CIGWELD

AN ESAB BRAND

DESIGNED & TESTED IN AUSTRALIA FOR OVER 100 YEARS

BLUEVENOM MG130

GASLESS MIG

SYNERGIC MIG

PLATE THICKNESS

GASLESS MIG WELDER

OPERATING MANUAL

BLUEVENOM MG130, P/N: W1202130

130A	SYNERGIC MIG	230/240V 10A	2 YEAR
POWER	WITH PLATE THICKNESS SELECTION	PLUG & PLAY	WARRANTY

CIGWELD
AN ESAB BRAND

WE APPRECIATE YOUR BUSINESS!

Congratulations on your new CIGWELD product. We are proud to have you as our customer and will strive to provide you with the best service and reliability in the industry. This product is backed by our extensive warranty and world-wide service network.

This Operating Manual has been designed to instruct you on the correct use and operation of your CIGWELD product. Your satisfaction with this product and its safe operation is our ultimate concern. Therefore please take the time to read the entire manual, especially the Safety Precautions. They will help you to avoid potential hazards that may exist when working with this product.

We have made every effort to provide you with accurate instructions, drawings, and photographs of the product(s) while writing this manual. However errors do occur and we apologize if there are any contained in this manual.

Due to our constant effort to bring you the best products, we may make an improvement that does not get reflected in the manual. If you are ever in doubt about what you see or read in this manual with the product you received, then check for a newer version of the manual on our website or contact our customer support for assistance.

YOU ARE IN GOOD COMPANY!

The Brand of Choice for Contractors and Fabricators Worldwide.

CIGWELD is a Market Leading Brand of Arc Welding Products for ESAB. We are a mainline supplier to major welding industry sectors in the Asia Pacific and emerging global markets including; Manufacturing, Construction, Mining, Automotive, Engineering, Rural and DIY.

We distinguish ourselves from our competition through market-leading, dependable products that have stood the test of time. We pride ourselves on technical innovation, competitive prices, excellent delivery, superior customer service and technical support, together with excellence in sales and marketing expertise.

Above all, we are committed to develop technologically advanced products to achieve a safer working environment for industry operators.

DESIGNED
& TESTED
IN AUSTRALIA
FOR OVER 100 YEARS

WARNING
Read and understand this entire Manual and your employer's safety practices before installing, operating, or servicing the equipment. While the information contained in this Manual represents the Manufacturer's best judgement, the Manufacturer assumes no liability for its use.

CIGWELD BLUEVENOM MG130 WELDING INVERTER OPERATING MANUAL NUMBER 0-5700 FOR:

PART NUMBER W1202130

Published by:

ESAB

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Publication Date: 01-10-2023

Revision Date:

RECORD THE FOLLOWING INFORMATION FOR WARRANTY PURPOSES:

Where Purchased:

Purchase Date:

Equipment Serial #:

BE SURE THIS INFORMATION REACHES THE OPERATOR. YOU CAN GET EXTRA COPIES FOR FREE BY DOWNLOADING FROM THE CIGWELD WEBSITE.

CAUTION

These INSTRUCTIONS are for experienced operators. If you are not fully familiar with the principles of operation and safe practices for arc welding and cutting equipment, we urge you to read our booklet, "Precautions and Safe Practices for Arc Welding, Cutting, and Gouging," Booklet 0-5407. Do NOT permit untrained persons to install, operate, or maintain this equipment. Do NOT attempt to install or operate this equipment until you have read and fully understand these instructions. If you do not fully understand these instructions, contact your supplier for further information. Be sure to read the Safety Precautions before installing or operating this equipment.

USER RESPONSIBILITY

This equipment will perform in conformity with the description thereof contained in this manual and accompanying labels and/or inserts when installed, operated, maintained and repaired in accordance with the instructions provided. This equipment must be checked periodically. Malfunctioning or poorly maintained equipment should not be used. Parts that are broken, missing, worn, distorted or contaminated should be replaced immediately. Should such repair or replacement become necessary, the manufacturer recommends that a telephone or written request for service advice be made to the Authorized Distributor from whom it was purchased.

This equipment or any of its parts should not be altered without the prior written approval of the manufacturer. The user of this equipment shall have the sole responsibility for any malfunction which results from improper use, faulty maintenance, damage, improper repair or alteration by anyone other than the manufacturer or a service facility designated by the manufacturer.

READ AND UNDERSTAND THE OPERATING MANUAL BEFORE INSTALLING OR OPERATING. PROTECT YOURSELF AND OTHERS!

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DECLARATION OF CONFORMITY

According to AS/NZS 3820:2020, Essential Safety Requirements for Electrical Equipment Radiocommunications Labelling (Electromagnetic Compatibility) Notice 2017

TYPE OF EQUIPMENT

Arc welding power source

TYPE DESIGNATION

BlueVENOM MG130 with serial number from: WC313 XXXX XXXX

BRAND NAME OR TRADEMARK

CIGWELD

MANUFACTURER OR HIS AUTHORIZED REPRESENTATIVE NAME, ADDRESS, AND TELEPHONE NO:

CIGWELD Pty Ltd 71 Gower Street
Preston, Victoria, Australia, 3072
Phone: +61 3 9474 7400;
www.cigweld.com.au

THE FOLLOWING HAS BEEN USED IN THE DESIGN:

AS 1674.2:2007	Safety in welding and allied processes, Part 2: Electrical
AS 60974.1:2020	Arc Welding Equipment, Part 1: Welding Power Sources
AS/NZS 3760-2010	In-service Safety Inspection and Testing of Electrical Equipment EN IEC 60974-1: 2018/A1:2019 Arc Welding Equipment, Part 1: Welding Power Sources
EN 60974-10: 2014/A1:2015	Arc Welding Equipment, Part 10: EMC requirements

BY SIGNING THIS DOCUMENT, THE UNDERSIGNED DECLARES AS MANUFACTURER, OR THE MANUFACTURER'S AUTHORIZED REPRESENTATIVE, THAT THE EQUIPMENT IN QUESTION COMPLIES WITH THE SAFETY REQUIREMENTS STATED ABOVE.

PLACE/DATE

Preston
01-10-2023

SIGNATURE

Jarrod Brennan
General Manager

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SECTION 1:
ARC WELDING SAFETY INSTRUCTIONS AND WARNINGS

WARNING

PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS KEEP AWAY UNTIL CONSULTING YOUR DOCTOR. DO NOT LOSE THESE INSTRUCTIONS. READ OPERATING/ INSTRUCTION MANUAL BEFORE INSTALLING, OPERATING OR SERVICING THIS EQUIPMENT.

Welding products and welding processes can cause serious injury or death, or damage to other equipment or property, if the operator does not strictly observe all safety rules and take precautionary actions.

Safe practices have developed from past experience in the use of welding and cutting machinery/equipment. These practices must be learned through study and training before using this equipment. Some of these practices apply to equipment connected to power lines; other practices apply to engine driven equipment. Anyone not having extensive training in welding and cutting practices should not attempt to weld.

Safe practices are outlined in the Australian Standard AS1674.2-2007 entitled: Safety in welding and allied processes Part 2: Electrical. This publication and other guides as to what you should learn before operating this equipment are listed at the end of these safety precautions.

HAVE ALL INSTALLATION, OPERATION, MAINTENANCE, AND REPAIR WORK PERFORMED ONLY BY QUALIFIED PEOPLE.

1.01 ARC WELDING HAZARDS

WARNING

ARC RAYS can burn eyes and skin;
NOISE can damage hearing.

Arc rays from the welding process produce intense heat and strong ultraviolet rays that can burn eyes and skin. Noise from some processes can damage hearing.

ARC RAYS AND NOISE

1. Use a Welding Helmet or Welding Faceshield fitted with a proper shade of filter (see ANSI Z49.1 and AS 1674 listed in Safety Standards) to protect your face and eyes when welding or watching the welding operation.
2. Wear approved safety glasses. Side shields recommended.
3. Use protective screens or barriers to protect others from flash and glare; warn others not to watch the arc.
4. Wear protective clothing made from durable, flame-resistant material (wool and leather) and foot protection.
5. Use approved ear plugs or ear muffs if noise level is high.
6. Never wear contact lenses while welding.

WARNING

ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on.

In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

ELECTRIC SHOCK

1. Do not touch live electrical parts.
2. Wear dry, hole-free insulating gloves and body protection.
3. Insulate yourself from work and ground using dry insulating mats or covers.
4. Disconnect input power or stop generator before installing or servicing this equipment. Lock input power disconnect switch open, or remove line fuses so power cannot be turned on accidentally.
5. Properly install and ground this equipment according to its Operating Manual and national, state, and local codes.
6. Turn off all equipment when not in use. Disconnect power to equipment if it will be left unattended or out of service.
7. Ensure your MIG Gun is fully insulated and in good condition. Make sure the Black Contact Tip Insulator is in place and replaced when worn. Never dip the MIG Gun nozzle and Tip in water to cool it. Do not touch the end of the MIG GUN or the Work Return Clamp at the same time with the trigger depressed, otherwise you could complete the electrical circuit and suffer an electrical shock.
8. Do not use worn, damaged, undersized, or poorly spliced cables.
9. Do not wrap cables around your body.
10. Ground the workpiece to a good electrical (earth) ground.
11. Do not touch MIG Wire while in contact with the work (ground) circuit.
12. Use only well-maintained equipment. Repair or replace damaged parts at once.
13. Wear a safety harness to prevent falling if working at heights.
14. Keep all panels and covers securely in place.

RECOMMENDED PROTECTIVE FILTERS FOR ELECTRIC WELDING

Description of Process	Approximate Range of Welding Current in Amps	Minimum Shade Number of Filter(s)
Manual Metal Arc Welding - covered electrodes (MMAW)	Less than or equal to 100	8
	100 to 200	10
	200 to 300	11
	300 to 400	12
	Greater than 400	13
Gas Metal Arc Welding (GWAW) (MIG) other than Aluminium and Stainless Steel	Less than or equal to 150	10
	150 to 250	11
	250 to 300	12
	300 to 400	13
	Greater than 400	14
Gas Metal Arc Welding (GMAW) (MIG) Aluminium and Stainless Steel	Less than or equal to 250	12
	250 to 350	13
Gas Tungsten Arc Welding (GTAW) (TIG)	Less than or equal to 100	10
	100 to 200	11
	200 to 250	12
	250 to 350	13
	Greater than 350	14
Flux-cored Arc Welding (FCAW) - with or without shielding gas	Less than or equal to 300	11
	300 to 400	12
	400 to 500	13
	Greater than 500	14
Air - Arc Gouging	Less than or equal to 400	12
Plasma - Arc Cutting	50 to 100	10
	100 to 400	12
	400 to 800	14
Plasma - Arc Spraying	–	15
Plasma - Arc Welding	Less than or equal to 20	8
	20 to 100	10
	100 to 400	12
	400 to 800	14
Submerged - Arc Welding	–	2(5)
Resistance Welding	–	Safety Spectacles or eye shield

Refer to standard AS/NZS 1338.1:2012 for comprehensive information regarding the above table.

FUMES AND GASES

WARNING

FUMES & GASES CAN BE HAZARDOUS TO YOUR HEALTH.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

1. Keep your head out of the fumes. Do not breathe the fumes.
2. If inside, ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.
3. If ventilation is poor, use an approved air-supplied respirator.
4. Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instruction for metals, consumables, coatings, and cleaners.
5. Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Shielding gases used for welding can displace air causing injury or death. Be sure the breathing air is safe.
6. Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapours to form highly toxic and irritating gases.
7. Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and if necessary, while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.

WELDING

WARNING

WELDING CAN CAUSE FIRE OR EXPLOSION.

Sparks and spatter fly off from the welding arc. The flying sparks and hot metal, weld spatter, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode or welding wire to metal objects can cause sparks, overheating, or fire.

1. Protect yourself and others from flying sparks and hot metal.
2. Do not weld where flying sparks can strike flammable material.
3. Remove all flammables within 15 m of the welding arc. If this is not possible, tightly cover them with approved leather or heat resistant covers.
4. Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
5. Watch for fire, and keep a fire extinguisher nearby.
6. Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
7. Do not weld on closed containers such as tanks or drums.
8. Connect work cable to the work as close to the welding area as practical to prevent welding current from travelling long, possibly unknown paths and causing electric shock and fire hazards.
9. Do not use welder to thaw frozen pipes.
10. Welding MIG Wire is sharp and can pierce skin easily, make sure you cut off the welding wire at the contact tip when not in use.
    Be careful were you place the MIG gun after welding, as it will be very hot and if laid down on flammable work surfaces such as wooden or plastic tables, melting and fires can occur.
    Do not touch the end of the MIG GUN or the Work Return Clamp after welding as they part will be hot and can cause serious burns.

FLYING SPARKS AND HOT METAL

WARNING

FLYING SPARKS & HOT METAL CAN CAUSE INJURY.

Sparks and spatter fly off from the welding arc. The flying sparks and hot metal, weld spatter, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode or welding wire to metal objects can cause sparks, overheating, or fire.

1. Wear approved face shield or safety goggles. Side shields recommended.
2. Wear proper body protection to protect skin.

MOVING PARTS

WARNING

MOVING PARTS CAN CAUSE INJURY.

Moving parts, such as fans, rotors, and belts can cut fingers and hands and catch loose clothing.

1. Keep all doors, panels, covers, and guards closed and securely in place.
2. Turn off input power before installing or connecting unit.
3. Have only qualified people remove guards or covers for maintenance and troubleshooting as necessary.
4. Keep hands, hair, loose clothing, and tools away from moving parts.
5. Reinstall panels or guards and close doors when servicing is finished and before reconnecting the power and switching on.

WARNING

This product, when used for welding or cutting,produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety code Sec. 25249.5 et seq.)

NOTE

Considerations About Welding And The Effects of Low Frequency Electric and Magnetic Fields.

WARNING

The procedures below are among those also normally recommended for pacemaker wearers. Consult your doctor for complete information.

The following is a quotation from the General Conclusions Section of the U.S. Congress, Office of Technology Assessment, Biological Effects of Power Frequency Electric & Magnetic Fields - Background Paper, OTA-BP-E-63 (Washington, DC: U.S. Government Printing Office, May 1989): "...there is now a very large volume of scientific findings based on experiments at the cellular level and from studies with animals and people which clearly establish that low frequency magnetic fields and interact with, and produce changes in, biological systems. While most of this work is of very high quality, the results are complex. Current scientific understanding does not yet allow us to interpret the evidence in a single coherent framework. Even more frustrating, it does not yet allow us to draw definite conclusions about questions of possible risk or to offer clear science- based advice on strategies to minimize or avoid potential risks."

To reduce magnetic fields in the workplace, use the following procedures:

1. Keep all doors, panels, covers, and guards closed and securely in place.
2. Turn off input power before installing or connecting unit.
3. Have only qualified people remove guards or covers for maintenance and troubleshooting as necessary.
4. Keep hands, hair, loose clothing, and tools away from moving parts.
5. Reinstall panels or guards and close doors when servicing is finished and before starting engine.

1.02 PRINCIPAL SAFETY STANDARDS

Safety in welding and allied processes Part 1: Fire Precautions, AS 1674.1-1997 from SAI Global Limited, www.saiglobal.com.

Safety in welding and allied processes Part 2: Electrical, AS 1674.2-2007 from SAI Global Limited, www. saiglobal.com.

Filters for eye protectors - Filters for protection against radiation generated in welding and allied operations AS/NZS 1338.1:2012 from SAI Global Limited, www.saiglobal.com.

Welding Processes, Code of Practice, JULY 2020 - Safe Work Australia. This document provides "Practical guidance on how to manage health and safety risks associated with welding". **The latest version is available free of charge at: https://www.safeworkaustralia.gov.au/doc/model-code-practice-welding-processes.**

Other International Standards and Codes of Practice

Safety in Welding and Cutting, ANSI Standard Z49.1, from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

Safety and Health Standards, OSHA 29 CFR 1910, from Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances, American Welding Society Standard AWS F4.1, from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202.

Code for Safety in Welding and Cutting, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

Safe Practices for Occupation and Educational Eye and Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 1430 Broadway, New York, NY 10018.

Cutting and Welding Processes, NFPA Standard 51B, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

SECTION 2: INTRODUCTION

2.01 HOW TO USE THIS MANUAL

This Operating Manual only applies to the Part Number listed on page 3. To ensure safe operation, read the entire manual, including the chapter on safety instructions and warnings.

Throughout this manual, the words WARNING, CAUTION, and NOTE may appear. Pay particular attention to the information provided under these headings. These special annotations are easily recognized as follows:

NOTE
An operation, procedure, or background information which requires additional emphasis or is helpful in efficient operation of the system.

CAUTION
A procedure which, if not properly followed, may cause damage to the equipment.

WARNING
An operation, procedure, or background information which requires additional emphasis or is helpful in efficient operation of the system.

ELECTRICAL WARNING
Gives information regarding possible electrical shock injury. Warnings will be enclosed in a box such as this.

DANGER
Means immediate hazards which, if not avoided, will result in immediate, serious personal injury or loss of life.

Additional copies of this manual may be purchased by contacting CIGWELD at the address and phone number for your location listed in the inside back cover of this manual. Include the Operating Manual number and equipment identification numbers.

Electronic copies of this manual can also be downloaded at no charge in Acrobat PDF format by going to the CIGWELD web site listed below and clicking on the Literature Library link: **www.cigweld.com.au**

2.02 EQUIPMENT IDENTIFICATION

The unit's identification number (specification or part number), model, and serial number are located on the Data Plate which is fixed to the bottom of the welding machine. In some cases, the Data Plate may be attached to the rear panel. Equipment which does not have a control panel such as cable assemblies are identified only by the specification or part number printed on the shipping container. Record these numbers on the bottom of page 3 for future reference.

2.03 RECEIPT OF EQUIPMENT

When you receive the equipment, check it against the invoice to confirm it is complete and inspect the equipment for possible damage due to shipping. If there is any damage, notify the carrier immediately to file a claim. Furnish complete information concerning damage claims or shipping errors to the location in your area listed in the inside back cover of this manual. Include all equipment identification numbers as described above along with a full description of the parts in error.

Move the equipment to the installation site before unboxing the unit. Use care to avoid damaging the equipment when using knives, breaker bars, hammers, etc, to unbox the machine and its accessories.

2.04 SYMBOL CHART

Note that only some of these symbols will appear on your model.

ON	SINGLE PHASE	WIRE FEED FUNCTION
OFF	THREE PHASE	WIRE FEED TOWARDS WORKPIECE WITH OUTPUT VOLTAGE OFF
DANGEROUS VOLTAGE	THREE PHASE STATIC FREQUENCY CONVERTER-TRANSFORMER-RECTIFIER	WELDING GUN
INCREASE/DECREASE	REMOTE	PURGING OF GAS
CIRCUIT BREAKER	DUTY CYCLE	CONTINUOUS WELD MODE
AC AUXILIARY POWER	PERCENTAGE	SPOT WELD MODE
FUSE	PANEL/LOCAL	SPOT TIME
AMPERAGE	SHIELDED METAL ARC WELDING (SMAW)	PREFLOW TIME
VOLTAGE	GAS METAL ARC WELDING (GMAW)	POSTFLOW TIME
HERTZ (CYCLES/SEC)	GAS TUNGSTEN ARC WELDING (GTAW)	QUICKSET PLATE THICKNESS PRE-SETS
FREQUENCY	AIR CARBON ARC CUTTING (CAC-A)	OUTPUT CURRENT
NEGATIVE	CONSTANT CURRENT	2-YEAR WARRANTY
POSITIVE	CONSTANT VOLTAGE OR CONSTANT POTENTIAL	BURNBACK TIME
DIRECT CURRENT (DC)	HIGH TEMPERATURE	DISTURBANCE IN GROUND SYSTEM
PROTECTIVE EARTH (GROUND)	FAULT INDICATION	INCHES PER MINUTE
LINE	ARC FORCE	METRES PER MINUTE
LINE CONNECTION	TOUCH START (GTAW)	SPOOL GUN
AUXILIARY POWER	VARIABLE INDUCTANCE	QUICKSET FOR MIG
RECEPTACLE RATING-AUXILIARY POWER	VOLTAGE INPUT	

2.05 DESCRIPTION

Sometimes all you need to get your job done is a basic, user friendly, yet intuitive welding machine that you simply plug in and weld away.

Introducing the new BlueVENOM MG130 Gasless MIG welding inverter with plate Thickness Settings.

Delivering 130Amps of pure BlueVENOM, the MG130 is a compact and lightweight unit at 4.5Kg, and is ready to take on all those light welding jobs around the home, farm and building site.

The BlueVenom MG130 is also the perfect welder for people just starting out in welding or those building trades people (electricians, plumbers, builders and carpenters) who require simplicity with excellent results for smaller jobs.

Some typical applications include the welding of; pipes, tubes, RHS, SHS, angle-iron, plates and sheet metal used for making fences, gates, supports, brackets, racking, crates, automotive panel repairs etc, plus artistic sculptures and all the other projects you dream up!

Being a Gasless MIG machine, you don't need to worry about renting or buying shielding-gas or the costs that go with it – using CIGWELD's tried and tested Gasless MIG wire, the MG130 is ready whenever you need it to be!

2.06 USER RESPONSIBILITY

This equipment will perform as per the information contained herein when installed, operated, maintained and repaired in accordance with the instructions provided. This equipment must be checked periodically. Defective equipment (including welding leads) should not be used. Parts that are broken, missing, partly worn, distorted or contaminated, should be replaced immediately. Should such repairs or replacements become necessary, it is recommended that such repairs be carried out by appropriately qualified persons approved by CIGWELD. Advice in this regard can be obtained by contacting an accredited CIGWELD Distributor/service agent.

This equipment or any of its parts should not be altered from standard specification without prior written approval of CIGWELD. The user of this equipment shall have the sole responsibility for any malfunction which results from improper use or unauthorised modification from standard specification, faulty maintenance, damage or improper repair by anyone other than appropriately qualified persons approved by CIGWELD.

2.07 WHAT'S IN THE BOX

BlueVENOM MG130 (Part No. W1202130)

- BLUEVENOM MG130 Power Source
- Gasless MIG Gun 2.5m - Direct Connect
- Work Clamp 200A with 1.5m Lead
- Feed Roll: 0.8/0.9mm Gasless Knurled (fitted)
- Contact Tips: 0.8mm (Fitted) & 0.9mm spare
- Gasless Nozzle (Fitted)
- Shoulder Strap
- Operating Manual

NOTE
Refer to the complete Warranty Schedule at the back of the manual.

2.08 TRANSPORTING METHODS

ELECTRICAL WARNING
ELECTRIC SHOCK can kill.
DO NOT TOUCH live electrical parts.

Disconnect input power conductors from de-energized supply line before moving the welding power source.

WARNING
FALLING EQUIPMENT can cause serious personal injury and equipment damage

2.09 DUTY CYCLE

The rated duty cycle of a Welding Power Source, is a statement of the time it may be operated at its rated welding current output without exceeding the temperature limits of the insulation of the component parts. To explain the 10 minute duty cycle period the following example is used. Suppose a Welding Power Source is designed to operate at a 20% duty cycle, 130 amperes at 20.5 volts. This means that it has been designed and built to provide the rated amperage (130) for 2 minutes, i.e. arc welding time, out of every 10 minute period (20% of 10 minutes is 2 minutes). During the other 8 minutes of the 10 minute period the Welding Power Source must idle and be allowed to cool.

2.10 SPECIFICATIONS

DESCRIPTION	BLUEVENOM MG130
Packaged Part Number	W1202130
Power Source Dimensions	(L) 350mm x (W) 140mm x (H) 225mm
Power Source Weight	4.5kg
Cooling	Fan Cooled
Welder Type	Gasless MIG Welder
Standards	AS 60974.1:2020 / IEC 60974-1:2019 EN 60974-10:2014/ A1:2015
Number of Phases	Single Phase
Nominal Supply Voltage	230/240 VAC ± 10%
Nominal Supply Frequency	50/60Hz

DESCRIPTION	BLUEVENOM MG130
Welding Current Range (MIG mode)	30-130A
Nominal DC Open Circuit Voltage MIG Weld Mode	43V
Effective Input Current (I1eff) refer Note 2	10 Amps (230VAC) 9.6 Amps (240VAC)
Maximum Input Current (I1max)	22.4 Amps (230VAC) 21.4 Amps (240VAC)
Minimum Single Phase Generator Recommendation (refer Note 4)	6kVA@0.8PF
MIG (GMAW) Welding Output, 40°C, 10 min	130A @ 20%, 20.5V 75A @ 60%, 17.8V 58A @ 100%, 16.9V
Protection Class	IP21S

NOTE 1 Due to variations that can occur in manufactured products, claimed performance, voltages, ratings, all capacities, measurements, dimensions and weights quoted are approximate only. Achievable capacities and ratings in use and operation will depend upon correct installation, use, applications, maintenance and service.

NOTE 2 The Effective Input Current should be used for the determination of cable size & supply requirements.

NOTE 3 Motor start fuses or thermal circuit breakers are recommended for this application. Check local requirements for your situation in this regard.

NOTE 4 Minimum Generator Recommendation at the Maximum Output Duty Cycle. Due to large variations in performance and specifications of different brands and types of generators, CIGWELD cannot guarantee full welding output power or duty cycle on every brand or type of generator. Some small generators incorporate low cost circuit breakers on their outputs. These circuit breakers usually will have a small reset button, and will trip much faster than a switchboard type circuit breaker. This may result in not being able to achieve full output or duty cycle from the power source / generator combination. For this reason we recommend a generator that incorporates switchboard type circuit breakers. CIGWELD recommends that when selecting a generator, that the particular power source / generator combination be adequately trialled to ensure the combination performs to the users expectations.

NOTE 5 CIGWELD reserves the right to change product performance and specifications without notice.

NOTE 6 If an extension lead is required to be used it is recommended to use a minimum size of 1.5mm2 Heavy Duty Extension Lead. Longer extension leads may impact welding performance and operation.

2.11 OPTIONAL ACCESSORIES

We recommend genuine CIGWELD products. The biggest range and best quality with guaranteed performance.

PART NUMBER	DESCRIPTION
BZN15GL	BZL 15 Gasless Nozzle, 7mm, Pack of 2
BZT6608	BZL Contact Tip 0.8mm M6 L: 25mm, Pack of 10
BZT6609	BZL Contact Tip 0.9mm M6 L: 25mm, Pack of 10
BZT6610	BZL Contact Tip 1.0mm M6 L: 25mm, Pack of 10
BZH15L	BZL 15 Tip Holder, M6, LH, Pack of 2
W4012907	Feed Roll 0.8/0.9mm V Knurled (Gasless Wires), supplied and fitted on machine
CWPLIER	MIG Pliers 8-Function, Cut Wire, Clean Nozzle, Remove Hot Nozzle, Pick up & hold hot welding jobs/pieces, Remove Contact Tip, Cut/Trim Spring Steel Liner, Long Nose Pliers, Mini Hammers to tap out spatter in the nozzle.
704814	Spatter Safe 2- 400ml Pump Can
W4011501	WeldSkill Welding Equipment Trolley
700638	Work Lead 200A, 3m, 16mm^2 cable, 25mm^2 Dinse

Contact Tip 0.8mm M6
P/N: BZT6608

Contact Tip 0.9mm M6
BZT6609

Tip Holder M6
P/N: BZH15L

2.12 RELATED PRODUCTS

PART NUMBER	DESCRIPTION
646766	WeldSkill Heavy Duty Welding Gloves - Medium
646755	WeldSkill Heavy Duty Welding Gloves - Large
646767	WeldSkill Heavy Duty Welding Gloves – XL
646771	WeldSkill Welding Jacket - Medium
646772	WeldSkill Welding Jacket - Large
646773	WeldSkill Welding Jacket - XL
646774	WeldSkill Welding Jacket - XXL
W4018001	CIGWELD Heavy Duty Backpack
WHAMXC130	Auto Darkening Welding Helmet Variable Shade 9-13 - Payday

PART NUMBER	DESCRIPTION
WHAMXC120	Auto Darkening Welding Helmet Variable Shade 9-13 - Torque
646764	WeldSkill Magnetic Welding Clamp/Holder - Medium
646765	WeldSkill Magnetic Welding Clamp/Holder - Large
646770	WeldSkill Welding Curtain – Dark Green, 1.74m x 1.74m
646777	WeldSkill Welding Curtain – Red, 1.74m x 1.74m
646776	Welding Curtain Frame, 1.8m x 1.8m
646778	Welding Blanket, 1.8m x 1.8m

MIG Pliers
P/N: CWPLIER

Magnetic Clamps
P/N: 646764 (Medium)
P/N: 646765 (Large)

WELDSKILL Heavy Duty Leather Welding Gloves
P/N: 646755 (Large)
P/N: 646767 (XL)

WeldSkill Welding Jacket
P/N: 646772 (Large)

Arcmaster XC30 Welding Helmet (Cyberskull)
P/N: WHAMXC230

SECTION 3: INSTALLATION

3.01 ENVIRONMENT

These units are designed for use in environments with increased hazard of electric shock.

A. Examples of environments with increased hazard of electric shock are:

1. In locations in which freedom of movement is restricted, so that the operator is forced to perform the work in a cramped (kneeling, sitting or lying) position with physical contact with conductive parts.
2. In locations which are fully or partially limited by conductive elements, and in which there is a high risk of unavoidable or accidental contact by the operator.

B. Environments with increased hazard of electric shock do not include places where electrically conductive parts in the near vicinity of the operator, which can cause increased hazard, have been insulated.

3.02 LOCATION

Be sure to locate the welder according to the following guidelines:

A. In areas, free from moisture and dust.

B. Ambient temperature between -10° C to 40° C.

C. In areas, free from oil, steam and corrosive gases.

D. In areas, not subjected to abnormal vibration or shock.

E. In areas, not exposed to direct sunlight or rain.

F. Place at a distance of 300mm or more from walls or similar that could restrict natural air flow for cooling.

3.03 VENTILATION

Since the inhalation of welding fumes can be harmful, ensure that the welding area is effectively ventilated.

3.04 MAINS SUPPLY VOLTAGE REQUIREMENTS

The Mains Supply Voltage should be within ± 15% of the rated Mains Supply Voltage. If actual Mains Supply Voltage is outside this range Welding Current may not be available and may cause internal components to fail.

Refer to Specifications on page 17 for Supply Voltage information.

The Welding Power Source must be:

- Correctly installed, if necessary, by a qualified electrician.
- Correctly earthed (electrically) in accordance with local regulations.
- Connected to the correct size power point and fuse as per the Specifications on page 17.

IMPORTANT NOTE!
This product has been fitted with a supply plug as indicated in Section 2.10. Note that the welding output range applicable with the fitted supply plug is detailed in Section 2.10.

WARNING
Any electrical work must be carried out by a qualified Electrical Tradesperson

3.05 GENERATORS

Refer to Note 4 on page 17 for recommendations when using with a Generator.

3.06 EXTENSION LEADS

If an extension lead is required to be used it is recommended to use a minimum size of 1.5mm^2 Heavy Duty Extension Lead. Longer extension leads may impact welding performance and operation.

3.07 ELECTROMAGNETIC COMPATIBILITY

WARNING
Extra precautions for Electromagnetic Compatibility may be required when this Welding Power Source is used in a domestic situation.

A. INSTALLATION AND USE - USERS RESPONSIBILITY

The user is responsible for installing and using the welding equipment according to the manufacturer's instructions. If electromagnetic disturbances are detected then it shall be the responsibility of the user of the welding equipment to resolve the situation with the technical assistance of the manufacturer. In some cases this remedial action may be as simple as earthing the welding circuit. In other cases it could involve constructing an electromagnetic screen enclosing the Welding Power Source and the work, complete with associated input filters. In all cases, electromagnetic disturbances shall be reduced to the point where they are no longer troublesome.

B. ASSESSMENT OF AREA

Before installing welding equipment, the user shall make an assessment of potential electromagnetic problems in the surrounding area. The following shall be taken into account

1. Other supply cables, control cables, signalling and telephone cables; above, below and adjacent to the welding equipment.
2. Radio and television transmitters and receivers.
3. Computer and other control equipment.
4. Safety critical equipment, e.g. guarding of industrial equipment.
5. The health of people around, e.g. the use of pacemakers and hearing aids.
6. Equipment used for calibration and measurement.
7. The time of day that welding or other activities are to be carried out.
8. The immunity of other equipment in the environment: the user shall ensure that other equipment being used in the environment is compatible: this may require additional protection measures.

   The size of the surrounding area to be considered will depend on the structure of the building and other activities that are taking place. The surrounding area may extend beyond the boundaries of the premises.

C. METHODS OF REDUCING ELECTROMAGNETIC EMISSIONS

1. **Mains Supply**
   Welding equipment should be connected to the mains supply according to the manufacturer's recommendations. If interference occurs, it may be necessary to take additional precautions such as filtering of the mains supply. Consideration should be given to shielding the supply cable of permanently installed welding equipment in metallic conduit or equivalent. Shielding should be electrically continuous throughout it's length. The shielding should be connected to the Welding Power Source so that good electrical contact is maintained between the conduit and the Welding Power Source enclosure.

1. **Maintenance of Welding Equipment**
   The welding equipment should be routinely maintained according to the manufacturer's recommendations. All access and service doors and covers should be closed and properly fastened when the welding equipment is in operation. The welding equipment should not be modified in any way except for those changes and adjustments covered in the manufacturer's instructions. In particular, the spark gaps of arc striking and stabilising devices should be adjusted and maintained according to the manufacturer's recommendations.

2. **Welding Cables**
   The welding cables should be kept as short as possible and should be positioned close together, running at or close to the floor level.

3. **Equipotential Bonding**
   Bonding of all metallic components in the welding installation and adjacent to it should be considered. However Metallic components bonded to the work piece will increase the risk that the operator could receive a shock by touching the metallic components and the electrode at the same time. The operator should be insulated from all such bonded metallic components.

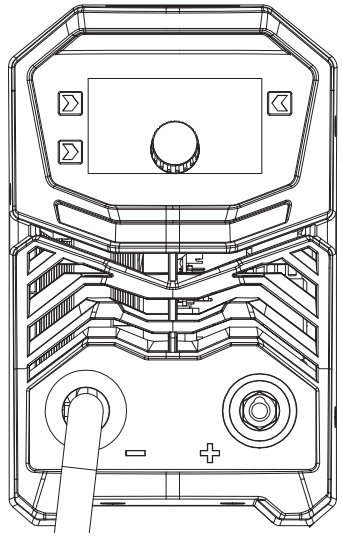
4. **Earthing of the Workpiece**
   Where the workpiece is not bonded to earth for electrical safety, nor connected to earth because of it's size and position, e.g. ship's hull or building steelwork, a connection bonding the workpiece to earth may reduce emissions in some, but not all instances. Care should be taken to prevent the earthing of the workpiece increasing the risk of injury to users, or damage to other electrical equipment. Where necessary, the connection of the workpiece to earth should be made by direct connection to the workpiece, but in some countries where direct connection is not permitted, the bonding should be achieved by suitable capacitance, selected according to national regulations.

5. **Screening and Shielding**
   Selective screening and shielding of other cables and equipment in the surrounding area may alleviate problems of interference. Screening the entire welding installation may be considered for special applications.

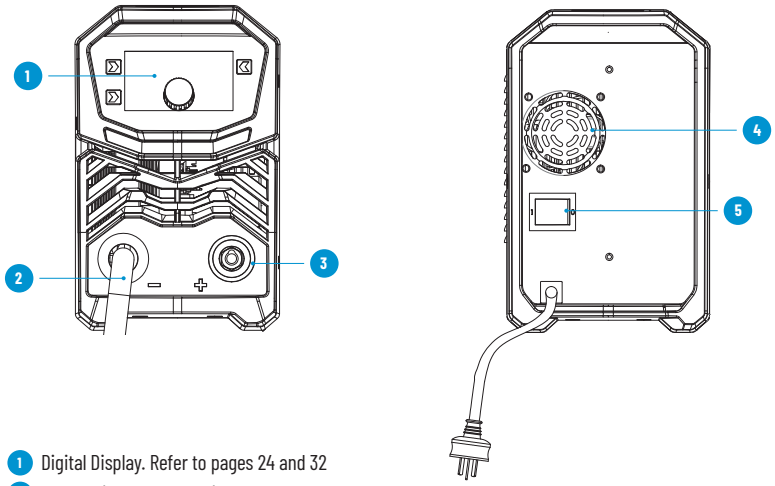
SECTION 4: OPERATION

Standard operating procedures apply when using these Welding machines, i.e. connect work lead directly to workpiece with the spring loaded clamp. The MIG wire is fed from the spool through the feed roller system and into the MIG Gun.

The welding amperage range (plate thickness pre-set) values should be used as a guide only. Current delivered to the arc is dependent on the Wire Feed Speed and welding arc voltage, and as welding arc voltage varies between different classes of MIG wire, welding current at given settings could vary accordingly to the type of MIG wire in use. The operator should use the plate thickness pre-set welding current values as a guide, then finally adjust the current setting to suit the application, by fine tuning the WFS / Amps and Volts / Trim settings.



4.01 POWER SOURCE CONTROLS, INDICATORS AND FEATURES



1. Digital Display. Refer to pages 24 and 32
2. MIG Gun (Direct Connect) Negative Polarity Gasless. Refer to page 25
3. Positive Output Welding Terminal. Refer to page 25
4. Fan On Demand. Refer to page 25
5. Power On/Off Switch. Refer to page 25

Figure 4-1: Power Source Controls, Indicators and Features

1 DIGITAL DISPLAY

The BlueVENOM MG130 is equipped with a 3.5" bright blue Sharp LED display which provides optimal clarity both indoors and outdoors. Easy press push buttons for selection of features to toggle through settings including: Gasless MIG Modes, Wire Diameters and Trigger Modes.

Figure 4-2: Digital Display

2 MIG GUN (DIRECT CONNECT) NEGATIVE POLARITY GASLESS

Direct Connect MIG Gun, Gasless will only be connected to the Negative (-) Polarity output.

CAUTION
Loose welding terminal connections can cause overheating and result in the male plug being fused in the DINSE terminal.

3 POSITIVE OUTPUT WELDING TERMINAL

The positive (+) welding terminal is used to connect the welding output of the power source to the work lead with clamp. Positive welding current flows from the power source via this twist & lock terminal, known as a DINSE Connector. It is essential, that the male plug is inserted and turned securely (by hand) to achieve a sound electrical connection.

4 FAN ON DEMAND

The BlueVENOM MG130 is fitted with a fan on demand feature. Fan on demand automatically switches the cooling fan off when it is not required. This has two main advantages; (1) to minimize power consumption, and (2) to minimise the amount of contaminants such as dust that are drawn into the power source. Note that the fan will only operate when required for cooling purposes and will automatically switch off when not required.

5 POWER ON/OFF SWITCH

This switch is used to turn the unit ON/OFF. When this switch is turned ON the LED Digital Display on the front panel will illuminate.

NOTE
If the Power Source is repeatedly switched On then Off rapidly or the supply to the power source is turned On and Off rapidly it may not turn On due to inbuilt protective devices acting. If this occurs leave the Power Source On/Off switch turned to the Off position for several minutes to allow for the protective devices to reset.

SECTION 5:
MIG GASLESS (FCAW) WELDING

5.01 INSTALLING MINI SPOOL (100mm DIAMETER)

As delivered from the factory, the unit is fitted with a Wire Spool Hub which accepts a Mini Spool of 100mm diameter MIG Gasless welding wire.

In order to fit a Minispool of 100mm diameter, remove the Wire Spool Retaining R-Clip and assemble parts in the sequence (1, 2, 3, 4) shown below in Figure 5-1.

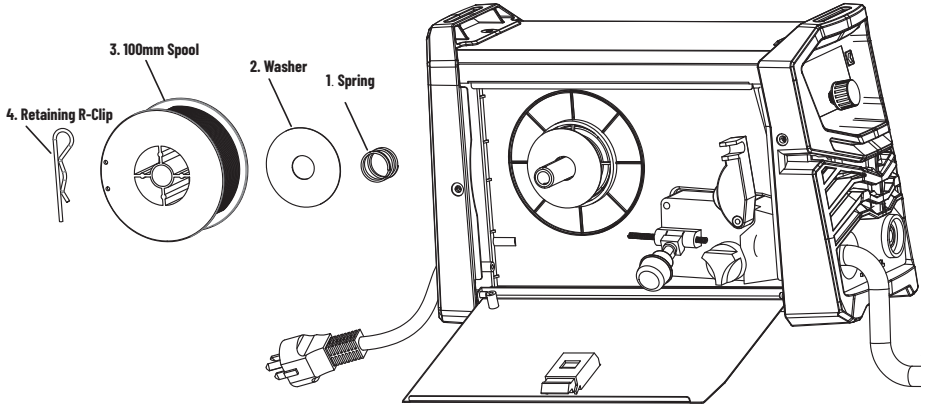


Figure 5-1: 100mm Spool Installation

5.02 INSERTING WIRE INTO THE WIRE FEED MECHANISM

Release the tension from the pressure roller by turning the adjustable wire drive tension screw (3) in an anticlockwise direction. Pull the pressure roller arm tension screw outward to release the pressure roller arm (1). With the MIG welding wire (4) feeding from the bottom of the spool (5) pass the wire through the inlet guide, between the rollers and into the MIG Gun Liner. Re-secure the pressure roller arm and wire drive tension screw and adjust the pressure accordingly. Remove the contact tip from the MIG Gun. With the MIG Gun lead reasonably straight, feed the wire through the MIG Gun by pressing the trigger switch. Fit the appropriate contact tip.

WARNING

Keep hands clear of the contact tip holder while feeding wire through to the gun. The wire can easily pierce you skin resulting in injury.

Keep MIG Gun away from eyes and face.

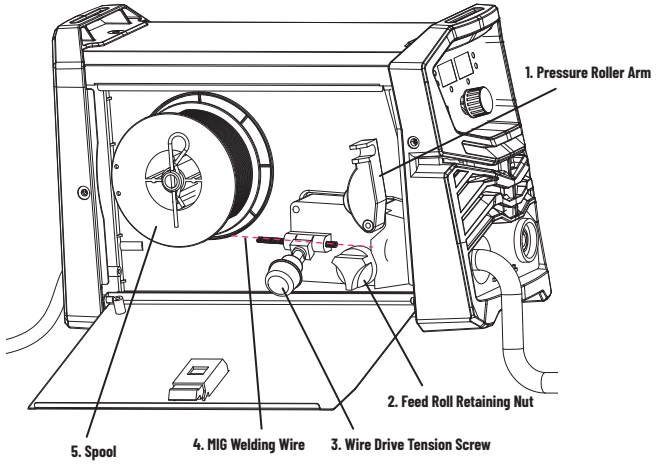


Figure 5-2:Inserting Wire into the Wire Feed Mechanism

5.03 FEED ROLL PRESSURE ADJUSTMENT

The pressure (top) roller applies pressure to the grooved feed roll via an adjustable pressure screw. These devices should be adjusted to a minimum pressure that will provide satisfactory WIREFEED without slippage. If slipping occurs, and inspection of the wire contact tip reveals no wear, distortion or burn back jam, the conduit liner should be checked for kinks and clogging by metal flakes and swarf. If it is not the cause of slipping, the feed roll pressure can be increased by rotating the pressure screw clockwise.

A simple check for the correct drive tension is to bend the end over of the wire (once out the end of the MIG Gun) and hold it about 50mm from a piece of wood (an insulated object) and let it run into the wood. The wire should coil up without stopping and slipping at the drive rollers, tighten the pressure/tension adjustment screw if it slips.

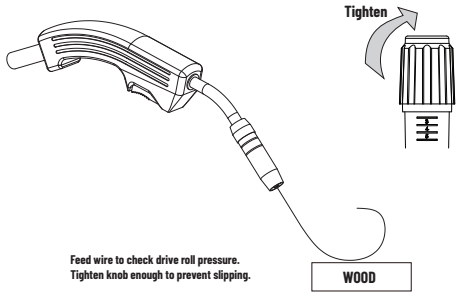


Figure 5-3: Feed Roll Pressure Adjustment

WARNING
Keep hands clear of the contact tip holder while feeding wire through to the gun. The wire can easily pierce you skin resulting in injury.

Keep MIG Gun away from eyes and face.

WARNING
Before changing the feed roll ensure that the mains supply to the power source is switched off.

CAUTION
The use of excessive pressure may cause rapid wear of the feed rolls, shafts and bearing.

5.04 CHANGING THE FEED ROLL

To change the feed roll, release the Wire Drive Tension Screw and pull the Pressure Roller Arm (top roller) outward and out of the way. Remove the feed roll retaining cover by rotating it anti-clockwise 90 degrees and pulling outwards. The feed roll can now be changed.

Once the feed roll is removed then replace the feed roll, ensuring that the wire size you are using is showing on the feed roll side facing outwards. Re-install by following these instructions in reverse.

A dual groove knurled feed roll is fitted as standard. It can accommodate 0.8/0.9mm Gasless Flux Cored Wires. Markings are indicated on the side edge of the feed roll, for example 0.8, 0.9.

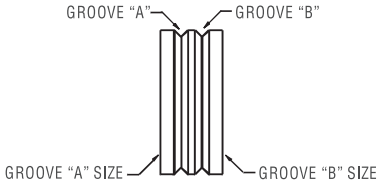


Figure 5-4: Dual Groove Feed Roll

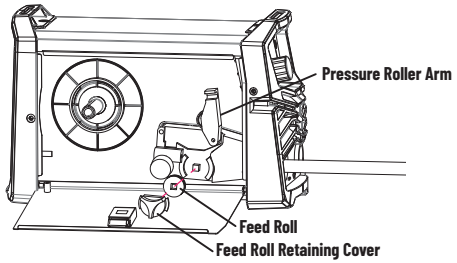


Figure 5-5: Changing the Feed Roll

WARNING
Moving Parts can cause injury!

5.05 MIG GASLESS (FCAW) OPERATION AND SETUP

Figure 5-6: MIG Mode

A. MIG Mode Selection Button

Selects QuickSet SYN or Manual Mode (MAN).

QuickSet Mode (SYN)

Selects QuickSet Mode depending on the wire diameter selected.

Quick Press of the Control Knob to toggle between MM (QuickSet Plate Thickness) and V+/- Voltage Trim.

Manual Mode (MAN)

Quick Press of the Control Knob to select either V+/- Voltage Trim and Amps (A) or V+/- Voltage Trim and M/min (Wirefeed Speed). Hold Control Knob depressed for 3 seconds to toggle between Amps (A) and Wire Feed Speed (M/min).

Voltage Trim Range is -2.5V to 2.5V.

Note that Manual Mode is still Semi Synergic (QuickSet). When the user selects the desired Amps (A) value the voltage will synergically change accordingly. If the value has been changed, to return to the factory parameters simply return the Volts Trim to display "SYN" to return to the QuickSet setting.

B. Trigger Mode Button

Select Trigger Mode Button

The trigger mode control is used to switch the functionality of the MIG Gun trigger between 2T (normal) and 4T (latch mode).

2T Normal Mode

In this mode, the MIG Gun trigger must remain depressed for the welding output to be active. Press and hold the MIG Gun trigger to activate the power source (weld). Release the MIG Gun trigger switch to cease welding.

4T Latch Mode

This mode of welding is mainly used for long welding runs to reduce operator fatigue. In this mode the operator can press and release the MIG Gun trigger and the output will remain active. To deactivate the power source, the MIG Gun trigger switch must again be depressed and released, thus eliminating the need for the operator to hold the MIG Gun trigger.

C. Select Gasless MIG Wire Diameter

QuickSet Mode (SYN)

Select the QuickSet (SYN) Gasless MIG wire diameter.

Manual Mode (MAN)

In Manual Mode the wire diameter, voltage and Wire Feed Speed (M/min) must be manually set.

D. Control Knob

Turn clockwise to increase the value;
Turn anti-clockwise to decrease the value;
Turn slowly in order to adjust value in small increments.
Turn quickly in order to adjust value in larger increments.

Control Knob in QuickSet Mode (SYN)

Quick Press of the Control Knob to toggle between MM (QuickSet Plate Thickness) and V+/- Voltage Trim.

Figure 5-7: Control Knob in QuickSet Mode (SYN)

Control Knob in Manual Mode (MAN)

Quick Press of the Control Knob to select either V+/- Voltage Trim and Amps (A) or V+/- Voltage Trim and M/min (Wirefeed Speed).

Hold Control Knob depressed for 3 seconds to toggle between Amps (A) and Wire Feed Speed (M/min).

Figure 5-8: Control Knob in Manual Mode (MAN) - Wire Feed Speed (M/min)

Figure 5-9: Control Knob in Manual Mode (MAN) - Amps (A)

E. Digital Meters

In QuickSet Mode (SYN) the digital meters display the Pre-Set Voltage, Plate Thickness (MM), or Volts Trim (V+/-).

In Manual Mode (MAN) the digital meters display the Pre-Set Voltage, Amps (A), Wire Feed Speed (M/min) or Volts Trim (V+/-).

At the completion of welding digital meters hold the last recorded welding voltage and amperage for 10 seconds. The amperage meter will hold the value until; (1) any of the front panel controls are adjusted in which case the unit will revert to viewing mode, (2) welding is recommenced, in which case actual welding amperage will be displayed, or (3) a period of 10 seconds elapses following the completion of welding in which case the unit will return to viewing mode.

Amps (A)

Welding Amps adjustment is only available in Manual Mode (MAN).

If the Welding Amps (A) are found to be too High or too Low for the application the setting can be adjusted by turning the Control Knob Clockwise to increase value or turning the Control Knob Anti-clockwise to decrease the value.
If the Control Knob is turned slowly it will adjust in small increments, if turned quickly, adjust in larger increments

Wire Feed Speed Control (M/min) (MAN Mode)

Wire Feed Speed adjustment is only available in Manual Mode (MAN). If in Amps (A) mode then hold Control Knob depressed for 3 seconds to change to M/min mode.

If the Welding Current is found to be too High or too Low for the application the Wire Feed Speed (M/min) can be adjusted to the desired value. Once Wire Feed Speed (M/min) function is selected the setting can be adjusted by turning the Control Knob Clockwise to increase value or turning the Control Knob Anti-clockwise to decrease the value. If the Control Knob is turned slowly it will adjust in small increments, if turned quickly, adjust in larger increments.

Note: Adjusting Wire Feed Speed (M/min) will also change the Voltage Value Synergically.

Figure 5-10: Select Wire Feed Speed (M/min)

Volts Trim V+/-

In either QuickSet (SYN) or Manual Mode (MAN) a quick press of the Control Knob will select Volts Trim (V+/-).

Volts Trim has a range of -2.5 to 2.5 Volts.

If the value has been changed, to return to the factory parameters simply return the Volts Trim to display "SYN" to return to the QuickSet setting.

For example, if the Pre-set Voltage is 19V and in Volts Trim (V+/-) mode the setting is changed to -2.0 then the Pre-set voltage will now be 17V. If the Volts Trim (V+/-) is changed to 2.0V then the Pre-set Voltage will be 21V.

Figure 5-11: Select Volts Trim (V+/-)

NOTE
The Pre-set functionality provided on this power source is intended to act as a guide only. Some differences may be observed between pre-set values and actual welding values due to factors including the mode of welding, differences in consumables, individual welding techniques and the transfer mode of the welding arc (ie dip versus spray transfer).

5.06 QUICKSET (SYN) AND MANUAL MODES (MAN)

QUICKSET Mode (SYN) in 2 Steps

With Pre-Sets installed the guess work is now taken out of the setup, to allow excellent welding results. All you need to set is the 1) MIG Wire Diameter and 2) Plate Thickness.

Plate thickness setting allows you to set up in a flash. There is no guessing the welding parameters. Use the Synergic feature to set the machine to the correct plate thickness you are welding. You can check the plate thickness with a measuring device, such as a ruler or vernier caliper. If two different plate thickness are to be joined then, add the two together and divide by 2 and use the average plate thickness as your setting guide.

Manual MIG Mode (MAN)

In Manual MIG Mode, Voltage, Amps (A) and Wire Feed Speed (M/min) can be selected and fine turned to the users individual liking.

5.07 SETUP FOR MIG (FCAW) WELDING WITH GASLESS MIG WIRE

A. Ensure that the Power Source ON/OFF switch located on the rear of the Power Source is in the OFF position.

B. Fit the correct Feed Roll for the Gasless MIG wire being used. Refer to section 2.11 Options and Accessories for Feed Roll types and Part Numbers.

C. Place the MIG wire spool onto the spool holder. Refer to section 5.01, 100mm diameter spool.

D. Switch the Power Source ON/OFF switch located on the rear of the Power Source to the ON position and ensure the Front Panel Digital Display is illuminated.

E. Select MIG SYN or MAN Mode. Refer to Section 5.05 for details.

F. Feed wire through the wire drive mechanism. Refer to section 5.02.

G. Connect the work lead to the positive welding terminal (+). Welding current flows from the Power Source via DINSE terminals. It is essential, that the male plug is inserted and turned securely to achieve a sound electrical connection.

WARNING
Moving Parts can cause injury!

WARNING
Before connecting the work clamp to the work piece make sure the mains power supply is switched off.

CAUTION
Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal.

Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

NOTE
Wire sizes for MIG GASLESS (Flux Cored Wire) are 0.8mm and 0.9mm diameter.

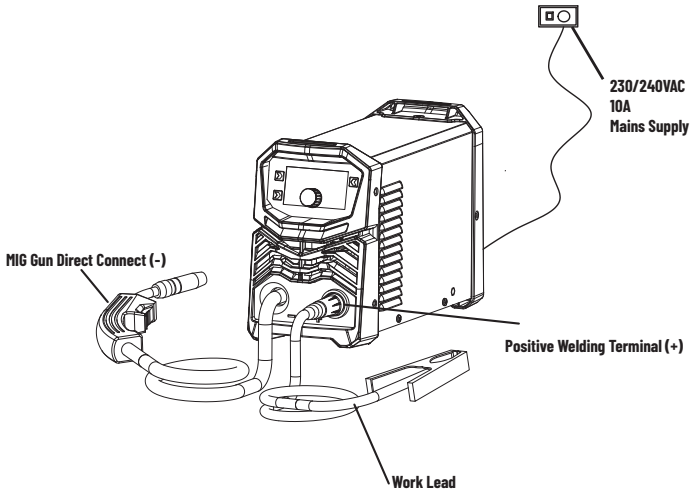


Figure 5-12: Setup for MIG Welding with Gasless MIG Wire

SETTING OF THE POWER SOURCE

Power source setting requires some practice by the operator, (however with the QuickSet feature of the BlueVENOM MG130, setting up the correct parameters is a very simple procedure - refer to Section 5.07 and 5.08), as the welding plant has two control settings that have to balance. These are the Wire Feed Speed control and the welding Voltage Control. The welding current is determined by the Wire Feed Speed control, the current will increase with increased Wire Feed Speed, resulting in a shorter arc. Less Wire Feed Speed will reduce the current and lengthen the arc. Increasing the welding voltage alters the current level slightly, but lengthens the arc. By decreasing the voltage, a shorter arc is obtained with a slight change in current level

When changing to a different electrode wire diameter, different control settings are required. A thinner electrode wire needs more Wire Feed Speed to achieve the same current level.

A satisfactory weld cannot be obtained if the Wire Feed Speed and Voltage settings are not adjusted to suit the electrode wire diameter and the thickness of the work piece.

If the Wire Feed Speed is too high for the welding voltage, "stubbing" will occur as the wire dips into the molten pool and does not melt. Welding in these conditions normally produces a poor weld due to lack of fusion. If, however, the welding voltage is too high, large drops will form on the end of the wire, causing spatter. The correct setting of voltage and Wire Feed Speed can be seen in the shape of the weld deposit and heard by a smooth regular arc sound. Refer to the Weld Guide located on the inside of the wirefeed compartment door for setup information.

ELECTRODE WIRE SIZE SELECTION

The choice of Electrode wire size and shielding gas used depends on thew following:

- Thickness of the metal to be welded
- Type of joint
- Capacity of the wire feed unit and Power Source
- The amount of penetration required
- The deposition rate required
- The bead profile desired
- The position of welding
- Cost of the wire

HANDY HINT
To make gasless MIG welding easy, CIGWELD recommend using the Plate Thickness QuickSet settings already preprogrammed into the welding machine.

This will help you aviod messy looking welds and help provide trouble free, pleasurable welding results.

5.08 CIGWELD MIG WIRE SELECTION CHART

BLUEVENOM MG130 MIG WELDING WIRE SELECTION CHART

DESCRIPTION	CLASS. AUS/ NZ STD (NEW)	CLASS. AWS STD	DIA.	PACK	PART NO	APPLICATION
Weldskill Gasless Welding Wire	B T 49 Z T11 1 NA	E71T-11	0.8mm	Minispool 0.9kg	WG0908	WeldSkill Gasless wire is an all positional self-shielded tubular flux cored wire recommended for single and multi-pass welding applications. It is excellent for lap, fillet and butt welding of thin gauged galvanised and mild steels. The resultant welds have a full coverage easy to scrape-off thin slag covering.
			0.9mm	Minispool 0.9kg	WG0909	

Note: Minispool = 100mm diameter

5.09 MIG (FCAW) WELDING TROUBLESHOOTING

SOLVING PROBLEMS BEYOND THE WELDING TERMINALS - INCONSISTENT WIRE FEED

Wire feeding problems can be reduced by checking the following points

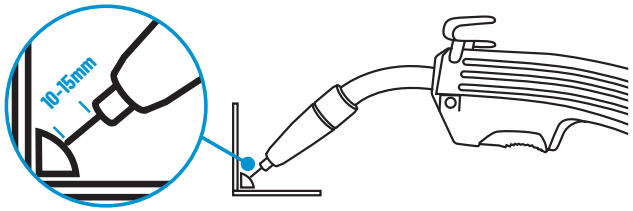
FAULT	CAUSE
1 Feed roll driven by motor in the wirefeed compartment slipping.	**A** Ensure that the feed roll is fitted correctly and matches size of wire being used. Refer to 5.04. **B** Replace feed roll if worn.
2 Wire rubbed against the mis-aligned guides and reduced wire feedability.	Mis-alignment of inlet/outlet guides.
3 Liner blocked with swarf	**A** Increased amounts of swarf are produced by the wire passing through the feed roll when excessive pressure is applied to the pressure roller adjuster. **B** Swarf can also be produced by the wire passing through an incorrect feed roll groove shape or size. **C** Swarf is fed into the conduit liner where it accumulates thus reducing wire feedability.
4 Incorrect or worn contact tip.	**A** The contact tip transfers the weld current to the electrode wire. If the hole in the contact tip is too large then arcing may occur inside the contact tip resulting in the wire jamming in the contact tip.
5 Poor work lead contact to work piece.	If the work lead has a poor electrical contact to the work piece then the connection point will heat up and result in a reduction of power at the arc
6 Bent liner.	This will cause friction between the wire and the liner thus reducing wire feedability.

THE IMPORTANCE OF A CORRECT STICKOUT

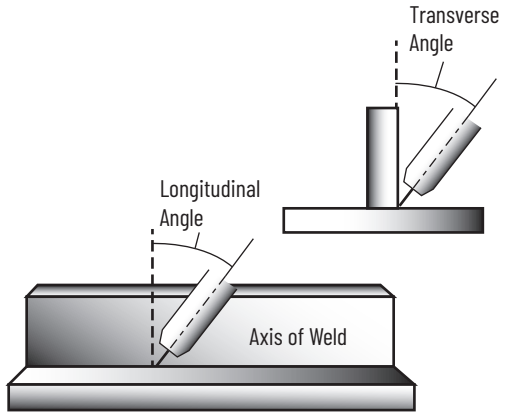
Stickout refers to the length of wire that extends beyond the contact tip of the welding gun during welding.

The Stickout is a critical parameter in gasless welding and plays a significant role in determining the quality and overall result of the weld.

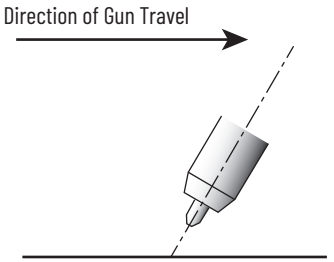
A correct Stickout for welding with gasless wire should be 10-15mm which is measured from the end of the Contact Tip to the Weld Pool.



Nozzle Angle. This refers to the position of the welding gun in relation to the joint. The transverse angle is usually one half the included angle between plates forming the joint. The longitudinal angle is the angle between the centre line of the welding gun and a line perpendicular to the axis of the weld. The longitudinal angle is generally called the Nozzle Angle and dragging (pulling). Whether the operator is left handed or right handed has to be considered to realize the effects of each angle in relation to the direction of travel.



Transverse and Longitudinal
Nozzle Axes



Nozzle Angle, Right Handed Operator

NOTE

Right Hand Operator direction of travel is Left to Right.

Left Hand Operator direction of travel is Right to Left

ESTABLISHING THE ARC AND MAKING WELD BEADS

Before attempting to weld on a finished work piece, it is recommended that practice welds be made on a sample of the work piece, as that of the finished piece.

The easiest welding procedure for the beginner to experiment with MIG welding is the flat position. The equipment is capable of flat, vertical and overhead positions.

For practicing MIG welding, secure some pieces of 1.5mm or 2.0mm mild steel plate 150 x 150mm. Use 0.8mm flux cored gasless wire.

BASIC MIG GASLESS (FCAW) WELDING TROUBLESHOOTING

FAULT	CAUSE	REMEDY
1 Undercut	**A** Welding arc voltage too high	**A** Decrease voltage or increase the Wire Feed Speed.
	B Incorrect gun angle	**B** Adjust angle.
	C Excessive heat input	**C** Increase the gun travel speed and/or decrease welding current by decreasing the voltage or decreasing the Wire Feed Speed.
2 Lack of penetration	**A** Welding current too low	**A** Increase welding current by increasing Wire Feed Speed and increasing voltage.
	B Joint preparation too narrow or gap too tight	**B** Increase joint angle or gap.
3 Lack of fusion	Voltage too low	Increase voltage.
4 Excessive spatter	**A** Voltage too high	**A** Decrease voltage or increase the Wire Feed Speed control.
	B Voltage too low	**B** Increase the voltage or decrease Wire Feed Speed.
5 Irregular weld shape	**A** Incorrect voltage and current settings. Convex, voltage too low. Concave, voltage too high.	**A** Adjust voltage and current by adjusting the voltage control and the Wire Feed Speed control.
	B Wire is wandering.	**B** Replace contact tip.
	C Insufficient or excessive heat input	**C** Adjust the Wire Feed Speed control or the voltage control.
6 Weld cracking	**A** Weld beads too small	**A** Decrease travel speed.
	B Weld penetration narrow and deep	**B** Reduce current and voltage and increase MIG Gun travel speed.
	C Excessive weld stresses	**C** Increase weld metal strength or revise design
	D Excessive voltage	**D** Decrease voltage.
	E Cooling rate too fast	**E** Slow the cooling rate by preheating part to be welded or cool slowly.
7 Cold weld puddle	**A** Loose welding cable connection.	**A** Check all welding cable connections.
	B Low primary voltage	**B** Contact supply authority.
	C Fault in power source	**C** Have an Accredited CIGWELD Service Provider to test then replace the faulty component.

5.10 MIG (FCAW) WELDING PROBLEMS

NOTE
Also refer to Error Codes in Section 6.06.

PROBLEM	CAUSE	REMEDY
1 Mains Supply Voltage is On, the On/Off switch on the rear panel is in the On position and the Front Panel Digital Display is illuminated however the power source will not MIG weld.	**A** Work Lead is not connected to the work piece.	**A** Ensure that the Work Lead is connected to the work piece and has a good connection to the work piece. Refer to Set Up for MIG Section 5.07.
2 When welding at maximum output (WFS and Volts) the machine stops welding.	**A** When output Amps (A) exceeds the rated maximum output of the machine the welding machine will sense this and initiates a safety circuit which stops the output current. Refer to Section 6.05 Error Codes for further detail.	**A** Reduce output Amps (A) (WFS and Volts).
	B Contact Tip of the MIG gun is too close to the work piece.	**B** Increase distance between the Contact Tip of the MIG gun and the work piece.
	C The Pre-set voltage is too high.	**C** Decrease the Pre-set voltage.
	D The MIG Welding Wire in use is not consistent with the selected MIG wire diameter, e.g. 0.8mm wire is selected but 0.9mm wire is used.	**D** Ensure that the correct MIG Welding Wire Diameter is selected for MIG Wire being used. Refer to Section 5.05.
3 Mains Supply Voltage is On, the On/Off switch in the rear panel is in the On position but the Front Panel Digital Display is Not illuminated and the power source will not weld.	This may occur due to the activation of an in-built protective device if the Power Source is repeatedly switched On then Off rapidly or the supply to the Power Source is switched On then Off rapidly.	If this occurs leave the Power Source On/Off switch in the Off position for several minutes to allow the protective device to reset.
4 The power source will not commence welding when the gun trigger switch is depressed and -P- -E2 Error Code is showing on the Front Panel Digital Display. This indicates an Over Temperature condition has occurred. Refer to Section 6.05 Error Codes for further detail.	Duty cycle of the Power Source has been exceeded. Refer to the Rating Label on the Rear Panel of Power Source for Duty Cycle Ratings. Check stickout well as per section 5.09.	Leave the power source switched ON and allow it to cool. Note that -P- -E2 Error Code must be cleared from the Front Panel Digital Display prior to commencement of welding.

PROBLEM	CAUSE	REMEDY
5 The Power Source will not feed MIG wire.	**A** Incorrect wire size on Feed Roll selected for MIG wire being used.	**A** Select the correct MIG wire size on feed roll to match the MIG wire being used. See Section 5.04 for feed roll fitting details.
	B Pressure Roller Arm is not secured in the correct position or not correctly adjusted.	**B** Secure Pressure Roller in the correct position and ensure that it is correctly adjusted. Refer to Section 5.02 and 5.03
	C MIG wire stuck in conduit liner or contact tip (burn-back jam).	**C** Check for clogged / kinked MIG Gun conduit liner or worn contact tip. Replace faulty components.
	D Wire on MIG Wire spool may be tangled or not coming off the Wire Spool correctly.	**D** Check Wire Spool for any tangles or crossovers in MIG wire and correct.
	E Wire Feed Motor Overload Error Code -P- -E3 is showing on the Front Panel Display.	**E** If the Error Code -P- -E3 is still remaining on the Front Display Panel despite performing these actions have an Accredited CIGWELD Service Provider investigate the fault.
6 Welding wire continues to feed when MIG Gun trigger is released.	**A** MIG Gun Trigger in 4T Mode	**A** Change MIG Gun Trigger Mode to 2T.
	B MIG Gun trigger leads shorted, or faulty MIG Gun Trigger.	**B** Check trigger switch operation. If the MIG Gun is damaged and requires replacement as it is a direct connect MIG Gun it will be required to be repaired or replaced by an Accredited CIGWELD Service Provider.
7 Inconsistent wire feed.	**A** Worn or dirty contact tip.	**A** Replace if necessary.
	B Incorrect MIG wire size selected on Feed Roll for MIG wire being used or Feed Roll is worn.	**B** Replace if necessary.
	C Wire on MIG Wire spool may be tangled or not coming off the Wire Spool correctly.	**C** Check Wire Spool for any tangles or crossovers in MIG wire and correct.
	D Worn, kinked or dirty conduit liner	**D** Clean or replace conduit liner.
	E Pressure Roller Arm is not secured in the down position or not correctly adjusted.	**E** Secure Pressure Roller in the down position and ensure that it is correctly adjusted. Refer to Section 5.04 and 5.05.

SECTION 6: ROUTINE SERVICE REQUIREMENTS, RESTORE FACTORY DEFAULT SETTINGS AND ERROR CODES

6.01 ROUTINE MAINTENANCE & INSPECTION

ELECTRICAL WARNING

There are extremely dangerous voltage and power levels present inside this product. Do not attempt to open or repair unless you are a qualified electrical tradesperson. Disconnect the Welding Power Source from the Mains Supply Voltage before disassembling.

Welding equipment should be regularly checked by a qualified electrical tradesperson to ensure that:

- The main earth wire of the electrical installation is intact.
- Power point for the Welding Power Source is effectively earthed and of adequate current rating.
- Plugs and cord extension sockets are correctly wired.
- Flexible cord is of the 3-core tough rubber or plastic sheathed type of adequate rating, correctly connected and in good condition.
- Welding terminals are shrouded to prevent inadvertent contact or short circuit.
- The frame of the Welding Power Source is effectively earthed.
- Gasless MIG Gun and Work Return Lead are in good condition.
- The Welding Power Source is clean internally, especially from metal filing, slag, and loose material. If any parts are damaged for any reason, replacement is recommended.

6.02 CLEANING THE WELDING POWER SOURCE

To clean the Welding Power Source, open the side door and use a vacuum cleaner to remove any accumulated dirt, metal filings, slag and loose material. Keep surfaces clean as accumulated foreign material may reduce the welders output welding current. Cover your welding machine when not in use, or store it away in a cupboard or suitable container to keep dust, moisture and vermin out of your machine.

CAUTION

Do not use compressed air to clean the Welding Power Source. Compressed air can force metal particles to lodge between live electrical parts and earthed metal parts within the Welding Power Source. This may result in arcing between this parts and their eventual failure.

6.03 CLEANING THE FEED ROLLS

Clean the grooves in the drive rolls frequently. This can be done by using a small wire brush. Also wipe off or clean the grooves on the upper feed roll. After cleaning, tighten the feed roll retaining knobs.

6.04 BASIC TROUBLESHOOTING

ELECTRICAL WARNING

There are extremely dangerous voltage and power levels present inside this product. Do not attempt to open or repair unless you are a qualified electrical tradesperson and you have had training in power measurements and troubleshooting techniques.

If major complex subassemblies are faulty, then the Welding Power Source must be returned to an Accredited CIGWELD Service Agent for repair.

The basic level of troubleshooting is that which can be performed without special equipment or knowledge.

6.05 RESTORE FACTORY DEFAULT SETTINGS

Figure 6-1: Restore Factory Default Settings

The BLUEVENOM MG130 can have Factory Default Settings restored.

To reset to factory settings switch the Power Source On/Off Switch on the rear panel to the Off position.

Once the Power Source has turned Off hold the 2T/4T button on the front panel depressed whilst switching the On/Off Switch to the On position until a series of dashes briefly display on the Front Digital Display indicating that a Factory Reset has been completed.

6.06 BLUEVENOM MG130 ERROR CODES

ERROR CODE	CAUSE	REMEDY
_P_E2  Figure 6-2: Over Temperature	Over Temperature	**A** Duty cycle of the Power Source has been exceeded. Leave the power source switched ON with the fan running and allow it to cool. Refer to the Rating Label on the Rear Panel of Power Source for Duty Cycle Ratings. **B** Check front and rear Panel Air Louvres are clean and not blocked by any dirt or obstacles. If damaged they should be replaced by an Accredited CIGWELD Service Provider. **C** Check that the fan is running normally during welding. If the fan is not running during welding it may be faulty and need replacing. Contact an Accredited CIGWELD Service Provider. Note this unit has Fan on Demand fitted. Refer to Section 4.01.8 for further details.
_P_E3  Figure 6-3: Wire Feed Motor Overload	Wirefeed Motor Overload	**A** MIG wire jammed in conduit liner or contact tip. (burn-back jam). Check for clogged / kinked MIG Gun conduit liner or worn contact tip. Replace faulty components. **B** Check Feed Roll Pressure adjustment and adjust if necessary. Refer to Section 5.03. **C** Check Wire Spool for any tangles or crossovers in MIG wire and correct. **D** If the fault persists despite performing these actions contact an Accredited CIGWELD Service Provider.

ERROR CODE	CAUSE	REMEDY
_P_E6  Figure 6-4: Output Over Current	Output Over Current	**A** Turn the power source OFF then turn the power source back ON. **B** Set the output current according to the rating label located on bottom panel of the Power Source. Check the welding stickout as per section 5.09. **C** If Error screen is still present contact an accredited CIGWELD Service Provider.
_P_E9  Figure 6-6: Thermal Protection Circuit Error	Thermal Protection Circuit Error	**A** Contact an Accredited CIGWELD Service Provider.

SECTION 7: KEY SPARE PARTS

7.01 BLUEVENOM MG130 KEY SPARE PARTS

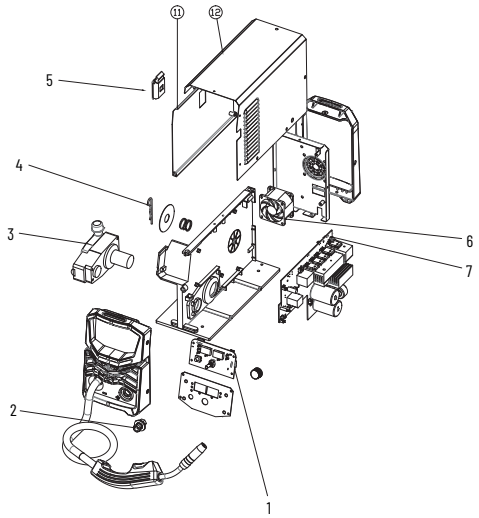


Figure 7-1: BlueVENOM MG130 Key Spare Parts

BLUEVENOM MG130 POWER SOURCE KEY SPARE PARTS

ITEM	PART NUMBER	DESCRIPTION	NOTE
1	W7007461	LED Display PCB	
2	W7007464	Dinse Socket 50mm^2	
3	W7007463	Wire Drive Assembly	
4	W7007465	Wire Spool R Clip Kit	Includes Retaining R-Clip, Spring and Washer
5	W7007357	Door Latch	
6	W7007462	Fan Assembly	
7	W7007460	Power Inverter PCB	

APPENDIX 1:
BLUEVENOM MG130 CIRCUIT DIAGRAM

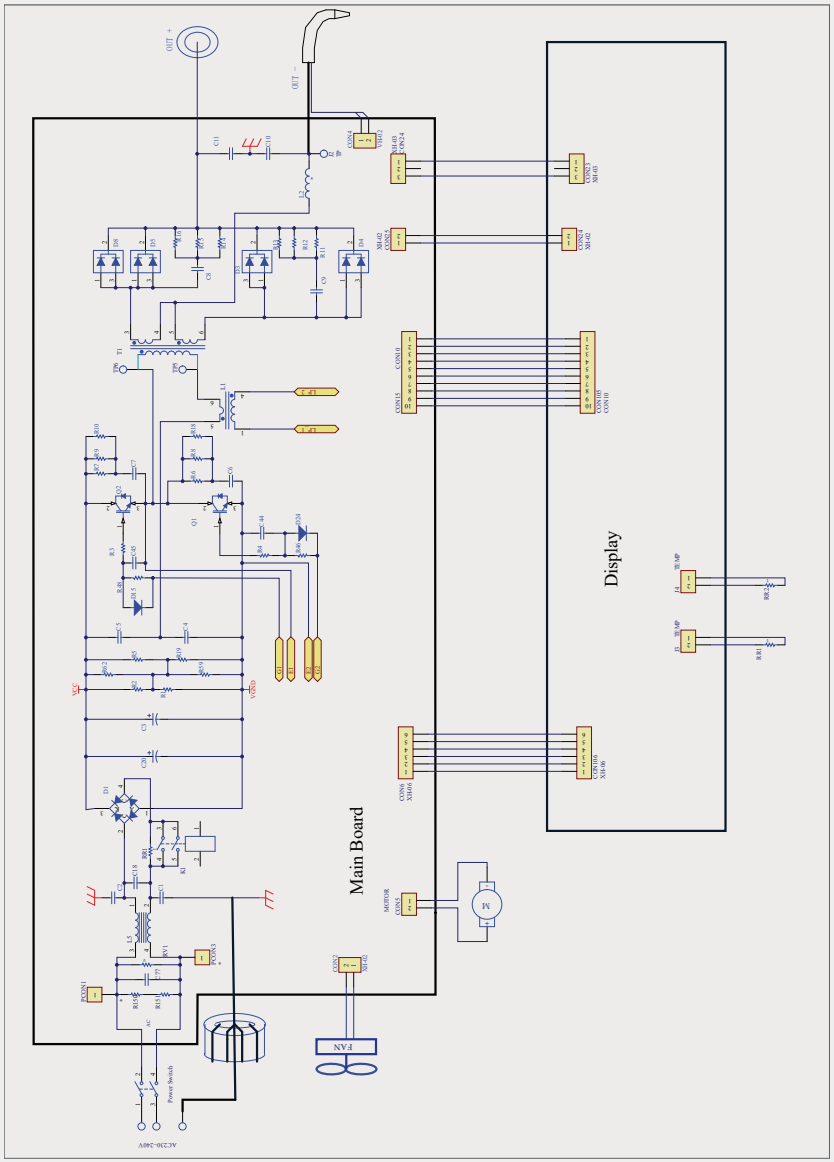


Figure 9-3 BlueVENOM MG130 Circuit Diagram

CIGWELD
AN ESAB BRAND

LIMITED WARRANTY TERMS

LIMITED WARRANTY: CIGWELD Pty Ltd, An ESAB Brand, hereafter, "CIGWELD" warrants to customers of its authorized distributors hereafter "Purchaser" that its products will be free of defects in workmanship or material. Should any failure to conform to this warranty appear within the time period applicable to the CIGWELD products as stated below, CIGWELD shall, upon notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with CIGWELD's specifications, instructions, recommendations and recognized standard industry practice, and not subject to misuse, repair, neglect, alteration, or accident, correct such defects by suitable repair or replacement, at CIGWELD's sole option, of any components or parts of the product determined by CIGWELD to be defective.

CIGWELD MAKES NO OTHER WARRANTY, EXPRESS OR IMPLIED. THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHERS, INCLUDING, BUT NOT LIMITED TO ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE.

LIMITATION OF LIABILITY: CIGWELD SHALL NOT UNDER ANY CIRCUMSTANCES BE LIABLE FOR SPECIAL, INDIRECT OR CONSEQUENTIAL DAMAGES, SUCH AS, BUT NOT LIMITED TO, LOST PROFITS AND BUSINESS INTERRUPTION.

The remedies of the Purchaser set forth herein are exclusive and the liability of CIGWELD with respect to any contract, or anything done in connection therewith such as the performance or breach thereof, or from the manufacture, sale, delivery, resale, or use of any goods covered by or furnished by CIGWELD whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not, except as expressly provided herein, exceed the price of the goods upon which such liability is based. No employee, agent, or representative of CIGWELD is authorized to change this warranty in any way or grant any other warranty.

PURCHASER'S RIGHTS UNDER THIS WARRANTY ARE VOID IF REPLACEMENT PARTS OR ACCESSORIES ARE USED WHICH IN CIGWELD'S SOLE JUDGEMENT MAY IMPAIR THE SAFETY OR PERFORMANCE OF ANY CIGWELD PRODUCT. PURCHASER'S RIGHTS UNDER THIS WARRANTY ARE VOID IF THE PRODUCT IS SOLD TO PURCHASER BY NON-AUTHORIZED PERSONS.

The warranty is effective for the time stated below beginning on the date that the authorized distributor delivers the products to the Purchaser. Notwithstanding the foregoing, in no event shall the warranty period extend more than the time stated plus one year from the date CIGWELD delivered the product to the authorized distributor.

Any claim under this warranty must be made within the warranty period which commences on the date of purchase of the product. To make a claim under the warranty, take the product (with proof of purchase from a CIGWELD Accredited Seller) to the store where you purchased the product or contact CIGWELD Customer Care 1300 654 674 for advice on your nearest Service Provider. CIGWELD reserves the right to request documented evidence of date of purchase. CIGWELD or our Accredited Distributor must be notified in writing of its claim within seven (7) days of becoming aware of the basis thereof, and at its own expense returning the goods which are the subject of the claim to CIGWELD or nominated Accredited Distributor/Accredited Service Provider

This warranty is given.
CIGWELD Pty Ltd A.B.N. 56007226815
71 Gower Street, Preston Victoria, Australia, 3072
Phone: 1300 654 674
Email: enquiries@cigweld.com.au
Website: www.cigweld.com.au

This warranty is provided in addition to other rights and remedies you have under law: Our goods come with guarantees which cannot be excluded under the Australian Consumer Law. You are entitled to replacement or refund for a major failure and to compensation for other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

Please note that the information detailed in this statement supersedes any prior published data produced by CIGWELD.

WARRANTY SCHEDULE – BLUEVENOM MG130 INVERTER

WARRANTY	WARRANTY PERIOD (PARTS AND LABOUR)
BlueVENOM MG130 Power Source	2 Years

ACCESSORIES	WARRANTY PERIOD
MIG Gun and work lead	3 Months
MIG Gun consumable items	NIL

CIGWELD LIMITED WARRANTY DOES NOT APPLY TO;

- Obsolete goods sold at auction, second-hand goods and prototype goods.
- Consumable Parts for MIG, Plasma welding, Plasma cutting and Oxy fuel torches, O-rings, fuses, filters or other parts that fail due to normal wear.

Notes:

* No employee, agent, or representative of CIGWELD is authorized to change this warranty in any way or grant any other warranty, and CIGWELD shall not be bound by any such attempt. Correction of non-conformities, in the manner and time provided herein, constitutes fulfilment of CIGWELD's obligations to purchaser with respect to the product.

* This warranty is void, and seller bears no liability hereunder, if purchaser used replacement parts or accessories which, in CIGWELD's sole judgment, impaired the safety or performance of any CIGWELD product and if the unit is altered or serviced by an unauthorised CIGWELD Service Provider. Purchaser's rights under this warranty are void if the product is sold to purchaser by unauthorized persons.

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AN **ESAB** BRAND

Version: AA **Issue Date: 01-10-2023** **Manual No: 0-5700**

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