



# 200A TIG/MMA HF AC/DC INVERTER WELDER 230V

MODEL NO: TIG200HFACDC.V2

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. KEEP THESE INSTRUCTIONS SAFE FOR FUTURE USE.



Refer to instructions



Wear protective gloves



Warning:  
Fumes & Gases



Warning:  
Electric Shock



Warning:  
Fire Risk



Warning:  
Arc Rays



Warning:  
Magnetic Fields

## 1. SAFETY

### 1.1. ELECTRICAL SAFETY

- ❑ **WARNING!** It is the user's responsibility to check the following: You must check all electrical equipment and appliances to ensure they are safe before using. You must inspect power supply leads, plugs and all electrical connections for wear and damage. You must ensure the risk of electric shock is minimised by the installation of appropriate safety devices. An RCCB (Residual Current Circuit Breaker) should be incorporated in the main distribution board. We recommend that an RCD (Residual Current Device) is used with all electrical products. It is particularly important to use an RCD together with portable products that are plugged into an electrical supply not protected by an RCCB. If in doubt consult a competent electrician. You may obtain a Residual Current Device by contacting your Sealey stockist. You must also read and understand the following instructions concerning electrical safety.
  - 1.1.1. The Electricity At Work Act 1989 requires all portable electrical appliances, if used on business premises, to be tested by a competent person on a regular basis by using a Portable Appliance Tester (PAT).
  - 1.1.2. The Health & Safety at Work Act 1974 makes owners of electrical appliances responsible for the safe condition of the appliance, and the safety of the appliance operator. If in any doubt about electrical safety, contact a competent electrician.
  - 1.1.3. Ensure the insulation on all cables and product itself is safe before connecting to mains power supply. See 1.1.1. use a Portable Appliance Tester (PAT).
  - 1.1.4. Ensure that cables are always protected against short circuit and overload.
  - 1.1.5. Check power supply, leads, plugs and all electrical connections regularly for wear or damage, especially power connections to ensure none is loose.
  - 1.1.6. Check the voltage marked on the product is the same as the electrical power supply to be used. Check fused plugs are fitted with correct capacity fuse.
  - 1.1.7. **DO NOT** pull or carry the powered appliance by its power supply lead. Products such as inverters must not be pulled or carried by their output cables.
  - 1.1.8. **DO NOT** pull power plugs from sockets by the power cable.
  - 1.1.9. **DO NOT** use worn or damage leads, plugs or connections. Replace or have repaired immediately by competent persons. In case of damage, cut off and fit a new plug according to the following instructions.
  - 1.1.10. NO plug is fitted to this machine. Whilst it is possible to perform TIG welding at lower power settings using a 13Amp mains source, ordinary ARC welding (without gas) and TIG welding at higher power settings will require the machine to be connected to a 30A supply either by direct wiring into your mains circuit or by fitting an industrial round pin plug & socket for more flexible usage. In either case we recommend you contact a competent electrician to assess your existing wiring installation and follow the recommendations in full. Particular attention should be paid to the provision of adequate fuses on the mains circuit and to the earthing of the machine.

If a 13A power source is used wire the plug as shown to the right.

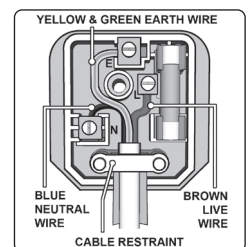
- a) **WARNING!** Ensure the unit is correctly earthed via a three-pin plug.
- b) Connect the Yellow/Green earth wire to the earth terminal 'E'.
- c) Connect the Brown live wire to live terminal 'L'.
- d) Connect the Blue neutral wire to the neutral terminal 'N'.

- ❑ **WARNING!** Be very cautious if using a generator to power the Inverter. The generator must be self regulating and stable with regard to voltage, waveform and frequency. The output must be greater than the power consumption of the inverter. If any of these requirements is not met the electronics within the Inverter may be affected.

**NOTE:** The use of an unregulated generator may be dangerous and will invalidate the warranty on the inverter.
- ❑ **WARNING!** The inverter may produce voltage surges in the mains supply which can damage other sensitive equipment (e.g. computers). To avoid this happening it is recommended that the Inverter is connected to a power supply that does not feed any sensitive equipment.

### 1.2. GENERAL SAFETY

- ▲ **DANGER!** Unplug the inverter from the mains power supply before connecting or disconnecting cables or performing maintenance or service. Direct contact with the inverter circuit is dangerous.
- ✓ Keep the inverter and cables in good working order and condition. (Take immediate action to repair or replace damaged parts).
- ✓ Use genuine parts and accessories only. (Non recommended parts may be dangerous and will invalidate the warranty).
- ✓ Locate inverter in an adequate working area for its function. Ensure area has adequate ventilation as welding fumes are harmful.



**RECOMMENDED FUSE**  
**RATING 13AMP:**  
TO GAIN MAXIMUM OUTPUT THE  
INVERTER MUST BE CONNECTED  
TO A 30AMP SUPPLY

- ❑ **WARNING!** If it is necessary for you to assemble the work clamp cable, ensure that sufficient copper strands are exposed and turned back to make full contact within the dinse plug to ensure a good electrical contact. Loose connection will cause overheating, rapid deterioration and loss in efficiency.
- ✓ Ensure there is no obstruction to the flow of clean cool air through the ventilation apertures and ensure there are no conductive dusts, corrosive vapours or humidity which could enter the inverter and cause serious damage.
- ✓ Keep working area clean and tidy and free from unrelated materials. Also ensure the working area has adequate lighting.
- ❑ **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 the workpiece is correctly secured before operating the inverter.
- ✓ Avoid unintentional contact with workpiece. Accidental or uncontrolled switching on of the torch may be dangerous and will cause the nozzle to wear.
- ✓ Keep unauthorised persons away from the working area, and any persons working within the area must wear the same protective items as the user.
- ✓ Operators must receive adequate training before using the inverter. The inverter must only be operated under supervision.
- ✓ Stand correctly keeping a good footing and balance, ensure the floor is not slippery, and wear non-slip shoes.
- ❑ **WARNING!** When unit is switched off wait for 15 seconds whilst capacitors discharge before opening the case.
- ✓ Turn voltage switch to "0" (off) when not in use.
- ✗ **DO NOT** operate the inverter if it or its cables are damaged.
- ✗ **DO NOT** use welding cables over 10m in length. (Cables should be as short as possible).
- ✗ **DO NOT** attempt to fit any non genuine torches, components, or parts to the inverter unit. To do so may cause damage and will invalidate the warranty.
- ✗ **DO NOT** use any metallic structure which is not part of the work piece as a substitute for the return cable. This may jeopardise results and may be dangerous. Exception: Metallic work bench, but connect as near to weld as possible.
- ✗ **DO NOT** hit the electrode on the workpiece, this may damage the electrode and make strike-up difficult.
- ✗ **DO NOT** get inverter wet or use in damp or wet locations or areas where there is condensation.
- ▲ **DANGER! DO NOT** weld near inflammable materials, solids, liquids, or gases.
- ✗ **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** pull the inverter by the cable, or the torch, and **DO NOT** bend or strain cables, protect from sharp or abrasive items, and **DO NOT** stand on cables or leads. Protect from heat. Long lengths of slack must be gathered & neatly coiled. **DO NOT** place cables where they may endanger
- ✗ **DO NOT** touch the workpiece close to the weld as it will be very hot. Allow to cool.
- ✗ **DO NOT** touch the torch immediately after use. Allow the torch to cool.
- ✗ **DO NOT** operate inverter while under the influence of drugs, alcohol or intoxicating medication, or if fatigued.
- ✓ When not in use store the inverter in a safe, dry, childproof area.

## 2. INTRODUCTION

Fan-cooled AC/DC power supply for pulse TIG and MMA welding applications. Suitable for welding aluminium, magnesium, stainless steel, steel, copper, nickel and titanium. TIG cycle includes post gas and current down-slope regulation. Features regulated high frequency (HF) push-button arc that prevents having to touch the workpiece to start, keeping the tip in good condition for longer. Includes connector for foot pedal when more control is required.

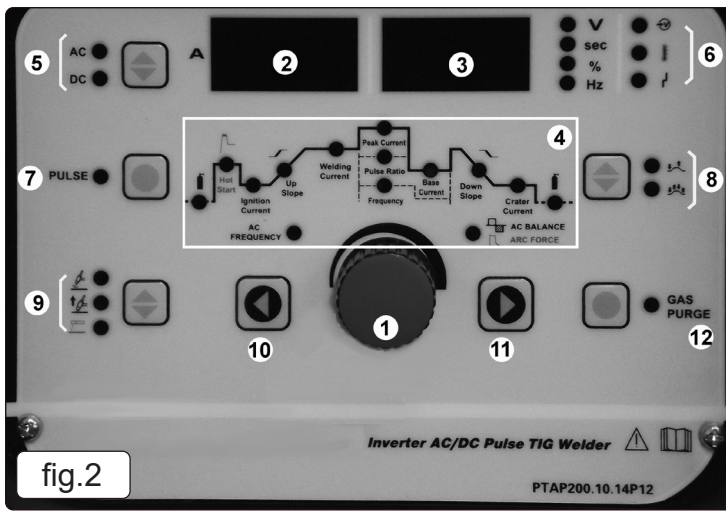
## 3. SPECIFICATION

Model No: ..... TIG200HFACDC.V2  
 Power Output: ..... 10-200A  
 Duty Cycle: ..... 100% @ 77A, 15% @ 200A  
 Electrode Capacity: ..... Ø1.6-4mm  
 Absorbed Power: ..... 8kW  
 Supply: ..... 230V\*

Insulation Class: ..... H  
 Protection: ..... IP21S  
 Accessories: .....  
 Electrode Holder (Optional): ..... MMA01  
 Foot Pedal (Optional): ..... TIG200HFACDCF  
 Note: \*to achieve maximum power a 32A supply may be required.

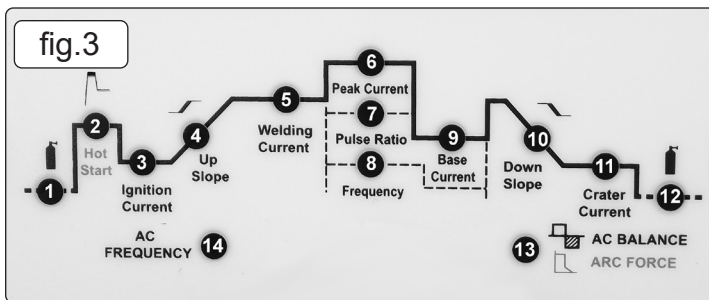
## 4. OPERATION





Key to fig.2

- 1: Adjustment Knob
- 2: Current Display
- 3: Voltage Display
- 4: Procedure Parameters (see fig.3)
- 5: AC/DC Selector
- 6: Status Indicator
- 7: Pulse Selector
- 8: Trigger Mode Selector
- 9: Welding Mode Selector
- 10: Parameter Minus Selector
- 11: Parameter Plus Selector
- 12: Gas Check Selector



Key to fig.3

- 1: Pre-flow time indicator
- 2: Hot Start Current Indicator (MMA)
- 3: Arc Starting Current Indicator (4T)
- 4: Uphill Time Indicator (4T)
- 5: Welding Current Indicator (CC)
- 6: Peak Current Indicator (Pulse)
- 7: Pulse Width Indicator (Pulse)
- 8: Pulse Frequency Indicator (Pulse)
- 9: Background Current Indicator (Pulse)
- 10: Minus Grade Time Indicator (4T)
- 11: Arc Stopping Current Indicator (4T)
- 12: Gas Delay Time Indicator
- 13: Clear Area Width (ACTIG) / Arc Force (MMA)
- 14: AC Frequency (ACTIG)

#### 4.1. LEAD CONNECTION

MMA Mode: Connect the electrode holder to the Positive (+) connector (fig.1.3) and the earth lead to the Negative (-) connector (fig.1.4).  
TIG Mode: Connect the earth clamp to the Positive (+) connector and the TIG torch to the negative (-) connector.


#### 4.2. GAS CONNECTION

- 4.2.1. Using the clear tubing supplied connect the regulator to the gas inlet on the back of the inverter (fig.1.2) and gas outlet on the front (fig.1.6). Secure the tubing on each connector by using the worm drive clamps supplied.
- 4.2.2. Open the regulator before opening the cylinder valve. Test for leaks.
- 4.2.3. Set the gas flow to suit the welding parameters required.
- 4.2.4. If necessary the gas flow can be adjusted during welding using the regulator knob.



#### 4.3. CONTROL CONNECTION

- 4.3.1. If using the torch trigger, connect the control plug from the lead assembly into the control connection (fig.1.5).
- 4.3.2. OPTIONAL PEDAL CURRENT CONTROL (TIG200HFACDCF). Connect the plug from the control pedal to the control connector (fig.1.5), Leave the lead from the lead assembly hanging loose.



#### 4.4. MMA: DC STICK ARC WELDING

- 4.4.1. Using the Up and Down keys, set the welding mode selector (fig.2.9) to  the welding current may be adjusted by means of the adjustment knob (fig.2.1).
- 4.4.2. The hot start current (fig.3.2) and arc force current only (fig.3.13) can be adjusted in this mode to match the material being welded. To select the parameter use the parameter selectors (figs.2.10 & 2.11) to cycle between functions. The value may be adjusted using the adjustment knob (fig.2.1).

#### 4.5. DC TIG WELDING

- 4.5.1. Using the Up and Down keys, set the welding mode selector (fig.2.9) to  for high frequency start or  for lift start.
- 4.5.2. Switch the AC/DC selector (fig.2.5) to DC.
- 4.5.3. The pre-flow time (fig.3.1), welding current (fig.3.5) and gas delay time indicator (fig.3.12) may be adjusted in this mode.
- 4.5.4. To select the parameter use the parameter selectors (figs.2.10 & 2.11) to cycle between functions. The value may be adjusted using the adjustment knob (fig.2.1).
- 4.5.5. 2 or 4 touch trigger control may be selected by using the trigger mode selector (fig.2.8).  
2 touch allows the power to be applied whilst the trigger is pressed.  
4 touch latches the trigger until the pressed for a second time.  
The 4 touch mode is useful for long runs of weld, saving operator fatigue and allowing a steadier weld. In this mode the power will be applied until the selected down slope time has elapsed

#### 4.6. DC PULSE TIG WELDING



- 4.6.1. Using the Up and Down keys, set the welding mode selector (fig.2.9) to  for high frequency start or  for lift start.
- 4.6.2. Switch the AC/DC selector to (fig.2.5) DC.
- 4.6.3. The pre-flow time (fig.3.1), pulse peak current (fig.3.6), pulse width (fig.3.7), pulse frequency (fig.3.8), pulse background current (fig.3.9) and gas delay time (fig.3.12) may all be adjusted in this mode.
- 4.6.4. To select the parameter use the parameter selectors (figs.2.10 & 2.11) to cycle between functions. The value may be adjusted using the adjustment knob (fig.2.1).

#### 4.7. AC TIG WELDING

- 4.7.1. Using the Up and Down keys, set the welding mode selector (fig.2.9) to  for high frequency start or  for lift start.
- 4.7.2. Switch the AC/DC selector (fig.2.5) to AC.

- 4.7.3. The pre-flow time (fig.3.1), welding current (fig.3.5), gas delay time (fig.3.12), clear area width (fig.3.13) and AC frequency (fig.3.14) may all be adjusted in this mode.
- 4.7.4. To select the parameter use the parameter selectors (figs.2.10 & 2.11) to cycle between functions. The value may be adjusted using the adjustment knob (fig.2.1).
- 4.7.5. Choose 2 or 4 touch control (see section 4.5.5).

**4.8. AC PULSE TIG WELDING**

- 4.8.1. Using the Up and Down keys, set the welding mode selector (fig.2.9) to  for high frequency start or  for lift start.
- 4.8.2. Switch the AC/DC selector (fig.2.5.) to AC.
- 4.8.3. Select pulse by using the pulse selector (fig.2.7).
- 4.8.4. The pre-flow time (fig.3.1), pulse peak current (fig.3.6), pulse width (fig.3.7), pulse frequency (fig.3.8), pulse background current (fig.3.9), gas delay time (fig.3.12), clear area width (fig.3.13) and AC frequency (fig.3.14) may all be adjusted in this mode.
- 4.8.5. To select the parameter use the parameter selectors (figs.2.10 & 2.11) to cycle between functions. The value may be adjusted using the adjustment knob (fig.2.1).
- 4.8.6. Choose 2 or 4 touch control (see section 4.5.5).

**4.9. GAS CHECK FUNCTION**

To check that the gas supply is working correctly, press the gas check selector (fig.2.12). This function also releases the pressure in the gas line after turning the regulator off before disconnecting.

**4.10. STATUS INDICATOR**

From the top the status indicator lights denote:  
 Power On  
 Over Temperature Indicator (If this shows, allow the welder to cool down before continuing).  
 High/Low Voltage

**5. MAINTENANCE**

**▲ DANGER! Unplug the inverter from the mains power supply before connecting or disconnecting cables or performing maintenance or service. Direct contact with the inverter circuit is dangerous.**

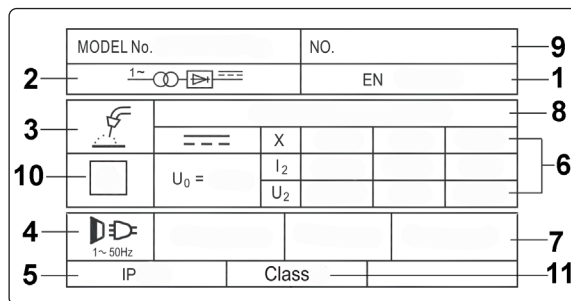
- 5.1. To avoid a build up of dust inside the machine which may block or restrict the ventilation system, periodically remove the covers and remove the dust with a low pressure air jet or vacuum cleaner. Replace covers immediately. Under no circumstances should the machine be operated with the covers removed.
- 5.2. TORCH. Avoid resting the torch and its associated cable on any hot surfaces. If the insulation is damaged in any way the torch must not be used.
- 5.3. Periodically check the condition of the gas tubing and the connections.

**6. RATINGS PLATE SYMBOLS**

6.1. Detailed technical data relative to the performance of the machine is located on the back panel plate. **Please note** that the ratings plate shown below is an example only intended to assist with the explanations of symbols. To determine the correct technical values of the machine in your possession, you must refer to the data plate.

6.2. On the rear of the inverter 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 - Inverter-transformer-rectifier symbols.
- 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<sub>0</sub>: Maximum open-circuit voltage.  
 I<sub>2</sub>, U<sub>2</sub>: 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<sub>1</sub>: Rated supply voltage and frequency.  
 I<sub>1max</sub>: Maximum current. I<sub>1eff</sub>: Maximum effective current.
- 8 - A/V - A/V: Welding current adjustment range and corresponding voltages.
- 9 - Serial Number. Specifically identifies each welder.
- 10 - Symbol for welding power sources which are suitable for supplying power to welding operations carried out in an environment with increased risk of electric shock (if applicable).
- 11 - Insulation Class.





#### 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.



#### 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](mailto: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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