

PATON

USER MANUAL
ПОСІБНИК КОРИСТУВАЧА
РУКОВОДСТВО ПОЛЬЗОВАТЕЛЯ

MINI
/MINI-C

ECO-160
/ECO-160-C

ECO-200
/ECO-200-C

ECO-250
/ECO-250-C



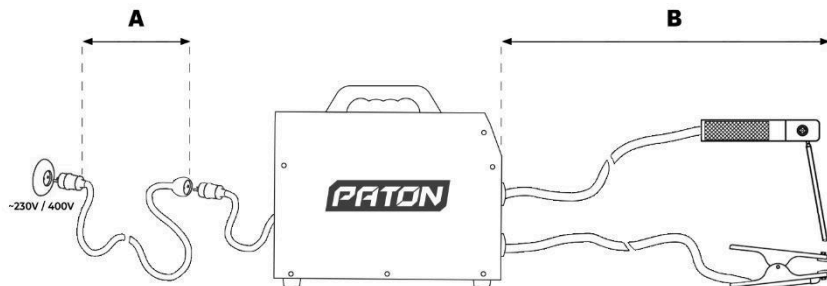


ENGLISH

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ATTENTION: Only use extension cables with the cross-section, length and appropriate certificates for the area of application. Always fully unroll the cable when using the cable reel. Avoid the formation of loops or knots on the power/extension cable.
(*values are indicated below)



Electrode diameter	Set current value	[A] Cross section of extension cable, mm ²	[A] Maximum length of extension cable, m
230V – MINI, ECO-160, ECO-200, ECO-250			
Ø2 mm	Not more than 80A	1,0	75
		1,5	115
		2,0	155
		2,5	195
		4,0	310
Ø3 mm	Not more than 120A	6,0	465
		1,5	75
		2,0	105
		2,5	130
Ø4 mm	Not more than 160A	4,0	205
		6,0	310
		2,0	75
		2,5	95
Ø5 mm Fusible	Not more than 200A	4,0	155
		6,0	230
		2,5	75
Ø5 mm refractory	Up to 250A	4,0	125
		6,0	185
		2,5	60
		4,0	100
		6,0	150

ATTENTION! The power button on the back of the MINI and ECO-160/200/250 series is not a power button, therefore the power supply to all internal electronics is not completely disconnected when the unit is switched off. For this reason, remember to disconnect the plug from the power supply after welding work for safety reasons.

1. GENERAL INFORMATION

PATON™ MINI, ECO-160, ECO-200, ECO-250, inverter rectifiers are designed for manual direct current MMA arc welding. The MINI and ECO series are designed for demanding users who need a compact and functional device with a full current rating of 150A/160A/200A/250A respectively.

This is sufficient to work with any electrode from $\varnothing 1.6\text{mm}$ to $\varnothing 6\text{mm}$. The duty cycle of the equipment is 40% which allows it to perform most tasks in the home sector as well as semi-professional (auto repair shops, etc.).

All PATON™ MINI and ECO models have an under- and over-voltage protection system.

The current stabilization system integrated in the device ensures compatibility with various power sources. By maintaining a constant level of input current, regardless of voltage fluctuations originating from the power source, the welding machine can operate correctly and efficiently in different power conditions, such as when using a generator or extension cords.

Main advantages:

1. In addition to protection against voltage surges, a stabilization system is installed for operation with significant long-term voltage drops in the supply mains from 170V to 260V.
2. Adapted to the standard power grid. Due to its high efficiency, the power source provides half the power consumption of traditional sources;
3. Convenience of work due to the long load duration at nominal current, which allows continuous welding with $\varnothing 3$ mm electrodes even with the weakest device of the series (at an ambient temperature of 25°C);
4. High reliability of equipment in production conditions with high dust and high humidity;
5. All electronic components of the device are impregnated with two layers of high-quality varnish, which ensures the reliability of the product throughout its lifetime;
6. Infinitely adjustable welding current;
7. Improved arc glow stability.
8. The device has the capability to be powered by a **power generator** or by utilizing lengthy **extension cables**;
9. All heating elements of the source are equipped with an electronic thermal protection system;
10. Ensures consistent fan speed regardless of machine load, delivering stable and continuous cooling performance under all operating conditions.

TECHNICAL CHARACTERISTICS	MINI	ECO-160	ECO-200	ECO-250
Rated supply voltage, V	230	230	230	230
Frequency (50/60 Hz), Phases	1	1	1	1
Supply voltage variation limits, V	+13%	+13%	+13%	+13%
	-30%	-30%	-30%	-30%
Fuse, inert (A)	19	20	25	32
Plug	Schuko	Schuko	CEE-3x32	CEE-3x32
Nominal welding current, A	150	160	200	250
Maximum welding current, A	180	190	240	300
Load duration (LD), 100 %. (A)	94	101	126	158
Load duration (LD), 60 %. (A)	120	130	160	200
Duty cycle at max. current - DC	40%	40%	40%	40%
Welding electrodes (mm)	1.6 - 4.0	1.6 - 4.0	1.6 - 5.0	1.6 - 6.0
Welding current control range (A)	20 – 150	20 – 160	25 – 200	32 – 250
"HOT-START" Function	Automatic			
"ARC FORCE" Function	Automatic			
"ANTI-STICK" Function	Automatic			
No-load voltage, V	up to 80	up to 80	up to 80	up to 80
Arc ignition current voltage, V	110			
Nominal consumption, KVa	4,0	4,4	5,5	7,0
Maximum consumption, kVA	5,0	5,5	6,9	8,8
Energy efficiency, %	90			
Cooling	Forced			
Operating temperature range	-25 ... +45°C			
Overall dimensions (length, width, height), mm:	200 x 100 x 235	200 x 100 x 240	270 x 110 x 240	270 x 110 x 240
Weight without accessories, kg	3,3	3,7	4	4,35
Standards and approvals	EN IEC 60974-1	EN IEC 60974-1	EN IEC 60974-1	EN IEC 60974-1
Protection class*	IP21	IP21	IP21	IP21
Transformer insulation class	H	H	H	H
Test standard	CE, EAC	CE, EAC	CE, EAC	CE, EAC
* Limitation (A)				

With reduced power, the ECO-200 and ECO-250 power sources can also be supplied from the 1-phase mains using a Schuko plug and a suitable adapter. Pay attention to the specified

maximum welding current values to avoid overloading the mains supply and tripping the fuse. For single-phase operation with a Schuko plug, a maximum of 160 A is recommended.

* IP21 housing prevents particles with a diameter of more than 12.5 mm from entering the product, and vertically dripping water does not interfere with the unit operation.

RECOMMENDED LENGTH OF WELDING CABLES WITH ELECTRODE HOLDER DURING WELDING:

Maximum current	[B] Cable length (one way), m	Cross-section area
Not more than 160A	1...4	8 mm ²
	2...5	10 mm ²
	3...8	16 mm ²
Not more than 200A	1...4	10 mm ²
	2...6,5	16 mm ²
	3...10	25 mm ²
Not more than 250A	1...6	16 mm ²
	2...9	25 mm ²
	3...13	35 mm ²



fig.1. Setting elements and display

- 1 – Digital seven-segment display
- 2 – Regulator of welding current, allowing to smoothly adjust the welding current.
- 3 – Power supply status indicator:
 - a) lights up green - the unit is ready for operation;
 - b) off – no power supply or low voltage in the mains;
- 4 – Unit operation indicator:
 - a) off (green light) - normal state of the device;
 - b) red light (yellow) - overheating.
- 5 – Main power on/off switch
- 6 – Power cable for the device.

A – Current socket "+" socket type - bayonet: for MMA welding

- the MMA electrode cable is connected (in very rare cases of using special electrodes, the "ground" cable is connected).

B – Current socket "-" socket type - bayonet: for MMA welding

- ground holder "ground" is connected (in very rare cases, using special electrodes, an electrode wire is connected)

2. START UP OF THE DEVICE

ATTENTION: Before starting up the device, please read section 11 "Safety rules".

2.1 INTENDED USE

The welding device is designed exclusively: for manual metal arc welding with covered electrode "MMA". Any modification of the device may adversely affect safety. Therefore, any interference with the device, safety components or their misuse for other purposes is expressly prohibited. Failure to comply with this prohibition will result in the loss of all warranty and product liability claims.

The product has been developed in accordance with generally approved principles of technology and with regard to efficiency and operational safety and may therefore be awarded the CE mark, which confirms these properties.

The use of the welding machine is appropriate if all the requirements of these operating instructions are met. Start-up and operation may only be carried out by qualified personnel who have been instructed about the product and trained in the operation of the welding equipment, provided that the welding unit, power cable and fitted accessories are used as intended and are in perfect working order.

2.2 PLACEMENT REQUIREMENTS

The units are protected against the ingress of extraneous solids with a diameter of more than 12.5 mm.

The equipment can be located and operated outside. The internal electrical parts of the units are protected from direct moisture.

ATTENTION! After welding work in hot weather or intensive welding work in any weather, do not switch off the unit immediately! It is necessary for the electronic components to cool down within 5 minutes.

ATTENTION! When operating the device in cold seasons, condensed water may appear inside after the device has been switched off and cooled down! Switch the welding unit on again 3 - 4 hours after switching it off. For this reason, do not switch off the welding unit in cold seasons if you plan to switch it on no later than 4 hours after switching it off.

ATTENTION! The device can be life-threatening if hit hard on the ground. Place on a stable hard surface.

The unit should be positioned in such a way as to ensure a free flow of cooling air through the vents on the front and rear covers of the unit. Pay attention to metal filings (which are generated, for example, during grinding), these should not be directly absorbed into the unit by the fan.

2.3 CONNECTING TO THE POWER GRID

The welding unit as standard is connected to the power supply:

1. Mains voltage 230V (-27% +18%) - for MINI devices, ECO-160/200/250;

ATTENTION: The device is connected to a mains voltage higher than 270 V (for MINI, ECO-160/200/250), all manufacturer's warranty obligations are void! The mains connection, cross-section of the supply cables and mains fuses must be selected on the basis of the technical data of the unit.

2.4 CONNECTING THE POWER PLUG

ATTENTION: The plug must match the supply voltage and current consumption of the welder (see technical data). Use sockets with guaranteed earthing according to safety regulations!

3. MANUAL METAL ARC (MMA) WELDING

ATTENTION! Due to unblocked connectors of the welding current connection (device connection) or dirt on the workpiece connection (paint, corrosion), the connection areas and wires can get hot and you can get burned if you touch them!

Daily check the welding current connections and, if necessary, lock them by turning them clockwise.

Thoroughly clean the workpiece connection area and attach properly! Do not use the workpiece structure parts as the welding current return line!

- insert the electrode holder into the source A "+" socket;
- insert the "earth" cable into the source B "-" socket;
- connect the "earth" cable to the material;
- connect the power plug to the mains;
- set the power switch (5) on the rear panel to the "ON" position;

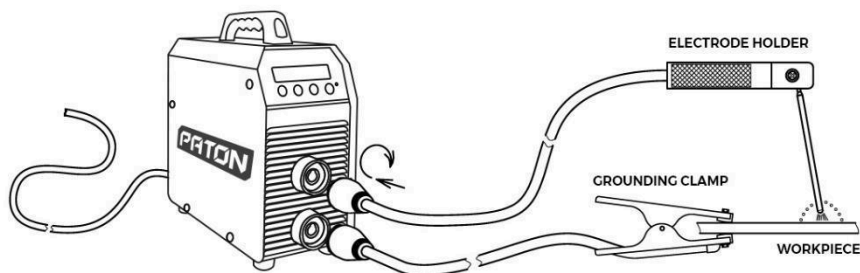


Fig. 2. Electrical diagram of MMA stick welding machine

ATTENTION! After the power switch (5) has been switched to the "ON" position, the covered electrode is under voltage. Do not touch the electrode to conductive objects or earthed objects such as, for example, the unit housing, etc. as the device will perceive this condition as a signal to start the welding process.

3.1 "HOT-START" FUNCTION

The advantages provided by the function are as follows:

- better ignition even when using low-ignition electrodes;
- better penetration of the base material during ignition, and thus less damage;
- preventing the formation of slag inclusions.

This is achieved by: For a short time at the moment of arc ignition, the welding current increases by a default level of +40%. (fig. 3).

Example: welding with $\varnothing 3\text{mm}$ electrode

The value of the welding current set by the regulator is 90A.

The Hot Start current is $90\text{A} + 33\% = 120\text{A}$.

3.2 "ARC-FORCE" FUNCTION

The advantages provided by the function are as follows:

- improves the stability of short-circuit arc welding;
- improves the transfer of metal droplets into the weld pool;
- improved arc ignition;
- reducing the probability of electrode sticking.

This is achievable through:

If the arc voltage is reduced below the minimum acceptable level for stable arc combustion, the welding current value increases by 30% of the set value (Figure 4).

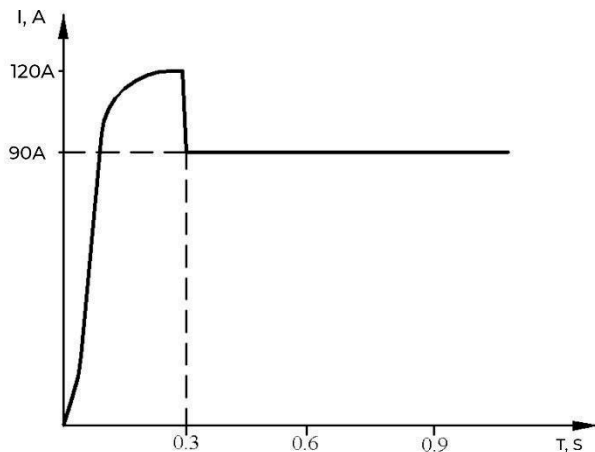


Fig. 3 Hot-Start function

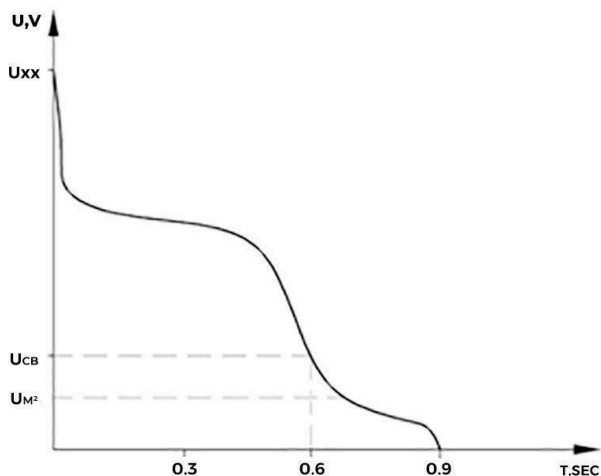


Fig. 4 Arc-Force function

3.3"ANTI-STICK" FUNCTION

During the initial arc ignition, the electrode can stick to the weld material which in turn can lead to overheating and subsequent damage to the electrode.

In this situation, the device reduces the welding current after 0.6...0.8 s. This makes it easier for the welder to separate (detach) the electrode from the material being welded

without the risk of burning his eyes by accidental arc ignition. Once the electrode is detached from the material, the welding process can continue unhindered.

4. MAINTENANCE AND SERVICING

ATTENTION!: Before opening the device, switch it off, remove the plug from the socket. Wait (about 5 minutes) for the device's internal electrical circuits to discharge, and only then carry out the remaining operations. If you walk away from the device, it is advisable to place a plate indicating that the device should not be switched on.

To keep your device in good condition for years to come, follow the recommendations:

- Perform safety checks at specified intervals (see section "Safety rules");
- In the event of intensive use, it is recommended to clean the unit every six months with compressed air. **ATTENTION!:** Blowing from too close a distance may damage electronic components;
- If there is a lot of dust, manual cleaning of the cooling system ducts is recommended.

5. GENERATOR OPERATION MODE

The power source is designed to work with the generator, provided that:

Electrode diameter	Set current value	Minimum generator power, kVA
\varnothing_2	not more than 80A	2,6
\varnothing_3	not more than 120A	4,1
\varnothing_4	not more than 160A	5,5
\varnothing_5 fusible	not more than 200A	6,9
\varnothing_5 refractory	not more than 250A	8,8

ATTENTION: For smooth operation, the output voltage of the generator must not exceed the permissible limits: 170-260V.

The power source can be supplied by various types of generators. However, some of these may not provide sufficient power for proper operation of the welding current source. Gensets with automatic voltage regulation (AVR) or an equivalent or better type of regulation, with the power rating specified in the operating manual.

6. STORAGE CONDITIONS

The used source should be stored in a dry closed room at a temperature of not less than 5 °C. The room must be free of fumes of acids or other chemically active substances.

7. TRANSPORTATION

The packaged device is suitable for transportation by all means of transport ensuring its safety, in accordance with the transport rules established for the mode of transport.

8. TECHNICAL PARAMETERS

ATTENTION! In the case of a power supply from an emergency source, the technical parameters are indicated on the rating plate on the rear panel. In this case, the power plug, mains cable must be selected according to the voltage used.

Parameters	MINI	ECO-160	ECO-200	ECO-250
Supply voltage 50/60 Hz, V	~230	~230	~230	~230
Supply voltage variation limits, V	170 – 260	170 – 260	170 – 260	170 – 260
Energy efficiency, %	90	90	90	90
Limits of regulation of welding current, A	20 – 150	20 – 160	25 – 200	32 – 250
Welding current at:				
10 min / 40%	150 A	160 A	200 A	250 A
10 min / 100%	94 A	101 A	126 A	158A
Maximum power consumption, kVA	5,0	5,5	6,9	8,8
Rated operating voltage: - MMA covered electrode, V	20,4 – 25,5	20,4 – 26	20,4 – 26,5	20,4 – 27,0

9.COMPLETION OF THE DEVICE






1. Power source with power cable - 1 pc;
2. Welding cable with electrode holder 3 m - 1 pc;
3. Welding cable with earth clamp 3 m - 1 pc;
4. Shoulder strap to carry device on shoulder - 1 pc;
5. Manual Operating instructions - 1 pc;
6. PATON™ branded cardboard box/plastic case - 1 pc.





**for MINI, ECO-160, ECO-200, ECO-250 models*

10. PROBLEM SOLVING

Fault	Reason	Solution
No welding current. Power switch is on, green power source indicator is not lit	Failure of the power supply cable	Check the power cable.
	The supply voltage is below 155V	Disconnect the device and connect it to the mains with the appropriate voltage
	Defective internal power supply system	Contact service provider
No welding current. Power switch is on, power source indicator lights up green	Welding cables are incorrectly screwed on.	Check condition of electrical connectors
	Ground clamp not correctly connected	Connect the ground clamp correctly with the workpiece
No welding current. Power switch is on, power source indicator lights up yellow	One of the temperature sensors has been activated	Wait until the device has cooled down, after which the device will switch on automatically
	Insufficient cooling air supply	Provide sufficient cooling air
	The temperature sensor was damaged	Contact the service
Bad ignition for welding with covered electrodes, source status indicator flashes yellow	The supply voltage at the beginning of the load is close to the minimum permissible value of 165 V	If it is not possible to increase the cross-section of the mains cables, try decreasing the set current until the arc can be struck. Then select the welding electrode with the welding current in mind.
During arc welding there is occasional arc stripping	The arc voltage is too high for the electrode used	If possible, use other electrodes or a more powerful welding machine.
The covered electrode sticks to the workpiece	Welding current value is too low	Set a higher welding current value
Poor welding quality (heavy spattering)	Incorrect polarity of the electrode	Change electrode polarity (as recommended by the electrode manufacturer)
	Poor ground contact	Attach the ground terminal as close as possible to the area to be welded

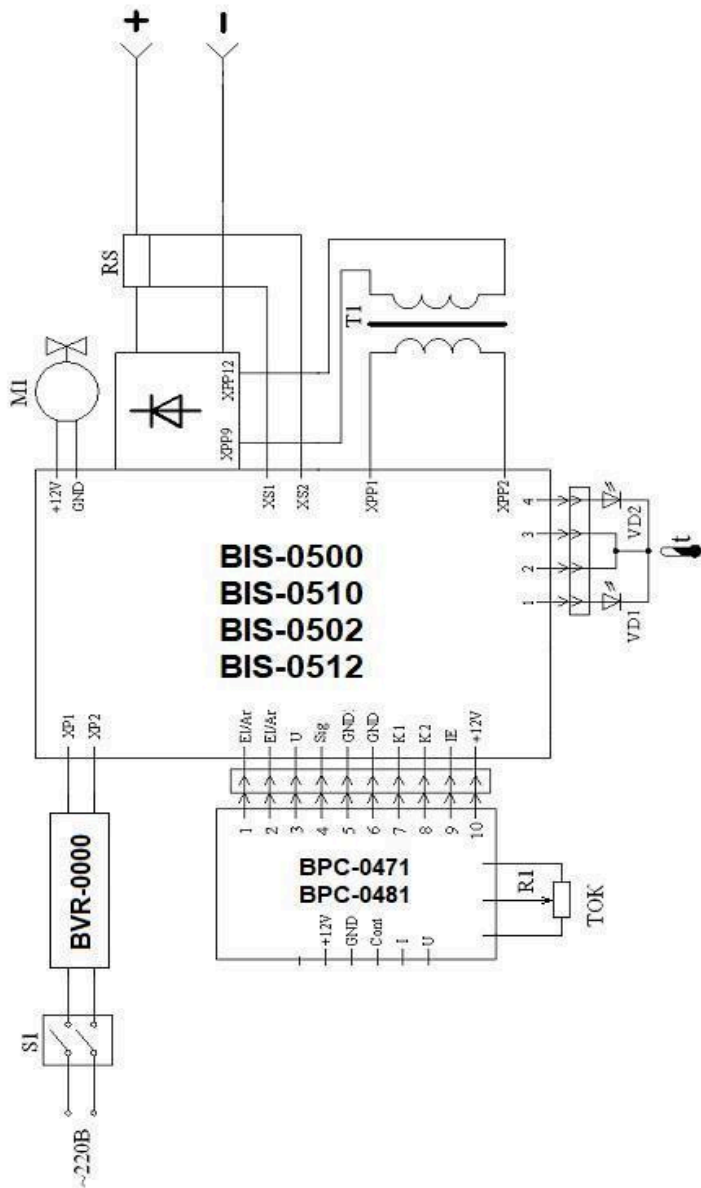
11. SAFETY RULES

	<p>The welder has been manufactured in accordance with technical standards and applicable safety regulations. However, in the event of improper handling there is a risk of</p> <ul style="list-style-type: none"> - Injury to the operator or third parties; - Damage to the machine itself or to the company's material assets; - Interference with the efficient flow of work.
	<p>OBLIGATIONS OF THE USER: The user undertakes to allow only those persons to work with the welding equipment who: are familiar with the basic safety rules, have been trained in the use of the welding equipment and are qualified. Have familiarised themselves with the section "Safety Regulations" and the precautionary guidelines given in this manual.</p>
	<p>DANGER FROM MAINS AND WELDING CURRENT:</p> <ul style="list-style-type: none"> - Electric shock can be fatal; - The welding cable must be strong, undamaged and insulated. Loose connections and damaged cables must be replaced immediately. Mains cables and welder cables must be checked regularly by a qualified electrician for proper insulation; - The outer casing of the unit must not be removed during use.
	<p>DANGER OF WELDING ARC RADIATION: It is not permitted to directly observe the welding arc with uncovered eyes. The arc and the spatter produced during the work may burn the skin or cause a flame, therefore a protective mask equipped with a tinted filter must be worn at all times (goggles should be equipped with DIN grade 9 10 filter glasses). Third parties in the area of operation must protect their eyes with special protective goggles or use non-flammable radiation-absorbing shields.</p>
	<p>DANGER OF HARMFUL GASES AND VAPOURS: The resulting smoke and harmful gases should be removed from the workplace with specialised equipment, ventilation openings must not be obstructed. Welding must be carried out in well-ventilated areas; welding fumes are hazardous to health, especially when welding materials such as lead, mercury, cadmium, zinc, beryllium and galvanised or stainless steel surfaces. Ensure sufficient fresh air flow in the room. Do not allow solvent vapours to enter the welding arc area.</p>
	<p>ELECTROMAGNETIC FIELD CAN BE DANGEROUS: The electromagnetic field created by the high voltage current flowing through the welding cables can adversely affect the performance of electrical equipment e.g. a cardiostimulator. People wearing such equipment should consult a doctor before entering an area where welding work is being carried out. Welding wires should be laid in parallel, as close together as possible.</p>

	<p>SPARKS CAN CAUSE FIRE OR EXPLOSION: Flammable items must be removed from the work area. Welding work must not be carried out around containers in which gases, fuels, petroleum products and other flammable products are stored. There is a risk of explosion of residues from these products. When carrying out welding work in explosive or fire-prone areas, special rules must be observed, which are in accordance with national and international standards. Fire fighting equipment such as: (powder or snow extinguishers, fire blankets) should be located near the work area in a visible, easily accessible place.</p>
	<p>ELECTRIC POWER SUPPLY: It is forbidden to work with damaged welding cables or on wet ground. Welding cables should be strong, undamaged and insulated. Weakened joints and damaged cable must be replaced immediately. The unit must not be moved by pulling the power cord or welding cables. Do not carry out any maintenance on the appliance while it is in operation. It is forbidden to remove the outer casing of the device while it is connected to the mains as well as to use the device with the cover removed.</p>
	<p>PERSONAL PROTECTIVE EQUIPMENT The following rules should be observed to ensure personal protection:</p> <ul style="list-style-type: none"> - wear sturdy footwear that retains insulating properties, even in wet conditions; - protect hands with insulating gloves; - Protect eyes with a protective mask with UV filter that meets safety standards; - Use only suitable (flame-retardant) clothing.
	<p>DANGER OF INTENSE NOISE The welding arc generated during welding can produce sound levels above 85 dB for up to 8 hours of working time. Welders working with the equipment must wear hearing protection during operation.</p>

12. ELECTRICAL SCHEME

Diagram of
electrical
connections
PATON™
ECO-160/200/2
50 DC MMA



13. WARRANTY OBLIGATIONS

PATON INTERNATIONAL LLC guarantees the proper operation of the device provided that the consumer complies with the handling, storage and transportation instructions.

ATTENTION!: In case of mechanical damage to the welder, free warranty service does not apply!

THE PERIOD OF THE MAIN WARRANTY FOR WELDING EQUIPMENT:

MODEL OF THE DEVICE	WARRANTY PERIOD
MINI	3 years
ECO-160	5 years
ECO-200	
ECO-250	

The warranty period begins on the day the device is sold to the end user based on a sales receipt, usually a delivery note and/or invoice.

If the product turns out to be defective, does not look or work as described, the customer has the right to a free repair, replacement, discount or refund.

The warranty exclusively covers damages that arise within the warranty period as a result of improper manufacturing of the sold product. Throughout the duration of the basic warranty, the service team pledges to implement the following actions for owners of PATON™ brand devices:

- Conducting a diagnosis to determine the cause(s) of the failure
- Providing the necessary components for the repair of the welding equipment
- Replacing defective components and parts
- Inspection of the repaired devices
- Free return of the repaired device
- The warranty period remains unaffected. Exception: for replaced parts, a warranty period of 6 months from the date of invoicing applies if the warranty period expires during the repair.

The warranty claimant is obliged to cooperate in the following manner:

- The purchased PATON welding power source, including any used accessories (such as cables, pressure regulators, torches, etc.), must be sent to the point of sale at the warranty claimant's expense.
- A document must be provided that conclusively verifies the date of purchase (e.g., delivery note/invoice) and clearly states the serial number.
- A completely filled out warranty card must be presented.
- Documents must be supplied fully completed in accordance with the information provided in the manual.

The following features are not covered by the factory warranty:

- Mechanical damages that impair the device's operation, such as the deformation of the casing or device parts due to a fall, the impact of a heavy object on the device, or damages to control elements, cables, or connectors;
- Signs of corrosion that have caused the malfunction;
- Environmental conditions, including the effects of high humidity on performance and electronic components, resulting in their damage;
- The accumulation of conductive dust (coal and grinding dust, metal filings, etc.), which has led to damage inside the device;
- Attempts to repair the device by the user themselves
- Damage resulting from the installation or insertion of unsuitable parts, the use of unauthorized accessories, or the application of inappropriate preservatives;
- Operation of the device with a non-approved generator.

Depending on operating conditions, it is recommended to regularly clean internal components and assemblies with compressed air to avoid failures. Before cleaning, remove the device's cover. Carefully clean the welding power source, holding the air gun at a sufficient distance to prevent damage to electrical components and mechanical connections. Please note that these tasks must be performed by a qualified electrician, followed by an inspection in line with the UK's Portable Appliance Testing (PAT) standards, including a detailed inspection report.

The fundamental warranty obligations do not apply to components of the welding equipment that are subject to operation and exposed to physical and/or chemical stress.

Claims related to the following will be accepted up to a maximum of two weeks after the date of sale, provided that the device shows no signs of use/damage due to external causes:

- the power on/off switch
- adjustment knobs / push buttons
- cable and plug connections
- control jacks
- the power cable and the plug of the power cable
- carrying handle, shoulder strap, case
- electrode holder and cable, torch, earth clamp and cable, and their sockets.

The seller reserves the right to refuse warranty repairs or to determine the month and year of manufacture of the device (identified by the serial number) as the commencement date of the warranty obligations.

- In case of loss of the warranty card by the owner,
- If the warranty card
 - is not filled out correctly, that is, in particular, completely and with truthful information including a legally valid signature,
 - is not sent within 30 days after receiving the welding power source by mail, fax, or email to the following address.

To maintain warranty claims, an annual, chargeable maintenance service is essential and must be documented by the warranty issuer in the event of a claim. The maintenance must be carried out at a PATON-certified service center.

THE WARRANTY IS VALID WITHIN THE UNITED KINGDOM

The copyright to this documentation remains the property of the manufacturer. Reproduction, even in part, is only allowed with written permission. The content of this document has been thoroughly checked and edited, however, we reserve the right to make changes, typographical errors, and mistakes.

14. INFORMATION ON DISPOSAL OF USED EQUIPMENT

The symbol shown on the products means that the device cannot be disposed of in the same way as household waste. The device must be handed over to an electrical equipment disposal point, where it will be accepted free of charge. Information about such collection points for used equipment can be found, for example, on websites. Proper disposal in accordance with Directive 2012/19/EU (WEEE) Waste Electrical and Electronic Equipment will preserve valuable natural resources and avoid environmental contamination. Failure to comply with the above recommendations may result in a fine in accordance with applicable regulations



If you wish to recycle the device, please contact your nearest retailer or contact the importer of the equipment, who will provide additional information.