

Thank you for choosing Super Weiye Handheld Welding Wire Feeding System. This user manual provides you with important safety, operation, maintenance and other information. Therefore, please read this user manual carefully before using this product.

In order to ensure safe operation and optimal operation of the product, please observe the following cautions and warnings and other information in this manual.

## I. Overview

This manual covers the basic installation, factory setting, operation and maintenance service of this welding wire feed product and a general description of each link.

The super welding wire feeding system is a wire feeding system launched in 2019. The product covers the independent research and development control system, and is equipped with the function of withdrawing and filling the wire. This product can be adapted to various handheld welding wire feeding systems

### 1.1 Operating environment and parameters

Supply voltage (V)	220±10%VAC50/60Hz
Place the environment	Flat, no vibration and shock
Working environment temperature (°C)	10~40
Working environment humidity (%)	<70
Maximum support wire weight	25KG
Maximum support for wire feeding wire warp	2.0mm

### 1.2 Attention information

- 1) Ensure reliable grounding before supplying power.
- 2) The wire feed wheel matches the wire warp and corresponds to the wire feed tube
- 3) Don't twist the wire feed tube

## 2. Installation

### 2.1 General definition of circuit wiring

2.1.1 The whole machine provides a three-core aviation plug, which is connected to the three-core aviation plug at the tail of the wire feeder and provides 220V power supply

2.1.2 The whole machine provides a two-core aviation plug, which is connected to the wire feeding port of the control system to provide wire feeding signal (passive contact, short-circuited wire feeding)

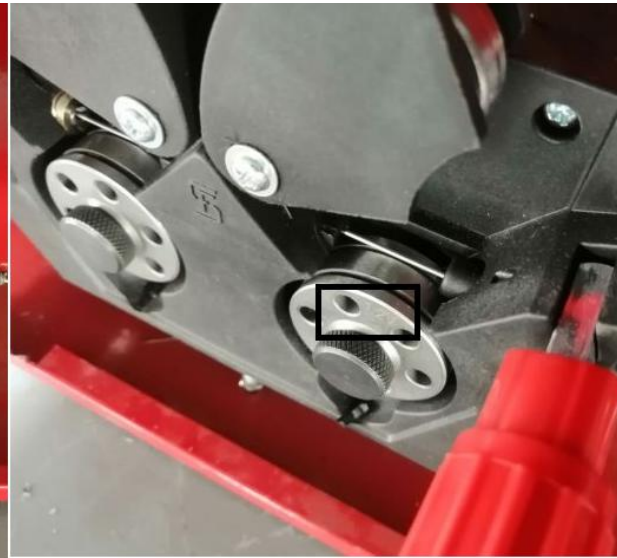
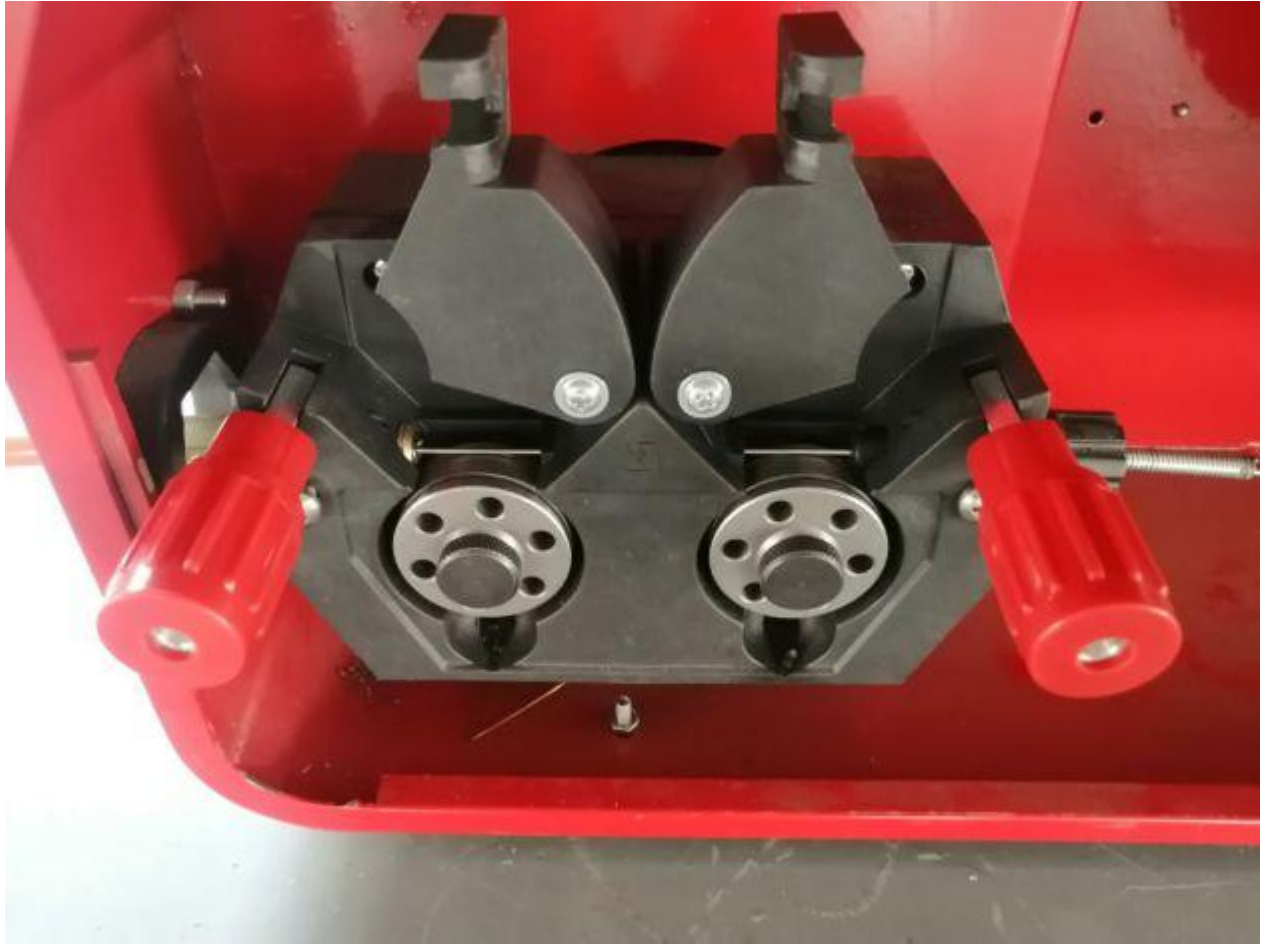
## 2.2 Installation of wire reel

1. The welding wire is ordinary welding wire, the common ones can be installed from 5KG-30KG, but do not use flux-cored welding wire
2. Adjust the strength of the roller through the inner hexagon, so that it is not too tight or too loose, and there is no jam when feeding the wire (normally it is not necessary to adjust)
3. Cover the cap after adjustment



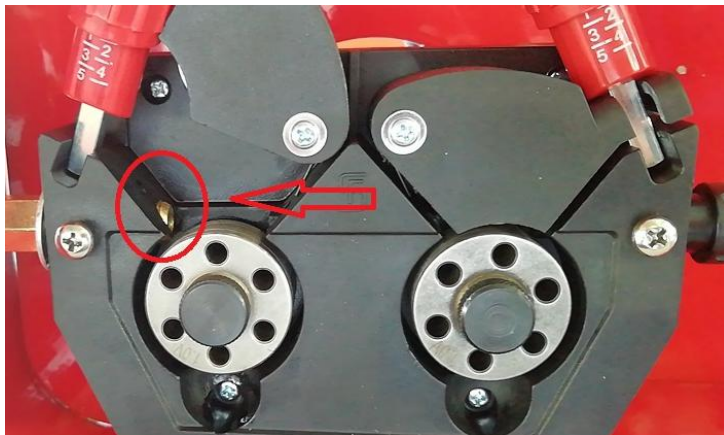
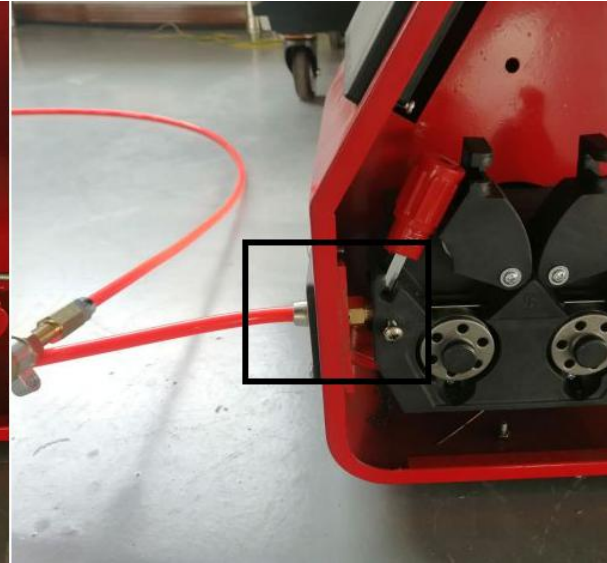
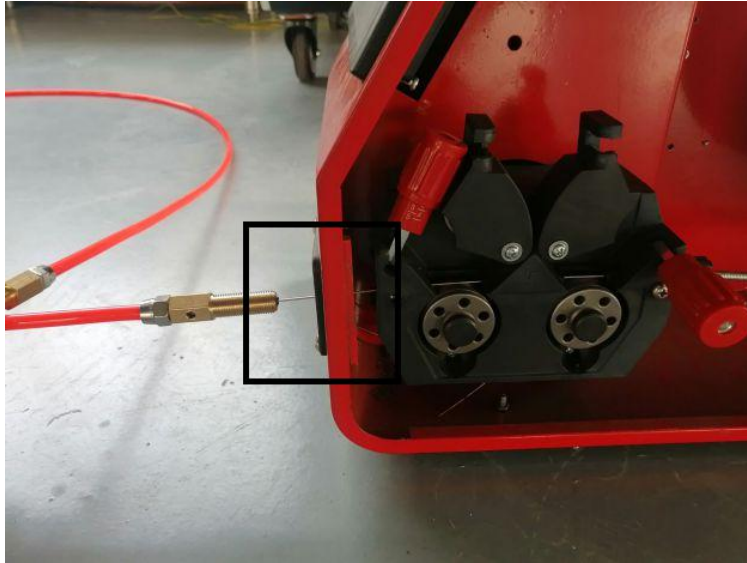
## 2. Installation of wire feed wheel

1. There are two wire feed wheels, with different models on both sides, corresponding to different core diameters, **Be sure to install it accordingly. If 1.2 welding wire is installed, the side with the 1.2 mark on the wire feed wheel is on the outside**
2. When installing, be sure to clamp the welding wire in the slot and then clamp



### 3. Installation of wire feeding tube

1. After putting the wire into the wire feeding tube, insert it into a suitable position. If it is too short, it may cause wire jamming. Then tighten the screw.
2. When installing the wire feed tube, first remove the copper nozzle at one end, And match the corresponding copper mouth







## 5. Operation panel

1. The numerical value on the homepage shows the wire feeding speed, which can be adjusted by the up and down keys. Please keep it running when using it
2. Manual wire feeding: After pressing and holding, the wire feeder starts to feed the wire, and the manual wire feeding speed depends on the background setting
3. Manual withdrawal: After pressing and holding, the wire feeder starts to withdraw, and the manual withdrawal speed depends on the background setting



4. After all settings on the setting page are completed, click to save
5. The wire feeding speed of the setting page is the default wire feeding speed, that is, after changing here, the power on and off will remain unchanged
6. Start-up delay: not set by default
- 7; Withdrawal length and patch length: set according to actual usage  
When the wire feeding is stopped, the system will first draw back a certain distance and then feed the wire a certain distance. This function is mainly used for wire breakage  
When the wire is still outside at the beginning of each welding, please set the retracted length to be greater than the length of the patch wire



# 激光焊接送丝系统

- 送丝速度  厘米/分钟 ▲ ▼
- 启动延时  毫秒 ▲ ▼
- 回抽长度  毫米 ▲ ▼
- 补丝长度  毫米 ▲ ▼
- 手动送丝速度  厘米/分钟 ▲ ▼
- 手动回抽速度  厘米/分钟 ▲ ▼

