

USER MANUAL

**SYNERGIC
INVERTER WELDING MACHINE
DIGIMIG 200 CHROME**

Sherman [®]
— digitec —





ATTENTION!

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, some of its functions may be modified and their operation may differ in detail from the descriptions in the manual. This is not a device error, but the result of progress and continuous modification work on the device.

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 the qualifications of an electric welder in the field of gas shielded welding,
- 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 MIG/MAG 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 appropriate persons to have them corrected. 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 radiation burns. arc and splinters,
- 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 at 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 power cables with damaged insulation. Improper insulation of handles and power cables may cause 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 using the MIG/MAG 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 impair 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.

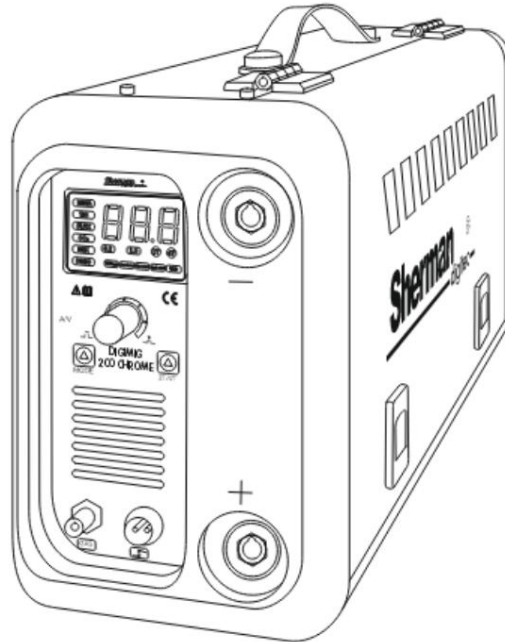
The above-mentioned hazards and general health and safety rules do not exhaust the issue of welder's work safety, because they do not take into account the specifics of the workplace. An important supplement to them are workplace health and safety instructions and training and instruction provided by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

3. GENERAL DESCRIPTION

The DIGIMIG 200 CHROME synergic welding machine is used for manual welding of steel and non-ferrous metals. It allows welding using MMA (covered electrode), TIG and MIG/MAG methods. Synergistic programs simplify its operation and allow the device to be used by people with less experience and hobbyists. Thanks to the change of polarity, the device allows for MIG/MAG welding using both standard wires in a shielding gas and self-shielding flux-cored wires.

The device is made in IGBT technology, which allows for a significant reduction in the weight and dimensions of the welder and an increase in efficiency while reducing energy consumption.

The welding machine is intended for use in closed or roofed rooms, not directly exposed to atmospheric influences.



4. TECHNICAL PARAMETERS

4.1 Welding machine

Supply voltage:	AC 230V 50Hz
Maximum power consumption:	7.1kVA
Rated welding current:/ duty cycle	MIG: 200A / 60%; MMA: 160A / 60%; TIG: 200A / 60%
No-load rated voltage Wire spool diameters:	60V
	100mm, 200mm
Maximum current consumption:	MIG: 26.9 A; MMA: 32.3 A; TIG: 20 A
Network security	25A
Weight (without accessories):	6kg
Dimensions [mm]:	410x165x240
Degree of protection:	IP21S

4.1.1 Parameter adjustment ranges

Welding current:	MIG: 40 – 200 A; MMA: 20 – 160 A; TIG: 20 – 200 A
Welding voltage:	MIG: 16 - 22 V
ANTI STICK (MMA)	On / Off
ARC FORCE (MMA):	0-70
HOT START (MMA):	0-100
VRD (MMA):	On / Off

4.2 MIG torch

Handle type:	TW-15
Maximum current capacity:	200A (CO2)
Cooling type:	gas
Cooling gas flow:	10-18 l/min
Length:	3m

Work cycle

The duty cycle is based on a 10-minute period. A duty cycle of 60% means that after 6 minutes of operation, a 4-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 40°C was determined by simulation.

Degree of protection

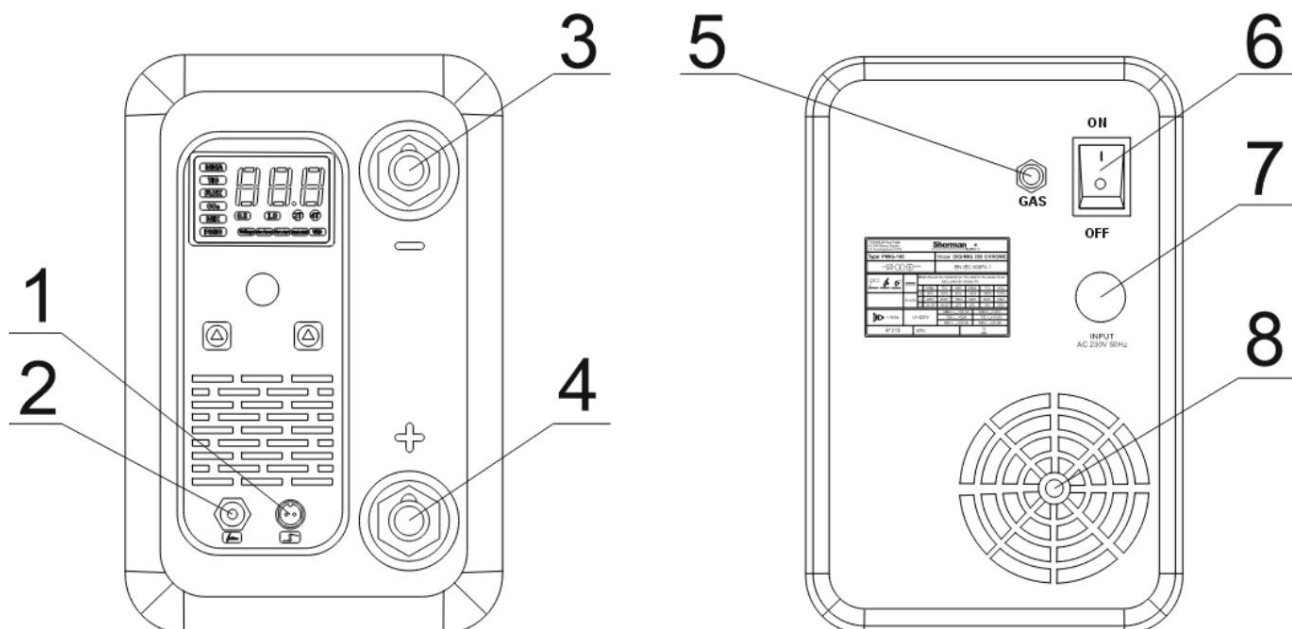
IP specifies the degree to which the device is resistant to the ingress of solid and water contaminants. IP21S means that the device is suitable for operation in closed rooms.

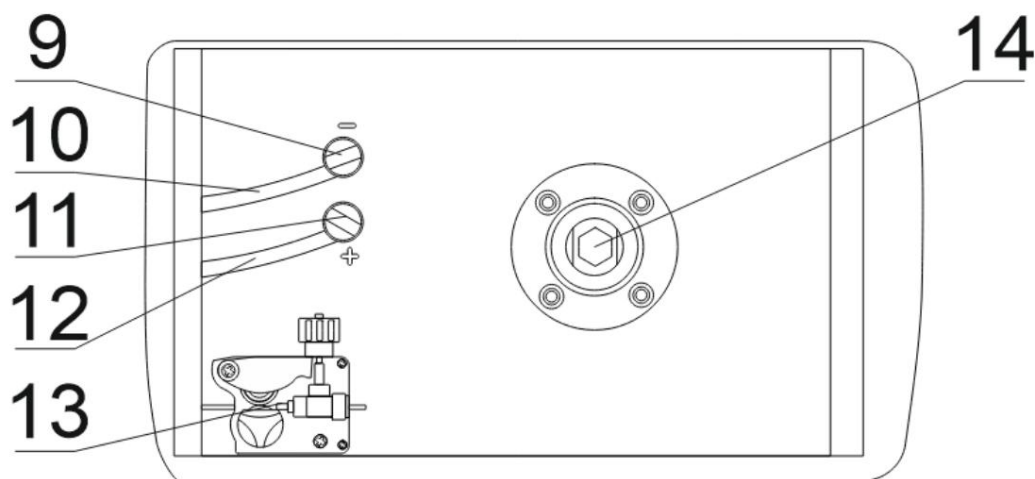
Overheating protection

The IGBT module is protected against overheating by a protective installation that turns off the power to the welding machine. The display shows the message E01. After a few minutes, the device cools down to a temperature that allows it to automatically switch on again. Do not disconnect the power supply during this time, because the continuously operating fan cools the internal radiators of the device in order to lower the temperature faster. After restarting, remember to limit the welding parameters in order to continue the continuous operation of the device.

5. PREPARING THE DEVICE FOR WORK

If the device is to be stored or transported in frosty conditions, the temperature must be above freezing before operation.





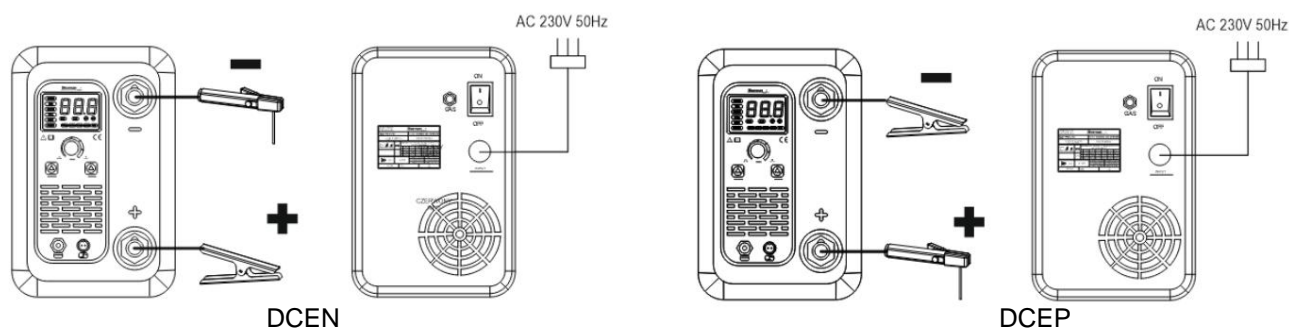
1. MIG gun control socket
2. MIG torch shielding gas socket
3. Socket "-"
4. Socket "+"
5. Shielding gas connection
6. Power switch
7. Power cord

8. Fan
9. Terminal "-" change polarity
10. Socket wire "-" black
11. Terminal "+" change polarity
12. Socket wire "+" red
13. Wire feeder
14. Wire spool pin

5.1 Connecting the cables

5.1.1 MMA method

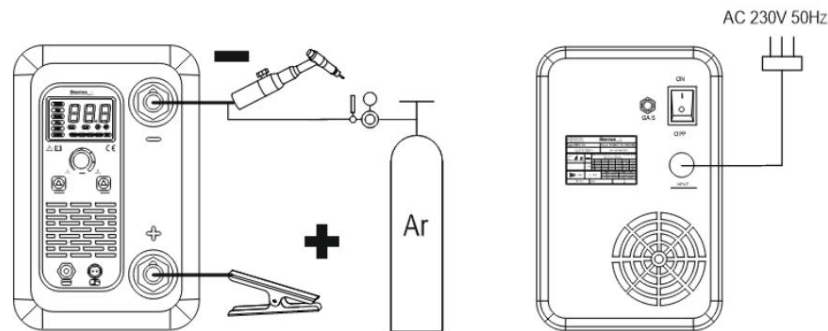
The ends of the welding cables should be connected to the sockets (3) and (4) located on the front panel so that the correct pole for the given electrode is on the electrode holder. The polarity of the welding cable connection depends on the type of electrode used and is given on the electrode packaging (negative polarity DCEN or positive polarity DCEP). The return cable clamp should be carefully secured to the welded material. Connect the device plug to a 230V 50Hz mains socket.



5.1.2 TIG method

For welding with this method, it is necessary to use an additional TIG torch. A gas-cooled torch with a current load of 200A, equipped with a shielding gas control valve, is required.

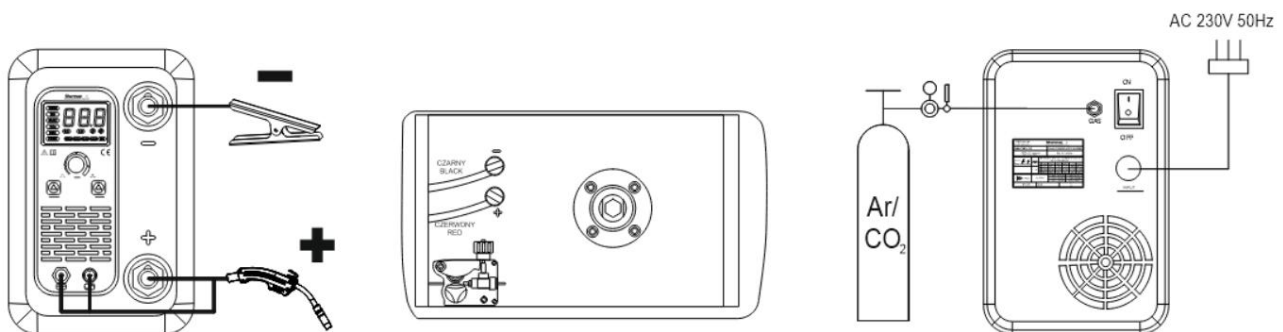
The current terminal of the handle should be connected to the negative polarity socket (3), and the gas hose to the reducer on the gas cylinder. The positive pole of the source (4) should be connected to the welded material using a cable with a clamp. Connect the device plug to a 230V 50Hz mains socket.



5.1.3 MIG method

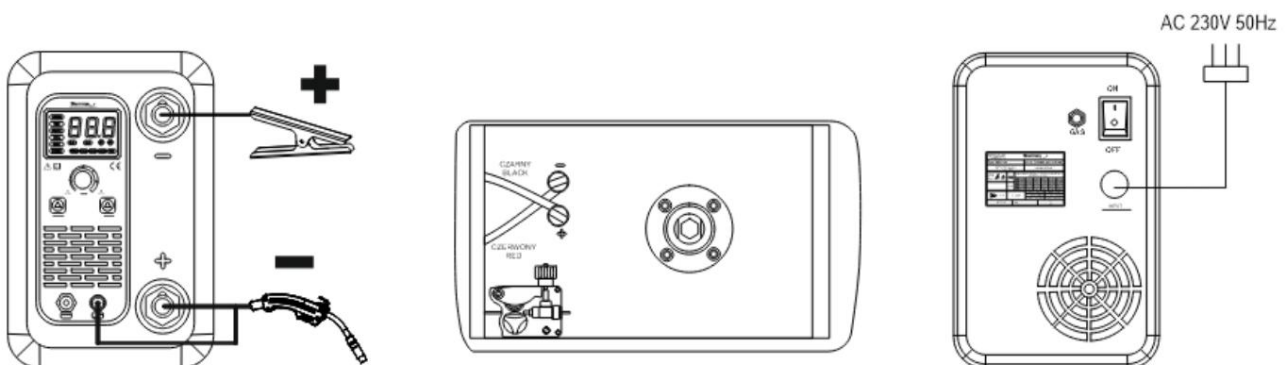
5.1.3.1 Welding in protective gases

The current terminal of the handle should be connected to the positive polarity socket (4), the gas hose of the handle should be screwed to the socket (2) and the control plug to the socket (1). The gas hose from the reducer should be led and secured to the gas connector (5) located on the rear wall of the device. The black wire (10) in the feeder chamber should be connected to the black polarity change terminal (9). The red wire (12) in the feeder chamber should be connected to the red polarity change terminal (11). The negative pole of the source (3) should be connected to the welded material using a wire with a clamp. Connect the device plug to a 230V 50Hz mains socket.



5.1.3.2 Welding with self-shielded steel wire

The current terminal of the handle should be connected to the upper current socket (4) and the control plug to the socket (1). The black wire (10) in the feeder chamber should be connected to the red polarity change terminal (11). Connect the red wire (12) in the feeder chamber to the red polarity change terminal (9). Connect the lower socket (3) to the welded material using a wire with a clamp. Connect the device plug to a 230V 50Hz mains socket.



5.2 Shielding gas connection

1. Secure the cylinder and secure it against tipping over.
2. Open the cylinder valve for a moment to remove any contamination.
3. Install the reducer on the cylinder.

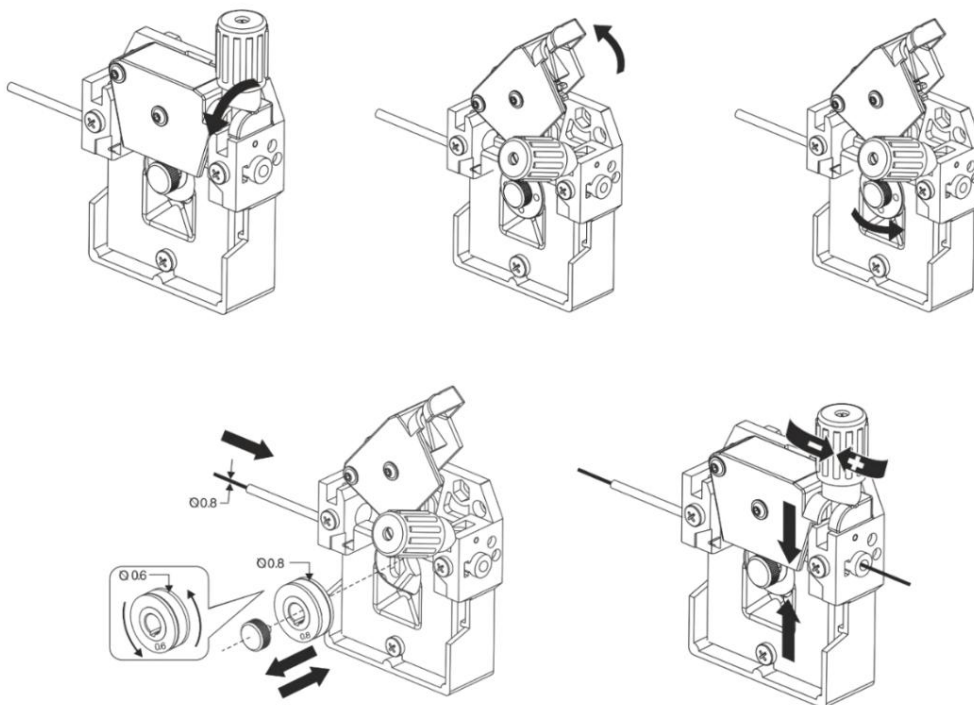
4. Connect the reducer with the gas connection (5) on the rear wall of the welding machine using a hose.
5. Unscrew the cylinder and reducer valve.

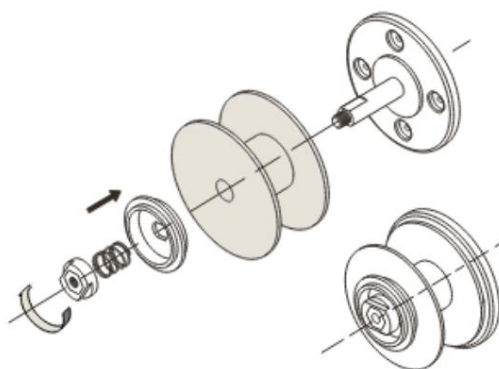
5.3 Connection to the mains

1. The device should only be used in a single-phase power supply system, three-wire, with grounded neutral point.
2. The DIGIMIG 200 CHROME inverter rectifier is designed to work with a 230V/50 Hz network protected by 25 A delayed fuses. The power supply should be stable, without voltage drops.
3. Before connecting the power supply, make sure that the power switch (6) is in the OFF position. (off).

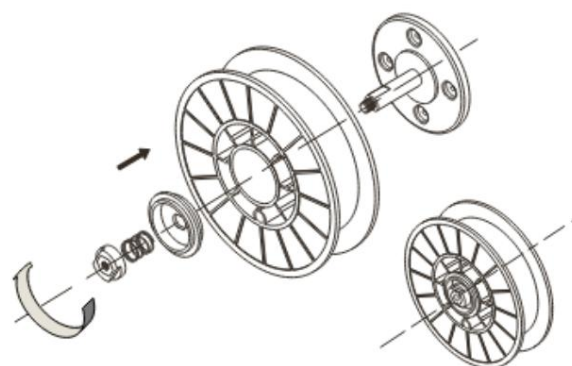
5.4 Installing the electrode wire spool

1. Open the side cover of the housing.
2. Place the spool of electrode wire on the mandrel.
3. Secure the spool against falling.
4. Release the pressure on the feed rollers.
5. Check that the drive rollers are suitable for the type and diameter of wire. If necessary, fit the correct roller. For steel wires, use V-groove rollers and for aluminium wires, use U-groove rollers. For welding with self-shielded wire, it is recommended to use knurled rollers.
6. Blunt the tip of the electrode wire.
7. Insert the wire through the feeder drive roller into the holder.
8. Press the wire into the grooves of the drive roller.
9. Unscrew the current tip from the holder, turn on the welding machine power supply and pull the wire into the welding machine holder by pressing the button on the welding torch handle.
10. Once the wire appears in the handle outlet, release the button and screw on the contact tip.
11. Adjust the feed roller pressure by turning the pressure knob. Too low a pressure will result in slipping of the drive roller, too high a pressure will increase the feeding resistance, which may lead to wire deformation and damage to the feeder.

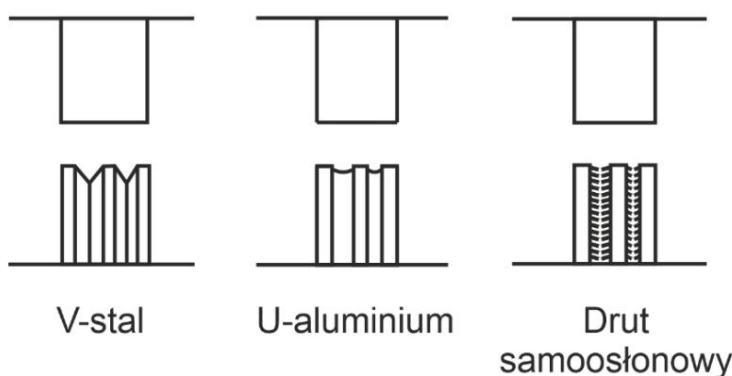




Spool D100



Spool D200



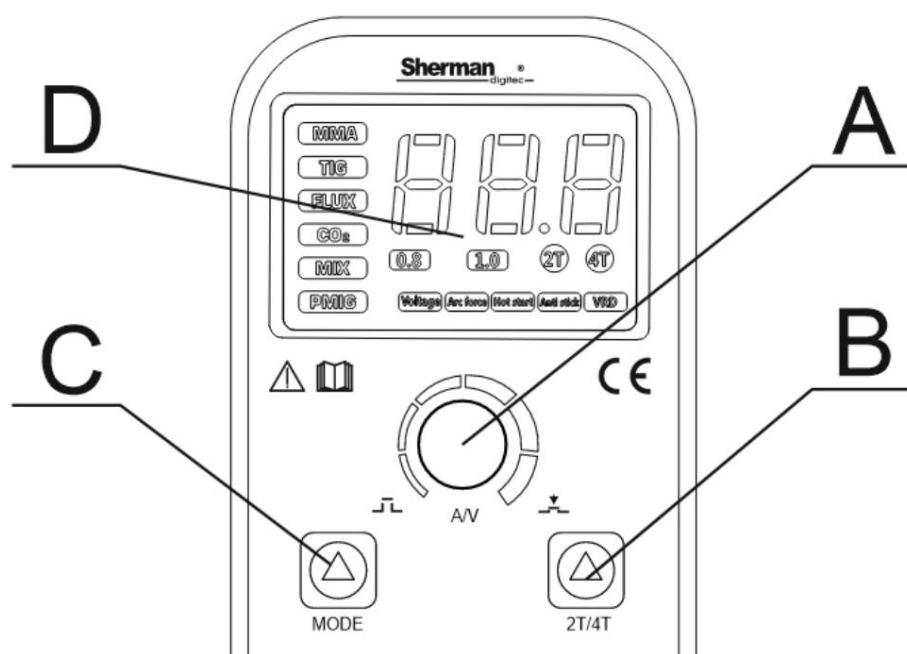
5.5 Preparing the MIG gun for work

Depending on the type of material being welded and the diameter of the electrode wire, fit the appropriate current tip and wire guide insert to the MIG torch.

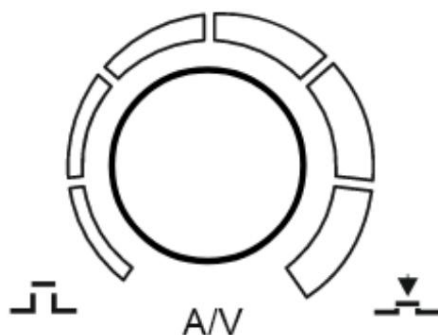
For welding steel, use steel welding tips and a steel insert. For welding aluminum, use aluminum welding tips and a Teflon insert.

6. SERVICE

6.1 Front panel



A – Multi-function knob.



The knob is used to adjust welding parameters and set functions.

During MMA welding, the welding current is regulated by the knob. After pressing the button, it is possible to set the Arc Force, Hot Start, Anti Stick and VRD functions,

During TIG welding, the knob is used only to adjust the welding current.

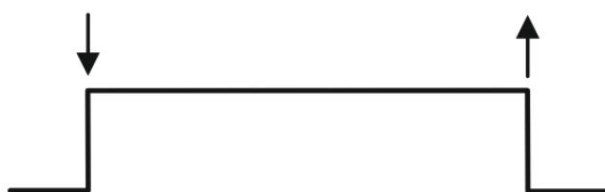
During MIG welding, the knob regulates the welding current. After pressing the knob, it is possible to correct the welding voltage. The transition to welding voltage correction is confirmed by lighting up

diodes  on the display.

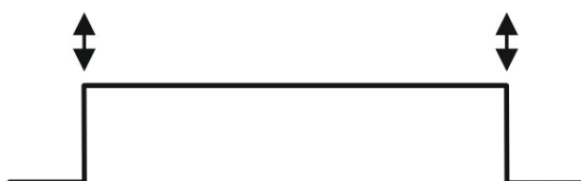
B – 2T/4T source control button



The button is active only during MIG/MAG welding. It allows you to select the source control mode. The selection of the appropriate mode is signaled by the lighting of the appropriate diode.



Pressing the welding torch button will ignite the arc and start welding. Releasing the button will extinguish the arc.



Pressing and releasing the welding torch button will ignite the arc and start welding.
Pressing and releasing the button again will turn the arc off.

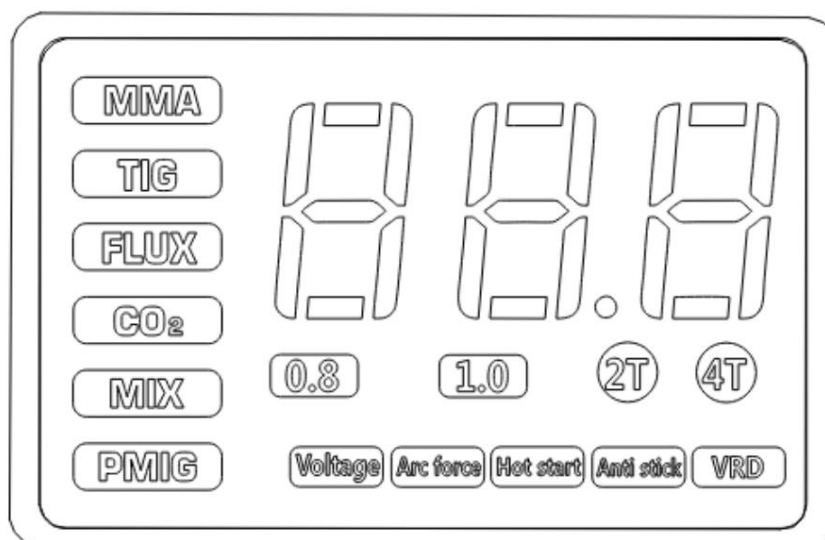
C – Welding method selection button



The button is used to select the welding method, synergistic program and electrode wire diameter.

MMA	MMA welding (covered electrode)
TIG	TIG welding (tungsten electrode in a protective gas shield)
FLUX	MIG/MAG welding of steel with steel flux-cored wire
CO ₂	Welding of steel using the MIG/MAG method with CO ₂ shielding.
MIX	MIG/MAG welding of steel in Ar/CO ₂ mixture shield. Recommended mixture proportions are 82% Ar 18% CO ₂ .
PMIG	Welding of aluminum alloys using the MIG/MAG method with argon-shielded pulse using AlMg5 wire (ER5356). The current pulse frequency is automatically selected by the device in the range of 20-250 Hz
0.8	Welding with 0.8mm diameter wire
1.0	Welding with 1.0mm diameter wire

D – Display



The display shows the welding current and symbols for adjustable functions and parameters, as well as error codes.



MMA	MMA welding
TIG	TIG welding
FLUX	MIG/MAG welding of steel with steel flux-cored wire
CO ₂	Welding of steel using the MIG/MAG method with CO ₂ shielding.
MIX	Welding of steel using the MIG/MAG method with Ar/CO ₂ mixture shielding.
PMIG	Welding of aluminum alloys using the MIG/MAG method with argon shielded pulse
Voltage	The diode is active only during MIG/MAG welding. It indicates the transition to welding voltage correction mode.
Arc force	Arc Force function allows you to adjust the dynamics of the welding arc.
Hot start	HOT START function for easier arc ignition.
Anti stick	ANTI STICK is a function that reduces the effects of electrode sticking.
VRD	The VRD function reduces the no-load voltage.
0.8	Welding with 0.8mm diameter wire
1.0	Welding with 1.0mm diameter wire
2T	Welding in two-stroke mode
4T	Welding in four-stroke mode
EDI	Thermal protection activation.

7. PARAMETER SETTINGS

7.1 MMA method

After selecting the MMA method, it is possible to adjust the welding current and the following functions:

Arc force	<p>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. Decreasing the value gives a soft arc and a smaller penetration depth, while increasing the value results in deeper penetration and the possibility of short arc welding.</p> <p>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.</p>
Hot start	<p>The HOT START function is popularly called hot start. It works when the arc is ignited, causing a momentary increase in welding current above the value set by the welder. HOT START is intended to prevent the electrode from sticking to the material, making it easier to</p> <div style="display: flex; justify-content: space-around; align-items: center;"> down is big </div> <p>arc ignition. When welding small elements, it is recommended to turn this function off, as it may cause the welded material to burn out.</p>

	ANTI STICK is a function that reduces the effects of a short circuit caused by sticking of the electrode. It causes a momentary significant reduction in welding voltage and current, facilitating the restoration of normal operation.
	The VRD function reduces the voltage in the no-load condition. 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.

7.2 TIG method

When the TIG method is selected, only the welding current can be adjusted.

7.3 MIG/MAG method

During MIG/MAG welding, the device operates in synergistic mode. This allows less experienced users to select welding parameters. In this mode, the device automatically selects the current welding and wire feed speed depending on the type of welded material and the diameter of the electrode wire. It is possible to correct the welding voltage.

Welding voltage correction

After setting the welding current, it is possible to correct the welding voltage. Pressing the adjustment knob will display the welding voltage and allow its correction in the range of +5 to -5 V.

The welder has built-in synergistic programs for selected materials, wire diameters and shielding gases according to the table below:

Material	Designation	Wire diameter	Shielding gas - recommended
Carbon steel	CO2	0.8/1.0	CO2
	MIX	0.8/1.0	Ar+CO2 (82/18)
	FLUX	0.8/1.0	-
Aluminum (ER 5356)	PMIG	1.0	Argon

- High quality argon should be used: 4.8 and above recommended

8. WELDING ALUMINUM ALLOYS

After selecting the PMIG mode, the welder switches to the synergistic program that allows for aluminum welding. The program has been selected for welding with AlMg5 wire type ER 5356, which is suitable for welding all types of structures and shapes.

Welding aluminum is not an easy task, it requires the welder to have experience, knowledge and maintain certain practices that will make it easier to weld aluminum elements. The device selects output parameters for the appropriate type of materials and types of wires in the synergistic program.

Depending on your needs, make appropriate voltage and inductance adjustments to achieve the desired effect.

First of all, you should remember a few important things that significantly affect the appearance of the weld and influence the correct course of the welding process.

Before starting welding work on aluminum components, the following steps must be performed:

Device:

- Make sure the feed rolls are designed for aluminum: the groove is U-shaped and designed for the correct diameter of welding wire. Using the wrong rolls will deform the wire and cause problems in the welding process.
- Make sure the feed rollers are not set too tight. Excessive wire tension can cause a feeding problem.
- Make sure the holder is equipped with a Teflon guide insert intended for aluminum. Using steel components used to feed steel wire will cause feeding problems.

- Make sure the contact tip is the correct size and designed for aluminum wire.
- It is worth replacing part of the wire guide insert in the feeder with a Teflon version, which improves wire feeding, just like in the case of a welding torch.

Work position:

- Attention should be paid to the proper preparation of the welding work site: the hall should be clean, have good ventilation and low air humidity should be maintained. The presence of iron oxide dust or dust from arc gouging of steel is unacceptable.
- Aluminum welding stations should be vacuumed with industrial vacuum cleaners once a day, completion of work.
- Welders' clothes should be clean, gloves must not be greasy.

Preparation of material:

- The welding site should be cleaned and degreased immediately before welding,
- Degrease aluminum elements by wiping them with a clean cloth soaked in a degreasing agent, e.g. acetone (Alcohol is not a good degreasing agent and we do not recommend using it when cleaning aluminum).
- Remove heavy oxide residues before welding. This is normally done manually or mechanically using a steel wire brush. If the material is heavily contaminated, it may be necessary to use a grinder.
- After proper surface preparation, the welding process should be performed as quickly as possible.
- If the part must remain unwelded for an extended period of time, protect it with brown wrapping paper and tape.

Proper storage of welding wire

- Aluminum welding wire should be stored in a clean, dry environment, preferably in original packaging.
- The wire does not need to be stored in air-conditioned rooms, it is best to store it in low humidity conditions. The wire must not be soaked in water.
- If a wire that is relatively cold is brought into a room on a hot, humid day and immediately opened, it is possible that the humid air will contaminate the wire. Therefore, if the wire is stored in an air-conditioned room, remember not to unpack the wire until it has warmed up and acclimatized to the ambient temperature.
- After finishing work, the wire should be removed from the feeder and secured in a plastic bag for next use.

For welding aluminum alloys, pure argon of high quality class, recommended not less than 4.8, should be used as a shielding gas. The gas flow should be selected according to the thickness and welding speed. Good welding results are achieved when the process direction is to the left.

9. ARC INITIATION

9.1 MMA method

1. Touch the electrode to the workpiece, rub briefly and remove.
2. In the case of arc initiation with electrodes whose coating forms a non-conductive slag after solidification, pre-clean the electrode tip by striking it several times against a hard surface until metallic contact with the welded material is achieved.

9.2 TIG method

1. Open the valve on the TIG torch to allow the shielding gas to flow.
2. Lightly touch the workpiece with the electrode, remove the electrode from the workpiece by tilting the handle so that the gas nozzle touches the material.
3. Once the arc is struck, straighten the torch and start welding.

9.3 MIG method

1. Bring the torch closer to the welded elements so that the distance between the nozzle and the welded elements was approximately 10 mm.
2. Press the button on the welding torch and start welding.

10. 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	Cause	Procedure
No power, failure signal or device malfunction	No connection or loose plug inside the device	Check and correct the connections of all electrical plugs inside the device
	The inside of the device is dirty	Remove the cover and clean the inside of the unit by blowing compressed air through it to remove dust and metal shavings from the control boards and electrical wires and connections.
No electrode wire feeding (feeder motor is running)	Roller pressure too weak	Set the correct pressure
	Incorrect guide roller groove diameter	Install the correct guide roller
	Dirty wire guide in the holder	Clean the electrode wire guide
	Electrode wire blocked in the current tip	Replace the contact tip
Irregular electrode wire feed	Damaged current terminal	Replace the contact tip
	The feed roller groove is dirty or damaged.	Clean the roller groove or replace the roller
	The wire spool rubs against the walls of the welding machine cover	Secure the wire spool correctly
The arc does not ignite	Lack of proper contact of the ground wire terminal	Improve the contact of the ground terminal
	Damaged switch in MIG torch	Replace the switch
	Improper connection of the MIG gun to the device	Check the condition of the electrical connections of the holder, check if the pins in the socket are not broken or jammed
The arc is too long and irregular	Welding voltage too high	Reduce welding voltage
	Wire feed speed too slow	Increase wire feed speed
Bow too short	Welding voltage too low	Increase welding voltage
	Wire feed speed too high	Reduce wire feed speed
After switching on the power, the display does not light up	No power supply voltage	Check the fuses at the mains connection
The fan is not working	The fan was blocked by a bent cover	Straighten the fan cover
Unsatisfactory weld quality when welding with the MIG method	Inappropriate or poor quality materials or consumables used,	Replace consumable parts. Change welding wire or gas cylinder to suitable or higher quality materials
	Shielding gas flows at an inappropriate rate.	Check the gas supply hose, improve the connection of the hose with the connectors and the condition of the quick connectors. Check the cylinder reducer
Unsatisfactory weld quality when welding using the MMA method, the electrode sticks to the welded material	Incorrect polarity of welding cable connection	Connect the welding cables correctly
	Wet electrode.	Replace the electrode
	The welder is powered by a generator or by a long extension cord with a cable cross-section that is too small.	Connect the device directly to the mains
Unsatisfactory weld quality when welding with the TIG method	Check the quality of the materials and consumables used, especially the tungsten electrode and shielding gas.	Replace consumables, replace the shielding gas with a higher quality one
	Shielding gas does not flow or flows with insufficient intensity	Check the cylinder reducer, gas supply hose, improve the hose connection with the connectors and the condition of the quick connectors.

List of errors indicated on the display

Error code	Description
E01	Overheating protection. Wait a few minutes until the device cools down to a temperature that allows it to automatically switch on again. Do not disconnect the power supply during this time, as the continuously operating fan cools the internal radiators of the device in order to lower the temperature faster. After restarting, remember to limit the welding parameters in order to continue the continuous operation of the device.

11. OPERATING INSTRUCTIONS

The DIGIMIG 200 CHROME welding machine should be operated 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, to 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 bringing a cold device into a warm room, wait until it dries completely and the device warms up to the ambient temperature. Starting a cold welder in these conditions can damage it. It is recommended that the welder be placed under a roof to protect it from adverse weather conditions if used outdoors.

The DIGIMIG 200 CHROME device 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:

No.	For steel wires	For aluminum wires
1	Feed roller 25x8mm (7x7mm)	Feed roller Al 25x8mm (7x7mm)
2	Contact tip TW-15 M6x25	Contact tip Al TW-15 M6x25
3	TW-15 current switch	
4	Gas nozzle TW-15	
5	Steel insert 3m	Teflon insert 3m

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.

12. 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 (depending on operating conditions) remove the cover and clean the inside of the device by blowing it with compressed air to remove dust and metal filings from the control boards and electrical wires and connections.

At least once every six months, a general inspection and condition of electrical connections should be carried out, 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.

13. STORAGE AND TRANSPORT INSTRUCTIONS

The device should be stored at a temperature of -10°C to +40°C and relative humidity 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.

14. COMPLETE SPECIFICATION

1. DIGIMIG 200 CHROME source 2.	1 pc.
TW-15 welding torch 3. Ground cable	1 pc.
with clamp 4. Electrode cable 5. Gas hose 6. Teflon insert	1 pc.
4. Operating instructions 5.	1 pc.
Packaging	1 pc.
	1 pc.
	1 pc.
	1 pc.

15. 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 normal household waste. According to the WEEE Directive (Directive 2012/19/EU) in force in the European Union, separate disposal methods must be used for used electrical and electronic equipment. In Poland, in accordance with the provisions of the Act of 11 September 2015 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.

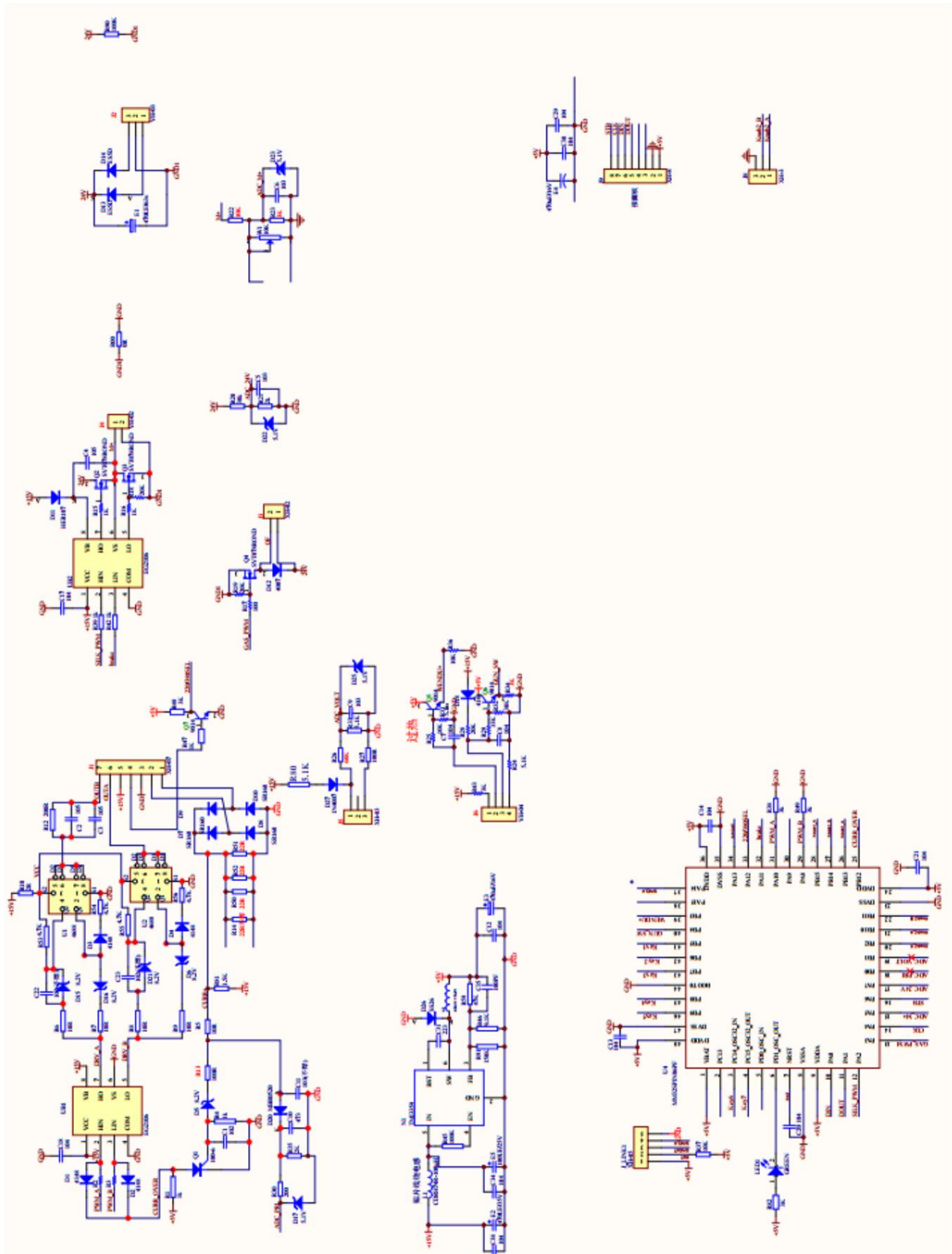
The user who intends to dispose of this product is obliged to return used electrical and electronic equipment to a collection point for used equipment. Collection points are run by, among others, wholesalers and retailers of this equipment and by municipal organizational units conducting activities in 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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16. ELECTRICAL DIAGRAM



DECLARATION OF CONFORMITY

01/DIGIMIG200CHROME/2025

Authorized manufacturer representative:

TECWELD Piotr Polak

41-943 Piekary Źłyskie
ul. Emerald 21/3/6

branch:

41-909 Bytom
1G KrzyŹowa Street
POLAND

We declare that the product listed below:

Inverter welder

Trade name:

DIGIMIG 200 CHROME

Type:

PMIG-160

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 IEC 60974-10:2022-07 Arc welding equipment - Part 10: Electromagnetic compatibility (EMC) requirements,

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:

2022

Bytom, 31.01.2025

Peter the Pole
(signature of authorized person)