

SifWELD®



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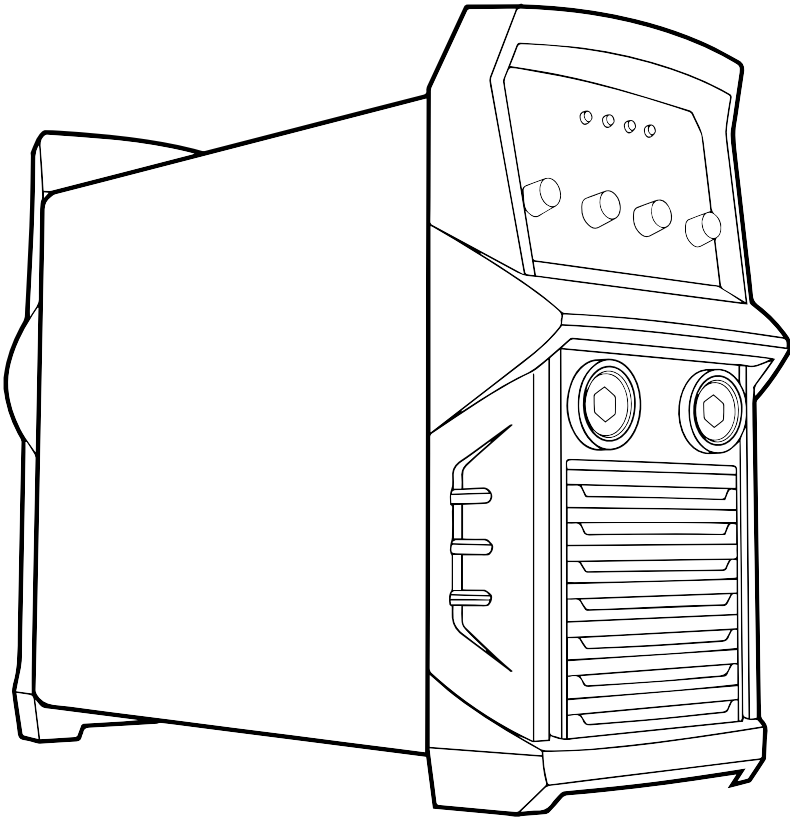


SifWeld MTS250

CE
Approved



Operation Manual



TSX1D250MTS

DECLARATION OF CONFORMITY

The Low voltage Directive 2006/95/EC of 12 December 2006, entering into force 16 January 2007
The EMC Directive 2004/108/EC, entering into force 20 July 2007
The RoSH Directive 2011/65/EC, entering into force 2 January 2013

Type of Equipment

Welding power source for MIG/MAG, TIG/TAG, MMA welding

Brand name or trade mark

SifWeld®

Type designation etc.

MTS250

Manufacturer or his authorised representative established within the EEA Name, address, telephone no, fax no

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The following harmonised standard in force with the EEA has been used in the design:

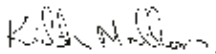
EN60974-1- Arc welding equipment- Part 1: Welding power sources
EN60974-10 Arc welding equipment - Part 10: Electromagnetic Compatibility (EMC) requirements

Additional information: restrictive use, Class A equipment, intended for use in locations other than residential

By signing this document, the undersigned declares as manufacturer, or the manufacturer's authorised representative established within the EEA, that the equipment in question complies with the safety requirements stated above.

Place and Date
Letchworth, UK
01-04-2015

Signature



Keith Mullan

Position
Quality Manager
Weldability Sif

WEEE Directive & Product Disposal

At the end of its serviceable life, this product should not be treated as household or general waste. It should be handed over to the applicable collection point for the recycling of electrical and electronic equipment, or returned to the supplier for disposal.



Safety Guidelines

These general safety norms cover both arc welding machines and plasma cutting machines unless otherwise noted. The equipment must only be used for the purpose it was designed for. Using it in any other way could result in damage or injury and in breach of the safety rules. Only suitably trained and competent persons should use the equipment. Operators should respect the safety of other persons.

Prevention against electric shock

The equipment should be installed by a qualified person and in accordance with current standards in operation. It is the user's responsibility to ensure that the equipment is connected to a suitable power supply. Consult with your utility supplier if required. If earth grounding of the work piece is required, ground it directly with a separate cable. Do not use the equipment with the covers removed. Do not touch live electrical parts or parts which are electrically charged. Turn off all equipment when not in use. Cables (both primary supply and welding) should be regularly checked for damage and overheating. Do not use worn, damaged, under sized or poorly jointed cables. Ensure that you wear the correct protective clothing, gloves, head and eye protection. Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work ground. Never touch the electrode if you are in contact with the work ground, or another electrode from a different machine. Do not wrap cables over your body. Ensure that you take additional safety precautions when you are welding in electrically hazardous conditions such as damp environments, wearing wet clothing, and metal structures. Try to avoid welding in cramped or restricted positions. Ensure that the equipment is well maintained. Repair or replace damaged or defective parts immediately. Carry out any regular maintenance in accordance with the manufacturer's instructions.

Safety against fumes and welding gases

Locate the equipment in a well-ventilated position. Keep your head out of the fumes. Do not breathe the fumes. Ensure the welding zone is in a well-ventilated area. If this is not possible provision should be made for suitable fume extraction. If ventilation is poor, wear an approved respirator. Read and understand the Material Safety Data Sheets (MSDS's) and the manufacturer's instructions for metals, consumable, coatings, cleaners, and de-greasers. Do not weld in locations near any de-greasing, cleaning, or spraying operations. Be aware that heat and rays of the arc can react with vapours to form highly toxic and irritating gases. Do not weld on coated metals, unless the coating is removed from the weld area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings on many metals can give off toxic fumes if welded.

Prevention against burns and radiation

Arc rays from the welding process produce intense, visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Wear an approved welding helmet fitted with a proper shade of filter lens to protect your face and eyes when welding or watching. Wear approved safety glasses with side shields under your helmet. Never use broken or faulty welding helmets. Always ensure there are adequate protective screens or barriers to protect others from flash, glare and sparks from the welding area. Ensure that there are adequate warnings that welding or cutting is taking place.

Wear suitable protective flame resistant clothing. The sparks and spatter from welding, hot work pieces, and hot equipment can cause fires and burns. Welding on closed containers, such as tanks, drums, or pipes, can cause them to explode. Accidental contact of electrode to metal objects can cause arcs, explosion, overheating, or fire. Check and be sure the area is safe and clear of inflammable material before carrying out any welding.

Protection against noise

Some welding and cutting operations may produce noise. Wear safety ear protection to protect your hearing.

Protection from moving parts

When the machine is in operation, keep away from moving parts such as motors and fans. Moving parts, such as the fan, may cut fingers and hands and snag garments. Protections and coverings may be removed for maintenance and controls only by qualified personnel, after first disconnecting the power supply cable. Replace the coverings and protections and close all doors when the intervention is finished, and before starting the equipment. Take care to avoid getting fingers trapped when loading and feeding wire during set up and operation. When feeding wire be careful to avoid pointing it at other people or toward your body. Always ensure machine covers and protective devices are in operation.

Precautions against fire and explosion

Avoid causing fires due to sparks and hot waste or molten metal. Ensure that appropriate fire safety devices are available near the cutting / welding area. Remove all flammable and combustible materials from the cutting / welding zone and surrounding areas. Do not cut/weld fuel and lubricant containers, even if empty. These must be carefully cleaned before they can be cut/welded. Always allow the cut/welded material to cool before touching it or placing it in contact with combustible or flammable material. Do not work in atmospheres with high concentrations of combustible fumes, flammable gases and dust. Always check the work area half an hour after cutting to make sure that no fires have begun

Risks due to magnetic fields

The magnetic fields created by high currents may affect the operation of pacemakers or electronically controlled medical equipment. Wearers of vital electronic equipment should consult their physician before beginning any arc welding, cutting, gouging or spot welding operations. Do not go near welding equipment with any sensitive electronic equipment as the magnetic fields may cause damage.

RF Declaration

Equipment that complies with directive 2004/108/EC concerning electromagnetic compatibility (EMC) and the technical requirements of EN60974-10 is designed for use in industrial buildings and not those for domestic use where electricity is provided via the low voltage public distribution system. Difficulties may arise in assuring class A electromagnetic compatibility for systems installed in domestic locations due to conducted and radiated emissions. In the case of electromagnetic problems, it is the responsibility of the user to resolve the situation. It may be necessary to shield the equipment and fit suitable filters on the mains supply.

LF Declaration

Consult the data plate on the equipment for the power supply requirements. Due to the elevated absorbency of the primary current from the power supply network, high power systems affect the quality of power provided by the network. Consequently, connection restrictions or maximum impedance requirements permitted by the network at the public network connection point must be applied to these systems. In this case the installer or the user is responsible for ensuring the equipment can be connected, consulting the electricity provider if necessary.

Materials and their disposal

The equipment is manufactured with materials, which do not contain any toxic or poisonous materials dangerous to the operator. When the equipment is scrapped, it should be dismantled separating components according to the type of materials. Do not dispose of the equipment with normal waste. The European Directive 2002/96/EC on Waste Electrical and Electronic Equipment states the electrical equipment that has reached its end of life must be collected separately and returned to an environmentally compatible recycling facility.

Handling of Compressed gas cylinders and regulators

All cylinders and pressure regulators used in welding operations should be handled with care. Never allow the electrode, electrode holder or any other electrically "hot" parts to touch a cylinder. Keep your head and face away from the cylinder valve outlet when opening the cylinder valve. Always secure the cylinder safely. Never deface or alter any cylinder.



The following signs and explanations are to remind the user of the potential risks involved and the dangers of misuse or mistreatment of the welding machine.



RUNNING PARTS MAY BE DANGEROUS!
Keep away from running components, including the fan.



ELECTRIC SHOCKS CAN KILL!
Never touch electrical parts. Keep the equipment in good condition, replace damaged parts, undertake regular maintenance according to the instructions.



BE AWARE OF SPARKS AND SPATTER
Wear protective clothing, such as leather gloves, Flame retardant overalls, boots and eyewear.



DO NOT TOUCH THERMAL COMPONENTS!
Thermal components may cause severe burns when in contact with unprotected skin.

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1. Preface

1.1 General

Congratulations on choosing your SifWeld MTS250 Compact welding machine.

Used correctly, SifWeld products can significantly increase the productivity of your welding, and provide years of economical service. This operating manual contains important information on the use, maintenance and safety of your SifWeld product. Please read the manual carefully before using the equipment for the first time. For your own safety and that of your working environment, pay particular attention to the safety instructions in the manual.

For more information on SifWeld products, consult an authorised SifWeld dealer, or visit the SifWeld web site at www.sifweld.com. The specifications presented in this manual are subject to change without prior notice.

Important notes

Items in the manual that require particular attention in order to minimise damage and personal harm are indicated with the '**NOTE!**' notation. Read these sections carefully and follow their instructions.

Disclaimer

While every effort has been made to ensure that the information contained in this guide is accurate and complete, no liability can be accepted for any errors or omissions. We reserve the right to change the specification of the product described at any time without prior notice. Do not copy, record, reproduce or transmit the contents of this guide without prior permission.

1.2 Introduction

The MIG 250 Compact power source is a multi-process power source designed for demanding professional use in Steel, Stainless, Cast Iron, Bronze, Aluminum, Copper welding. The power source has a control panel that allows ready control of the functions of the power source and the wire feeder.

The MIG 250 Compact power source is inverter-based MIG welding machines with added MMA and TIG function. These are industrial machine equipped with an integrated 4 roll gear driven wire feeder. The MIG function allows you to weld with Solid wires, Flux-cored Gas and Gasless wires. The Mig 250 Compact an inverter power source that can provide MIG, MMA and gas less self- shielded welding options.

Its IGBT power device with unique control mode provides excellent reliability with a high duty cycle. The system has a closed loop feedback control, constant voltage output, which allows it to operate with a wide tolerance to mains fluctuation, within $\pm 15\%$.

It has continuously adjustable welding voltage and current, to provide excellent welding characteristics. Adopting a unique welding dynamic characteristic control circuit in MIG, provides a stable arc, low spatter, excellent weld appearance and high welding efficiency.

By removing the ball at the end of the wire after welding, a high no-load voltage, and slow wire feed at the start presents exceptional arc starting.

The machine also has a very stable welding current in MMA, excellent arc ignition, and can be used with a wide variety of welding electrodes.

Features

- Innovative IGBT Inverter Technology
- MIG/Mag with Gas and Gasless wire function
- Stick Electrode (MMA) Function
- DC TIG welding with scratch start
- Burn Back Controls
- Gas Check / Inch Wire
- Separate 4 Roll Geared Wire Feeder
- LED Digital Display
- Euro MIG torch connection
- Excellent arc stability for MIG/TIG/MMA welding with minimal spatter
- High duty cycle
- Suitable for 0.6 to 1.0 mm wires
- Spool gun interface

1.3 Technical Specifications

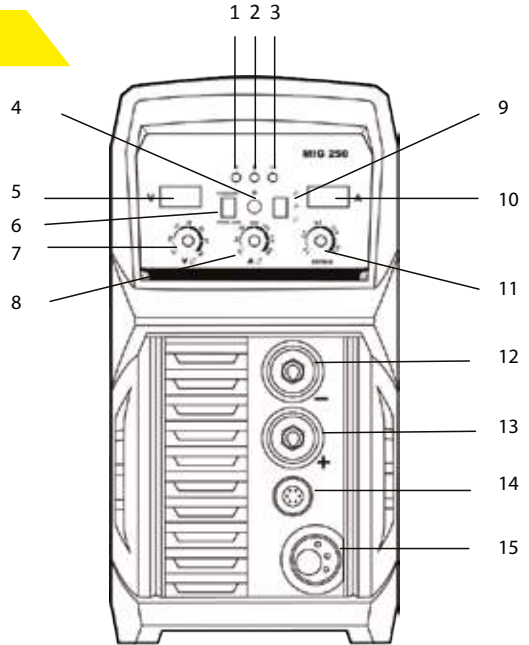
SifWeld MTS250	MIG	MMA
Power voltage (V)	1 ph 230/240v	
Rated duty cycle	250Amps @ 35%	
	150Amps @ 100%	
Rated power MIG	12.8 KVA	
I Max	45.0Amps	51.0Amps
I eff	26.6Amps	28.0Amps
Wire feed type	Gear Driven 4 Roll	
Protection class	IP21S	
Insulation class	F	
Dimensions (Power source) mm	550 x 290 x 680	
Weight (Power source) kg	35	
Dimensions (Air cooled package) mm	810 x 510 x 1110	
Weight (Air cooled package) kg	78	

1.4 Overview of Machine

Front View

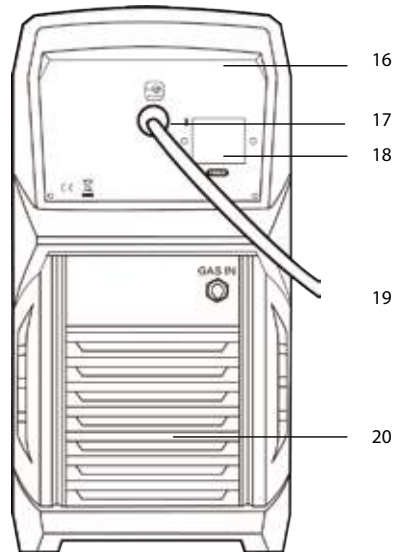
Power Source Front Panel Layout

1. Power LED
2. Overheating LED
3. VRD LED
4. Wire Inching Button
5. Voltage meter
6. Standard Mig / Spoolgun Switch
7. Voltage control knob in MIG
8. Current control knob in MMA
9. MMA/TIG/MIG switch
10. Current meter
11. Wire feed control knob in MIG
12. "-“ output terminal
13. "+“ output terminal
14. Socket of wire pull torch control cable
15. Euro connector of the welding torch in MIG



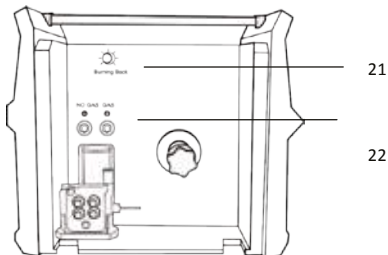
Rear View

16. Rating Plate
17. Input cable
18. Power switch
19. Gas solenoid inlet fitting
20. Fan



Inside View

21. Burnback Knob
22. No Gas/Gas Socket



2. Installation

Unpacking

Check the packaging for any signs of damage. Carefully remove the machine and retain the packaging until the installation is complete.

Location

The machine should be located in a suitable position and environment. Care should be taken to avoid moisture, dust, steam, oil or corrosive gases. Place on a secure level surface and ensure that there is adequate clearance around the machine to ensure natural airflow.

Input connection

Before connecting the machine you should ensure that the correct supply is available. Details of the machine requirements can be found on the data plate of the machine or in the technical parameters shown in the manual. The equipment should be connected by a suitably qualified competent person. Always ensure the equipment has a proper grounding. Never connect the machine to the mains supply with the panels removed.

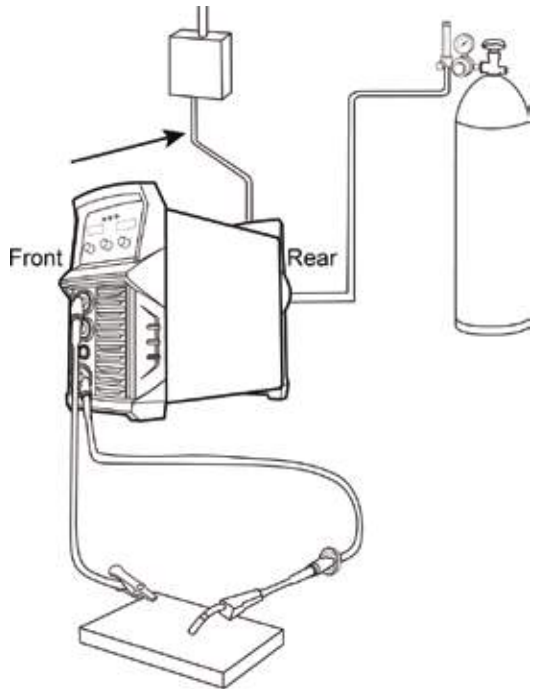
Output connections

In general when using manual arc welding electrodes the electrode holder is connected to the positive terminal and the work return to the negative terminal. Always consult the electrode manufacturer's data sheet if you have any doubts. When using the machine for TIG welding the TIG torch should be connected to the negative terminal and the work return to the positive terminal.

MIG Welding

Insert the welding torch into the MIG torch Euro connector output socket on the front panel of the machine, and tighten it. Install the wire spool on the spindle adapter. Connect the cylinder equipped with the gas regulator to the gas inlet on the back panel of the machine with a gas hose. Insert the cable plug with work clamp into the “-” output terminal on the front panel of the welding machine, and tighten it clockwise.

Insert the quick plug of the gas / no gas selector into the “+” output terminal of the welding machine, and tighten it clockwise. Ensure that the groove size in the feeding position on the drive roll matches the contact tip size of the welding torch and the wire size being used. Release the pressure arm of the wire feeder to thread the wire through the guide tube, and into the drive roll groove. Adjust the pressure arm, ensuring no sliding of the wire. Too high pressure will lead to wire distortion, which will affect wire feeding. Press the wire inch button to thread the wire out of the torch contact tip.

**Gas less Self Shielded Welding**

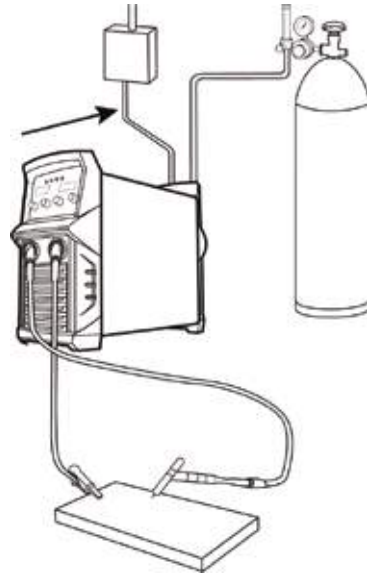
Insert the welding torch into the “Euro connector for torch in MIG” output socket on the front panel of the machine, and tighten it. Insert the cable plug with work clamp into the “+” output terminal on the front panel of the welding machine, and tighten it clockwise. Insert the quick plug of the gas / no gas selector into the “-” output terminal on the middle plate of the welding machine, and tighten it clockwise.

Install the wire spool on the spindle adapter, ensuring that the groove size in the feeding position on the drive roll matches the contact tip size of the welding torch and the wire size being used. Release the pressure arm of the wire feeder to thread the wire through the guide tube, and into the drive roll groove. Adjust the pressure arm, ensuring no sliding of the wire. Too high pressure will lead to wire distortion, which will affect wire feeding. Press the wire inch button to thread the wire out of the torch contact tip.

TIG Welding

Insert the cable plug with the work clamp into the "+" socket on the front panel of the welding machine, and tighten it clockwise. Insert the cables plug of the TIG torch into the "-" socket on the front panel of the machine and tighten clockwise.

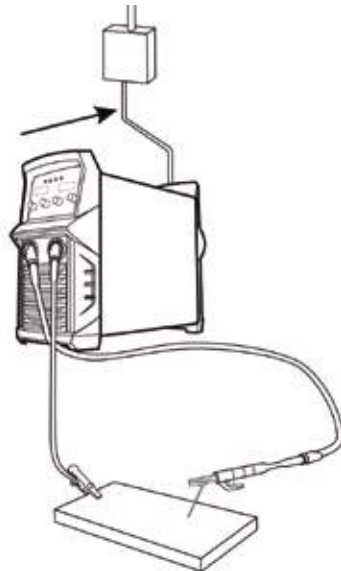
Connect the gas hose to the regulator / flow meter located on the shield gas cylinder and connect the other end to the machine. Open the valve on the TIG torch and "scratch" the electrode on the work piece to start the arc.



MMA welding

Insert the cable plug with electrode holder into the "+" socket on the front panel of the welding machine, and tighten it clockwise.

Insert the cable plug of the work return lead into the "-" socket on the front panel of the welding machine, and tighten it clockwise.



3. Operation

Before starting any welding activity ensure that you have suitable eye protection and protective clothing. Also take the necessary steps to protect any persons within the area.

MMA

After connecting the welding leads as detailed you will need to switch the power switch on the back panel to "ON" Select MMA by switching to the MMA welding mode. There is voltage output at both output terminals. Set the amperage on the machine suitable for the electrode being used. Ensure you check that you have the electrode polarity correct. Please see below a guide to amperages required.

Electrode Diameter (mm)	Welding Current (A)	Electrode Diameter (mm)	Welding Current (A)
1.0	20~60	3.2	108~148
1.6	40~84	4.0	140~180
2.0	60~100	5.0	180~220
2.5	80~120	6.0	220~260

MIG/MAG

Connect the MIG torch leads as detailed above. Ensure that a suitable inert gas supply is connected. Switch the power switch on the back panel to "ON", the machine is started with the power LED on and the fan working. Switch the MMA/MIG switch to MIG mode. Select pull position if using a remote torch

Open the gas valve of the cylinder, and adjust the gas regulator to obtain the desired flow rate. Adjust the "voltage control knob in MIG" and "wire feed speed control knob in MIG" on the front panel of the machine to get the correct welding voltage and welding current. Operate the torch trigger, and welding can be carried out. Where required adjust the burn-back time potentiometer (above the feed unit inside the machine) to get the proper electrode stick-out. One second after the arc stops, the gas supply will be cut off.

Gas selection

Metal inert gas welding (MIG): Uses Argon (Ar), Helium (He) or Ar-He mixtures as the shield gas, and it mainly used for welding aluminium and its alloys. Metal active gas welding (MAG): Uses Argon (Ar) mixed with a certain amount of CO₂ / O₂ as the shield gas, and it usually used in short circuit transfer and spray transfer. It can be applicable to flat position welding, vertical position welding, overhead position welding and all-position welding, and it mainly used for welding carbon steel, high strength low alloy steel and stainless steel. Welding robots mostly use the MAG process. CO₂ (carbon dioxide) gas shielded arc welding (CO₂ welding): It uses CO₂ as the shield gas, and is usually used in globular transfer and short circuit transfer to implement welding. It can be used to weld in different positions. As compared with other welding methods, CO₂ welding has many advantages, though it produces more spatters, CO₂ welding is widely used for general metal structure welding.

1) Welding current setting

Set the welding current after the above preparation. Short circuiting transfer is mainly fit for electrode wires of diameter 0.6~1.2mm. As a guide for short circuit welding set the welding current according to the table below.

Wire Diameter (mm)	Welding Current Range (A)	Optimal Current (A)
0.8	50~120	70~100
1.0	70~180	80~120
1.2	80~350	100~200

2) Welding speed selecting

The welding quality and productivity should be taken into consideration for the selecting of welding speed. In the case that the welding speed increases, it weakens the protection effect and quickens the cooling. As a consequence, it is not good for weld bead shaping. In the event that the speed is too slow, the work-piece will be burned through, and a good weld bead will be unavailable. In practical operation, the welding speed should not exceed 50cm/min.

3) Wire Stick-out

The increase of the stick-out can improve the productivity, but too long stick-out may lead to excessive spatter, wire breaking and unstable welding. Generally, the stick-out should be 10 times as the welding wire diameter.

4) Shield gas flow selection

The protection effect is the primary consideration. Besides, the protection effect of inner-angle welding is better than that of external-angel welding, so the gas flow in inner-angle welding should be lower. Less or no shield gas is needed in FCAW. Refer to the table below for the recommended gas flow rates.

Welding Mode	Welding with thin wire	Welding with thick wire	Welding with thick wire under high current
Gas Flow (L/m)	5~15	15~20	20~2

4. Troubleshooting

In the event of a failure of the machine, contact an authorised SifWeld service agent. The following operation requires sufficient professional knowledge on electric aspects and comprehensive safety knowledge. Make sure the input cable of the machine is disconnected from the electricity supply and wait for 5 minutes before removing the machine covers before taking your unit for servicing, check the list below.

The overheat LED is on.

- Check the welding current and welding time. Refer to the manual, and operate accordingly
- Check the running status of the fan when welding. If the fan does not work, check if the power supply of the fan is 230V: If the power supply is normal, check the fan; if the power supply is abnormal, check the connecting cable of the power supply.
- Replace the thermal switch if it is damaged or faulty.

The power LED is off, and there is no output current.

- Check if the fan works. If it does not work, it indicates that the power supply is not present. Check any fuses cables and supply switches.
- If the fan works, it indicates that the control PCB PK-63 inside the machine may be defective.

There is no response when operating the torch trigger, and the protection LED is off.

- Check if the torch trigger is working.
- Check if the welding torch is well connected to the Euro connector, and check the connections of the Euro connector.
- The control PCB PK-63 inside the machine may be defective.

The wire feeder feeds wire when operating the torch trigger, gas feeds, but there is no output current, and the protection LED is off.

- Check if the work return connected to the workpiece is in good condition.
- Check if the quick plug is connected to correct quick socket.
- Check if the euro connector is intact.
- Check the welding torch for damage.
- The control PCB PK-63 inside the machine may be defective.

There is output current when operating the torch trigger to feed gas, but the wire feeder does not feed wire.

- Check the wire feeder for clogging or damage.
- Check the contact tip of welding torch for clogging or damage.
- The control PCB PK-63 inside the machine may be defective.

Welding can be carried out when pushing the torch trigger, but the voltage cannot be adjusted.

- Check if the voltage feedback wire inside the machine is in good condition.
- The control PCB PK-63 inside the machine may be defective.

5. Maintenance

The utilisation level of the power source and its working environment should be taken into consideration in planning the frequency of maintenance of the machine. Appropriate use and preventive maintenance guarantee the trouble-free use of the equipment. This allows you to avoid interruptions in use and increases the productivity of the machine.

5.1 Cables

Check the condition of welding and mains cables daily. Do not use damaged cables. Also make sure that all extension cables used in the mains connection are in proper condition and compliant with regulations.

NOTE! The mains cables may be repaired and installed only by electrical contractors and installers authorised to perform such operations.

5.2 Power source

Before cleaning the interior of the machine, you need to remove the case by unscrewing the mounting screws at the top and sides of the machine.

NOTE! To prevent damage, wait approximately two minutes after disconnecting the mains cable before removing the machine's case. Perform the following cleaning and maintenance at least every six months:

1. Clean the interior of the machine and the fan grills net of any dust and stains – for example, with a soft brush and vacuum cleaner.
 - Do not use pressurised air. The stain may become compressed into the grooves of the coolers.
 - Do not use a pressure-washing device.
2. Check the electrical connections of the machine. Clean any oxidised connections, and tighten the loosened ones.
 - Check for the right tension before you start repairing the connections.

NOTE! Remember that the machine may be repaired only by an electrical contractor or installer authorised to perform such operations.

5.3 Regular maintenance

Authorised service agents perform regular maintenance by agreement. Tasks included in regular maintenance:

- Cleaning of equipment.
- Inspection and maintenance of the welding gun.
- Checking of connectors, switches, and control knobs.
- Checking of electrical connections.
- Checking of the mains cable and plug.
- Replacement of damaged or worn parts.
- Calibration testing, with adjustment of the functions and operational values of the machine, if necessary.

6. Warranty

Weldability Sif warrants its customers that all new SifWeld manual welding and cutting equipment purchased shall be free of failure from defective materials or production for a period of 2 Years from the date of purchase.

This warranty period can be extended to 5 Years from the date of purchase (including the standard warranty period) for customers in the United Kingdom and Republic Of Ireland; or to 3 Years from date of purchase for customers in all other countries, subject to registration of the product at www.sifweld.com within the first year of purchase, and undergoing annual preventative maintenance servicing with effect from the second year of ownership.

All warranty periods start from the date of purchase from Weldability Sif or an approved SifWeld distributor to the original end user. The date on the sales invoice is considered the date of purchase for the purpose of the warranty period, or the date of manufacture is used if proof of purchase is not available. Equipment is warranted to the original owner/user customer, and is not transferable.

Subject to the underlying purchase contract, or, failing such, the Weldability Sif general terms and conditions of sale, both the cost of replacement parts and Weldability Sif's labour expense in correcting defects covered by the warranty, will be assumed by Weldability Sif during the warranty period. Weldability Sif shall in no event be responsible for any direct or indirect damages, third party expenses, as well as any loss of income/revenue, all of which are specifically excluded under this warranty.

The warranty does not cover : Any defects resulting from normal wear and tear; Improper use; Failure to observe the operating and maintenance instructions; Connection to an incorrect or faulty mains supply; Overloading during use; Any transport or storage damage; External damage such as fire, impact or damage due to natural causes, e.g flooding; Use of unapproved spare or wear parts or replacement parts not supplied by or approved by Weldability Sif; Any modification or alteration of the equipment; or any other circumstances beyond the control of Weldability Sif. The warranty period is based on a single 8-hour 5-day shift pattern and the extended warranty is not applicable to units that are purchased for rental or hire. Weldability Sif will submit an invoice for any repair work performed outside the scope of the warranty.

Any warranty repair must be performed by Weldability Sif or an Authorised SifWeld Service Centre. The customer is responsible for all shipping costs and risk associated with items that are returned covered under warranty. Weldability Sif may opt to refund the purchase price (less any costs and depreciation due to use and wear). Faults/defects found under warranty should be reported to the Weldability Sif Technical team for review. A warranty claim reference number will be issued and details of the most appropriate Authorised SifWeld Service Centre will be advised, if appropriate. The customer has no claim to any loan or replacement products whilst repairs are being performed or replacements are being provided.

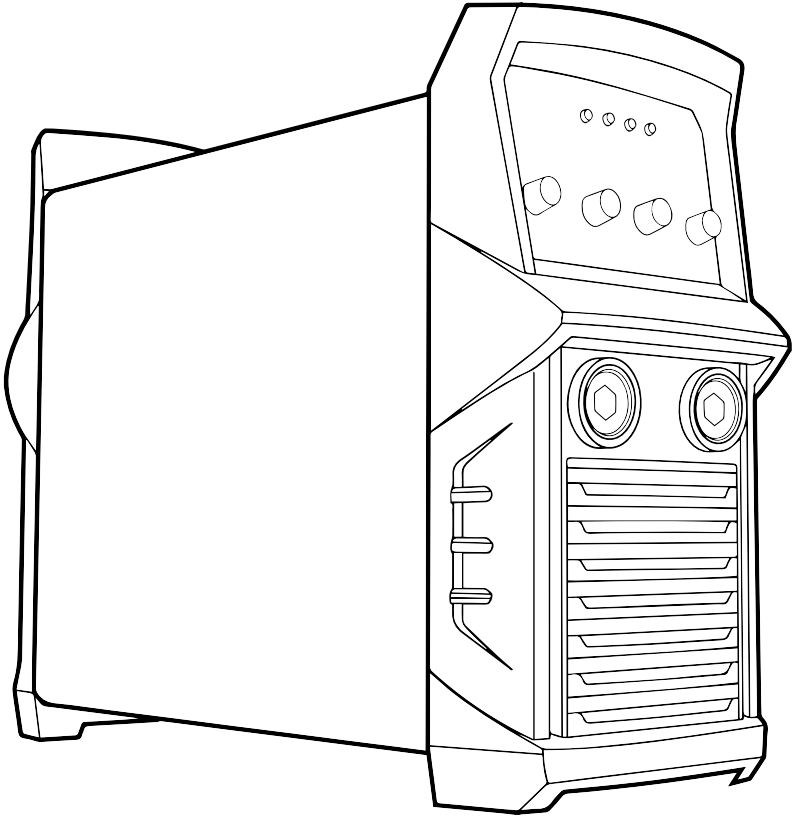
The decision about repair or replacement of any defective part(s) is made by Weldability Sif. The replaced part(s) remain(s) property of Weldability Sif. The warranty extends only to the machine power-source, wire-feed unit and parts contained inside. No other warranty is expressed or implied, including with regard to the fitness of the equipment for any particular application.

Under the terms of the warranty, welding torches, their consumable parts, wire-feed drive-rolls and guide tubes, work return cables and clamps, electrode holders, connection and extension cables, mains and control leads, plugs, wheels, coolant, etc. are not covered.

The extended warranty is only valid where products have been used strictly in accordance with the operating instructions, all installation guidelines have been implemented, all legal requirements have been observed, regular preventative maintenance has been undertaken and a continuous history of annual servicing has been completed and recorded. Failure to register the equipment online within 1 year of purchase, or to complete the required annual servicing cycle from year 2, will invalidate the extended warranty period.

Annual preventative maintenance servicing must be arranged and paid-for by the equipment owner/user and carried out by Weldability Sif or an Authorised SifWeld Service Centre, in order to maintain validity of the extended warranty. Service visits can be booked online at www.sifweld.com or by calling 0870 330 7757 and will be charged at an average of £65 net per hour of travel/ servicing time. Please allow an average of 2 hours servicing per machine and one hour each way of travel.

Warranty support is facilitated by our network of Authorised SifWeld Service Centres that provide highly experienced capability and carry-out the professional repair, service and calibration of SifWeld equipment.



Weldability **sif**

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