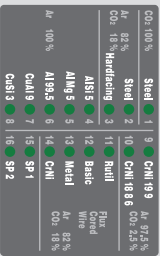


1 Setting the wire diameter



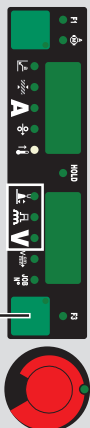
Special diameter

2 Specifying the filler metal and shielding gas



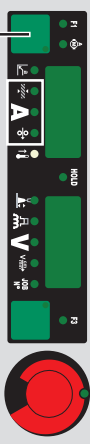
Special setting

6 Correcting parameters



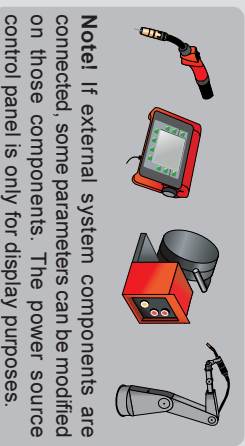
- select desired parameter
- correct desired parameter
- Arc length correction
- Arc-force dynamic correction / pulse correction / arc-force dynamic
- Arc voltage

5 Setting the welding power



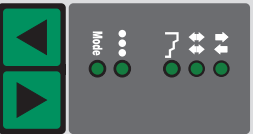
- select desired parameter
- set desired parameter
- Specify sheet thickness
- Specify welding current
- Specify wire feed speed

Important! In synergic mode, all the remaining parameters are set automatically.



Note! If external system components are connected, some parameters can be modified on those components. The power source control panel is only for display purposes.

3 Setting the mode



- 2-step mode
- 4-step mode
- Special 4-step mode (Aluminum welding start-up)
- Spot welding
- Special function

1 - 6 Commissioning sequence

Follow operating instructions

Feeder inching

Gas test

Setup/store

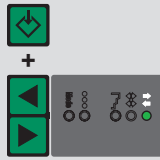
4 Selecting the process



- MIG/MAG pulse synergic
- MIG/MAG standard synergic
- MIG/MAG standard manual
- Job mode
- TIG
- Rod electrode (MMA)

MIG/MAG setup

2-step mode



- 1-5 Starting current
- 5 L Slope
- 1-E final current
- E-5 time - starting current
- E-E time - end current

MIG/MAG setup

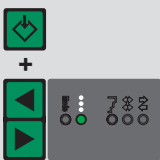
Procedure



- U P r Gas pre-flow time
- U P o Gas post-flow time
- F d c Wire feeder creep
- F d , Feeder inching speed
- b b c Burn back correction *
- R L 5 Hotstart current *
- R L E Hotstart time *
- F Frequency **
- d F d Wirefeed deviation **
- R L 2 Arc length correction
- F R C Return to factory setting
- 2 n d 2nd menu level
- P P U Select push-pull unit
- E - C Cooling unit control
- E - t Cooling unit watchdog
- i , t o Ignition timeout
- R r c Arc-break watchdog
- F E D Wire-end settings
- 5 E E Country setting
- 5 2 L Special 2-step variants
- 5 4 E Special 4-step variants
- U n n JobMaster mode select.
- r r Welding cct resistance
- L L Welding cct inductivity
- L L Gas correction ***

MIG/MAG setup

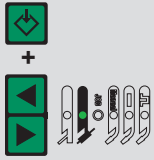
Spot welding



- 1-5 Starting current
- 5 L Slope
- 1-E final current

5 P L Spot-welding time

TIG - setup



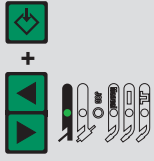
- 2 n d 2nd menu level
- E - C Cooling unit control
- E - t Cooling unit watchdog
- U 5 5 Comfort stop sensitivity
- r r Welding cct resistance
- L L Welding cct inductivity

Gas setup



- U P r Gas pre-flow time
- U P o Gas post-flow time
- U P U Gas flushing
- U R 5 Gas flow rate ***

Electrode - setup



- H E U Hotstart current
- H E , Hotstart time
- 2 n d 2nd menu level
- r r Welding cct resistance
- L L Welding cct inductivity
- E 1 n Characteristic selection
- R 5 E Anti-stick
- U c o Break voltage

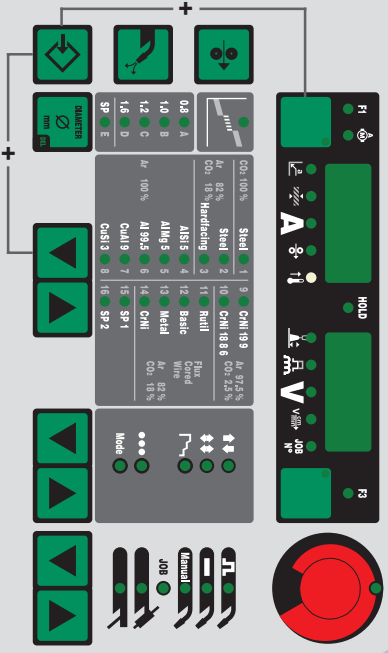
Exit setup



- Exit setup
- Save job

Job correction

For details of Job mode and Job correction, see operating instructions



Display firmware versions

Power source firmware e.g. 324 010 Welding database e.g. 0 164
 Wirefeeder firmware e.g. R20 101 Total welding time e.g. 003 528

* ... only for standard synergic process
 ** ... only with SynchroPuls option
 *** ... only with digital control option