User's Manual
MMA rectifier
PONTE 200J MOST

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INSTRUKCJA OBSŁUGI
USER MANUAL
PONTE 200J MOST

Warning! A copy of this manual should be kept
at the place of operation of the device and should always be available to the operator.
Warning! Every person using
or responsible for the maintenance of this device should read the entire contents of
this manual before starting work.
This will enable optimal use of the device's capabilities.

CE

Catalog number
PONTE 200J - 53 00 030691

User's Manual
version 1.0 dated 02.14.2026

Table of contents:

1.INTRODUCTION

Thank you for purchasing the **PONTE 200J** inverter welding machine from **MOST**. Please read this user manual before starting work.
The **PONTE 200J MOST** device is used for welding steel or stainless steel with a coated MMA electrode or the Lift TIG method. We hope you will be satisfied with this equipment. This manual can be supplemented with training conducted by our qualified personnel. If you are interested, please contact your nearest **RYWAL-RHC** Group branch (see the last page of the manual).

Recycling

In accordance with Directive 2012/19/EU WEEE II (WEEE – Waste Electrical and Electronic Equipment), the device must be recycled by a specialized company after it has been taken out of service. Do not dispose of used devices with normal waste!

The components used in the construction of both cutters do not contain critical raw materials in a total amount exceeding 1g in accordance with the requirements of the Ecodesign Directive 2009/125/EC and Regulation 2019/1784 Annex II point 3h.

Manufacturer:
RYWAL-RHC Sp. z o.o.
ul. Polna 140B, 87-100 Torun.

2. Manual Health and safety

	The use and maintenance of welding equipment can be dangerous. The user must follow health and safety rules to avoid accidents. Welding equipment may only be used by qualified personnel. Keep up to date with national regulations regarding the use of this equipment and accident prevention.
	Remove all combustible materials from the welding area before starting work. Do not weld in tanks that previously stored flammable liquids (fuel). Remove all combustible materials from the area where sparks may fly during welding. Welding may only be carried out in rooms that are adequately ventilated and equipped with fixed or mobile filter ventilation devices.
	Electricity. The device will only work properly if it is installed correctly. Disconnect the device during long breaks in operation. Do not leave the equipment unattended. Always make sure that the installation is grounded.
	The operator's skin is exposed to the danger of contact with welding arc radiation and aggressive substances. Wear appropriate protective clothing, footwear, and gloves. Take care to protect bystanders from the ultraviolet radiation emitted by the welding arc. Harmful gases and fumes are produced during welding. Use respiratory protection. The noise generated during welding or soldering can damage your hearing. Use personal hearing protection.
	Do not weld without adequate eye protection. Take care to protect bystanders from radiation.
	Risk of burns. Never touch materials without gloves during or shortly after welding. Avoid skin contact with airborne particles. Do not point the plasma torch toward your body.
	Place a fire extinguisher near the welding site. After welding, check the work area for fire hazards.
	People with pacemakers are not allowed to work with this device.
	Electromagnetic interference. The device may affect other devices sensitive to electromagnetic interference (robots, computers, etc.). Make sure that the devices within the welding area are resistant to interference. To reduce interference, it is recommended to use cables that are as short as possible and laid parallel to each other. Work at least 100m away from sensitive equipment. Always ensure that the installation is grounded. If interference with other devices still occurs, shield the cables properly or use appropriate filters. The device complies with current standards. In accordance with PN-EN IEC 60974-10, it is classified as class A and is intended for use in workshop and industrial environments. Using the device near residential buildings, and especially when powered from a domestic mains supply, may cause interference with other electrical or telecommunications equipment. The user is responsible for the correct connection of the device and the elimination of any electromagnetic interference.

CAUTION! The following instructions should be read before installation. and start-up of the device. The health and safety instructions should be known to every operator and employee responsible for equipment maintenance.

PRELIMINARY REMARKS

The device may only be started up and operated after thoroughly reading the following instructions. Electric arc welding requires compliance with fire safety regulations.
It is necessary to use a set of personal protective equipment (PPE) - protective clothing, footwear, and protective gloves in accordance with Regulation 2016/455 (EU). Personal protective equipment (PPE) includes: welding mask, welding gloves, protective clothing, leather shoes.
Despite the high technical standard of the device, operators should demonstrate considerable discipline in applying health and safety requirements that protect against harmful and hazardous factors arising from welding technology during operation.

OPERATING CONDITIONS

This device can operate in harsh conditions. However, it is important to take simple preventive measures to ensure long life and reliable operation, including:
- do not place or use this device on a surface with a slope greater than 10º,
- do not use this device to defrost pipes,
- this device must be placed in a location where there is free circulation of clean air without restrictions on air flow to and from the fan. When the device is connected to the mains, do not cover it with anything, e.g., a tarpaulin.
- Keep dirt and dust that may enter the device to a minimum.
- this device has an IP23S enclosure protection rating, keep it dry and do not place it on wet ground or in a puddle,
- do not use the device for welding tanks that have contained flammable substances.

ENVIRONMENTAL CONDITIONS

Air temperature range during:
- operation from -10ºC to +40ºC
- transport and storage from -25ºC to +50ºC
- relative air humidity from 50% at +40°C to 90% at +20%

GASES AND FUMES

During electric arc welding, harmful gases and fumes containing ozone, hydrogen, oxides, and metal particles are produced. Therefore, the welding station should have very good ventilation (dust and fume extraction or be located in a well-ventilated area). Metal surfaces intended for welding should be free of chemical contaminants, especially degreasing agents (solvents), as these decompose during welding, producing toxic gases. Welding or soldering of galvanized parts or parts coated with cadmium or chromium is only permitted with the use of a device for extracting and filtering contaminants and with a supply of fresh air to the workstation.

RADIATION

Ultraviolet radiation emitted during welding is harmful to the eyes and skin, therefore it is necessary to use a welding mask with protective filters and PPE (listed above).
The welding station (welding) should meet certain requirements, including:
- have adequate lighting,
- have fixed or movable screens, as needed, to protect bystanders from the effects of radiation,
- be located in a room with walls of an appropriate color, preferably matte gray (radiation absorption).

FIRE SAFETY

The welding station should be located at a safe distance from flammable materials (especially on the floor or walls), which should protect against fire from hot metal droplets. It is advisable to equip the station with fire blankets and fire extinguishers, e.g., powder or snow extinguishers.

ELECTRIC SHOCK PROTECTION

It is unacceptable to connect the device to an inappropriate installation or an installation with unproven zeroing effectiveness. Removing external covers while the device is connected to the mains, as well as using the device with the covers removed, is PROHIBITED. The device must not be operated while suspended, e.g., from a crane or hoist.
Maintenance work should be performed by authorized persons in accordance with the safety conditions applicable to the devices being maintained.

3. Installation and transport

The user is responsible for connecting the device in accordance with the manufacturer's operating instructions. In the event of electromagnetic interference, the user should remove the cause if necessary, with the manufacturer's knowledge.

· Before using the equipment, the operator should assess the possible impact of interference on the environment, in particular the presence of people with pacemakers.
· Working with a power generator is not recommended.
· Connection or repair of the device may only be carried out by trained personnel.
· Connecting several cutters (in series or in parallel) is prohibited.
· Always disconnect the device from the power supply before removing the covers.
· Perform the necessary cleaning and maintenance procedures periodically (see section 12 of this manual).
· Ensure that the power supply and grounding are sufficient and appropriate.
· Before welding, check the condition of the cables; if damaged, repair or replace them.
· Ensure that the correct spare parts are used in the TIG welding torch (optional).

Ground cable

It is recommended to use cables that are as short as possible, placed close to each other, preferably at floor level or as close to it as possible.

Location of the welding machine

Observe the following rules:

· Ensure easy access to connections, cables, and switches.
· Do not place the device in small, confined spaces.
· Do not place the device on surfaces with a slope greater than 10 degrees.

Transport

Take special care when transporting the device with a forklift or lift truck – risk of damage to the device chassis.

Before transporting the device, disconnect the power supply at the rear of the device. The maximum permissible angle of inclination during transport is 10°.

4. Technical data and assembly

Technical data	Unit	PONTE 200J MOST
Power	V/Hz	1x230/50-60 +/-15%
Network protection	A	16C
Max. current I1 MMA/TIG	A	39/27
Max. effective current I1eff MMA/TIG	A	12,3/8,5
Cos factor		0,72
Power supply efficiency	%	86
MMA/TIG welding current range	A/V	20/20,8 - 200/28,0 10/10,4 - 200/18
Welding current / duty cycle MMA and TIG	A/%	200/10 80/60 65/100
Open circuit voltage U20	V	62
Power consumption in idle state	W	26
Noise emission	dB(A)	< 70
Current control		Stepless
Insulation class		H
Enclosure protection rating		IP23S
EMC interference level according to PN-EN IEC 60974-10 Class A		Class A
Dimensions (W x L x H)	mm	375x131x252
Weight	kg	5,5

Table 1: Technical data PONTE 200J MOST

Completing the device

The device is delivered in a cardboard box with a 3-meter/16 mm² ground and electrode cable and 2-meter power cable with a plug.

Optional equipment:

TIG torch T17V 35/50 4 m	56 01 061705
Wireless remote control with HRC-03 receiver	53 00 03069Z
HRC-01 wired remote control	53 00 03068P

5. Construction of the device

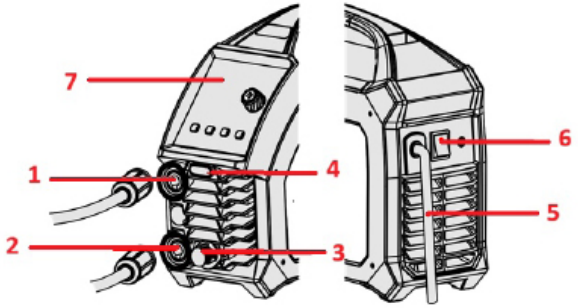


Figure 1: Device structure

Pos.	Description
1	Welding cable socket (+)
2	Ground cable socket (-)
3	Remote control socket
4	Wireless control module
5	Power cord with plug
6	ON/OFF switch
7	Control panel

Table 2: Construction of the PONTE 200J MOST device

6. PONTE 200J MOST CONTROL PANEL

1. Welding parameter and error code display
2. Fault status LEDs.
3. Selection of welding method
4. Selection of MMA electrode diameter or manual parameters.
5. VRD diode.
6. Parameter knob (encoder).
7. Selecting the MMA function.
8. Remote control selection.

Figure 2: PONTE 200J MOST control panel and function description

6.1 Symbols on the control panel

VRD function for MMA electrode welding

Warning! Read the instructions.

Electric shock warning

WEEE mark

A

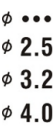
Unit of current „A”

Overheating protection indicator

Error Occurrence Indicator

MMA welding mode

LIFT TIG welding mode



Manual parameters or MMA electrode diameter selection

MMA welding current

Hot start for MMA

Arc Force MMA

Welding method switch

Function switch

Active wireless communication indicator

Remote control

Pairing the wireless remote control

6.2 Welding parameter display (1)

1. Welding current display.
2. Countdown time for restoring factory settings (RESET) (see chapter 6.10).
3. Displaying the service code
4. Displaying error codes in the event of a failure

6.3. Warning and error LEDs (2)

Thermal overheating

Power supply current too high

6.4 Selecting the operating mode (3)

Before welding, press the welding mode button **(3)** to switch between welding MMA and Lift TIG.

If the indicator is on, it means that the MMA method has been selected.

If the indicator is on, it means that the Lift TIG method is selected.

6.5 Selection of the diameter of the MMA welding electrode (4)

In the MMA welding method, press the manual or synergic electrode diameter for mode selection button **(4)**.
If the indicator is lit, ϕ ••• it means that the MMA manual mode is selected and any welding current setting.
If the indicator ϕ **2.5** ϕ **3.2** ϕ **4.0** is on, it means that synergistic mode is selected welding current settings depending on the electrode diameter.

NOTE! In synergic mode, optimal welding parameters are automatically selected based on the electrode diameter, and the welding current is precisely adjusted using a knob. The remaining parameters (Hot Start and Arc Force) are not adjustable

6.6 Setting the MMA function (7)

When welding MMA in manual mode, the welding current, hot start current and Arc Force settings can be selected by pressing the MMA parameter selection button (7).

If the indicator is lit, the welding current has been set. The welding current can be set by turning the knob **(6)**.

If the indicator is lit, it means that the hot start current has been set with the knob **(6)** in the range from 0 to 60 amps (MMA manual mode only).

If the indicator is lit, it means the Arc Force parameter is selected. Arc Force value can be set by turning the adjustment knob **(6)** (MMA manual mode only).

NOTE! After a certain period of inactivity, the device panel will automatically return to the welding current parameter settings.

6.7 Setting the LIFT TIG mode parameters (7)

In the LIFT TIG welding method, turn the adjustment knob **(6)** to set the welding current.

6.8 VRD function indicator (5) (open circuit voltage reduction)

By default, this function is disabled and the indicator **(5)** does not light up. To activate the VRD function (reducing the open circuit voltage for use in environments with a risk of electric shock), you must change the setting of relay SW1 - please contact our service center.

When the VRD function is activated, the indicator **(5)** VRD lights up green to indicate that the in case of correct function is in operation.
If the VRD function is on and no welding is taking place and the VRD indicator light is on in red VRD this indicates that the function is not working properly.

The VRD indicator never lights up during welding.

6.9 Displaying the service code

Before welding, press the welding mode selection button **(3)** and the parameters **(6)** for 3 seconds, the service code should be shown on the display. After pressing any button or turning the knob **(6)** , the service code will disappear, as well as after 20 seconds without taking any action.

6.10 Restoring factory settings (RESET).

Before welding, press the welding mode selection button **(3)** for 5 seconds to return usfactory settings.
After pressing (3) for 1 second, the display will start counting down from 3. Once the countdown has finished, the factory settings will be restored. If the button is released before the countdown has finished, the factory settings will not be restored. Factory settings: MMA manual settings, MMA current 80A; TIG current 80A.

6.11 HRC-01 Wired Remote Control (Optional)

Before welding, press the remote control function button **(8)** on the , to enable the function remote control.
The indicator **(8)** will light up to indicate that the remote control function is active.
If the HRC-01 remote control is connected, it controls the welding current. If the remote control is not connected, the welding current is adjusted using the knob **(6)**.

6.12 HRC-03 Wireless Remote Control (Optional)

NOTE: The HRC-03 remote control is supplied with a receiver, which must be mounted on the front of the device in the socket (4) – see the installation instructions included with the remote control. The remote control is supplied without a CR2032 battery – when installing it, pay particular attention to the position of the battery retaining tabs. If you have any problems with installing the receiver, contact service **RYWAL-RHC.**

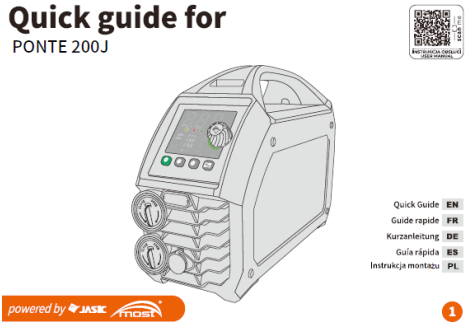
1/ Before welding, press and hold the remote control function button **(8)** and the red button on the remote control simultaneously for approximately 2 seconds to pair the wireless control.

During pairing, the blue indicator of the wireless receiver module **(4)** as in Fig. 1) flashes. After successful pairing, the remote control mode indicator **(8)** lights up, and the indicator (4) lights up blue continuously.
After successful pairing, the message „OK" will appear on the welding machine display.
The welding current can be adjusted using the „+" or „-" buttons on the HRC-03 remote control. The current range is the minimum and maximum current value set by the knob **(6)**.

2/ Disconnecting the HRC-03 remote control.
To disconnect the adapter, press the remote control button **(8)** and the indicator **(4)** remains blue, which means panel, will go out. Current adjustment is now only possible using the knob (6). that after pressing the red button on the remote control , the adapter can be paired with the PONTE 200J again. To that after pressing the red button on the remote control, the adapter can be paired with the PONTE 200J again. To permanently disconnect the adapter, press the button (8) for a few seconds. After disconnection, the display (1) will show „FAL" and the wireless receiver module indicator. There will be one was constantly lit green.

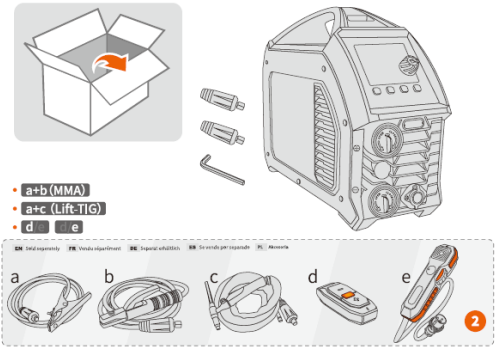
7. Connecting the device and preparing it for operation

The device is supplied with a paper copy of a short manual for connecting the power supply (electricity and compressed air) and connecting the working cables.



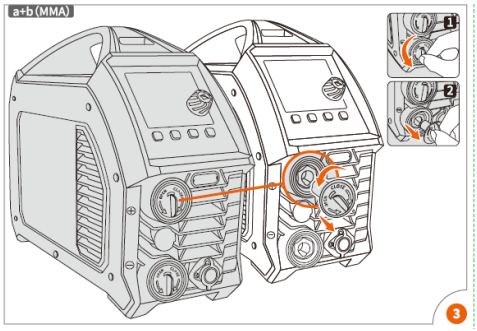
The steps should be carried out in the following order: 7.1

7.1 Remove the device from the box and check its completeness (see device completion, chapter 4 of this manual):

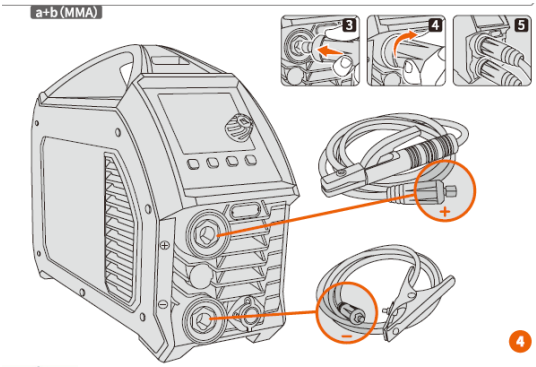


Items „c”, „d” and „e” are optional.

7.2 Remove the socket covers:

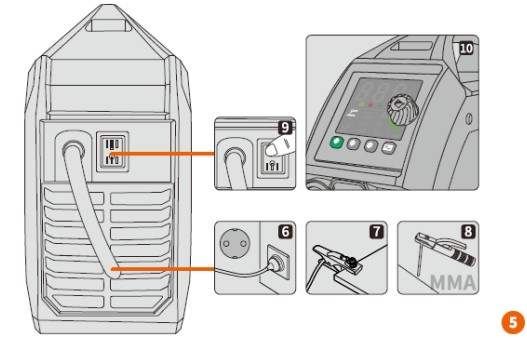


7.3 Connect the ground cable and electrode cable:

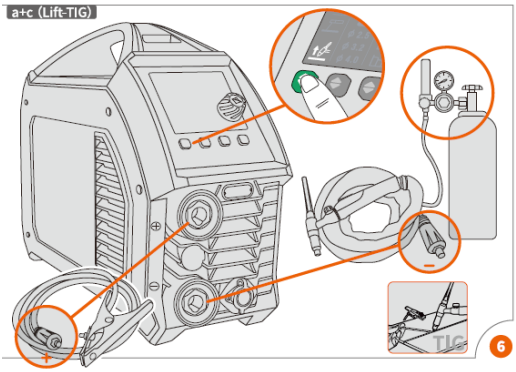


ATTENTION! Before connecting the cables, make sure that the device is not turned ON (button **(6)** as shown in figure **(1)**)

7.4 Prepare the device for MMA welding and set the parameters according to chapter 8:

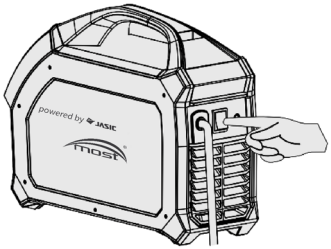


7.5 Prepare the device for Lift TIG welding and set the parameters according to chapter 9:



8. MMA welding

8.1 Turn on the device using the (6) ON button as shown in Figure 1:



NOTE! The PONTE 200J is equipped with intelligent fan control.
The fan starts during welding and continues to run for a period of time after welding is completed. This saves electricity.

8.2 Select MMA electrode welding using the button (3) and manual control using the button (4).

8.3 For the MMA manual control parameters, you can set the Hot Start current (helps with arc ignition) and Arc Force (helps with positional welding).

8.4 Alternatively, select MMA electrode welding with the button (3) and the synergistic parameters (the diameter of the coated electrode used) with the button (4).

After selecting the coated electrode diameter, the device will automatically set the welding current, HotStart value and Arc Force.The user can set his own parameter values using the knob **(6)** .After finishing welding, turn off the power using the **(6) OFF** button as shown in Figure 1.

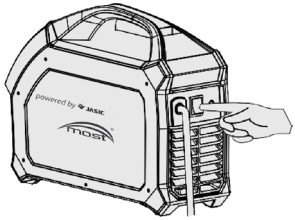
NOTE! The device is equipped with an anti-stick function. If a short circuit lasting 2 seconds occurs during welding, the device automatically activates the anti-stick function. This means that the welding current is reduced to 20 A to allow the electrode to detach from the workpiece. Once the short circuit is resolved, the welding current automatically returns to the set value (see section 6.6).

No.	Material thickness (mm)	Covered electrode diameter (mm)	Welding current (A)
1	1~2	1.6	25~40
2	≤4	2.0	40~65
		2.5	50~80
		3.2	100~130
3	4~12	3.2	100~130
		4.0	160~210
4	>12	5.0	200~270
		6.0	220~300

Table 5: Current range for MMA coated electrode welding

9. LIFT TIG welding

9.1 Turn on the device using the (6) ON button as shown in Figure 1:



9.2 Select Lift TIG welding using the button (3).

9.3 Set the welding current using the knob (6).

The table below gives approximate parameters for welding steel (stainless steel):

Tungsten electrode diameter (mm)	Thickness of the material being welded (mm)	Maximum welding current (A)	Argon flow (l/min)
1~2	1~3	50	5
		50~80	6
2~4	3~6	80~120	7
		121~160	8
		161~200	9

Table 6: Recommended parameters for Lift TIG welding.

9.4 Activities during LIFT TIG welding

Open the valve on the gas cylinder regulator and the valve on the torch handle. Touch tungsten electrode to the workpiece for less than 2 seconds and remove it approximately 2 mm to strike the arc. Alternatively, the arc can be struck by rubbing the tungsten electrode against the workpiece and removing it approximately 2 mm. the workpiece and removing it approximately 2 mm. Then close the gas valve on the TIG welding torch.

NOTE! During welding, maintain a constant distance between the electrode tip and the material, and do not allow the tungsten tip to touch the weld pool.

10. Electrical diagram

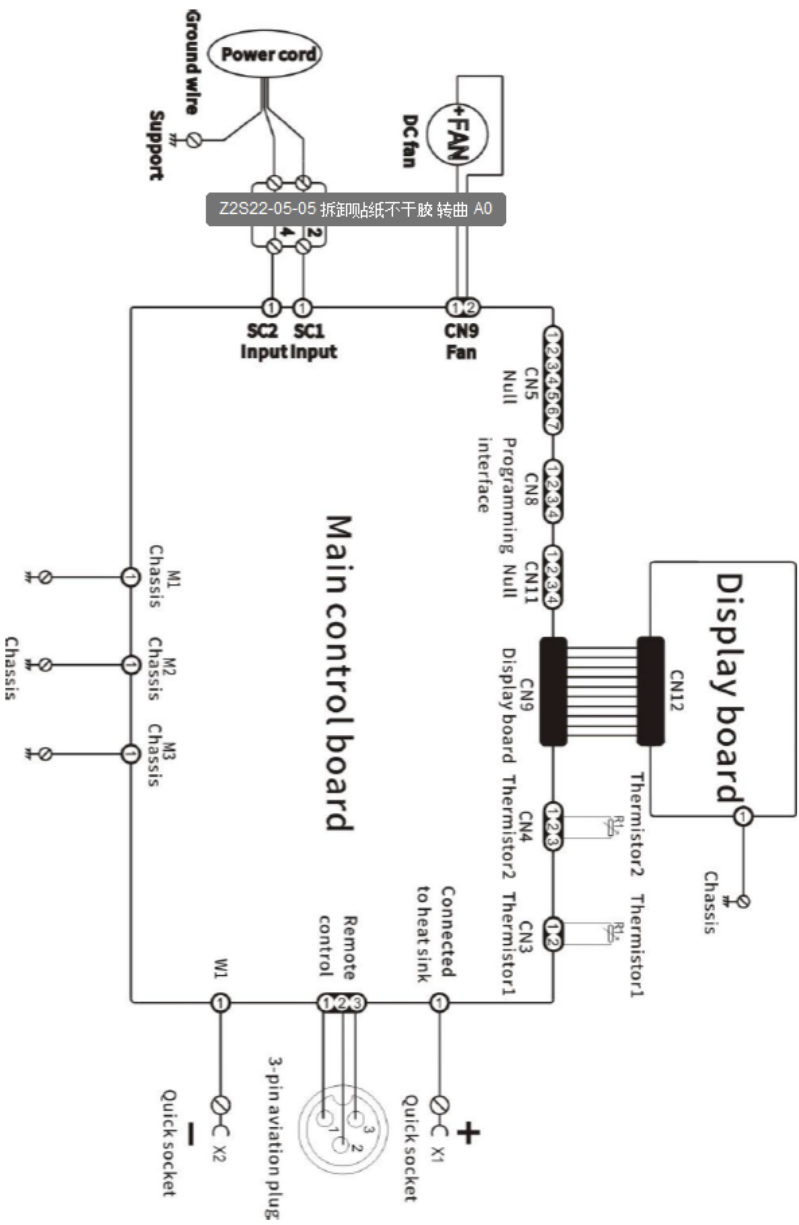


Figure 5: PONTE 200J MOST electrical diagram

11. Spare parts

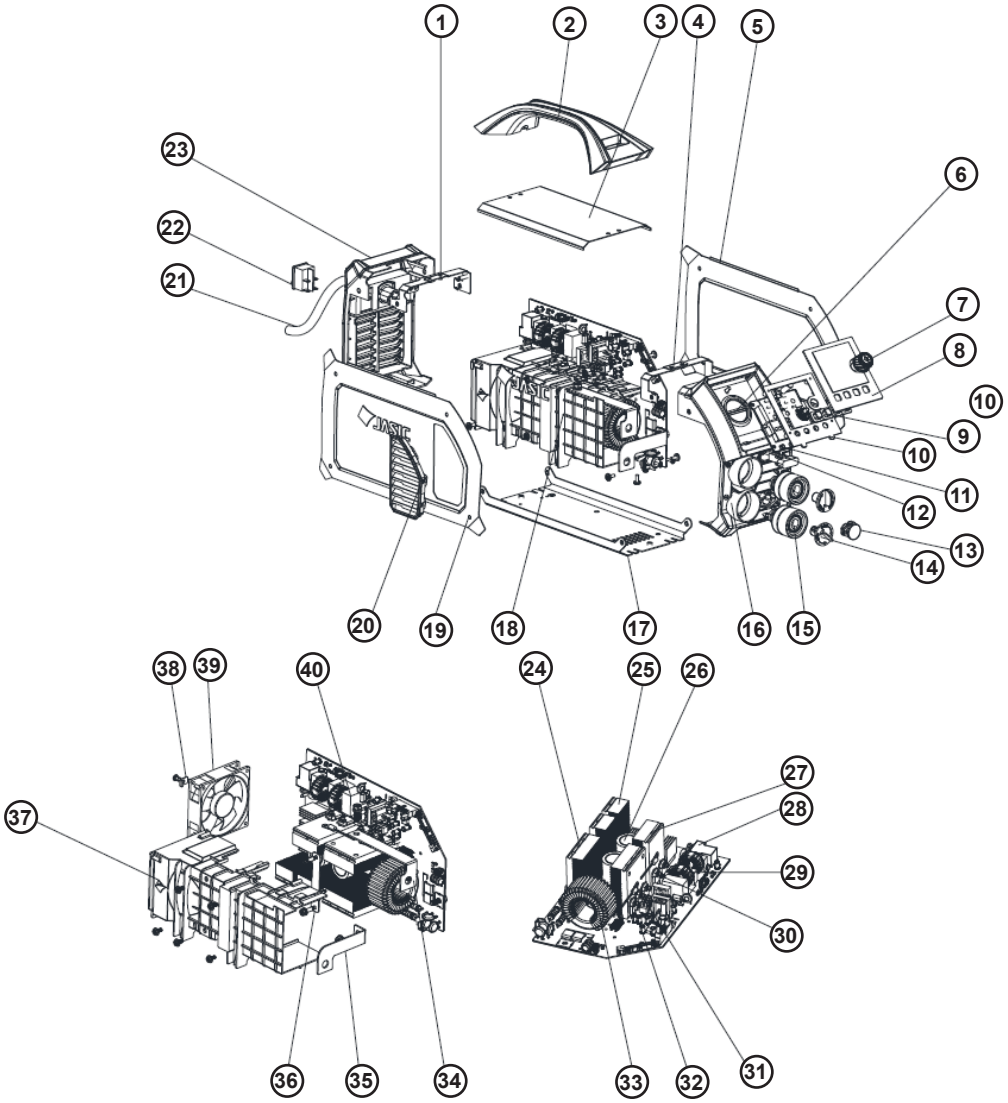


Figure 6: Spare parts for PONTE 200J MOST

No.	Product code	Description	Quantity pcs.	No.	Product code	Description	Quantity pcs.
1	10083448	Rear bridge	1	20	10083485	Fan grille	1
2	10083468	Handle	1	21	51001928	Power cables	1
3	10083527	Top cover	1	22	10083524	Main switch	1
4	10083446	Front bridge	1	23	10083469	Back panel	1
				24	10083455	62 mm radiator	1
5	10083440	Right cover	1	25	10083459	35 mm radiator	2
6	10083208	Cover ring	1	26	51000899	Capacitor	2
7	10083484	Knob	1	27	10083457	50 mm radiator	1
8	10083458	Display panel	1	28	10066349	Relay	1
9	10083453	Silicone seal	1	30	51000601	IGBT	4
10	10083474	Metal display frame	1	31	51000703	Thermistor	2
12	10083487	Plug	1	32	10064546	Rectifier (tube)	6
13	51000383	Remote control socket	1	33	10083488	Main transformer	1
14	10083486	Power socket cover	2	34	10083444	Positive connection	1
15	10021855	Power socket	2	35	10083436	Negative connection	1
16	10083470	Front panel	1	36	10083443	Radiator connection	1
17	10083435	Base plate	1	37	10083472	Fan cover	1
18	51000442	Inverter	1	39	10056858	Fan	1
19	10083450	Left cover	1	40	51000449	Motherboard	1

Table 6: PONTE 200J MOST components

12. Device maintenance, error codes and troubleshooting

CAUTION! Before repairing or removing covers, make sure the device is disconnected from the mains.

12.1 List of inspections and periodic maintenance to be performed by operator or service

Type of work	Frequency of care and maintenance		
Responsibility	Interval A	Interval B	Interval C
	Operator	Operator	Service
1-shift work	Before each start-up	8 weeks	12 months
2-shift work		4 weeks	6 months
3-shift work		2 weeks	3 months

NOTE! In highly polluted environments, the above-mentioned distances B and C must be reduced by 50%. Always wait at least 5 minutes after disconnecting the device from the mains before removing the control panel.

Interval A (Operator)	Check the condition of the cables and correct connections, replace if necessary.
	Check the condition and operation of the cooling fan, keep the intake and exhaust openings clean air.
	Keep your device clean.
Interval B (Operator)	Remove dust from the outside of the case and inside the device with vacuum cleaner, do not use compressed air.
	Check and tighten all screws.
	Check the condition of all electrical contacts and correct if necessary.
Interval C (Service) (Only by authorized employees service)	To ensure functionality and warranty, the device is subject to mandatory inspection at least once a year (see interval C) by authorized service center. Safety regulations must also be observed and in particular Standard PN-EN IEC 60974-14 Arc welding equipment - Part 14: Calibration, validation and repeatability testing.

12.2 Error Codes and Repair Recommendations

Error code	Description	Cause	Recommendations
E10	Protection against overvoltage	Current measured too high output	Restart your device. If the alarm still goes off occurs, contact the service.
E31	Current too low power supply	Supply voltage too low	Turn it off and on again. If the voltage is still too high high, check the power supply. If the problem persists repeats, contact service.
E32	Power supply voltage too high	Voltage exceeds 230V + 15%	Turn the device on and off. If the supply voltage is too high, connect the device to the correct power supply. If the voltage is correct and the error persists, contact service.
E34	Power supply voltage too low	Internal voltage too low	Turn the device off and on. If the error persists, contact service.
VRD	Function error VRD	Idle voltage too high	Turn the device off and on. If the error persists, contact service.
E60	Overheating	Temperature too high IGBT inverter	Do not turn off the device. Wait for it to cool down device until the indicator goes out and continue working.
E62	Overheating	Temperature too high rectifier diodes	Do not turn off the device. Wait for it to cool down device until the indicator goes out and continue working.

Table 6: Error Codes

12.3 Problems with MMA welding

Problem	Cause	Solution
No bow	Incomplete welding circuit	Check if the ground wire is connected Check all cable connections
	Incorrect welding mode selected	Check if the button **(3)** is set to MMA method
	No power	Make sure the device is turned on and connected to power
Porosity - small cavities or holes resulting from the presence of gas in the weld	Bow too long	Arc length reduction
	Dirty, contaminated or damp working element	Remove moisture and coatings such as paint, grease, oil and dirt, including mill scale
	Damp electrodes	Use only dry electrodes

Problem	Cause	Recommendations
Excessive spatter	Current too high	Reduce the current or choose a larger electrode
	Bow too long	Arc length reduction
Weld without fusion	Insufficient energy	Increase the current or change the electrode
	Dirty, contaminated or damp workpiece	Remove moisture and coatings such as paint, grease, oil and dirt, including metal mill scale
	Improper welding technique	Use the correct technique welding or seek help with the correct technique
No material penetration	Insufficient energy	Increase the current or change the electrode
	Improper welding technique	Use the correct technique welding or seek help with the correct technique
	Poor joint preparation	Check the shape of the connector and fit, make sure the material is not too thick in relation to the electrode size
Excessive penetration - overburning	Excessive energy	Reduce current or change electrode
	Incorrect electrode insertion speed	Try increasing your speed weld guidance
Uneven weld face	Unstable handling	Use two whenever possible hands to stabilize the grip, practice the technique
Deformation of metal due to overheating during welding	Too much heat supplied	Reduce the current or use smaller electrode
	Improper welding technique	Use the correct technique welding or seek help with the correct technique
	Poor preparation or construction of the joint	Check the design and fit of the connector, making sure the material is not too thick. Seek assistance in properly designing and fitting the connector
The arc behaves unusually, special types of electrodes	Incorrect polarity	Change polarity, check manufacturer's polarity recommendations

12.4 Problems with Lift TIG welding

Problem	Cause	Recommendations
Tungsten burns out quickly	Incorrect gas or no gas	Use pure argon. Check that the cylinder contains gas, that it is connected and that the regulator is open
	Insufficient gas flow	Check that the gas is connected, check that the hoses, gas valve and burner are not clogged or kinked
	The burner cap is not tight	Make sure the TIG torch cap has the O-ring in place and is tight
	TIG torch connected to the (+) pole	Connect the TIG torch to the (-) socket
	The wrong type of tungsten electrode is being used	Check and if necessary change the tungsten type
Tungsten inclusions in the weld	Tungsten contact with the weld pool	Protect tungsten from contact with a weld pool. Raise the torch so that the tungsten electrode is 2-5 mm from the workpiece.
Short circuit of the electrode and the additional material (rod)	Touching the welding wire to the tungsten electrode	When welding wire The welding wire should not touch the tungsten. The wire should be inserted into the leading edge of the weld pool ahead of the tungsten.
Porosity - poor appearance and color of the joint	Incorrect gas/poor gas flow/ gas leak	Check that the gas is connected, the regulator is open, the hoses, gas valve and burner are not blocked. Set the gas flow to 6~12 l/min. Check the hoses and fittings for leaks.
	Contaminated welded material	Remove moisture and coatings such as paint, grease, oil and dirt
	Contaminated wire welding	Clean the welding wire
	Incorrect welding wire	Check the correct selection of welding wire
Yellowish coating/smoke on the ceramic nozzle and discolored tungsten	Incorrect gas	Use pure argon
	Insufficient flow gas	Set the gas flow within the range 6~12 l/min.
	Ceramic nozzle too small	Increase the size of the ceramic nozzle
Unstable arc during DC welding	Welding torch connected to the (+) pole	Connect the TIG torch to the (-) socket
	Contaminated weld metal	Remove coatings such as paint, grease, oil and dirt, including mill scale
	Tungsten electrode contaminated at the tip	Remove 10 mm of contaminated tungsten and resharpen the end of the electrode
	Bow too long	Lower the torch so that the tip of the tungsten electrode is 2-5 mm from the workpiece

Problem	Cause	Recommendations
The arc wanders during DC welding	Poor gas flow	Set the gas flow within the range 6~12 l/min
	Incorrect arc length	Lower the torch so that the tungsten was 2-5 mm from the workpiece.
	Tungsten incorrect or in poor condition	Check if it is used correct type of tungsten. Remove 10 mm from the welded end of the tungsten and re-sharpen the rod
	Poorly prepared tungsten electrode	The grinding direction should be along the electrode axis, not crosswise. Use an appropriate grinding method and electrode sharpener
	Contaminated base metal or welding wire	Remove coatings such as paint, grease, oil, and dirt. Use clean welding wire
Arc difficult to start or no DC arc	Incorrect parameter setting	Check if the parameters are correct
	No gas, incorrect gas flow	Check if the gas is connected, and the reducer is open, check, Check that the hoses, gas valve and burner are not blocked. Set the gas flow to 6~12 l/min
	Incorrect tungsten electrode size or type	Check and change if necessary diameter or type
	Loose connection of power cables	Check all connections and tighten them when necessary
	The ground terminal is not connected to the material being welded	If possible, connect direct ground terminal to the workpiece.

NOTE! Returning the device to its factory settings (RESET) is described in section 6.10.

13. EU Declaration of Conformity

1. **Product:** MMA rectifier **PONTE 200J MOST**
2. **Name and address:**
   RYWAL-RHC Sp. z o.o.
   ul. Polna 140B
   87-100 Torun
3. **This declaration of conformity is issued under the sole responsibility of manufacturer.**
4. **Subject of the declaration:** MMA rectifier **PONTE 200J MOST**

5. The above-mentioned subject of this declaration complies with the relevant requirements of Union harmonisation legislation:

   - with the Low Voltage Directive LVD 2014/35/EU,

   - with the EMC 2014/30/EU Electromagnetic Compatibility Directive,

   - with the Directive on the restriction of the use of certain hazardous substances in electrical and electronic equipment RoHS 2011/65/EU.

   - with the Ecodesign Directive 2009/125/EC and Regulation 2019/1784 (EU).

6. References to the relevant harmonized standards in relation to which the declared compliance is: PN IEC 60974-1:2023 + A11:2023 + A12:2024; PN IEC 60974-10:2022.

7. Additional information:
   none

Signed on behalf of:

Product Manager
Dyrektor Produktu

mgr inż. Wojciech Wierzba

Toruń, 19.01.2026

Devices are subject to constant change and improvement.
We reserve the right to make changes.

END.

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87-100 Toruń

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www.rywal.eu

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Zintegrowany System Zarządzania ISO 9001 & ISO 14001