

1 Setting the wire diameter



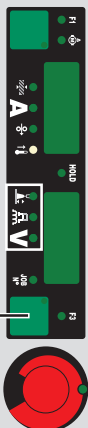
Special diameter

2 Specifying the filler metal and shielding gas

Weld	ER70 S3 (Ni-CO)	1	9	ER T1 K45	Filler metal
Shield	ER70 S3 (Ni-CO)	2	10	ER 0713	Shielding gas
Wire	Mand. Coated (Ni-CO)	3	11	ER 308 (Ni-CO)	Shield
Aluminum wire	ER 4043 (Al)	4	12	ER 308 (Ni-CO)	Shielding gas
Aluminum wire	ER 5356 (Al)	5	13	ER 316 (Ni-Al)	Shielding gas
Copper wire	ER 6002 (Al)	6	14	ER 316 (Ni-Al)	Shielding gas
Copper wire	ER 6014 (Al)	7	15	SP 1	Shielding gas
ER60 S3 (Al)	8	16	SP 2		

Special setting

6 Correcting parameters



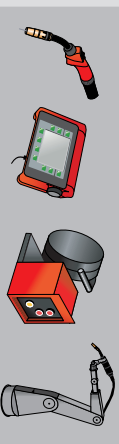
- select desired parameter
- correct desired parameter
- Arc length correction
- Arc-force dynamic correction / pulse correction / arc-force dynamic
- Arc voltage

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 mode
- Special function

1 - 6 Commissioning sequence

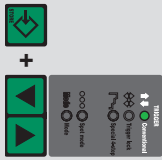
- Follow operating instructions
- Feeder inching
- Gas test
- Setup/store

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

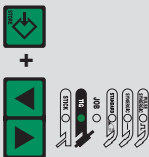
MIG/MAG setup

Procedure



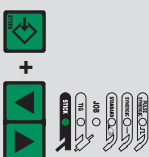
- PPR Gas pre-flow time
- PPD Gas post-flow time
- FDc Wire feeder creep
- Fd, Feeder inching speed
- b,b,c Burn back correction *
- RL5 Hotstart current *
- RLt Hotstart time *
- F Frequency **
- dFd Wirefeed deviation **
- RL2 Arc length correction
- FRL Return to factory setting
- 2nd 2nd menu level
- PPU Select push-pull unit
- C-C Cooling unit control
- C-L Cooling unit watchdog
- l,t,o Ignition timeout
- Rr,c Arc-break watchdog
- F,c,D Wire-end settings
- 5Ee Country setting
- 52L Special 2-step variants
- 54L Special 4-step variants
- LUv JobMaster mode select.
- LL Welding cct resistance
- LL Welding cct inductivity
- LL Gas correction ***

TIG - setup



- 2nd 2nd menu level
- C-C Cooling unit control
- C-L Cooling unit watchdog
- C55 Comfort stop sensitivity
- LL Welding cct resistance
- LL Welding cct inductivity

Electrode - setup



- HEU Hotstart current
- HE, Hotstart time
- 2nd 2nd menu level
- LL Welding cct resistance
- Lt Welding cct inductivity
- E1n Characteristic selection
- R5E Anti-stick
- UCD Break voltage

Gas setup



- PPR Gas pre-flow time
- PPD Gas post-flow time
- PPU Gas flushing
- FL5 Gas flow rate ***

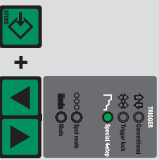
Exit setup



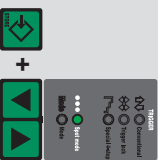
- Exit setup
- Save job

MIG/MAG setup

Spot welding



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



Spot-welding time

... only for standard synergic process

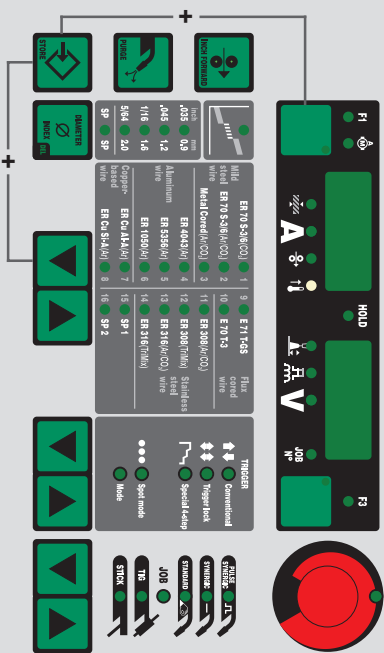
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... only with SynchroPuls option

control option

Job correction

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



Display firmware versions

Power source firmware e.g. 324 070 Welding database e.g. 0 164
Wirefeeder firmware e.g. R2D 101 Total welding time e.g. 003 528