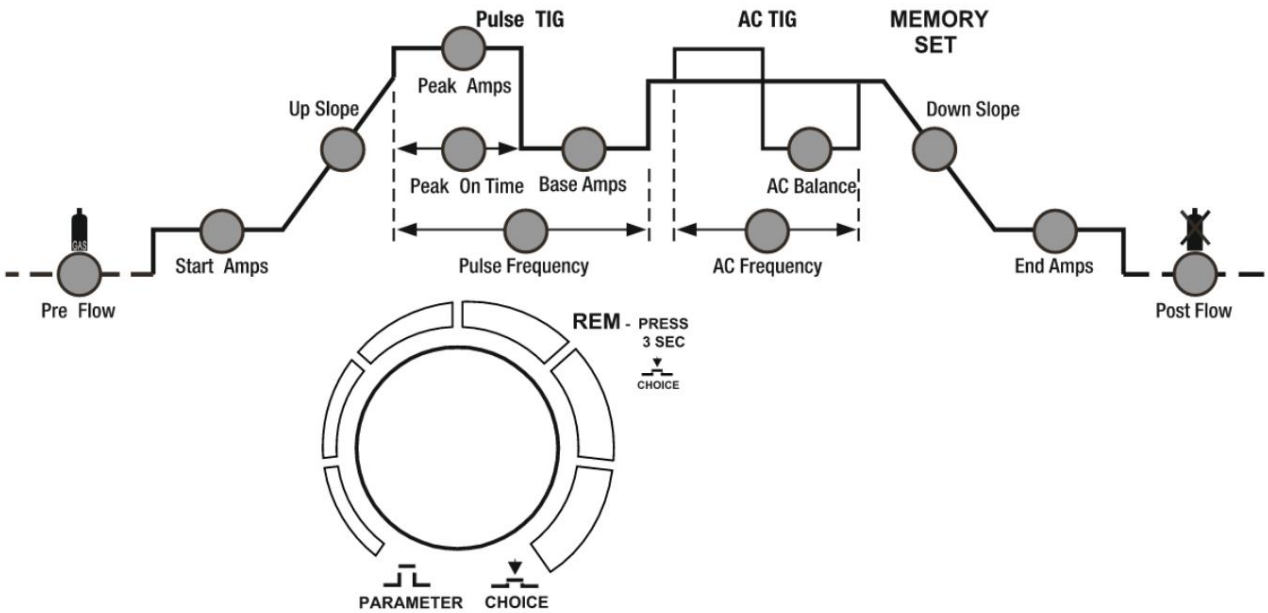
The button is active only when welding with the TIG method. The mode selection is signaled by the lighting of the corresponding diode. - Pulse welding, ——— - welding without pulse.

D – Adjustment knob

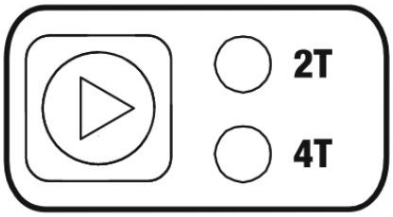
The adjustment knob is used to change welding parameters and to enable and disable the remote control option.

Pressing the knob briefly causes a transition between the set parameters. The currently set parameter is indicated by the lighting of the corresponding diode, and the current parameter value appears on the parameter display (H). Turning the knob to the left decreases the parameter value, and turning it to the right increases it. Pressing the knob again saves the parameter value and moves to the next parameter.

Pressing the knob and holding it for 3 seconds turns the remote control on or off.
Enabling the remote control option is confirmed by lighting up the REM diode.



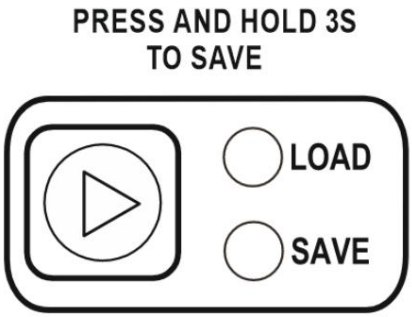
E – Source mode selection button (two-stroke/four-stroke)



The button is active only when welding using the TIG method. The mode selection is signaled by the lighting of the corresponding diode.

In the two-stroke mode, pressing the switch in the handle grip will turn on the ionizer and ignite the arc. Welding is carried out with the switch pressed. Releasing the switch will end welding. In the four-stroke mode, pressing the switch in the handle grip will turn on the ionizer and ignite the arc, then you should release the switch and weld with the switch released. Pressing the switch again will end welding.

F – Settings memory



The device has a memory of the last setting, which means that after switching it off and on again, the last set parameters are restored. It is also possible to save 10 sets of settings. To save the current settings, press the button and hold it until the "SAVE" diode lights up (about 3 seconds). After the "SAVE" diode lights up, the memory display (I) will show a flashing set number under which the settings will be saved. This number can be changed using the knob. Pressing the button again will save the settings under the selected number and the "SAVE" diode will turn off.

To recall a saved set of settings, press the button briefly. After the "LOAD" LED lights up, use the knob to select the number of the set of settings that you want to recall. Pressing the button briefly again will load the settings and turn off the "LOAD" LED.

After loading the set of settings, the number of the loaded set of parameters will appear on the display (I). If any of the parameters is changed during operation, a dash will appear on the memory display. To save the changes, proceed as for standard saving.

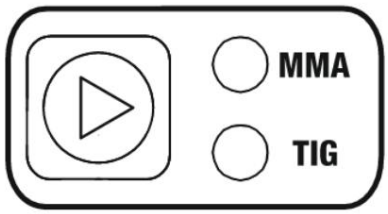
settings.

If after entering the save mode or loading the settings and the "LOAD" or "SAVE" LED is lit, the adjustment knob is not moved or the button is not pressed again for approximately 10 seconds, the device will return to the normal parameter adjustment mode.

If the device is switched off while a set of parameters is loaded in the memory, the last used set will be loaded automatically after switching it on again and its number will appear on the display. If no set of parameters is loaded in the memory and the device is switched off, the last used parameters will be restored after switching it on and a dash will appear on the display (I).

If after loading a set of parameters, any of the parameters is changed and the device is turned off, after switching it on, the last used parameters will be restored without loading the last set, and a dash will appear on the display (I).

G – Welding method selection button



The button is used to select the welding method. The selection of the method is signaled by lighting up corresponding diode. MMA – welding with a coated electrode, TIG – welding with a tungsten electrode in a protective gas shield.

H – welding parameter display

The display shows the parameters during their setting and during welding. The lighting of the appropriate diode on the side of the display indicates the parameter unit. When the welder is started, the display shows the inscription "LL". The message "Err" signals overheating or improper operation of the device.

I – Display of the parameter set memory

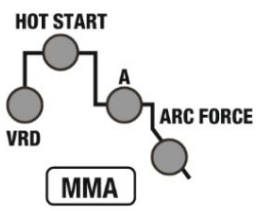
The display shows the number of the parameter set that was loaded or under which the current set will be saved.

8.3 Overheating protection

The power source is equipped with a thermal, automatic overload switch. When the temperature of the welder is too high, the protection will disconnect the welding current, the OC diode will light up, and the display will show the message "Err". After the temperature drops, the switch will automatically reset.

9. PARAMETER SETTINGS

9.1 MMA method



After selecting the MMA method, it is possible to adjust the welding current, select the VRD function and adjust the HOT START and ARC FORCE functions.

VRD function
The VRD function reduces the voltage in the no-load state. The correct voltage value is restored only just before the arc is struck. This minimizes the risk of electric shock, but in some cases it may make it difficult to strike the arc. To turn the VRD function on or off, set the welding current to 108A, and then press the (E) button for about 3 seconds. The activation of the function is signaled by the VRD diode lighting up.

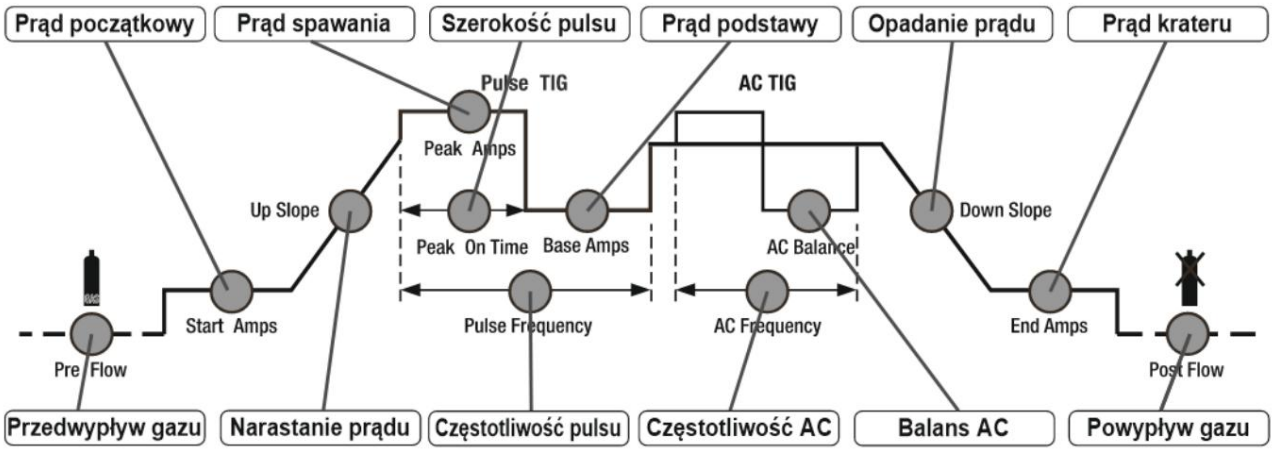
HOT START function
The HOT START function is popularly called hot start. It works when the arc is ignited,
causing a momentary increase in the welding current above the value set by the welder. HOT START is intended to prevent the electrode from sticking to the material and is a great convenience when striking the arc. When welding small elements, it is recommended to turn this function off, as it can cause the welded material to burn out.

Adjustment range: 0 - 100A

ARC FORCE function
The ARC FORCE function allows you to adjust the dynamics of the welding arc. Shortening the arc length is accompanied by an increase in the welding current, which stabilizes the arc. Reducing the value gives a soft arc and a smaller penetration depth, while increasing the value causes deeper penetration and the possibility of short arc welding. When the ARC FORCE function is set to a high value, you can weld while maintaining a minimum arc length and a high electrode melting speed
Adjustment range: 0 - 50A

9.2 TIG method

Use the welding method selection button to select TIG welding. Use the current type selection button to select direct current (DC) or alternating current (AC). Use the pulse switch to turn the pulse on or off. Set the welding parameters:



Initial current - the current that appears in the circuit after pressing the button in the handle grip. The
the higher the initial current, the easier it is to ignite the arc. However, when welding thin sheets, too high a value of the initial current can lead to burning the sheet. In some welding modes, the current does not increase to heat the welded part.
Adjustment range: 10 - 200A

Welding current
Adjustment range: 10 - 200A

Pulse width – the pulse duration, allows for the regulation of the penetration depth. Increasing the width increases the penetration depth, decreasing it limits the amount of heat introduced into the material, reducing the risk of burning through thinner sheets or smaller elements.

Lower pulse width values should be used for higher currents. A wider pulse width should be used for small currents, for example a width greater than 50% should be used for currents below 100A.

Adjustment range: 10 - 90%

Base current – the current responsible for maintaining the welding process, the lower value of the current pulse.
Makes it easier to control the amount of heat introduced into the material.
Base current adjustment is only possible during pulse welding
Adjustment range: 5 - 95% of welding current

Current slope down time - the time it takes for the welding current to fall from the set value to zero or the crater current value.

Adjustment range: 0 - 25s

Crater current - current used in some welding modes, when the arc is not extinguished immediately after the welding current falls. It allows filling the crater at the end of the weld.
Adjustment range: 10 - 200A

Gas pre-flow time - the time from pressing the button on the handle until the arc is struck.
It should usually be longer than 0.5 s to deliver shielding gas to the torch nozzle outlet to cover the weld start and tungsten electrode. In case of longer gas supply line from the cylinder, the pre-flow time should be longer.

Adjustment range: 0.1 - 1s

Current rise time - the time it takes for the welding current to rise from the initial current to the set welding current value.
Adjustment range: 0 - 10s

Pulse frequency – the frequency at which the current pulse value changes between the welding current and the base current.
Adjustment range: 0.5 - 200Hz

AC current frequency – a useful function when welding aluminum. The higher the frequency, the better the weld quality and the better the arc focus
Adjustment range: 40 - 200Hz

AC Current Balance – The ratio of the duration of the positive current phase to the negative current phase. Reducing the balance introduces more heat into the material, achieving a narrower weld and deeper penetration, while also reducing the thermal load on the tungsten electrode. Increasing the balance introduces less heat into the material, achieving better cleaning, a wider weld and shallower penetration, but significantly loads the tungsten electrode.

Adjustment range: 30 - 70%

Gas postflow time - the time from arc extinction to closing the gas valve to shield the solidifying weld pool from air and to cool the tungsten electrode. Too short a postflow time can result in weld oxidation. When welding in TIG AC mode (alternating current), this time should be longer.

Adjustment range: 0 - 15s

10. WELDING

10.1. Welding with coated electrode (MMA)

10.1.1 Arc Initialization

Arc initiation in coated electrode welding involves touching the electrode to the welded material, briefly rubbing it and then tearing it off. In the case of arc initiation with electrodes whose coating forms a non-conductive slag after solidification, the tip of the electrode should be pre-cleaned by striking it several times against a hard surface until metallic contact with the welded material is achieved.

10.1.2 Conducting the welding process

Use the welding method selection button to select the MMA method. In this mode, you can adjust the welding current, turn the VRD function on or off, and adjust the HOT START and ARC FORCE functions.
Welding current adjustment is possible immediately after switching on the power supply. Turning the adjustment knob will change the welding current.

10.2. Welding in a protective gas shield (TIG method).

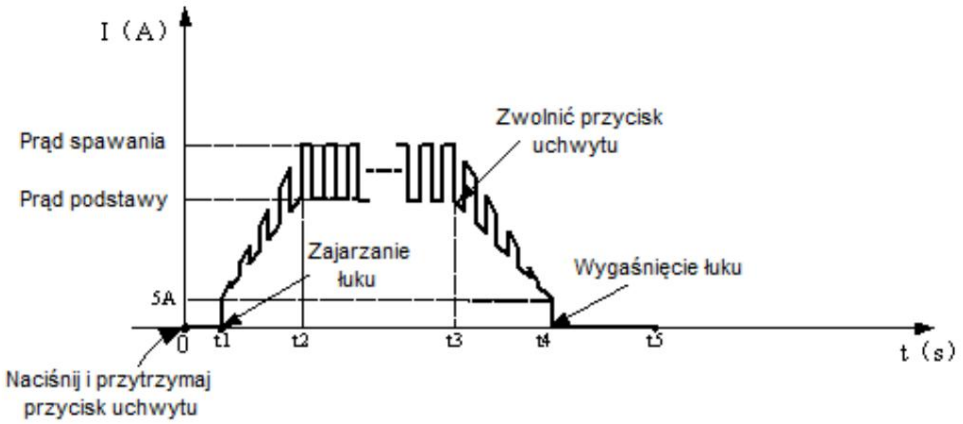
10.2.1 Arc initiation and welding process in the TIG method

The DIGITIG PULSE AC/DC 200GD device is equipped with an ionizer enabling contactless arc ignition.

To ignite the arc in the two-stroke mode, bring the electrode within 2 millimeters of the welded material and press the button on the torch handle to turn on the ionizer. After the arc has been correctly initiated, weld with the button pressed. Releasing the button on the handle starts the current drop phase and ends the welding process.

To ignite the arc in the four-stroke mode, bring the electrode within 2 millimeters of the welded material and press the button on the torch handle to turn on the ionizer. Once the arc has been correctly ignited, you can release the button and weld with the button released. To end welding, press and release the button on the handle again.

10.2.2 TIG welding in 2T modeÿ



ÿ 0ÿ Press and hold the handle button. The protective gas begins to flow;

ÿ 0ÿt1ÿ Gas pre-flow;

ÿ t1ÿt2ÿ Arc ignition, welding current increases from the minimum value to the set value welding current. If the pulsator is on, the current is modulated.

ÿ t2ÿt3ÿ During welding, the gun button should remain pressed;

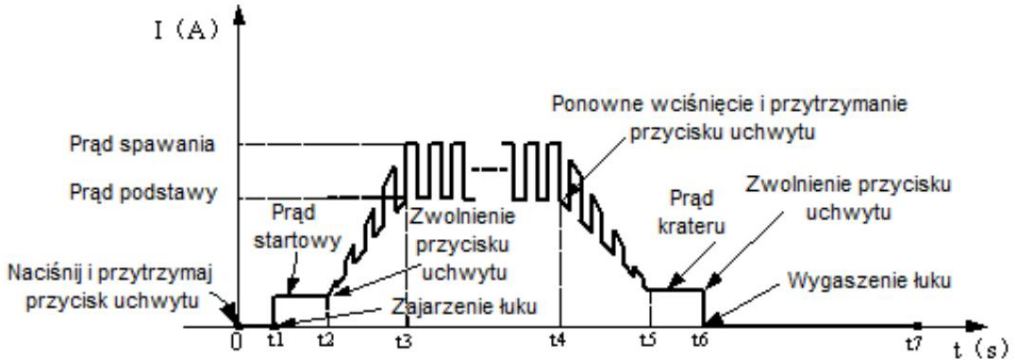
Note: If the pulsator is on, the welding current pulses, if the pulsator is off, the welding current has a constant value

t3ÿ Release the torch button, the welding current begins to fall. If the pulsator is on, the falling current is modulated;

ÿ t3ÿt4ÿ The welding current drops to the minimum value, the arc is extinguished;

ÿ t4ÿt5ÿ Gas post-flow. ÿ t5ÿ Solenoid valve closes gas flow, welding finished.

10.2.3 TIG welding in 4T modeÿ



ÿ 0ÿ ÿ 0ÿ Press and hold the handle button. The protective gas begins to flow;

t1ÿ Gas pre-flow time. Adjustable range: 0~1.0s; ÿ t1ÿ Arc ignition, starting current is set;

ÿ t2ÿ Release the torch button, the current starts to increase to the set welding current value. When the pulsator is on, the current is modulated;

ÿ t2ÿt3ÿ Current rise time; ÿ t3ÿt4ÿ Welding process;

Note: If the pulsator is on, the welding current pulses, if the pulsator is off, welding current is constant; Press the

ÿ t4ÿ torch button. The welding current begins to fall to the crater current value. If the pulsator is switched on, the falling current is modulated;

ÿ t4ÿt5ÿ Current fall time;

ÿ t5ÿt6ÿ Crater Current;

ÿ t6ÿ Release the handle button. The arc is extinguished, shielding gas flows out;

ÿ t7ÿ The solenoid valve closes the gas flow, ending welding.

11. BEFORE YOU CALL FOR SERVICE

If the device does not function properly, before sending the welding machine to the service center, check the list of basic faults and try to fix them yourself.
Any repairs to the device may only be performed after disconnecting the plug from the power socket.

Note! The device is not sealed and the user can remove the welding machine housing to eliminate minor faults.

Symptoms	Ways to remove
The control panel does not light up, the fan does not work, there is no output voltage	1. Make sure the switch is in the ON position 2. Check the fuse and voltage in the network 3. Remove the cover and check the connection of all plugs electrical inside the device
Control panel lights up, fan does not work, no output voltage.	1. Check if the device is not connected to a higher voltage network. If so, connect to 230V network and switch on again 2. The supply voltage is unstable and causes the overvoltage protection to be activated. Turn the device off for 2-3 minutes and turn it on again. 3. Turning the switch on and off for a short time caused the overvoltage protection to activate. Turn the device off for 2-3 minutes and turn it on again 4. There was other damage that required repair by Authorized service
The control panel lights up, the fan works, problems with arc ignition	1. Check the TIG torch, replace the consumable parts if necessary. are worn out

The control panel lights up, the fan works, the welder does not strike the arc	1. Check the terminals and the correct electrical conductivity of the electrode and ground cables. 2. Check the connection of the TIG torch to the device, pay attention to whether the pins in the socket are not broken or jammed. 3. Unscrew the TIG torch handle and check if the switch is in the handle is functional
The control panel lights up, the fan works, the OC diode lights up, the display shows the message "Err"	1. The device has overheated. Wait a few minutes. After the diode goes out, continue welding.
Unsatisfactory weld quality in MMA welding, the electrode sticks to the welded material	1. Check the welding polarity connections wires 2. Check if the electrode is wet. Replace the electrode. 3. The welder is powered by a generator or via a long extension cord with too small a cable cross-section. Connect the device directly to the mains
Unsatisfactory welds welding with the TIG method quality	1. Replace consumable parts. Change the tungsten electrode or gas cylinder to higher quality materials 2. Check if the shielding gas is flowing at the appropriate intensity 3. Check the gas supply hose, improve the connection hose with connectors and condition of quick connectors 4. Check the cylinder reducer.

12. OPERATING INSTRUCTIONS

The DIGITIG PULSE AC/DC 200GD device should be used in an atmosphere free from corrosive components and high dust levels. The device should not be placed in dusty places, near working grinders, etc. Dust and contamination with metal filings of control boards, cables and
connections inside the device may lead to an electrical short circuit and, consequently, damage to the welding machine.

Avoid operation in high humidity environments, especially where dew occurs on metal parts.

If dew appears on metal parts, e.g. after moving a cold device into a warm room, wait until the dew disappears. It is recommended that the welder is placed under a roof to protect it from adverse weather conditions when operating outdoors.

The DIGITIG PULSE AC/DC 200GD should be operated under the following conditions:

- changes in the effective value of the supply voltage not greater than 10%
- ambient temperature from -10°C to +40°C
- atmospheric pressure 860 to 1060 hPa
- relative humidity of atmospheric air not exceeding 80%
- altitude above sea level up to 1000m

List of consumable parts for the TIG T-26 torch:

No.	Name
	Tungsten electrode
1	2 T-26 clamping sleeve
	T-26 current switch
3	4 T-26 gas nozzle

A full list of consumables and spare parts is available on the website www.tecweld.pl and at TECWELD. It is possible to purchase these parts directly.

13. MAINTENANCE INSTRUCTIONS

As part of daily maintenance, you should keep the welding machine clean, check the condition of external connections and the condition of electrical wires and cables.

Replace consumable parts regularly.
Periodically remove the cover and clean the inside of the unit by blowing compressed air through it to remove dust and metal filings from the control boards and electrical wires and connections.

At least once every six months, the general condition of the device and electrical connections should be inspected, in particular:

- condition of electric shock protection - condition of insulation
- status of the security system
- correct operation of the cooling system

Damage resulting from operating the welding machine in improper conditions or failure to follow maintenance recommendations is not covered by warranty repairs.

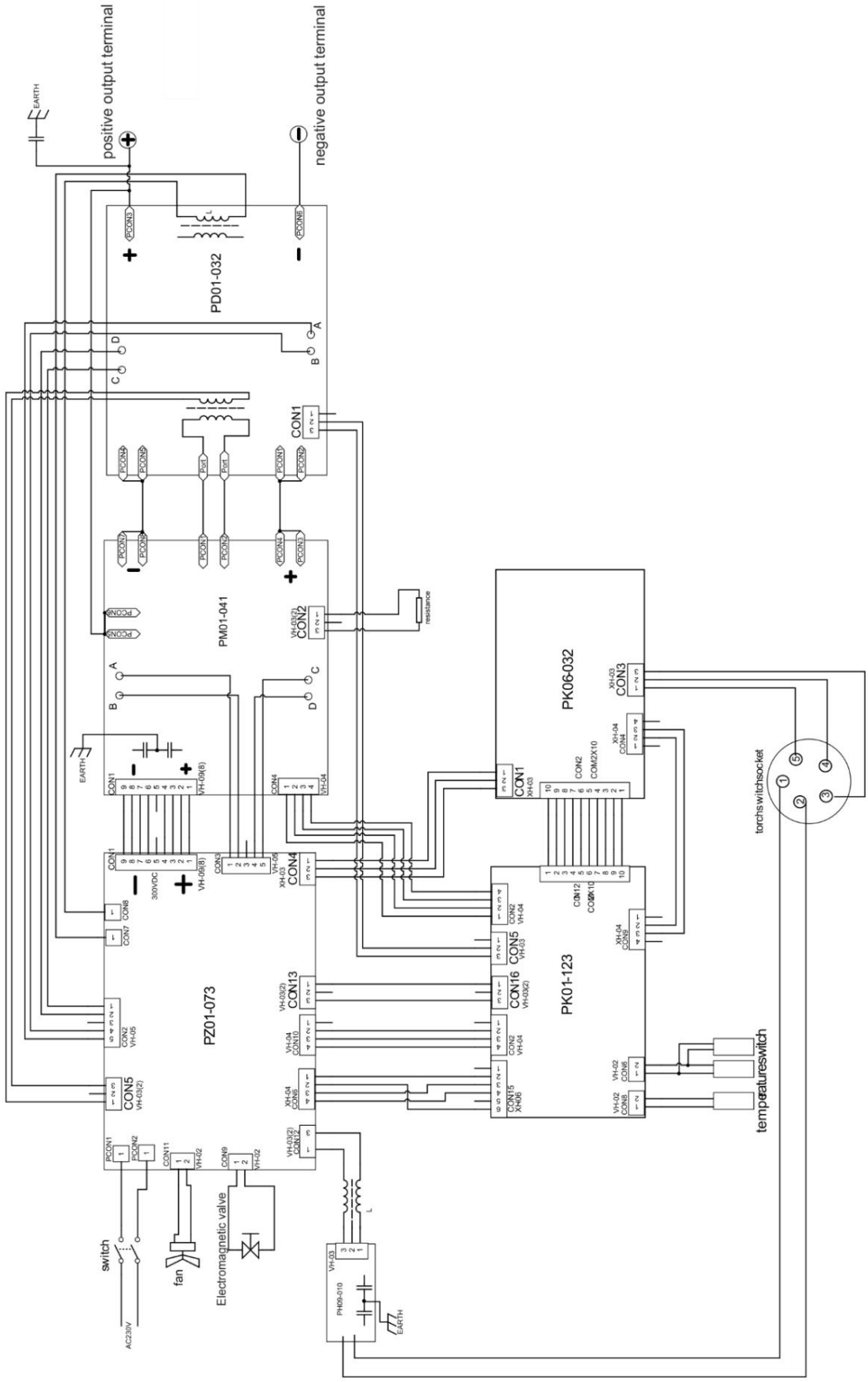
14. STORAGE AND TRANSPORT INSTRUCTIONS

The device should be stored at a temperature of -10°C to +40°C and relative humidity of up to 80%, free from corrosive fumes and dust. The transport of packed devices should be carried out in covered means of transport. During transport, the packed device should be secured against moving and ensured in the correct position.

15. COMPLETE SPECIFICATION

1. DIGITIG PULSE AC/DC 200GD source 2. TIG	1 pc.
welding torch 3. Electrode cable 4. Ground	1 pc.
cable with clamp 5. Operating	1 pc.
instructions 6. Packaging	1 pc.
	1 pc.
	1 pc.

16. ELECTRICAL DIAGRAM



17. WARRANTY

The warranty is granted for a period of 12 months for business entities, but excluding warranty claims, or 24 months for consumers from the date of sale.

The warranty will be honored upon presentation by the claimant of proof of purchase (invoice or receipt) and a warranty card with the product name, serial number, date of sale and the stamp of the point of sale.

To order a warranty repair, please fill out the form available at www.tecweld.pl in the SERVICE tab. Based on the notification, the device will be transported to the service by a courier company. Devices sent in any other way at the expense of TECWELD will not be accepted!

The welding machine must be delivered with a welding torch. Complaints about the machine without a welding torch will not be considered.
The device sent for complaint must be packed in the original carton secured with original polystyrene shapes. TECWELD is not responsible for any damage to the welder caused during transport.

If you intend to dispose of this product, do not dispose of it with your normal household waste. According to the WEEE directive (Directive 2002/96/EC) in force in the European Union, separate collection methods must be used for used electrical and electronic equipment.

In Poland, in accordance with the provisions of the Act of 1 July 2005 on waste electrical and electronic equipment, it is prohibited to place used equipment marked with the crossed-out wheeled bin symbol together with other waste.
The user who intends to dispose of this product is obliged to return used electrical and electronic equipment to a collection point for used equipment. Collection points are run by, among others, wholesalers and retailers of this equipment and by municipal organizational units conducting activities in the field of waste collection.

The above statutory obligations were introduced to limit the amount of waste generated from used electrical and electronic equipment and to ensure an appropriate level of collection, recovery and recycling of used equipment. Proper implementation of these obligations is especially important when the used equipment contains hazardous components that have a particularly negative impact on the environment and human health.

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DECLARATION OF CONFORMITY
01/DIGITIGPACDC200GD/2023

Authorized manufacturer representative:
TECWELD Piotr Polak
41-943 Piekary ÿlÿskie
ul. Emerald 21/3/6

branch:
41-909 Bytom
1G Krzyÿowa Street
POLAND

We declare that the product listed below:

Inverter welder

Trade name: **DIGITIG PULSE ACDC 200GD**

Type: **TIG ACDC 200GD**

Manufacturer's trademark: Sherman® digitec

to which this declaration relates complies with the requirements of the following European Union directives and national provisions implementing these directives:

Low Voltage Directive LVD 2014/35/EU

EMC Electromagnetic Compatibility Directive 2014/30/EU

RoHS II Directives 2011/65/EU

and complies with the following standards:

PN-EN IEC 60974-1:2018-11/A1:2019-06 Arc welding equipment - Part 1: Welding energy sources,

PN-EN 60974-10:2014-12 Arc welding equipment - Part 10: Requirements for electromagnetic compatibility (EMC),

PN-EN IEC 63000:2019-01 Technical documentation for the assessment of electrical and electronic products electronic in relation to the restriction of hazardous substances.

Year of CE marking on the device: 2016

Bytom, 03/04/2023

Peter the Pole
(signature of authorized person)