



## Welding machine

**Phoenix 401 Progress puls FKG**

**Phoenix 401 Progress puls FKW**

**Phoenix 501 Progress puls FKW**

099-005296-EW501

28.01.2013

**Register now!**  
For your benefit  
**Jetzt Registrieren**  
und Profitieren!

[www.ewm-group.com](http://www.ewm-group.com)

**3** Years  
**5** Years  
transformer  
and rectifier  
**ewm-warranty\***  
24 hours / 7 days

\* Details for ewm-warranty  
[www.ewm-group.com](http://www.ewm-group.com)

# General instructions

## CAUTION



### **Read the operating instructions!**

**The operating instructions provide an introduction to the safe use of the products.**

- Read the operating instructions for all system components!
- Observe accident prevention regulations!
- Observe all local regulations!
- Confirm with a signature where appropriate.

## NOTE



**In the event of queries on installation, commissioning, operation or special conditions at the installation site, or on usage, please contact your sales partner or our customer service department on +49 2680 181-0.**

**A list of authorised sales partners can be found at [www.ewm-group.com](http://www.ewm-group.com).**

Liability relating to the operation of this equipment is restricted solely to the function of the equipment. No other form of liability, regardless of type, shall be accepted. This exclusion of liability shall be deemed accepted by the user on commissioning the equipment.

The manufacturer is unable to monitor whether or not these instructions or the conditions and methods are observed during installation, operation, usage and maintenance of the equipment.

An incorrectly performed installation can result in material damage and injure persons as a result. For this reason, we do not accept any responsibility or liability for losses, damages or costs arising from incorrect installation, improper operation or incorrect usage and maintenance or any actions connected to this in any way.

## 1 Contents

<b>1</b>	<b>Contents.....</b>	<b>3</b>
<b>2</b>	<b>Safety instructions.....</b>	<b>7</b>
2.1	Notes on the use of these operating instructions .....	7
2.2	Explanation of icons.....	8
2.3	General .....	9
2.4	Transport and installation .....	13
2.4.1	Lifting by crane .....	14
2.4.2	Ambient conditions .....	15
2.4.2.1	In operation .....	15
2.4.2.2	Transport and storage.....	15
<b>3</b>	<b>Intended use .....</b>	<b>16</b>
3.1	Applications.....	16
3.1.1	MIG/MAG standard welding .....	16
3.1.1.1	rootArc.....	16
3.1.1.2	forceArc.....	16
3.1.2	MIG/MAG pulse welding.....	16
3.1.3	TIG (Liftarc) welding .....	16
3.1.4	MMA welding .....	16
3.1.4.1	Air arc gouging.....	16
3.2	Documents which also apply .....	17
3.2.1	Warranty .....	17
3.2.2	Declaration of Conformity.....	17
3.2.3	Welding in environments with increased electrical hazards.....	17
3.2.4	Service documents (spare parts and circuit diagrams).....	17
3.2.5	Calibration/Validation .....	17
<b>4</b>	<b>Machine description – quick overview .....</b>	<b>18</b>
4.1	Front view .....	18
4.2	Rear view .....	20
4.3	Inside view .....	22
4.4	Machine control – Operating elements.....	24
4.4.1	Machine control – Concealed operating elements.....	26
<b>5</b>	<b>Design and function.....</b>	<b>28</b>
5.1	General .....	28
5.2	Installation.....	29
5.3	Machine cooling.....	29
5.4	Workpiece lead, general .....	29
5.5	Welding torch cooling system .....	30
5.5.1	General.....	30
5.5.2	List of coolants.....	30
5.5.3	Adding coolant.....	31
5.6	Mains connection .....	32
5.6.1	Mains configuration .....	32
5.7	Shielding gas supply (shielding gas cylinder for welding machine).....	33
5.8	MIG/MAG welding.....	34
5.8.1	Welding torch and workpiece line connection .....	34
5.8.1.1	MIG/MAG standard welding .....	35
5.8.1.2	MIG/MAG cored wire welding .....	36
5.8.2	Wire feed .....	37
5.8.2.1	Open the protective flap of the wire feeder.....	37
5.8.2.2	Inserting the wire spool .....	37
5.8.2.3	Changing the wire feed rollers .....	38
5.8.2.4	Inching the wire electrode .....	39
5.8.2.5	Spool brake setting .....	41

5.8.3	Definition of MIG/MAG welding tasks .....	42
5.8.4	Welding task selection .....	42
5.8.4.1	Basic welding parameters .....	42
5.8.4.2	Operating mode.....	42
5.8.4.3	Welding type (MIG/MAG standard/pulse arc welding) .....	42
5.8.4.4	Choke effect / dynamics .....	43
5.8.4.5	Superpulses .....	43
5.8.4.6	Burn-back .....	44
5.8.5	MIG/MAG operating point.....	44
5.8.5.1	Selecting the display unit.....	45
5.8.5.2	Operating point setting using material thickness .....	45
5.8.5.3	Arc length correction setting.....	45
5.8.5.4	Accessory components for operating point setting .....	45
5.8.6	MIG/MAG welding data display .....	46
5.8.7	forceArc.....	47
5.8.8	rootArc .....	48
5.8.9	MIG/MAG functional sequences / operating modes.....	49
5.8.9.1	Explanation of signs and functions.....	49
5.8.10	MIG/MAG automatic cut-out .....	49
5.8.11	Conventional MIG/MAG Welding (GMAW non synergic) .....	62
5.8.11.1	Setting the operating point (welding output).....	62
5.8.12	MIG/MAG program sequence ("Program steps" mode) .....	63
5.8.12.1	Selection of the program sequence parameter.....	63
5.8.12.2	MIG/MAG overview of parameters .....	64
5.8.12.3	Example, tack welding (non-latched) .....	65
5.8.12.4	Example, aluminium tack welding (non-latched special) .....	65
5.8.12.5	Example, aluminium welding (latched special) .....	66
5.8.12.6	Example, visible seams (latched super pulse) .....	67
5.8.12.7	Welding process changeover .....	68
5.8.13	Main program A mode .....	69
5.8.13.1	Selecting parameters (program A) .....	71
5.8.14	Standard MIG/MAG torch .....	72
5.8.15	MIG/MAG special-torches.....	72
5.8.15.1	Program- and Up- / down operation.....	72
5.9	Remote control.....	73
5.9.1	Advanced settings .....	74
5.9.1.1	Selecting, changing and saving parameters .....	74
5.9.1.2	Reset to factory settings.....	76
5.9.1.3	The special parameters in detail .....	77
5.9.1.4	Switching between Push/Pull and intermediate drive .....	85
5.10	TIG welding .....	86
5.10.1	Welding torch and workpiece line connection .....	86
5.10.2	Welding task selection .....	87
5.10.3	Welding current setting.....	87
5.10.4	TIG arc ignition .....	87
5.10.4.1	Liftarc ignition .....	87
5.10.5	Function sequences/operating modes.....	88
5.10.5.1	Explanation of signs and functions.....	88
5.10.6	TIG automatic cut-out .....	91
5.10.7	TIG program sequence ("Program steps" mode) .....	92
5.10.7.1	TIG parameter overview.....	92
5.11	MMA welding.....	93
5.11.1	Connecting the electrode holder and workpiece lead .....	93
5.11.2	Welding task selection .....	94
5.11.3	Welding current setting.....	94
5.11.4	Arcforce.....	94
5.11.5	Hotstart .....	95
5.11.6	Antistick.....	95
5.11.7	Parameter overview .....	95

5.12	Interfaces .....	96
5.12.1	Automation interface.....	96
5.12.2	RINT X12 robot interface.....	97
5.12.3	BUSINT X10 Industrial bus interface.....	97
5.12.4	DVINT X11 Wire feed interface .....	97
5.12.5	PC Interfaces.....	97
5.12.6	Setting options, internal.....	97
5.12.6.1	Switching between Push/Pull and intermediate drive .....	97
5.13	Protecting welding parameters from unauthorised access.....	98
<b>6</b>	<b>Maintenance, care and disposal.....</b>	<b>99</b>
6.1	General .....	99
6.2	Maintenance work, intervals .....	99
6.2.1	Daily maintenance tasks .....	99
6.2.1.1	Visual inspection .....	99
6.2.1.2	Functional test.....	99
6.2.2	Monthly maintenance tasks.....	100
6.2.2.1	Visual inspection .....	100
6.2.2.2	Functional test.....	100
6.2.3	Annual test (inspection and testing during operation) .....	100
6.3	Maintenance work.....	100
6.4	Disposing of equipment .....	101
6.4.1	Manufacturer's declaration to the end user.....	101
6.5	Meeting the requirements of RoHS .....	101
<b>7</b>	<b>Rectifying faults .....</b>	<b>102</b>
7.1	Checklist for rectifying faults .....	102
7.2	Error messages (power source) .....	103
7.3	Resetting JOBS (welding tasks) to the factory settings .....	105
7.3.1	Resetting a single JOB .....	105
7.3.2	Resetting all JOBS.....	106
7.4	General operating problems .....	106
7.4.1	Interface for automated welding.....	106
7.5	Vent coolant circuit.....	107
<b>8</b>	<b>Technical data .....</b>	<b>108</b>
8.1	Phoenix 401 Progress FKG .....	108
8.2	Phoenix 401 Progress FKW .....	109
8.3	Phoenix 501 Progress FKW .....	110
<b>9</b>	<b>Accessories .....</b>	<b>111</b>
9.1	General accessories .....	111
9.2	Remote control / connection cable .....	111
9.3	Options.....	112
9.4	Computer communication.....	112
<b>10</b>	<b>Replaceable parts .....</b>	<b>113</b>
10.1	Wire feed rollers.....	113
10.1.1	Wire feed rollers for steel wire.....	113
10.1.2	Wire feed rollers for aluminium wire .....	113
10.1.3	Wire feed rollers for cored wire .....	113
10.1.4	Conversion sets.....	114
<b>11</b>	<b>Appendix A .....</b>	<b>115</b>
11.1	JOB-List .....	115
<b>12</b>	<b>Appendix B .....</b>	<b>116</b>
12.1	Overview of EWM branches .....	116



## 2 Safety instructions

### 2.1 Notes on the use of these operating instructions



#### **DANGER**

**Working or operating procedures which must be closely observed to prevent imminent serious and even fatal injuries.**

- Safety notes include the "DANGER" keyword in the heading with a general warning symbol.
- The hazard is also highlighted using a symbol on the edge of the page.



#### **WARNING**

**Working or operating procedures which must be closely observed to prevent serious and even fatal injuries.**

- Safety notes include the "WARNING" keyword in the heading with a general warning symbol.
- The hazard is also highlighted using a symbol in the page margin.



#### **CAUTION**

**Working or operating procedures which must be closely observed to prevent possible minor personal injury.**

- The safety information includes the "CAUTION" keyword in its heading with a general warning symbol.
- The risk is explained using a symbol on the edge of the page.

#### **CAUTION**

**Working and operating procedures which must be followed precisely to avoid damaging or destroying the product.**

- The safety information includes the "CAUTION" keyword in its heading without a general warning symbol.
- The hazard is explained using a symbol at the edge of the page.

#### **NOTE**








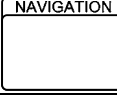





**Special technical points which users must observe.**

- Notes include the "NOTE" keyword in the heading without a general warning symbol.

Instructions and lists detailing step-by-step actions for given situations can be recognised via bullet points, e.g.:

- Insert the welding current lead socket into the relevant socket and lock.

## 2.2 Explanation of icons

Symbol	Description
	Press
	Do not press
	Turn
	Switch
	Switch off machine
	Switch on machine
	ENTER (enter the menu)
	NAVIGATION (Navigating in the menu)
	EXIT (Exit the menu)
	Time display (example: wait 4s/press)
	Interruption in the menu display (other setting options possible)
	Tool not required/do not use
	Tool required/use



## 2.3 General



### DANGER



#### Electric shock!

**Welding machines use high voltages which can result in potentially fatal electric shocks and burns on contact. Even low voltages can cause you to get a shock and lead to accidents.**

- Do not touch any live parts in or on the machine!
- Connection cables and leads must be free of faults!
- Switching off alone is not sufficient!
- Place welding torch and stick electrode holder on an insulated surface!
- The unit should only be opened by specialist staff after the mains plug has been unplugged!
- Only wear dry protective clothing!
- Wait for 4 minutes until the capacitors have discharged!



#### Electromagnetic fields!

**The power source may cause electrical or electromagnetic fields to be produced which could affect the correct functioning of electronic equipment such as IT or CNC devices, telecommunication lines, power cables, signal lines and pacemakers.**

- Observe the maintenance instructions! (see Maintenance and Testing chapter)
- Unwind welding leads completely!
- Shield devices or equipment sensitive to radiation accordingly!
- The correct functioning of pacemakers may be affected (obtain advice from a doctor if necessary).



#### Do not carry out any unauthorised repairs or modifications!

**To avoid injury and equipment damage, the unit must only be repaired or modified by specialist, skilled persons!**

**The warranty becomes null and void in the event of unauthorised interference.**

- Appoint only skilled persons for repair work (trained service personnel)!



### WARNING



#### Risk of accidents if these safety instructions are not observed!

**Non-observance of these safety instructions is potentially fatal!**

- Carefully read the safety information in this manual!
- Observe the accident prevention regulations in your country.
- Inform persons in the working area that they must observe the regulations!



#### Risk of injury due to radiation or heat!

**Arc radiation results in injury to skin and eyes.**

**Contact with hot workpieces and sparks results in burns.**

- Use welding shield or welding helmet with the appropriate safety level (depending on the application)!
- Wear dry protective clothing (e.g. welding shield, gloves, etc.) according to the relevant regulations in the country in question!
- Protect persons not involved in the work against arc beams and the risk of glare using safety curtains!



## WARNING



### Explosion risk!

**Apparently harmless substances in closed containers may generate excessive pressure when heated.**

- Move containers with inflammable or explosive liquids away from the working area!
- Never heat explosive liquids, dusts or gases by welding or cutting!



### Smoke and gases!

**Smoke and gases can lead to breathing difficulties and poisoning. In addition, solvent vapour (chlorinated hydrocarbon) may be converted into poisonous phosgene due to the ultraviolet radiation of the arc!**

- Ensure that there is sufficient fresh air!
- Keep solvent vapour away from the arc beam field!
- Wear suitable breathing apparatus if appropriate!



### Fire hazard!

**Flames may arise as a result of the high temperatures, stray sparks, glowing-hot parts and hot slag produced during the welding process.**

**Stray welding currents can also result in flames forming!**

- Check for fire hazards in the working area!
- Do not carry any easily flammable objects such as matches or lighters.
- Keep appropriate fire extinguishing equipment to hand in the working area!
- Thoroughly remove any residue of flammable substances from the workpiece before starting welding.
- Only continue work on welded workpieces once they have cooled down.  
Do not allow to come into contact with flammable material!
- Connect welding leads correctly!



### Danger when coupling multiple power sources!

**Coupling multiple power sources in parallel or in series has to be carried out by qualified personnel and in accordance with the manufacturer's guidelines. Before bringing the power sources into service for arc welding operations, a test has to verify that they cannot exceed the maximum allowed open circuit voltage.**

- Connection of the machine may be carried out by qualified personnel only!
- When decommissioning individual power sources, all mains and welding current leads have to be safely disconnected from the welding system as a whole. (danger due to inverse voltages)!



## CAUTION



### Noise exposure!

**Noise exceeding 70 dBA can cause permanent hearing damage!**

- Wear suitable ear protection!
- Persons located within the working area must wear suitable ear protection!

**CAUTION****Obligations of the operator!****The respective national directives and laws must be observed for operation of the machine!**

- National implementation of the framework directive (89/391/EWG), as well as the associated individual directives.
- In particular, directive (89/655/EWG), on the minimum regulations for safety and health protection when staff members use equipment during work.
- The regulations regarding work safety and accident prevention for the respective country.
- Setting up and operating the machine according to IEC 60974-9.
- Check at regular intervals that users are working in a safety-conscious way.
- Regular checks of the machine according to IEC 60974-4.

**Damage due to the use of non-genuine parts!****The manufacturer's warranty becomes void if non-genuine parts are used!**

- Only use system components and options (power sources, welding torches, electrode holders, remote controls, spare parts and replacement parts, etc.) from our range of products!
- Only insert and lock accessory components into the relevant connection socket when the machine is switched off.

**Damage to the machine due to stray welding currents!****Stray welding currents can destroy protective earth conductors, damage equipment and electronic devices and cause overheating of components leading to fire.**

- Make sure all welding leads are securely connected and check regularly.
- Always ensure a proper and secure electrical connection to the workpiece!
- Set up, attach or suspend all conductive power source components like casing, transport vehicle and crane frames so they are insulated!
- Do not place any other electronic devices such as drillers or angle grinders, etc., on the power source, transport vehicle or crane frames unless they are insulated!
- Always put welding torches and electrode holders on an insulated surface when they are not in use!

**Mains connection****Requirements for connection to the public mains network**

High-performance machines can influence the mains quality by taking current from the mains network. For some types of machines, connection restrictions or requirements relating to the maximum possible line impedance or the necessary minimum supply capacity at the interface with the public network (Point of Common Coupling, PCC) can therefore apply. In this respect, attention is also drawn to the machines' technical data. In this case, it is the responsibility of the operator, where necessary in consultation with the mains network operator, to ensure that the machine can be connected.

## CAUTION



### EMC Machine Classification

In accordance with IEC 60974-10, welding machines are grouped in two electromagnetic compatibility classes (see technical data):

**Class A** machines are not intended for use in residential areas where the power supply comes from the low-voltage public mains network. When ensuring the electromagnetic compatibility of class A machines, difficulties can arise in these areas due to interference not only in the supply lines but also in the form of radiated interference.

**Class B** machines fulfil the EMC requirements in industrial as well as residential areas, including residential areas connected to the low-voltage public mains network.

### Setting up and operating

When operating arc welding systems, in some cases, electro-magnetic interference can occur although all of the welding machines comply with the emission limits specified in the standard. The user is responsible for any interference caused by welding.

In order to **evaluate** any possible problems with electromagnetic compatibility in the surrounding area, the user must consider the following: (see also EN 60974-10 Appendix A)

- Mains, control, signal and telecommunication lines
- Radios and televisions
- Computers and other control systems
- Safety equipment
- The health of neighbouring persons, especially if they have a pacemaker or wear a hearing aid
- Calibration and measuring equipment
- The immunity to interference of other equipment in the surrounding area
- The time of day at which the welding work must be carried out

### Recommendations for reducing interference emission

- Mains connection, e.g. additional mains filter or shielding with a metal tube
- Maintenance of the arc welding equipment
- Welding leads should be as short as possible and run closely together along the ground
- Potential equalization
- Earthing of the workpiece. In cases where it is not possible to earth the workpiece directly, it should be connected by means of suitable capacitors.
- Shielding from other equipment in the surrounding area or the entire welding system

## 2.4 Transport and installation



### WARNING



#### **Incorrect handling of shielding gas cylinders!**

**Incorrect handling of shielding gas cylinders can result in serious and even fatal injury.**

- Observe the instructions from the gas manufacturer and in any relevant regulations concerning the use of compressed air!
- Place shielding gas cylinders in the holders provided for them and secure with fixing devices.
- Avoid heating the shielding gas cylinder!



### CAUTION



#### **Risk of tipping!**

**There is a risk of the machine tipping over and injuring persons or being damaged itself during movement and set up. Tilt resistance is guaranteed up to an angle of 10° (according to EN 60974-A2).**

- Set up and transport the machine on level, solid ground!
- Secure add-on parts using suitable equipment!
- Replace damaged wheels and their fixing elements!
- Fix external wire feed units during transport (avoid uncontrolled rotation)!



#### **Damage due to supply lines not being disconnected!**

**During transport, supply lines which have not been disconnected (mains supply leads, control leads, etc.) may cause hazards such as connected equipment tipping over and injuring persons!**

- Disconnect supply lines!

### CAUTION



#### **Equipment damage when not operated in an upright position!**

**The units are designed for operation in an upright position!**

**Operation in non-permissible positions can cause equipment damage.**

- Only transport and operate in an upright position!

## 2.4.1 Lifting by crane



### DANGER



#### **Risk of injury during lifting by crane!**

**When lifting the equipment by crane, serious injuries can be inflicted by falling equipment or add-on units.**

- Transport on all lifting lugs at the same time (see Fig. Lifting principle)!
- Ensure that there is an even load distribution! Only use ring chains or suspension ropes of the same length!
- Observe the lifting principle (see Fig.)!
- Remove all accessory components before lifting (e.g. shielding gas cylinders, tool boxes, wire feed units, etc.)!
- Avoid jerky movements when raising or lowering!
- Use shackles and load hooks of the appropriate size!

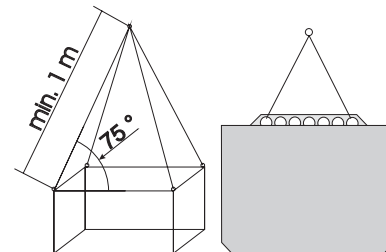


Fig. Lifting principle



#### **Risk of injury due to unsuitable lifting eye!**

**In case of improper use of lifting eyes or the use of unsuitable lifting eyes, persons can be seriously damaged by falling equipment or add-on components!**

- The lifting eye must be completely screwed in!
- The lifting eye must be positioned flat onto and in full contact with the supporting surfaces!
- Check that the lifting eyes are securely fastened before use and check for any damage (corrosion, deformation)!
- Do not use or screw in damaged lifting eyes!
- Avoid lateral loading of the lifting eyes!

## 2.4.2 Ambient conditions



### CAUTION



#### Installation site!

**The machine must not be operated in the open air and must only be set up and operated on a suitable, stable and level base!**

- The operator must ensure that the ground is non-slip and level, and provide sufficient lighting for the place of work.
- Safe operation of the machine must be guaranteed at all times.

### CAUTION



#### Equipment damage due to dirt accumulation!

**Unusually high quantities of dust, acid, corrosive gases or substances may damage the equipment.**

- Avoid high volumes of smoke, vapour, oil vapour and grinding dust!
- Avoid ambient air containing salt (sea air)!



#### Non-permissible ambient conditions!

**Insufficient ventilation results in a reduction in performance and equipment damage.**

- Observe the ambient conditions!
- Keep the cooling air inlet and outlet clear!
- Observe the minimum distance of 0.5 m from obstacles!

### 2.4.2.1 In operation

**Temperature range of the ambient air:**

- -20 °C to +40 °C

**Relative air humidity:**

- Up to 50% at 40 °C
- Up to 90% at 20 °C

### 2.4.2.2 Transport and storage

**Storage in an enclosed space, temperature range of the ambient air:**

- -25 °C to +55 °C

**Relative air humidity**

- Up to 90% at 20 °C

## 3 Intended use

This machine has been manufactured according to the latest developments in technology and current regulations and standards. It must only be operated in line with the instructions on correct usage.



### WARNING



#### **Hazards due to improper usage!**

**Hazards may arise for persons, animals and material objects if the equipment is not used correctly. No liability is accepted for any damages arising from improper usage!**

- The equipment must only be used in line with proper usage and by trained or expert staff!
- Do not modify or convert the equipment improperly!

## 3.1 Applications

### 3.1.1 MIG/MAG standard welding

Metal arc welding using a wire electrode whereby gas from an external source surrounds the arc and the molten pool to protect them from the atmosphere.

#### 3.1.1.1 rootArc

Stable, soft, short arc even with long welding leads; ideal for simple, reliable root welding without pool support, easy gap bridging.

#### 3.1.1.2 forceArc

Welding with a powerful forced arc, deep fusion penetration and virtually spatter-free weld seams of the highest quality.

### 3.1.2 MIG/MAG pulse welding

Welding process for optimum welding results when joining stainless steel and aluminium thanks to controlled drop transfer and targeted, adapted heat input.

### 3.1.3 TIG (Liftarc) welding

TIG welding process with arc ignition by means of workpiece contact.

### 3.1.4 MMA welding

Manual arc welding or, for short, MMA welding. It is characterised by the fact that the arc burns between a melting electrode and the molten pool. There is no external protection; any protection against the atmosphere comes from the electrode.

#### 3.1.4.1 Air arc gouging

During air arc gouging, bad welding seams are heated with a carbon electrode and then removed with compressed air. Special electrode holders and carbon electrodes are required for air arc gouging.



## 3.2 Documents which also apply

### 3.2.1 Warranty

#### NOTE



For further information, please see the accompanying supplementary sheets "Machine and Company Data, Maintenance and Testing, Warranty"!

### 3.2.2 Declaration of Conformity



The designated machine conforms to EC Directives and standards in terms of its design and construction:

- EC Low Voltage Directive (2006/95/EC),
- EC EMC Directive (2004/108/EC),

This declaration shall become null and void in the event of unauthorised modifications, improperly conducted repairs, non-observance of the deadlines for the repetition test and / or non-permitted conversion work not specifically authorised by the manufacturer.

The original copy of the declaration of conformity is enclosed with the unit.

### 3.2.3 Welding in environments with increased electrical hazards



In compliance with IEC / DIN EN 60974, VDE 0544 the machines can be used in environments with an increased electrical hazard.

### 3.2.4 Service documents (spare parts and circuit diagrams)



#### DANGER



**Do not carry out any unauthorised repairs or modifications!**

**To avoid injury and equipment damage, the unit must only be repaired or modified by specialist, skilled persons!**

**The warranty becomes null and void in the event of unauthorised interference.**

- Appoint only skilled persons for repair work (trained service personnel)!

Original copies of the circuit diagrams are enclosed with the unit.

Spare parts can be obtained from the relevant authorised dealer.

### 3.2.5 Calibration/Validation



We hereby confirm that this machine has been tested using calibrated measuring equipment, as stipulated in IEC/EN 60974, ISO/EN 17662, EN 50504, and complies with the admissible tolerances.

Recommended calibration interval: 12 months

## 4 Machine description – quick overview

### 4.1 Front view

#### NOTE

-  Coolant tank and quick connect coupling of coolant supply and return are only fitted in machines with water cooling.
-  The maximum possible machine configuration is given in the text description. If necessary, the optional connection may need to be retrofitted (see "Accessories" chapter).

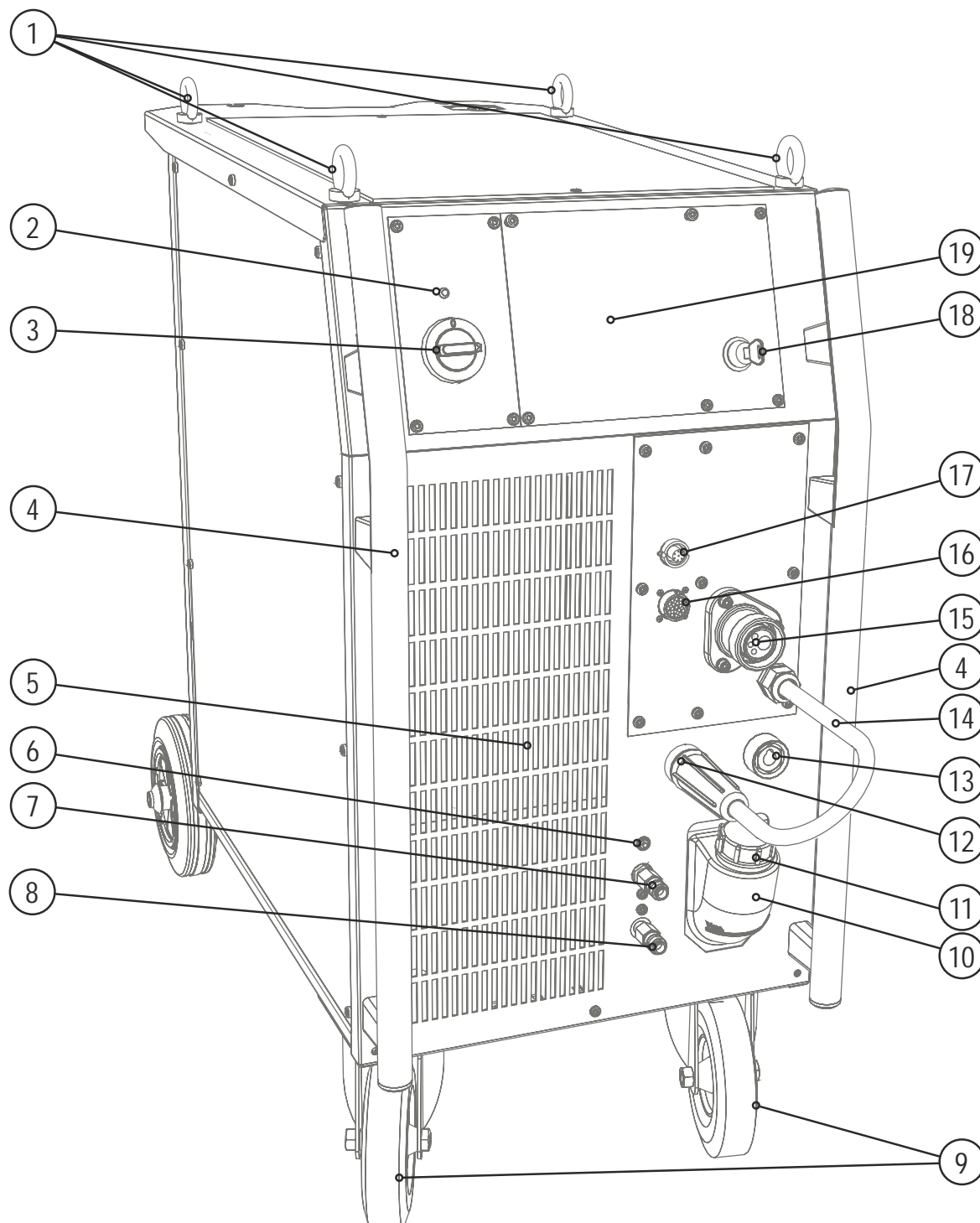










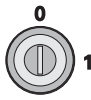


Figure 4-1

Item	Symbol	Description
1		<b>Lifting lug</b>
2		<b>Ready for operation signal light</b> Signal light on when the machine is switched on and ready for operation
3		<b>Main switch, machine on/off</b>
4		<b>Carrying handle</b>
5		<b>Cooling air inlet</b>
6		<b>Automatic cut-out of coolant pump key button</b> press to reset a triggered fuse
7		<b>Quick connect coupling (red)</b> coolant return
8		<b>Quick connect coupling (blue)</b> coolant supply
9		<b>Wheels, guide castors</b>
10		<b>Coolant tank</b>
11		<b>Coolant tank cap</b>
12		<b>"-" welding current connection socket</b> <ul style="list-style-type: none"> <li>MIG/MAG welding: Workpiece connection</li> <li>MIG/MAG cored wire welding: Welding current to central connection/torch</li> <li>TIG welding: Welding current connection for welding torch</li> <li>MMA welding: Workpiece or electrode holder connection</li> </ul>
13		<b>Connection socket, "+" welding current</b> <ul style="list-style-type: none"> <li>MIG/MAG welding: Welding current to central connection/torch</li> <li>MIG/MAG cored wire welding: Workpiece connection</li> <li>TIG welding: Workpiece connection</li> <li>MMA welding: Workpiece or electrode holder connection</li> </ul>
14		<b>Welding current cable, polarity selection</b> Welding current to the central connector/torch, enables polarity selection. <ul style="list-style-type: none"> <li>MIG/MAG: Connection socket for "+" welding current</li> <li>Self-shielding cored wire/TIG: Connection socket for "-" welding current</li> </ul>
15		<b>Euro torch connector</b> Integrated welding current, shielding gas and torch trigger
16		<b>19-pole connection socket (analogue)</b> For connecting analogue accessory components (remote control, welding torch control lead, etc.)
17	 digital	<b>7-pole connection socket (digital)</b> For connecting digital accessory components (documentation interface, robot interface or remote control, etc.).
18		<b>Key switch for protection against unauthorised use</b> Position "1" > changes possible, Position "0" > changes not possible. Please take note of chapter "Protecting welding parameters from unauthorised access"
19		<b>Machine control</b> See Machine control – operating elements chapter

## 4.2 Rear view

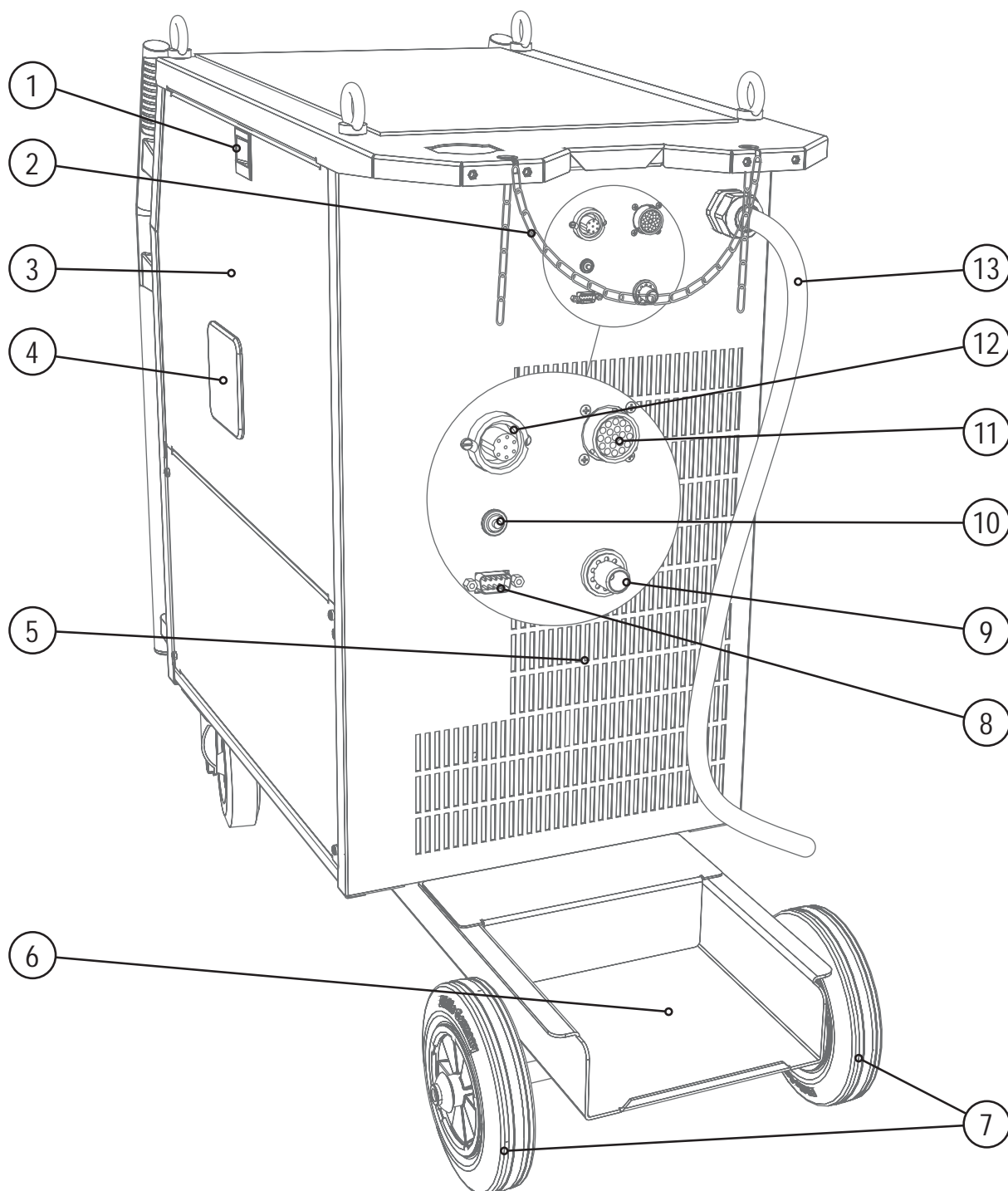







Figure 4-2

Item	Symbol	Description
1		<b>Slide latch, lock for the protective cap</b>
2		<b>Securing elements for shielding gas cylinder (strap/chain)</b>
3		<b>Protective cap</b> Cover for the wire feed mechanism and other operating elements. Depending on the machine series, additional stickers with information on the replacement parts and JOB lists will be located on the inside.
4		<b>Wire spool inspection window</b> Check wire supply
5		<b>Cooling air outlet</b>
6		<b>Bracket for shielding gas cylinder</b>
7		<b>Wheels, fixed castors</b>
8		<b>PC interface, serial (D-Sub connection socket, 9-pole)</b>
9		<b>Connecting nipple G<sup>1</sup>/<sub>4</sub>, shielding gas connection</b>
10		<b>Key button, automatic cutout</b> Wire feed motor supply voltage fuse press to reset a triggered fuse
11	 analog	<b>19-pole interface for mechanised welding (analogue), optional</b> (see "Design and function" chapter)
12	 digital	<b>7-pole connection socket (digital)</b> For connecting digital accessory components (documentation interface, robot interface or remote control, etc.).
13		<b>Mains connection cable</b>

## 4.3 Inside view

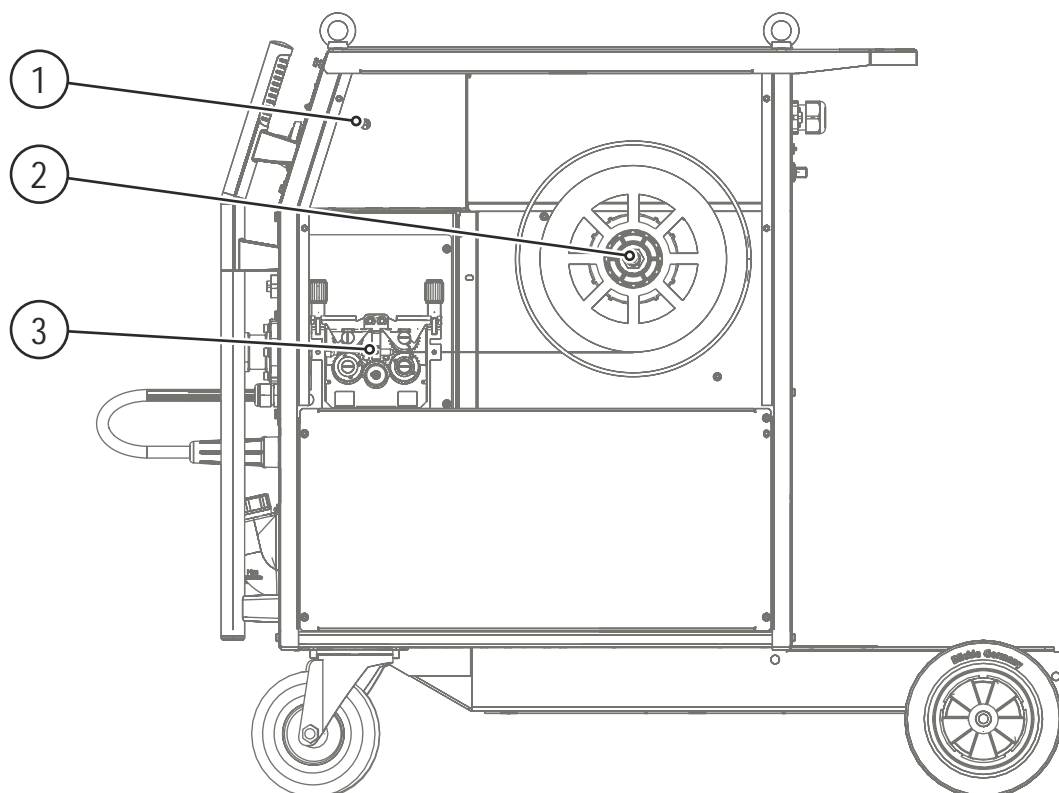



Figure 4-3

Item	Symbol	Description
1		<b>Welding torch function changeover switch</b> (special welding torch required) Changing over programs or JOBs Infinite adjustment of welding performance.
2		<b>Wire spool holder</b>
3		<b>Wire feed unit</b>

## 4.4 Machine control – Operating elements

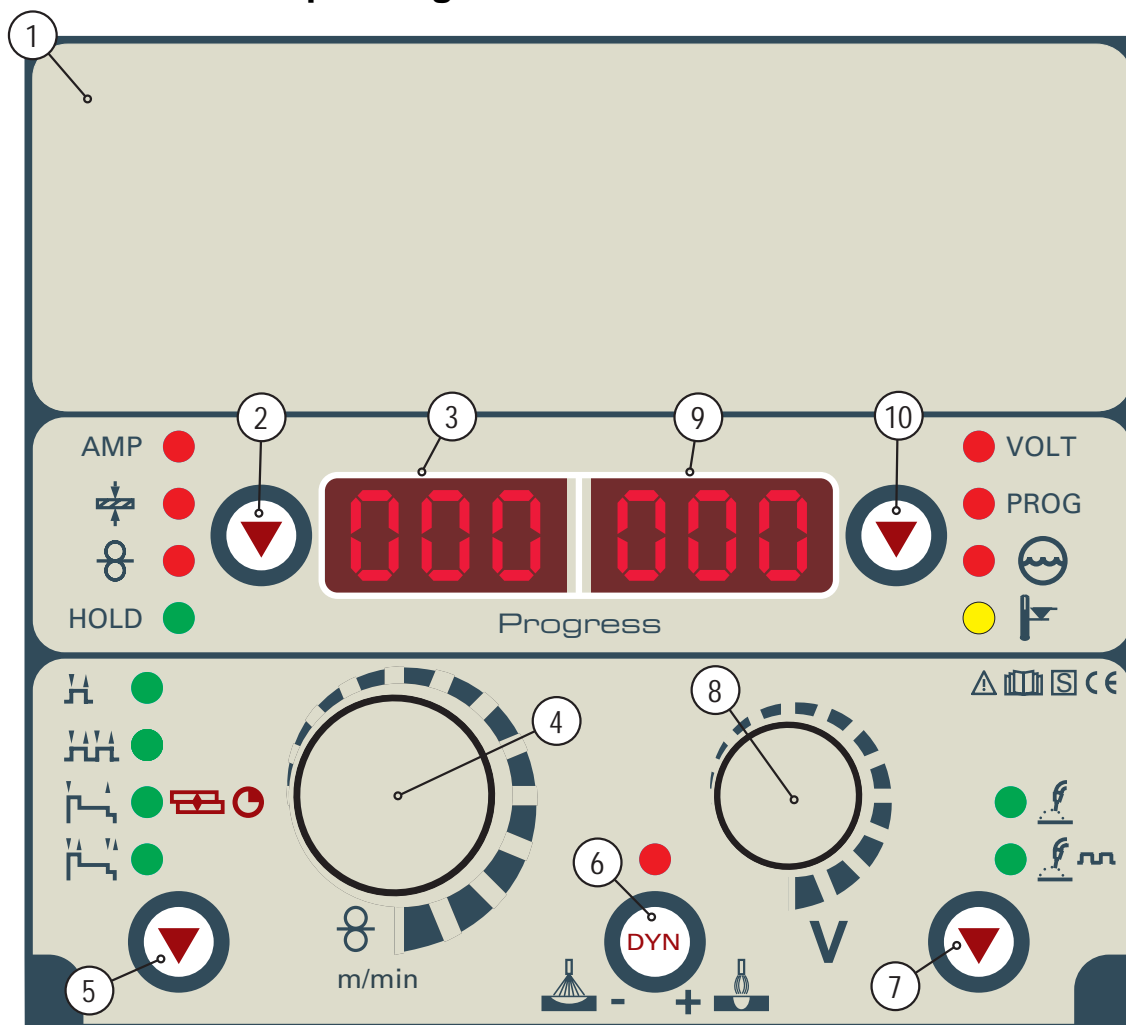

















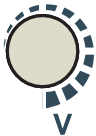






Figure 4-4



Item	Symbol	Description
1		<b>Lid</b> (see chap. "Machine control – concealed operating elements")
2		<b>Button, Parameter selection left</b> <b>AMP</b> Welding current  Material thickness  Wire speed <b>HOLD</b> After each completed welding process, the last parameter values used for the welding process are shown on the display in the main program; the signal light is on
3		<b>Display, left</b> Welding current, material thickness, wire speed, hold values
4		<b>Welding parameter setting, rotary dial</b> For setting the welding performance, for selecting the JOB (welding task) and for setting other welding parameters.
5		<b>Select operating mode button</b>  Non-latched  Latched  Signal light lights up in green: Special non-latched  Signal light lights up in red: MIG spot welding  Special latched
6		<b>Dynamics/choke effect button</b>  Arc harder and narrower  Arc softer and wider
7		<b>Button, Select welding type</b>  MIG/MAG standard welding  MIG/MAG pulse arc welding
8		<b>Arc length correction/selection of welding program, rotary dial</b> <ul style="list-style-type: none"> <li>Correction of the arc length from -9.9 V to +9.9 V.</li> <li>Selection of welding programs 0 to 15 (not possible if accessory components, such as program torches, are connected).</li> </ul>
9		<b>Display, right</b> Welding voltage, program number
10		<b>Button, Parameter selection (right)</b> <b>VOLT</b> Welding voltage <b>Prog</b> Program number  Coolant error  Temperature error

## 4.4.1 Machine control – Concealed operating elements

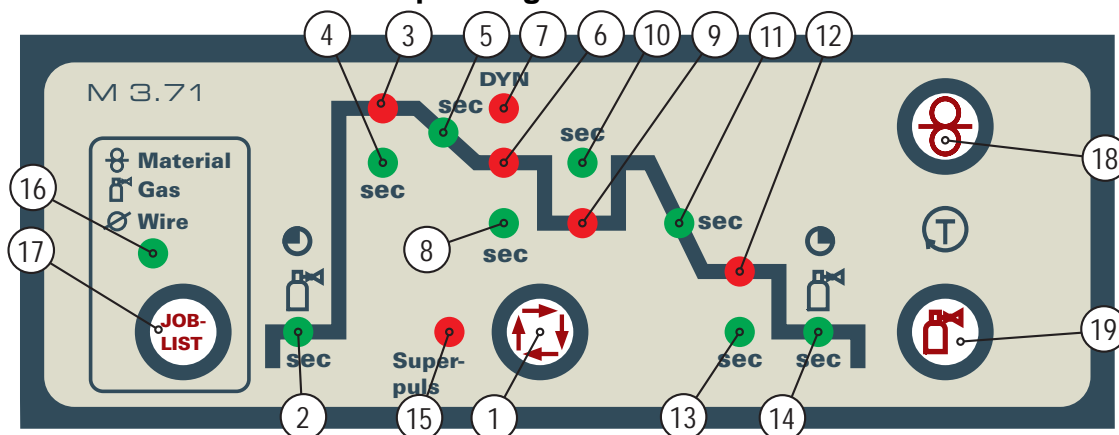






Figure 4-5

Item	Symbol	Description
1		<b>Select welding parameters button</b> This button is used to select the welding parameters depending on the welding process and operating mode used.
2		<b>Signal light, gas pre-flow time</b> Setting range 0.0 s to 20.0 s
3		<b>Signal light, start program (P<sub>START</sub>)</b> <ul style="list-style-type: none"> <li>Wire speed: 1% to 200% of the main program P<sub>A</sub></li> <li>Correction of the arc length -9.9 V to +9.9 V</li> </ul>
4	<b>sec</b>	<b>Signal light, start time</b> Setting range, absolute 0.0 s to 20.0 s (0.1 s increments)
5	<b>sec</b>	<b>Signal light, slope time program P<sub>START</sub> to main program P<sub>A</sub></b> Setting range 0.0 s to 20.0 s (0.1 s increments)
6		<b>Signal light, main program (P<sub>A</sub>)</b> <ul style="list-style-type: none"> <li>Wire speed WF-min. to WF-max.</li> <li>Correction of the arc length -9.9 V to +9.9 V</li> </ul>
7	<b>DYN</b>	<b>Signal light, dynamics</b> Setting range -40 to +40
8	<b>sec</b>	<b>Signal light, duration of main program P<sub>A</sub></b> Setting range 0.0 s to 20.0 s (0.1 s increments). Used e.g. in connection with the super pulse function
9		<b>Signal light, reduced main program (P<sub>B</sub>)</b> <ul style="list-style-type: none"> <li>Wire speed: 1% to 200% of the main program P<sub>A</sub></li> <li>Correction of the arc length -9.9 V to +9.9 V</li> </ul>
10	<b>sec</b>	<b>Signal light, duration reduced main program P<sub>B</sub></b> Setting range 0.0 s to 20.0 s (0.1 s increments). Used e.g. in connection with the super pulse function.
11	<b>sec</b>	<b>Signal light, slope time program P<sub>A</sub> (or P<sub>B</sub>) to end program P<sub>END</sub></b> Setting range 0.0 s to 20.0 s (0.1 s increments)
12		<b>Signal light, end program (P<sub>END</sub>)</b> <ul style="list-style-type: none"> <li>Wire speed: 1% to 200% of the main program P<sub>A</sub></li> <li>Correction of the arc length -9.9 V to +9.9 V</li> </ul>
13	<b>sec</b>	<b>Signal light, duration of end program P<sub>END</sub></b> Setting range 0.0 s to 20.0 s (0.1 s increments)
14		<b>Signal light, gas post-flow time</b> Setting range 0.0 s to 20.0 s

Item	Symbol	Description
15	<b>Super-puls</b>	<b>Signal lamp, super pulse function</b> Lights up when the super pulse function is active.
16	 Material Gas Wire	<b>Signal light, JOB-List</b> Illuminates upon display or selection of the JOB number
17		<b>Key button, JOB-List</b> Selection of the welding task (JOB) from the JOB list
18		<b>Wire inching button</b> See also "Inching the Wire Electrode" chapter
19		<b>Gas test / rinse button</b> <ul style="list-style-type: none"> <li>Gas test: For setting the shielding gas quantity</li> <li>Rinse: For rinsing longer tube packages</li> </ul> See also "Shielding Gas Supply" chapter

## 5 Design and function

### 5.1 General



#### WARNING



##### **Risk of injury from electric shock!**

**Contact with live parts, e.g. welding current sockets, is potentially fatal!**

- Follow safety instructions on the opening pages of the operating instructions.
- Commissioning may only be carried out by persons who have the relevant expertise of working with arc welding machines!
- Connection and welding leads (e.g. electrode holder, welding torch, workpiece lead, interfaces) may only be connected when the machine is switched off!



#### CAUTION



##### **Insulate the arc welder from welding voltage!**

**Not all active parts of the welding current circuit can be shielded from direct contact. To avoid any associated risks it is vital for the welder to adhere to the relevant safety regulations. Even low voltages can cause a shock and lead to accidents.**

- Wear dry and undamaged protective clothing (shoes with rubber soles/welder's gloves made from leather without any studs or braces)!
- Avoid direct contact with non-insulated connection sockets or connectors!
- Always place torches and electrode holders on an insulated surface!



##### **Risk of burns on the welding current connection!**

**If the welding current connections are not locked, connections and leads heat up and can cause burns, if touched!**

- Check the welding current connections every day and lock by turning in clockwise direction, if necessary.



##### **Risk of injury due to moving parts!**

**The wire feeders are equipped with moving parts, which can trap hands, hair, clothing or tools and thus injure persons!**

- Do not reach into rotating or moving parts or drive components!
- Keep casing covers or protective caps closed during operation!



##### **Risk of injury due to welding wire escaping in an unpredictable manner!**

**Welding wire can be conveyed at very high speeds and, if conveyed incorrectly, may escape in an uncontrolled manner and injure persons!**

- Before mains connection, set up the complete wire guide system from the wire spool to the welding torch!
- Remove the pressure rollers from the wire feeder if no welding torch is fitted!
- Check wire guide at regular intervals!
- Keep all casing covers or protective caps closed during operation!



##### **Risk from electrical current!**

**If welding is carried out alternately using different methods and if a welding torch and an electrode holder remain connected to the machine, the open-circuit/welding voltage is applied simultaneously on all cables.**

- The torch and the electrode holder should therefore always be placed on an insulated surface before starting work and during breaks.

**CAUTION****Damage due to incorrect connection!**

**Accessory components and the power source itself can be damaged by incorrect connection!**

- Only insert and lock accessory components into the relevant connection socket when the machine is switched off.
- Comprehensive descriptions can be found in the operating instructions for the relevant accessory components.
- Accessory components are detected automatically after the power source is switched on.

**Using protective dust caps!**

**Protective dust caps protect the connection sockets and therefore the machine against dirt and damage.**

- The protective dust cap must be fitted if there is no accessory component being operated on that connection.
- The cap must be replaced if faulty or if lost!

## 5.2 Installation

**CAUTION****Installation site!**

**The machine must not be operated in the open air and must only be set up and operated on a suitable, stable and level base!**

- The operator must ensure that the ground is non-slip and level, and provide sufficient lighting for the place of work.
- Safe operation of the machine must be guaranteed at all times.

## 5.3 Machine cooling

To obtain an optimal duty cycle from the power components, the following precautions should be observed:

- Ensure that the working area is adequately ventilated.
- Do not obstruct the air inlets and outlets of the machine.
- Do not allow metal parts, dust or other objects to get into the machine.

## 5.4 Workpiece lead, general

**CAUTION****Risk of burns due to incorrect connection of the workpiece lead!**

**Paint, rust and dirt on the connection restrict the power flow and may lead to stray welding currents.**

**Stray welding currents may cause fires and injuries!**

- Clean the connections!
- Fix the workpiece lead securely!
- Do not use structural parts of the workpiece as a return lead for the welding current!
- Take care to ensure faultless power connections!

## 5.5 Welding torch cooling system

### 5.5.1 General

#### CAUTION



##### Coolant mixtures!

**Mixtures with other liquids or the use of unsuitable coolants result in material damage and renders the manufacturer's warranty void!**

- Only use the coolant described in this manual (overview of coolants).
- Do not mix different coolants.
- When changing the coolant, the entire volume of liquid must be changed.



##### Insufficient frost protection in the welding torch coolant!

**Depending on the ambient conditions, different liquids are used for cooling the welding torch (see overview of coolants).**

**Coolants with frost protection (KF 37E or KF 23E) must be checked regularly to ensure that the frost protection is adequate to prevent damage to the machine or the accessory components.**

- The coolant must be checked for adequate frost protection with the TYP 1 frost protection tester (see accessories).
- Replace coolant as necessary if frost protection is inadequate!

#### NOTE



**The disposal of coolant must be carried out according to official regulations and observing the relevant safety data sheets (German waste code number: 70104)!**

- Coolant must not be disposed of together with household waste.
- Coolant must not be discharged into the sewerage system.
- Recommended cleaning agent: water, if necessary with cleaning agent added.

### 5.5.2 List of coolants

The following coolants may be used (for item nos., please see the Accessories chapter):

Coolant	Temperature range
KF 23E (Standard)	-10 °C to +40 °C
KF 37E	-20 °C to +10 °C
DKF 23E (for plasma machines)	0 °C to +40 °C

## 5.5.3 Adding coolant

The unit is supplied ex works with a minimum level of coolant.

### NOTE



After the initial filling, wait for at least one minute when the machine is switched on so that the tube package is filled with coolant completely and without bubbles.

With frequent changes of torch and during the initial filling process, the cooling unit tank should be topped up as necessary.

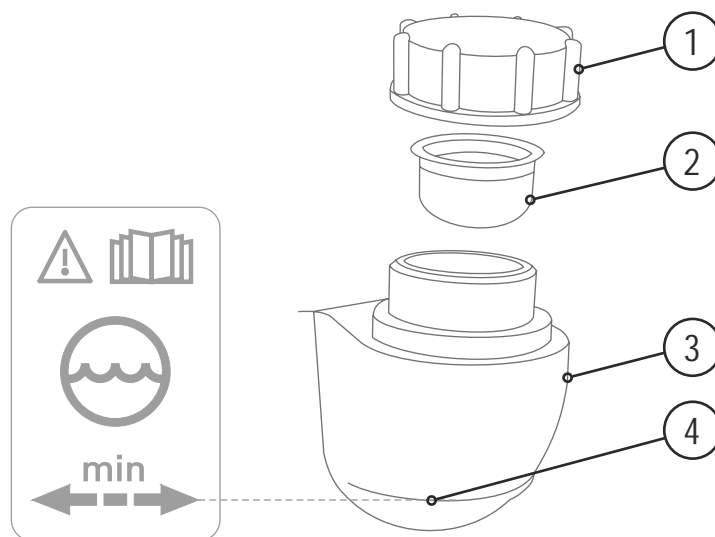


Figure 5-1

Item	Symbol	Description
1		Coolant tank cap
2		Coolant filter sieve
3		Coolant tank
4		"Min" mark Minimum coolant level

- Unscrew and remove the coolant tank sealing cover.
- Check filter sieve insert for dirt, clean if necessary and reinsert into position.
- Top up coolant to the filter sieve insert, close sealing cover again.

### NOTE



The level of coolant must never fall below the "min" mark.



If there is less coolant in the coolant tank than the minimum required you may need to vent the coolant circuit. In this case the welding machine will automatically shut down the coolant pump and signal an error, see chapter "Rectifying faults".

## 5.6 Mains connection



### DANGER



#### Hazard caused by improper mains connection!

**An improper mains connection can cause injuries or damage property!**

- Only use machine with a plug socket that has a correctly fitted protective conductor.
- If a mains plug must be fitted, this may only be carried out by an electrician in accordance with the relevant national provisions or regulations!
- Mains plug, socket and lead must be checked regularly by an electrician!
- When operating the generator always ensure it is earthed as stated in the operating instructions. The resulting network has to be suitable for operating devices according to protection class 1.

### 5.6.1 Mains configuration

#### NOTE



**The machine may be connected to:**

- a three-phase system with four conductors and an earthed neutral conductor
- a three-phase system with three conductors of which any one can be earthed, e.g. the outer conductor

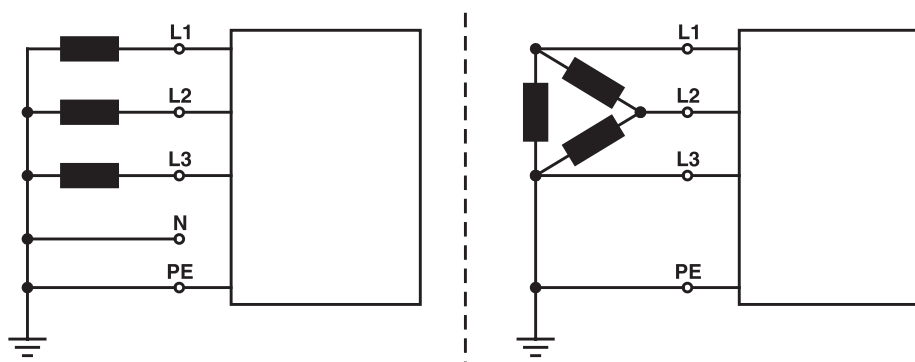


Figure 5-2

#### Legend

Item	Designation	Colour code
L1	Outer conductor 1	brown
L2	Outer conductor 2	black
L3	Outer conductor 3	grey
N	Neutral conductor	blue
PE	Protective conductor	green-yellow

#### CAUTION



#### Operating voltage - mains voltage!

**The operating voltage shown on the rating plate must be consistent with the mains voltage, in order to avoid damage to the machine!**

- For mains fuse protection, please refer to the "Technical data" chapter!

- Insert mains plug of the switched-off machine into the appropriate socket.



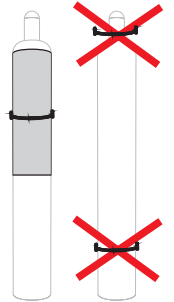
## 5.7 Shielding gas supply (shielding gas cylinder for welding machine)

### WARNING



**Risk of injury due to improper handling of shielding gas cylinders! Improper handling and insufficient securing of shielding gas cylinders can cause serious injuries!**

- Secure shielding gas cylinders using the standard fastening elements on the unit (chain/belt)!
- The fastening elements must tightly enclose the shielding gas cylinder!
- Attach the fastening elements within the upper half of the shielding gas cylinder!
- Do not attach any element to the shielding gas cylinder valve!
- Observe the instructions from the gas manufacturer and any relevant regulations concerning the use of compressed air!
- Avoid heating the shielding gas cylinder!



### CAUTION



**Faults in the shielding gas supply.**

**An unhindered shielding gas supply from the shielding gas cylinder to the welding torch is a fundamental requirement for optimum welding results. In addition, a blocked shielding gas supply may result in the welding torch being destroyed.**

- Always re-fit the yellow protective cap when not using the shielding gas connection.
- All shielding gas connections must be gas tight.

### NOTE



**Before connecting the pressure regulator to the gas cylinder, open the cylinder valve briefly to expel any dirt.**

## 5.8 MIG/MAG welding

### 5.8.1 Welding torch and workpiece line connection

#### NOTE



#### **Fault with the wire guide!**

**On delivery, the central connector (Euro) is fitted with a capillary tube for welding torches with spiral guides. Conversion is necessary if a welding torch with a plastic core is used!**

Welding torch with plastic core:

- use with guide tube!

Welding torch with spiral guide:

- use with capillary tube!

**Depending on the wire electrode diameter or type, either a spiral guide or plastic core with the correct inner diameter has to be inserted in the torch!**

Recommendation:

- Use a spiral guide to weld hard, unalloyed wire electrodes (steel).
- Use a plastic core to weld or braze soft, high-alloy wire electrodes or aluminium materials.

#### **Preparation for connecting welding torches with a plastic core:**

- Push forward the capillary tube on the wire feed side in the direction of the central connector and remove it there.
- Slide plastic core guide tube off the central connector.
- Carefully insert the central plug for the welding torch, with the still oversized plastic liner, into the central connector and screw together with crown nut.
- Use a suitable tool to cut off the plastic liner just before the wire feed roller, making sure not to pinch it.
- Unfasten and remove the central plug on the welding torch.
- Cleanly remove the burr from the separated end of the plastic core!

#### **Preparation for connecting welding torches with a spiral guide:**

- Check that the capillary tube is correctly positioned in relation to the central connector!

## 5.8.1.1 MIG/MAG standard welding

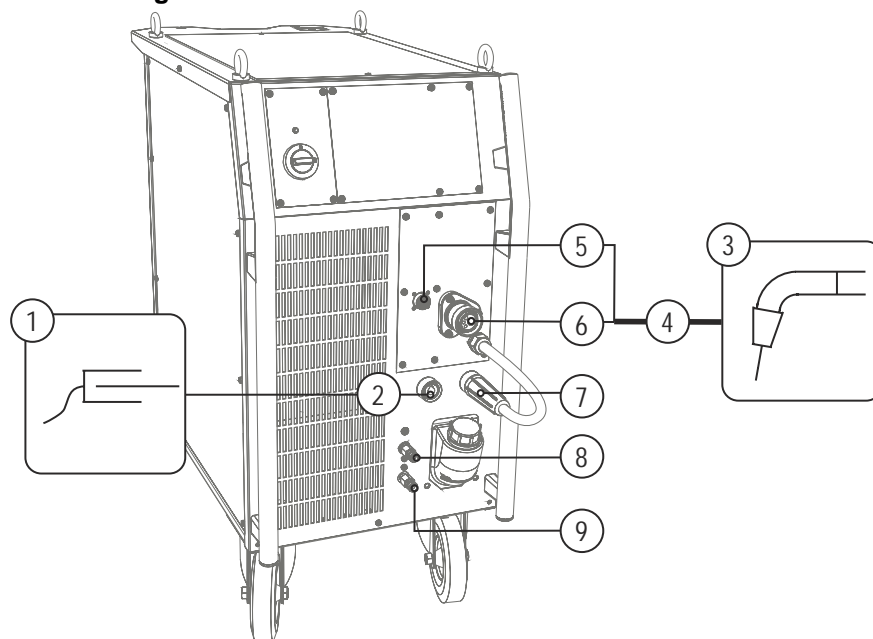









Figure 5-3

Item	Symbol	Description
1		<b>Workpiece</b>
2		<b>"-" welding current connection socket</b> • MIG/MAG welding: Workpiece connection
3		<b>Welding torch</b>
4		<b>Welding torch hose package</b>
5		<b>19-pole connection socket (analogue)</b> For connecting analogue accessory components (remote control, welding torch control lead, etc.)
6		<b>Euro torch connector</b> Integrated welding current, shielding gas and torch trigger
7		<b>Welding current cable, polarity selection</b> Welding current to central connection/torch. Permits polarity selection for MIG/MAG welding. • Standard applications: Connection for "+" welding current connection socket
8		<b>Quick connect coupling (red)</b> coolant return
9		<b>Quick connect coupling (blue)</b> coolant supply

- Insert the central plug for the welding torch into the central connector and screw together with crown nut.
- Insert the plug on the workpiece lead into the "-" welding current connection socket and lock.
- Welding current lead, insert polarity selection into the "+" welding current connection socket and lock.

### Where applicable:

- Lock connecting nipples of the cooling water tubes into the corresponding quick connect couplings: Return line red to quick connect coupling, red (coolant return) and supply line blue to quick connect coupling, blue (coolant supply).

### Only MIG/MAG torches with special functions (additional control lead):

- Insert the torch control lead plug into the 19-pole connection socket and lock in place.

## 5.8.1.2 MIG/MAG cored wire welding

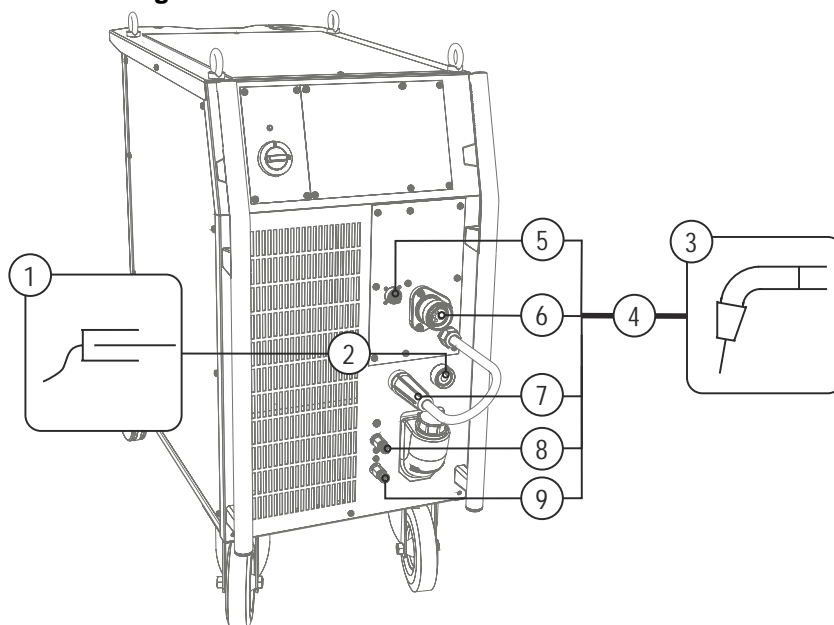


Figure 5-4

Item	Symbol	Description
1		<b>Workpiece</b>
2		<b>Connection socket, "+" welding current</b> • MIG/MAG cored wire welding: Workpiece connection
3		<b>Welding torch</b>
4		<b>Welding torch hose package</b>
5		<b>19-pole connection socket (analogue)</b> For connecting analogue accessory components (remote control, welding torch control lead, etc.)
6		<b>Euro torch connector</b> Integrated welding current, shielding gas and torch trigger
7		<b>Welding current cable, polarity selection</b> Welding current to central connection/torch. Permits polarity selection for MIG/MAG welding. • Cored wire welding: Connection for "-" welding current connection socket
8		<b>Quick connect coupling (red)</b> coolant return
9		<b>Quick connect coupling (blue)</b> coolant supply

- Insert the central plug for the welding torch into the central connector and screw together with crown nut.
- Insert the plug on the workpiece lead into the "+" welding current connection socket and lock.
- Welding current lead, insert polarity selection into the "-" welding current connection socket and lock.

### Where applicable:

- Lock connecting nipples of the cooling water tubes into the corresponding quick connect couplings:  
Return line red to quick connect coupling, red (coolant return) and supply line blue to quick connect coupling, blue (coolant supply).

### Only MIG/MAG torches with special functions (additional control lead):

- Insert the torch control lead plug into the 19-pole connection socket and lock in place.

## 5.8.2 Wire feed

### 5.8.2.1 Open the protective flap of the wire feeder

#### CAUTION



To perform the following steps, the protective flap of the wire feeder needs to be opened. Make sure to close the protective flap again before starting to work.

- Unlock and open protective flap.

### 5.8.2.2 Inserting the wire spool



#### CAUTION



**Risk of injury due to incorrectly secured wire spool.**

If the wire spool is not secured properly, it may come loose from the wire spool holder and fall to the ground, causing damage to the machine and injuries.

- Securely fasten the wire spool to the wire spool holder using the knurled nut.
- Before you start working, always check the wire spool is securely fastened.

#### NOTE



Standard D300 wire spool holder can be used. Adapters (see accessories) are required when using standardised basket coils (DIN 8559).

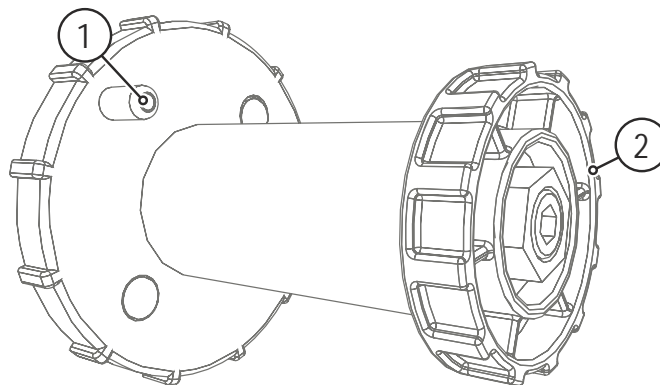


Figure 5-5

Item	Symbol	Description
1		<b>Carrier pin</b> For fixing the wire spool
2		<b>Knurled nut</b> For fixing the wire spool

- Loosen knurled nut from spool holder.
- Fix welding wire reel onto the spool holder so that the carrier pin locks into the spool bore.
- Fasten wire spool using knurled nut.

## 5.8.2.3 Changing the wire feed rollers

### NOTE



#### Unsatisfactory welding results due to faulty wire feeding!

Wire feed rollers must be suitable for the diameter of the wire and the material.

- Check the roller label to verify that the rollers are suitable for the wire diameter. Turn or change if necessary!
- use V-groove rollers with for steel wires and other hard wires,
- use U-groove rollers for aluminium wires and other soft, alloyed wires.

- Slide new drive rollers into place so that the diameter of the wire used is visible on the drive roller.
- Screw the drive rollers in place with knurled screws.

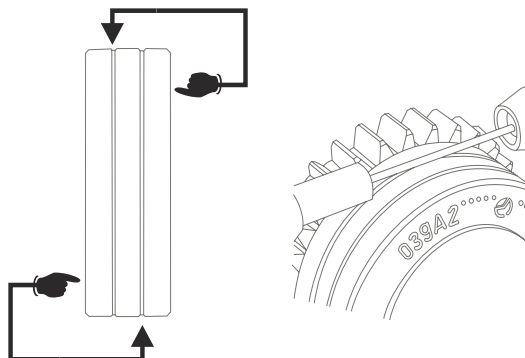


Figure 5-6

## 5.8.2.4 Inching the wire electrode

**CAUTION****Risk of injury due to moving parts!**

The wire feeders are equipped with moving parts, which can trap hands, hair, clothing or tools and thus injure persons!

- Do not reach into rotating or moving parts or drive components!
- Keep casing covers or protective caps closed during operation!

**Risk of injury due to welding wire escaping in an unpredictable manner!**

Welding wire can be conveyed at very high speeds and, if conveyed incorrectly, may escape in an uncontrolled manner and injure persons!

- Before mains connection, set up the complete wire guide system from the wire spool to the welding torch!
- Remove the pressure rollers from the wire feeder if no welding torch is fitted!
- Check wire guide at regular intervals!
- Keep all casing covers or protective caps closed during operation!

**Risk of injury due to welding wire escaping from the welding torch!**

The welding wire can escape from the welding torch at high speed and cause bodily injury including injuries to the face and eyes!

- Never direct the welding torch towards your own body or towards other persons!

**CAUTION****Extensive wear due to incorrect contact pressure!**

**Incorrect contact pressure will cause extensive wear of the wire feed rollers!**

- With the adjusting nuts of the pressure units set the contact pressure so that the wire electrode is conveyed but will still slip through if the wire spool jams.
- Set the contact pressure of the front rollers (in wire feed direction) to a higher value!

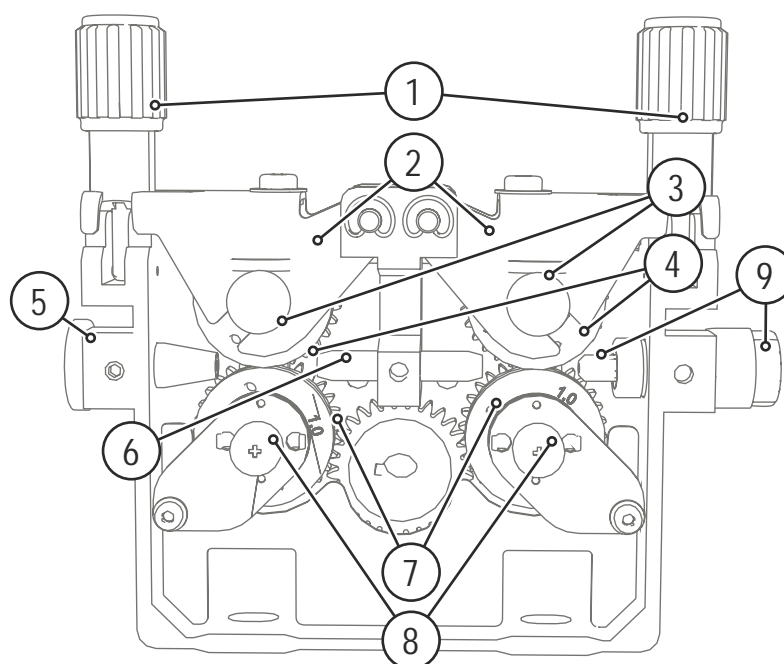


Figure 5-7

Item	Symbol	Description
1		Pressure unit
2		Clamping unit
3		Knurled nut
4		Pressure roller
5		Wire feed nipple
6		Guide tube
7		Drive rollers
8		"Undetachable" knurled screws
9		Wire feed nipple with wire stabiliser

- Extend and lay out the torch hose package.
- Unfasten pressure units and fold out (clamping units and pressure rollers will automatically flip upwards).
- Unwind welding wire carefully from the wire spool and insert through the wire inlet nipple over the drive roller grooves and the guide pipe into the capillary tube and Teflon core using guide pipe.
- Press the clamping element with the pressure roller back downwards and fold the wire units back up again (wire electrode should be in the groove on the drive roller).
- Set the contact pressure with the adjusting nuts of the pressure unit.
- Press the wire inching button until the wire electrode projects out of the welding torch.

## NOTE



The inching speed is infinitely adjustable by simultaneously pressing the wire inching button and turning the wire speed rotary dial. The display shows the selected inching speed.



## 5.8.2.5 Spool brake setting

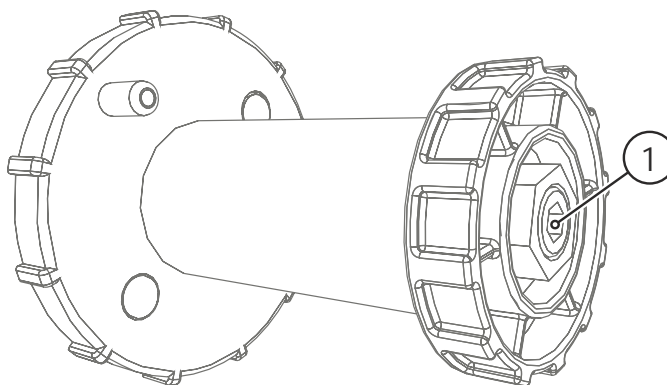


Figure 5-8

Item	Symbol	Description
1		<b>Allen screw</b> Securing the wire spool retainer and adjustment of the spool brake

- Tighten the Allen screw (8 mm) in the clockwise direction to increase the braking effect.

### NOTE



Tighten the spool brake until the wire spool no longer turns when the wire feed motor stops but without it jamming during operation!

## 5.8.3 Definition of MIG/MAG welding tasks

This range of machines feature simple operation with a very wide range of functions.

- Various JOBS (i.e. welding tasks consisting of welding process, material type, wire diameter and shielding gas type) have been pre-defined (see appendix for a list of JOBS).
- Simple JOB selection from a list of pre-defined JOBS (sticker on the machine).
- The required process parameters are calculated by the system depending on the operating point specified (single-dial operation via wire speed rotary dial).
- Additional parameters can be modified as required in the configuration menu on the control or using the PC300.NET welding parameter software.

## 5.8.4 Welding task selection

### 5.8.4.1 Basic welding parameters

- Select JOB (welding task) with JOB list.

The JOB list sticker can be found on the inside of the protective flap of the wire feeder.

**You can only change the JOB number when no welding current is flowing.**

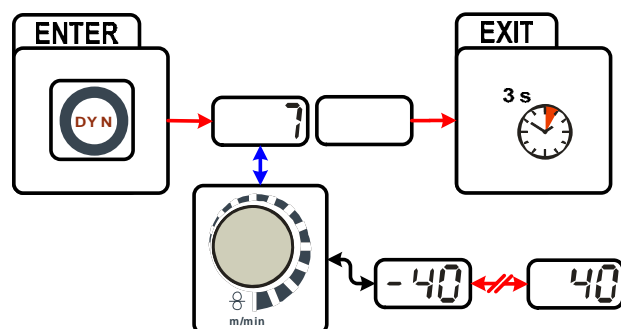
Operating element	Action	Result	Display
	1 x	Select JOB list (LED  is on)	
		Set JOB number. Wait 3s until the setting has been adopted.	


### 5.8.4.2 Operating mode

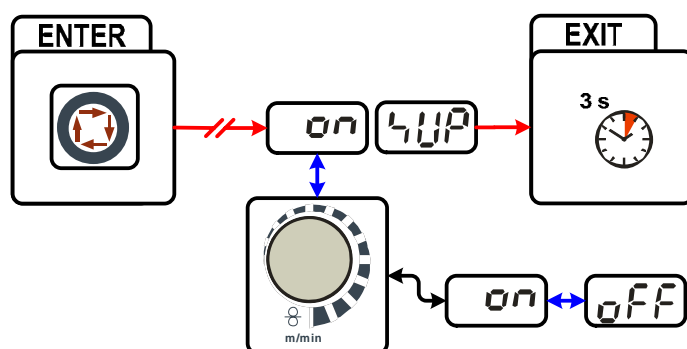
Operating element	Action	Result	Display
	n x	<b>Select operating mode</b> The LED displays the selected operating mode. Non-latched operation Latched operation Green Special non-latched mode Red Spot operating mode Special latched mode	No change



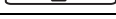
### 5.8.4.3 Welding type (MIG/MAG standard/pulse arc welding)

Operating element	Action	Result	Display
	n x	<b>Select welding type</b> The signal light indicates the selection. Standard MIG/MAG welding Pulse arc MIG/MAG welding	No change



Display	Setting/selection
	<b>Dynamics setting</b> 40: Arc harder and narrower -40: Arc softer and wider



Display	Setting/selection
	<b>Selects super pulses</b> Switches function on or off.
	<b>Switch on</b> Switching on machine function
	<b>Switch off</b> Switching off machine function

5.8.4.6 Burn-back

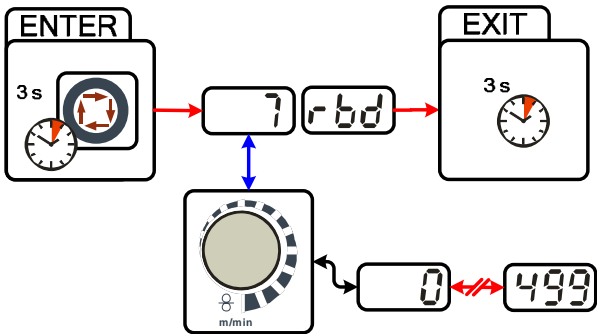


Figure 5-11

Display	Setting/selection
	<b>menu burn back</b> Set burn back
	<b>Parameter setting (setting range 0 to 499)</b> Back-burn set too high: large drops developing on the wire electrode result in poor ignition properties or the wire electrode sticking to the welding nozzle. Back-burn set too low: Wire electrode sticks in the molten pool

5.8.5 MIG/MAG operating point

The operating point (welding output) is specified using the principle of MIG/MAG one-dial operation, i.e. the user need only specify the operating point by setting the required wire speed, for example, and the digital system will calculate the optimum values for welding current and voltage (operating point).

The operating point setting can also be specified using the accessory components such as the remote control, welding torch, etc.

## 5.8.5.1 Selecting the display unit



Figure 5-12

The operating point (welding performance) can be displayed as the welding current, material thickness or wire speed.

Operating element	Action	Result
	n x	Switching the display between: <div> <div>AMP</div> <div></div> <div>Welding current</div> </div> <div> <div></div> <div>Material thickness</div> </div> <div> <div></div> <div>Wire speed</div> </div>

### Application example

Aluminium is to be welded.

- Material = AlMg,
- Gas = Ar 100%,
- Wire diameter = 1.2 mm

The correct wire speed is not known and is to be determined.

- Select the appropriate JOB (see "JOB list" sticker)
- Switch to the material thickness display
- Set the material thickness as appropriate (e.g. 5 mm)
- Switch to the wire speed display

The resulting wire speed will be shown (e.g. 8.4 m/min).

## 5.8.5.2 Operating point setting using material thickness

Given below is a description of the setting work via the wire speed parameters as an example of operating point setting.

Operating element	Action	Result	Display
		Increase or reduce welding performance via the wire speed parameter. Display example: 10.5 m/min	

## 5.8.5.3 Arc length correction setting

The arc length can be corrected as follows.

Operating element	Action	Result	Display
		"Arc length correction" setting (Display example: -0.9V, setting range -9.9 V to +9.9 V)	

## 5.8.5.4 Accessory components for operating point setting

The operating point can also be set with various accessory components such as

- remote controls
- special torches
- PC software
- robot and industrial bus interfaces (optional mechanised welding interface required – not possible for all machines in this series!)

You will find an overview of accessory components in the "Accessories" chapter. See the operating instructions for the machine in question for a more detailed description of the individual machines and their functions.

### 5.8.6 MIG/MAG welding data display

To the left and right of the control displays are the "Parameter selection" buttons (⏮). They are used to select welding parameters to be displayed.

Each press of the button advances the display to the next parameter (LEDs next to the button indicate the selection). After the last parameter is reached, the system starts again from the beginning.



Figure 5-13

The display shows:

- Nominal values (before welding)
- Actual values (during welding)
- Hold values (after welding)

Parameter	Nominal values	Actual values	Hold values
Welding current	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Material thickness	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Wire speed	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Welding voltage	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

When the settings are changed (e.g. wire speed), the system switches over immediately to the setpoint setting.

## 5.8.7 forceArc

Heat-reduced, directionally stable and powerful arc with deep penetration for the upper power range.

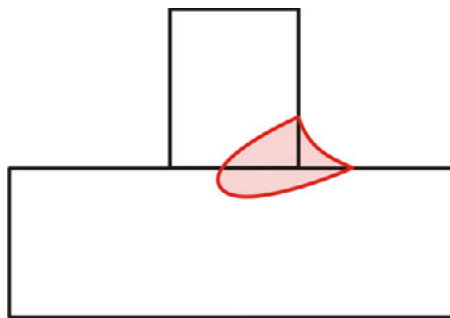


Figure 5-14

- Smaller included angle due to deep penetration and directionally stable arc
- Excellent root and sidewall fusion
- Secure welding also with very long stick-outs
- Reduced undercuts
- Un-, low- and high-alloyed steels as well as high-tensile fine-grained building steels
- Manual and automated applications

forceArc welding from:		Wire Ø (mm)							
Material	Gas	0.8		1		1.2		1.6	
		JOB	⊗	JOB	⊗	JOB	⊗	JOB	⊗
Steel	Ar 91–99%	190	17.0	254	12.0	255	9.5	256	7.0
	Ar 80–90%	189	17.0	179	12.0	180	9.5	181	6.0
CrNi	Ar 91–99%	x	x	251	12.0	252	12.0	253	6.0

You can make use of these properties after selecting the forceArc process (see the "Selecting a MIG/MAG welding task" chapter).

**As with pulse arc welding, it is important to make sure of a good welding current connection.**

- Keep welding current cables as short as possible and ensure that cable cross-sections are adequate!
- Fully unroll welding current cables, torch tube packages and, if applicable, intermediate tube packages. Avoid loops!
- Use welding torches, preferably water-cooled, that are suitable for the higher power range.
- Use welding wire with adequate copper coating when welding steel. The wire spool should have layer spooling.

### NOTE



#### Unstable arc!

**Welding current cables that are not fully unrolled can cause faults in the arc (flickering).**

- Fully unroll welding current cables, torch tube packages and, if applicable, intermediate tube packages. Avoid loops!

## 5.8.8 rootArc

Short arc with easy weld modelling capabilities for effortless gap bridging and positional welding.

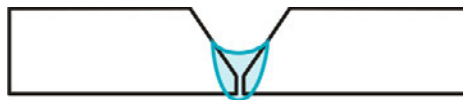


Figure 5-15

- Reduced spatter compared to standard short arc
- Good root formation and secure sidewall fusion
- Un-alloyed and low-alloy steels
- Manual and automated applications

rootArc welding up to:		Wire Ø (mm)											
		0.6		0.8		0.9		1		1.2		1.6	
Material	Gas	JOB		JOB		JOB		JOB		JOB		JOB	
Steel	CO2	x	x	x	x	x	x	204	6.0	205	5.0	x	x
	Ar 80–90%	x	x	x	x	x	x	206	6.0	207	5.0	x	x

### NOTE



#### Unstable arc!

**Welding current cables that are not fully unrolled can cause faults in the arc (flickering).**

- Fully unroll welding current cables, torch tube packages and, if applicable, intermediate tube packages. Avoid loops!















## 5.8.9 MIG/MAG functional sequences / operating modes

### NOTE



There are optimum pre-sets for welding parameters such as gas pre-flow and burn back, etc. for numerous applications (although these can also be changed if required).

### 5.8.9.1 Explanation of signs and functions

Symbol	Meaning
	Press torch trigger
	Release torch trigger
	Tap torch trigger (press briefly and release)
	Shielding gas flowing
I	Welding output
	Wire electrode is being conveyed
	Wire creep
	Wire burn-back
	Gas pre-flows
	Gas post-flows
	Non-latched
	Special, non-latched
	Latched
	Special, latched
t	Time
PSTART	Ignition program
PA	Main program
PB	Reduced main program
PEND	End program
t2	Spot time

### 5.8.10 MIG/MAG automatic cut-out

### NOTE



The welding machine ends the ignition process or the welding process with an

- Ignition fault (no welding current flows within 5 s after the start signal).
- Arc interruption (arc is interrupted for longer than 3 s).

## Non-latched mode

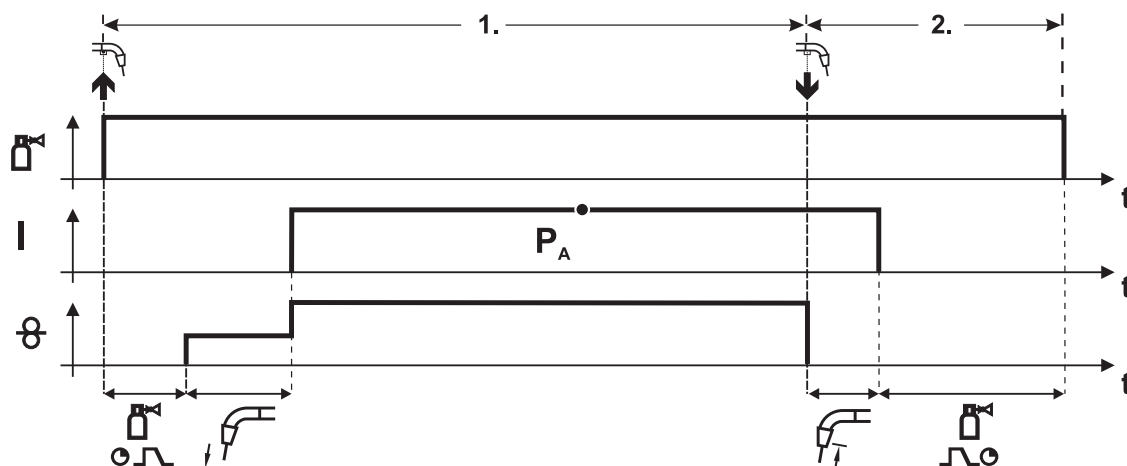


Figure 5-16

### Step 1

- Press and hold torch trigger.
- Shielding gas is expelled (gas pre-flows).
- Wire feed motor runs at "creep speed".
- Arc ignites after the wire electrode makes contact with the workpiece; welding current flows.
- Change over to pre-selected wire speed.

### Step 2

- Release torch trigger.
- WF motor stops.
- Arc is extinguished after the preselected wire burn-back time expires.
- Gas post-flow time elapses.

## Non-latched operation with superpulse

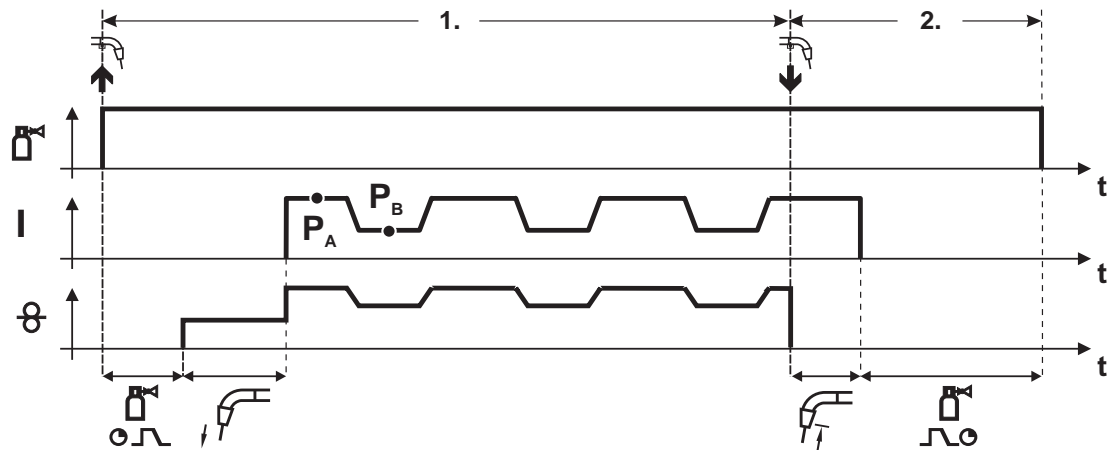


Figure 5-17

### Step 1

- Press and hold torch trigger.
- Shielding gas is expelled (gas pre-flows).
- Wire feed motor runs at "creep speed".
- Arc ignites after the wire electrode makes contact with the workpiece; welding current flows.
- Start the super pulse function beginning with main program  $P_A$ :  
The welding parameters change at the specified times between main program  $P_A$  and the reduced main program  $P_B$ .

### Step 2

- Release torch trigger.
- Super pulse function is ended.
- WF motor stops.
- Arc is extinguished after the preselected wire burn-back time expires.
- Gas post-flow time elapses.

## Special, non-latched

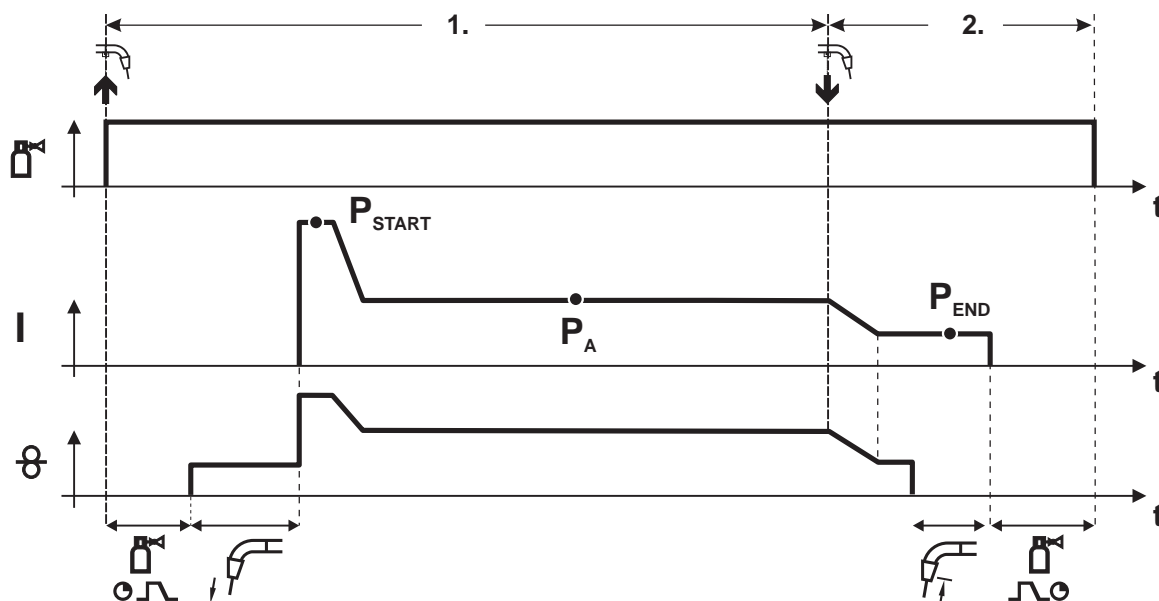


Figure 5-18

### Step 1

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)
- Wire feed motor runs at "creep speed".
- Arc ignites after the wire electrode makes contact with the workpiece, welding current is flowing (start program  $P_{START}$  for the time  $t_{start}$ )
- Slope to main program  $P_A$ .

### Step 2

- Release torch trigger
- Slope to end program  $P_{END}$  for the time  $t_{end}$ .
- WF motor stops.
- Arc is extinguished after the preselected wire burn-back time expires.
- Gas post-flow time elapses.

## Spot welding

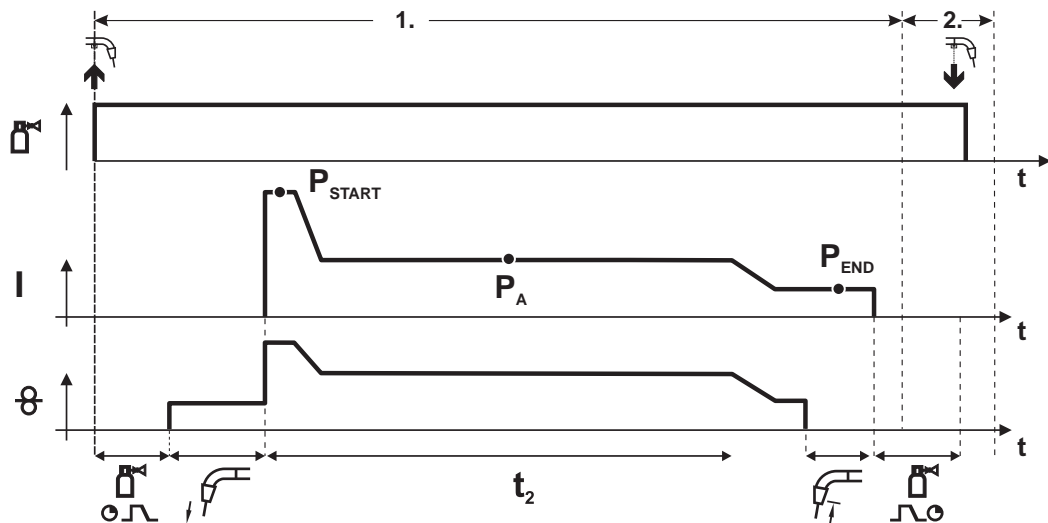



Figure 5-19

### NOTE

 The ignition time  $t_{start}$  must be added to the spot time  $t_2$ .

#### 1st cycle

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)
- Wire feed motor runs at "creep speed"
- Arc ignites after the wire electrode makes contact with the workpiece, welding current is flowing (start program  $P_{START}$ , spot time starts)
- Slope to main program  $P_A$
- After the set spot time elapses, slope goes to end program  $P_{END}$
- Wire feed motor stop welding.
- Arc is extinguished after the pre-selected wire burn-back time elapses
- Gas post-flow time elapses.

#### 2nd cycle

- Release torch trigger

Releasing the torch trigger (step 2) interrupts the welding process even if the spot time has not yet elapsed (slope to end program  $P_{END}$ ).

## Special, non-latched with superpulse

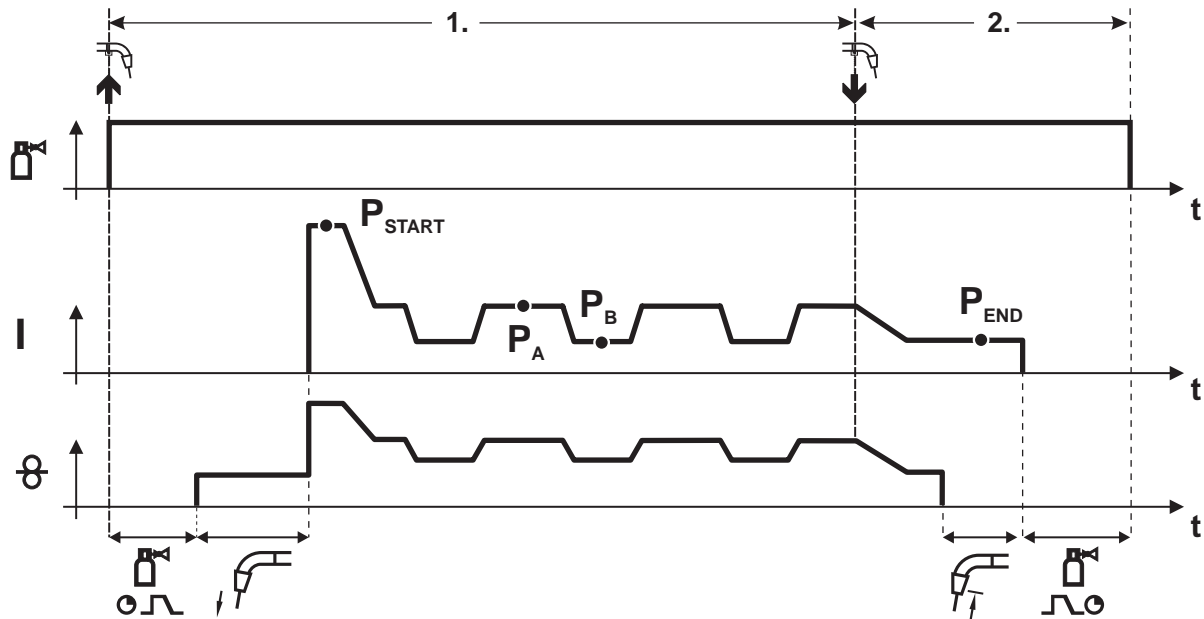


Figure 5-20

### Step 1

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)
- Wire feed motor runs at "creep speed".
- Arc ignites after the wire electrode makes contact with the workpiece, welding current is flowing (start program  $P_{START}$  for the time  $t_{start}$ ).
- Slope on main program  $P_A$ .
- Start the super pulse function beginning with main program  $P_A$ :  
The welding parameters change at the specified times between main program  $P_A$  and the reduced main program  $P_B$ .

### Step 2

- Release torch trigger
- Super pulse function is ended.
- Slope to end program  $P_{END}$  for the time  $t_{end}$ .
- WF motor stops.
- Arc is extinguished after the preselected wire burn-back time expires.
- Gas post-flow time elapses.

## Latched mode

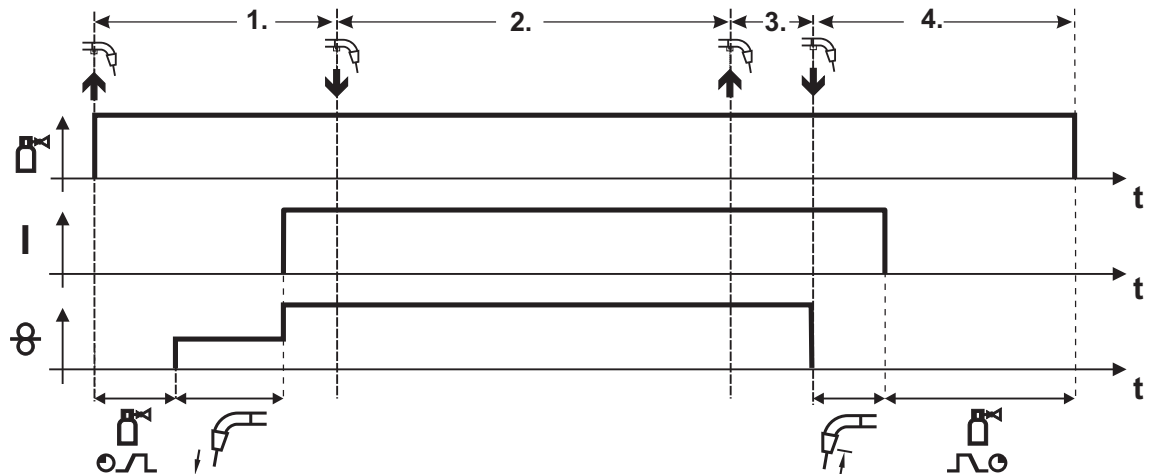


Figure 5-21

### Step 1

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)
- Wire feed motor runs at "creep speed".
- Arc ignites after the wire electrode makes contact with the workpiece; welding current flows.
- Change over to pre-selected WF speed (main program P<sub>A</sub>).

### Step 2

- Release torch trigger (no effect)

### Step 3

- Press torch trigger (no effect)

### Step 4

- Release torch trigger
- WF motor stops.
- Arc is extinguished after the preselected wire burn-back time expires.
- Gas post-flow time elapses.

## Latched mode with superpulse

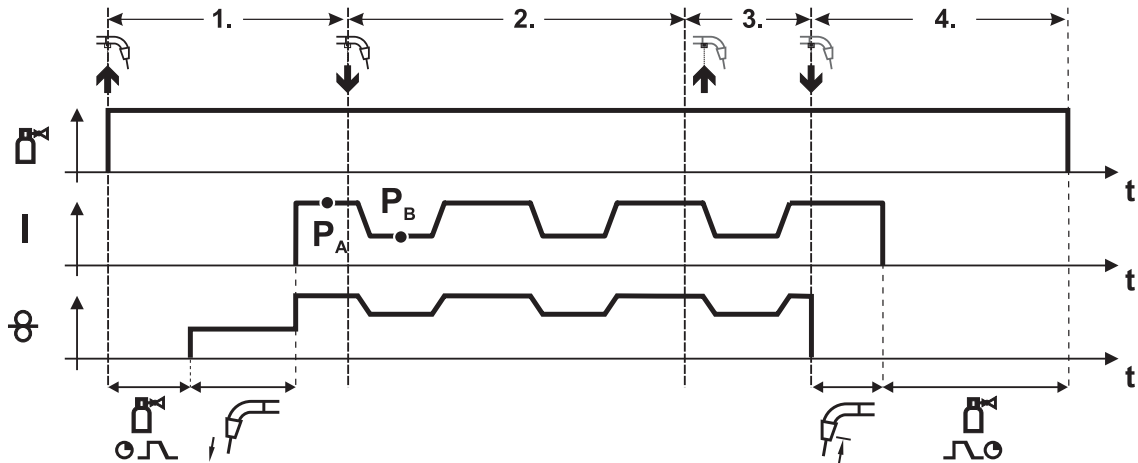


Figure 5-22

### Step 1:

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)
- Wire feed motor runs at "creep speed".
- Arc ignites after the wire electrode makes contact with the workpiece; welding current flows.
- Start the super pulse function beginning with main program P<sub>A</sub>.  
The welding parameters change at the specified times between main program P<sub>A</sub> and the reduced main program P<sub>B</sub>.

### Step 2:

- Release torch trigger (no effect)

### Step 3:

- Press torch trigger (no effect)

### Step 4:

- Release torch trigger
- Super pulse function is ended.
- WF motor stops.
- Arc is extinguished after the preselected wire burn-back time expires.
- Gas post-flow time elapses.



## Latched mode with alternating welding process

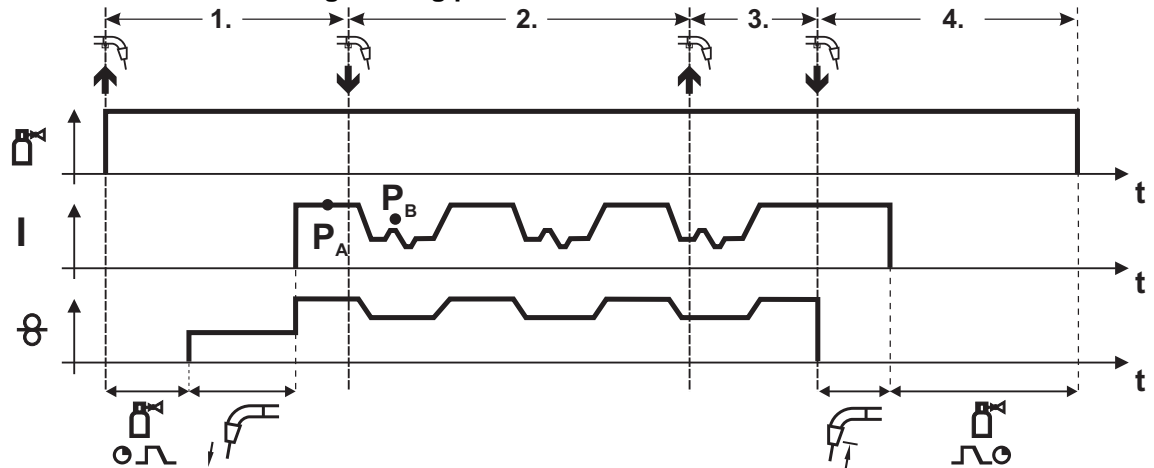


Figure 5-23

### 1st cycle:

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)
- Wire feed motor runs at "creep speed"
- Arc ignites after the wire electrode makes contact with the workpiece; welding current flows
- Start the process alternation starting with process  $P_A$ :  
The welding processes alternate between the process  $P_A$  stored in the JOB and the opposite process  $P_B$  at the specified times ( $t_2$  and  $t_3$ )

**If a standard process is stored in the JOB, this means that there is a permanent alternation between the processes, starting with the standard process and followed by the pulse process. The same applies if the situation is reversed.**

### 2nd cycle:

- Release torch trigger (no effect)

### 3<sup>rd</sup> cycle:

- Press torch trigger (no effect)

### 4<sup>th</sup> cycle:

- Release torch trigger
- Super pulse function is ended
- WF motor stops
- Arc is extinguished after the pre-selected wire burn-back time elapses
- Gas post-flow time elapses

## NOTE



**This function can be activated using the PC300.Net software.**  
Refer to the software operating instructions.

## Latched special

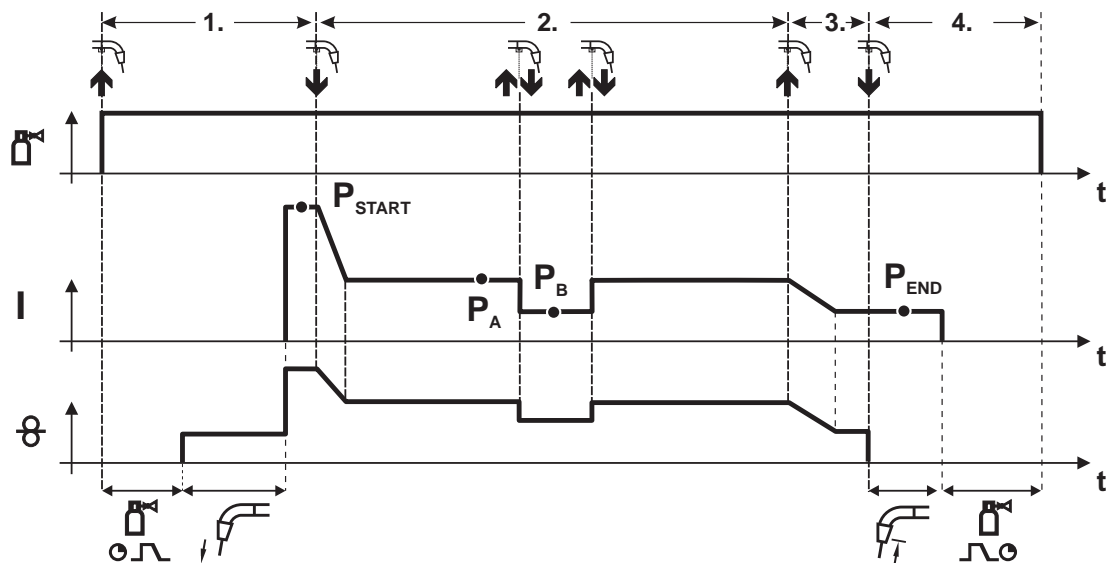


Figure 5-24

### Step 1

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)
- Wire feed motor runs at “creep speed”.
- Arc ignites after the wire electrode makes contact with the workpiece, welding current is flowing (start program  $P_{START}$ )

### Step 2

- Release torch trigger
- Slope to main program  $P_A$ .

The slope on main program  $P_A$  is given at the earliest after the set time  $t_{START}$  elapses and at the latest when the torch trigger is released.

Tapping<sup>1)</sup> can be used to change over to the reduced main program  $P_B$ .

Repeated tapping will switch back to the main program  $P_A$ .

### Step 3

- Press and hold torch trigger
- Slope to end program  $P_{END}$ .

### Step 4

- Release torch trigger
- WF motor stops.
- Arc is extinguished after the preselected wire burn-back time expires.
- Gas post-flow time elapses.

## NOTE



<sup>1)</sup> Prevent tapping (brief press and release within 0.3 seconds)

If the welding current is to be prevented from switching over to the reduced main program  $P_B$  by tapping, the parameter value for WF3 needs to be set to 100% ( $P_A = P_B$ ) in the program sequence.

## Latched special with welding process alternation

### NOTE



This function can be activated using the PC300.NET software.

- Refer to the software operating instructions.

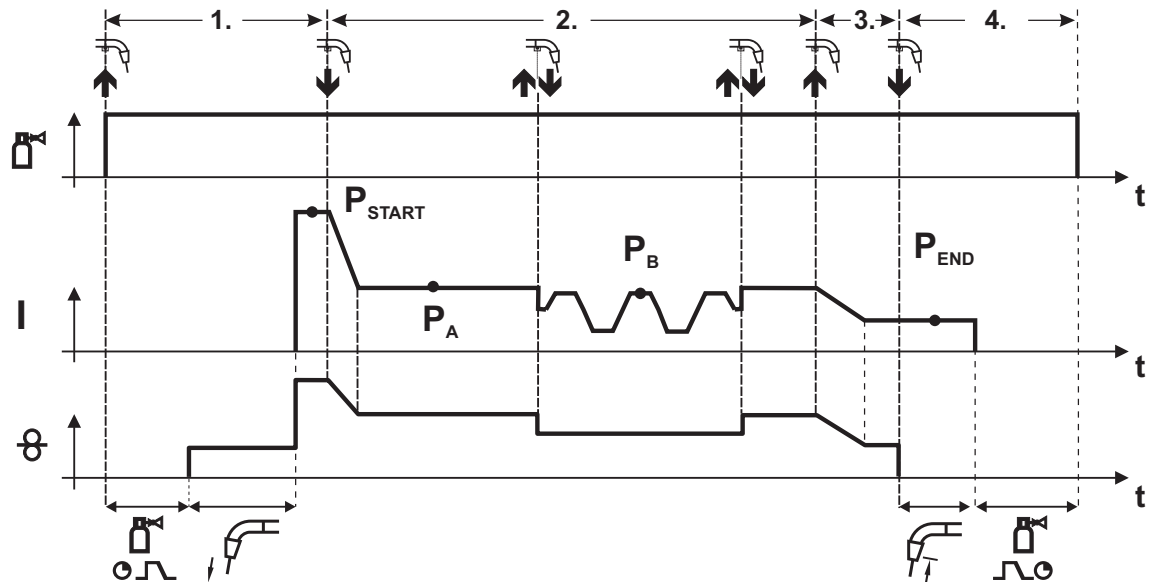


Figure 5-25

#### 1st cycle

- Press and hold torch trigger.
- Shielding gas is expelled (gas pre-flows)
- Wire feed motor runs at "creep speed"
- Arc ignites after the wire electrode makes contact with the workpiece, welding current is flowing (start program  $P_{START}$ )

#### 2nd cycle

- Release torch trigger
- Slope on main program  $P_A$

The slope on main program  $P_A$  is given at the earliest after the set time  $t_{START}$  elapses and at the latest when the torch trigger is released.

Tapping (pressing the torch trigger for less than 0.3 sec.) changes over the welding process ( $P_B$ ).

If a standard process has been defined in the main program, tapping changes to the pulse process, and tapping again will return to the standard process, etc.

#### 3<sup>rd</sup> cycle

- Press and hold torch trigger
- Slope to end program  $P_{END}$

#### 4th cycle

- Release torch trigger
- WF motor stops
- Arc is extinguished after the pre-selected wire burn-back time elapses
- Gas post-flow time elapses

## Latched special with alternating welding process

### NOTE



**This function can be activated using the PC300.NET software.**

- Refer to the software operating instructions.

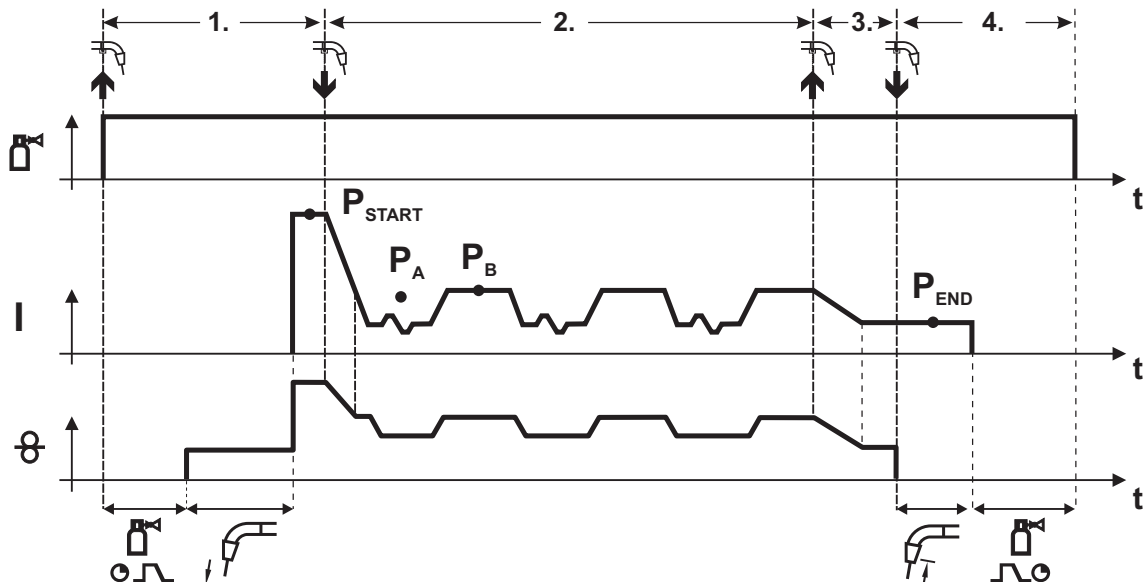


Figure 5-26

#### 1st cycle

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)
- Wire feed motor runs at "creep speed"
- Arc ignites after the wire electrode makes contact with the workpiece, welding current is flowing (start program  $P_{START}$  for the time  $t_{start}$ )

#### 2nd cycle

- Release torch trigger
- Slope on main program  $P_A$
- Start the process alternation starting with process  $P_A$ :  
The welding processes alternate between the process  $P_A$  stored in the JOB and the opposite process  $P_B$  at the specified times ( $t_2$  and  $t_3$ )

**If a standard process is stored in the JOB, this means that there is a permanent alternation between the processes, starting with the standard process and followed by the pulse process. The same applies if the situation is reversed.**

#### 3<sup>rd</sup> cycle

- Press the torch trigger
- Super pulse function is ended
- Slope in the end program  $P_{END}$  for the time  $t_{end}$

#### 4th cycle

- Release torch trigger
- WF motor stops
- Arc is extinguished after the pre-selected wire burn-back time elapses
- Gas post-flow time elapses

## Special, latched with superpulse

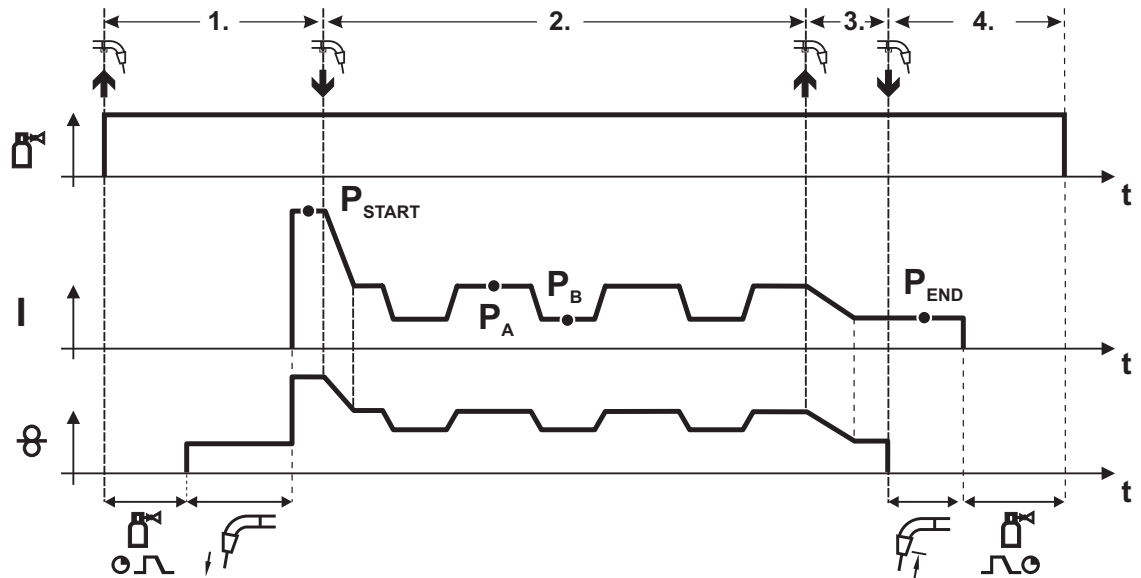


Figure 5-27

### Step 1

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)
- Wire feed motor runs at "creep speed".
- Arc ignites after the wire electrode makes contact with the workpiece, welding current is flowing (start program  $P_{START}$  for the time  $t_{start}$ ).

### Step 2

- Release torch trigger
- Slope on main program  $P_A$ .
- Start the super pulse function beginning with main program  $P_A$ :  
The welding parameters change at the specified times between main program  $P_A$  and the reduced main program  $P_B$ .

### Step 3

- Press the torch trigger.
- Super pulse function is ended.
- Slope in the end program  $P_{END}$  for the time  $t_{end}$ .

### Step 4

- Release torch trigger
- WF motor stops.
- Arc is extinguished after the preselected wire burn-back time expires.
- Gas post-flow time elapses.

## 5.8.11 Conventional MIG/MAG Welding (GMAW non synergic)

- With wire-feed speeds less than 8 m/min select JOB 188.
- With wire-feed speeds over 8 m/min select JOB 187.

You can only change the JOB number when no welding current is flowing.

Operating element	Action	Result	Display
	1 x	Select JOB list. (LED  Material  Gas  Wire is on)	
		Set JOB number. Wait 3 s until the setting has been applied.	 

### 5.8.11.1 Setting the operating point (welding output)

The operating point (welding performance) is set using the wire-feed speed and the welding voltage.

Operating element	Action	Result
	n x	<b>Switch the display between:</b> <b>AMP</b> Welding current (display of actual and hold value only) Material thickness Wire speed <b>HOLD</b> After welding, the values used last from the main program are displayed.

The settings are made using the rotary dials for welding parameter setting and arc length correction.

Operating element	Action	Result
		Increase or reduce the welding performance via the wire speed parameter. JOB 188: from 1-8 m/min JOB 187: from 8-21 m/min
Operating element	Action	Result
		Set the welding voltage. Setting range: -9.9 V-9.9 V

## 5.8.12 MIG/MAG program sequence ("Program steps" mode)

### NOTE



This function can only be enabled with the PC300.NET software.

- (See operating instructions for the software)

Certain materials, such as aluminium, require special functions in order to be able to weld them safely and at high quality. The latched special operating mode is used here with the following programs:

- Start program  $P_{START}$  (reduction of cool points at the start of the seam)
- Main program  $P_A$  (continuous welding)
- Reduced main program  $P_B$  (targeted heat reduction)
- End program  $P_{END}$  (minimisation of end craters via targeted heat reduction)

The programs include the parameters wire speed (operating point), arc length correction, slope times, program duration, etc.

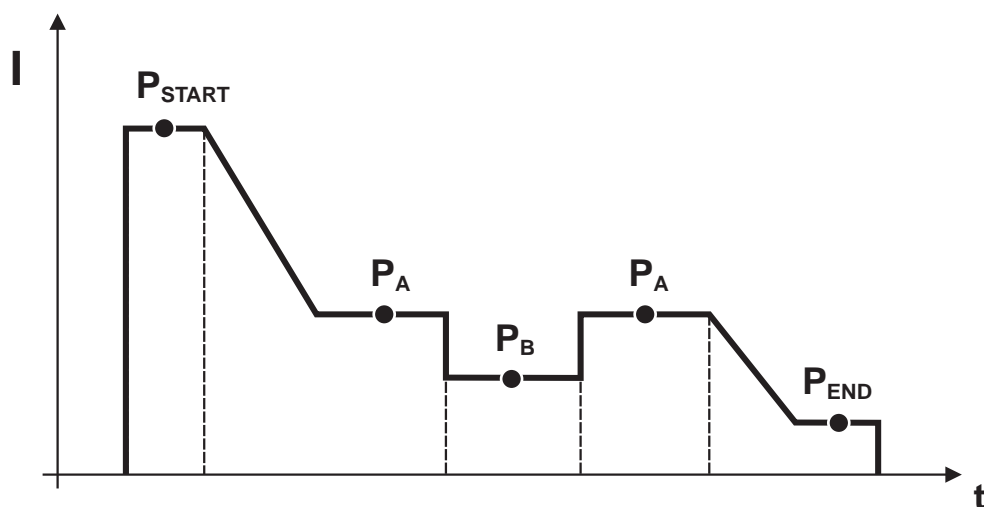


Figure 5-28

In every JOB, separate settings can be made for the ignition program, reduced main program and end program as to whether or not to alternate with the pulse process.

These properties are stored on the welding machine with the JOB. This means that in the factory settings, the pulse process is active during the end program in all forceArc JOBs.

### 5.8.12.1 Selection of the program sequence parameter

Operating Element	Action	Result	Display
		Select parameter in the program sequence	
		Setting welding parameters	

## 5.8.12.2 MIG/MAG overview of parameters

### NOTE



In the factory setting,  $P_{START}$ ,  $P_B$ , and  $P_{END}$  are "relative programs". They relate to percentages of the wire feed value from the main program  $P_A$ .

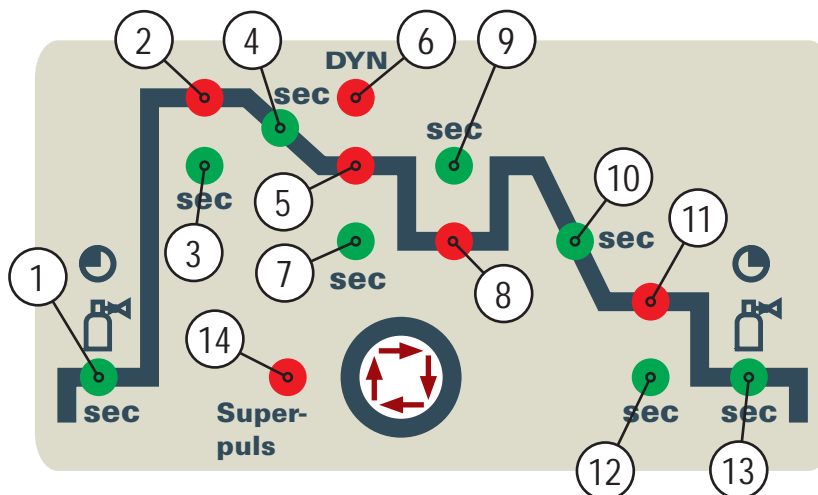


Figure 5-29

### Basic Parameters

Item	Meaning / Explanation	Setting Range
1	Gas pre-flow time	0.0s to 20.0s
2	$P_{START}$ Wire speed, relative Arc length correction	1% to 200% -9.9V to +9.9V
3	Duration	0.0s to 20.0s
4	Slope duration from $P_{START}$ to $P_A$	0.0s to 20.0s
5	$P_A$ Wire speed, absolute	0.1 m/min to 40 m/min
6	Dynamics	-40 to +40
7	Duration (spot time and superpulse)	0.01s to 20.0s
8	$P_B$ Wire speed, relative Arc length correction, relative	1% to 200% -9.9V to +9.9V
9	Duration	0.01s to 20.0s
10	Slope duration from $P_A$ to $P_{END}$	0.0s to 20s
11	$P_{END}$ Wire speed, relative Arc length correction	1% to 200% -9.9V to +9.9V
12	Duration (superpulse)	0.0s to 20s
13	Gas post-flow time	0.0s to 20s
14	Superpulses	On / Off



### 5.8.12.3 Example, tack welding (non-latched)

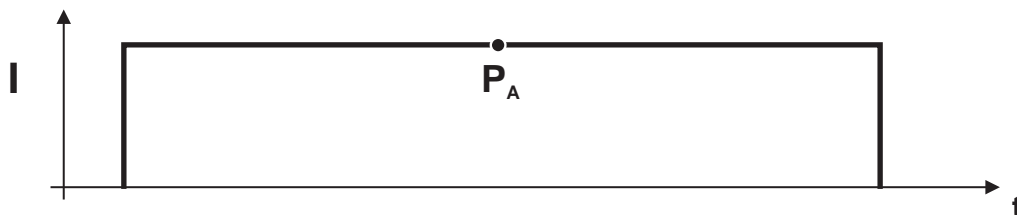


Figure 5-30

#### Basic parameters

Parameter	Meaning / explanation	Setting range
GASstr	Gas pre-flow time	0.0s to 20.0s
GASend:	Gas post-flow time	0.0s to 20s
RUECK	Wire burn-back length	2 to 500
<b>"P<sub>A</sub>" main program</b>		
Parameter	Meaning / explanation	Setting range
	Setting the wire speed	

### 5.8.12.4 Example, aluminium tack welding (non-latched special)

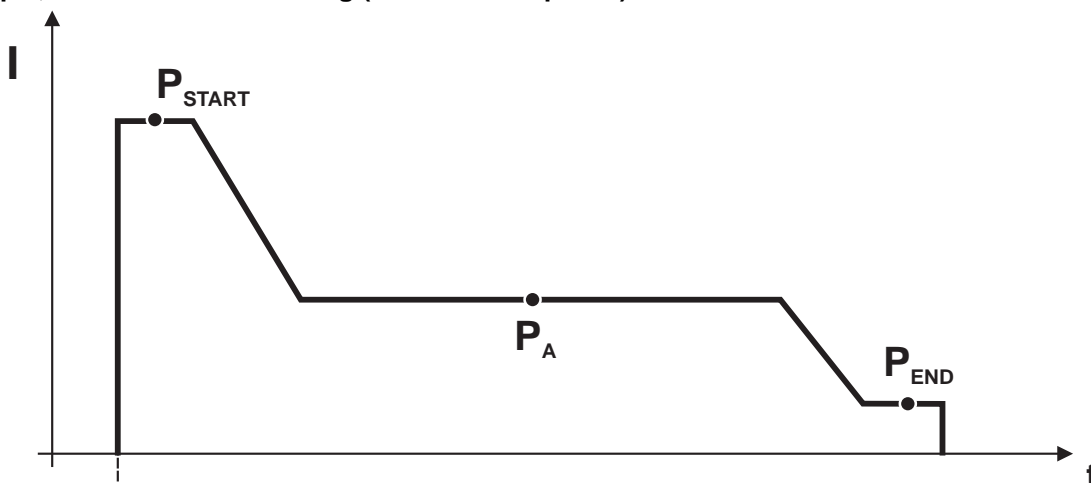


Figure 5-31

#### Basic parameters

Welding parameter	Meaning / explanation	Setting range
GASstr	Gas pre-flow time	0.0s to 20.0s
GASend:	Gas post-flow time	0.0s to 20.0s
RUECK	Wire burn-back length	2 to 500
<b>"P<sub>START</sub>" start program</b>		
Welding parameter	Meaning / explanation	Setting range
DVstart	Wire speed	0% to 200%
Ustart	Arc length correction	-9.9V to +9.9V
tstart	Duration	0.0s to 20s
<b>"P<sub>A</sub>" main program</b>		
Welding parameter	Meaning / explanation	Setting range
	Setting the wire speed	
<b>"P<sub>END</sub>" end-crater program</b>		
Welding parameter	Meaning / explanation	Setting range
DVend	Wire speed	0% to 200%
Uend	Arc length correction	-9.9V to +9.9V
tend	Duration	0.0s to 20s

## 5.8.12.5 Example, aluminium welding (latched special)

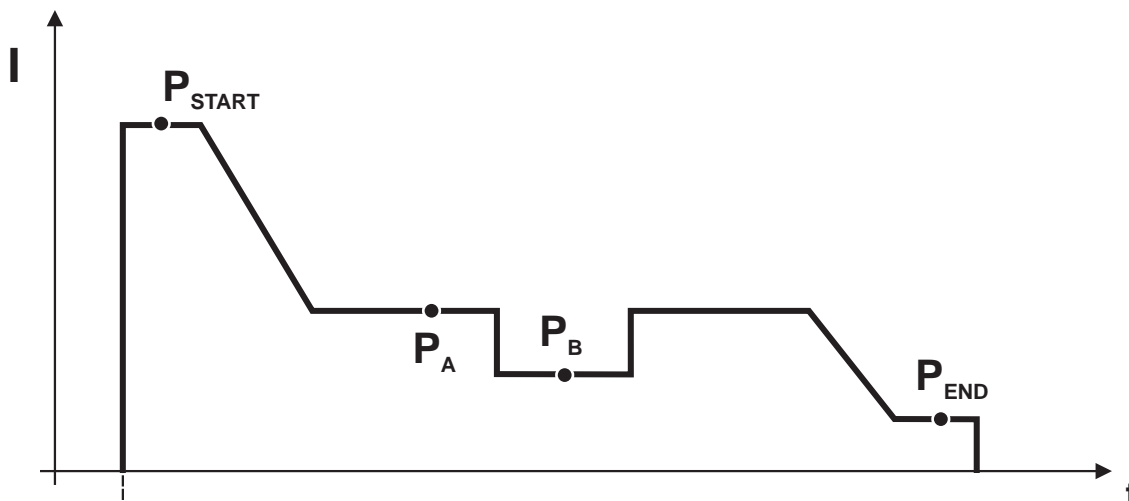


Figure 5-32

### Basic parameters

Welding parameter	Meaning / explanation	Setting range
GASstr	Gas pre-flow time	0.0s to 20.0s
GASend:	Gas post-flow time	0.0s to 20.0s
RUECK	Wire burn-back length	2 to 500

### "P<sub>START</sub>" start program

Welding parameter	Meaning / explanation	Setting range
DVstart	Wire speed	0% to 200%
ustart	Arc length correction	-9.9V to +9.9V
tstart	Duration	0.0s to 20s

### "P<sub>A</sub>" main program

Welding parameter	Meaning / explanation	Setting range
	Setting the wire speed	

### "P<sub>B</sub>" reduced main program

Welding parameter	Meaning / explanation	Setting range
DV3	Wire speed	0% to 200%
U3	Arc length correction	-9.9V to +9.9V

### "P<sub>END</sub>" end-crater program

Welding parameter	Meaning / explanation	Setting range
tSend	Slope duration from P <sub>A</sub> or P <sub>B</sub> to P <sub>END</sub>	0.0s to 20s
DVend	Wire speed	0% to 200%
Uend	Arc length correction	-9.9V to +9.9V
tend	Duration	0.0s to 20s

### 5.8.12.6 Example, visible seams (latched super pulse)

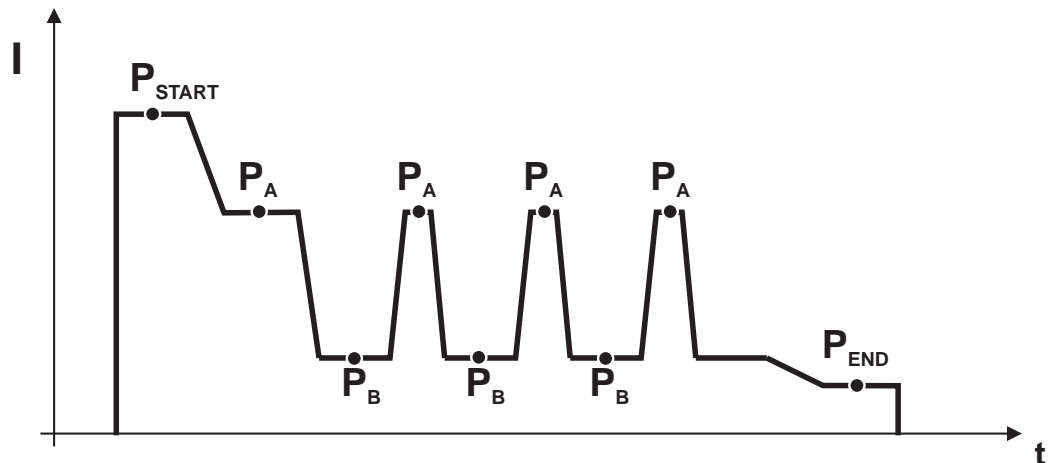


Figure 5-33

#### Basic parameters

Welding parameter	Meaning / explanation	Setting range
GASstr	Gas pre-flow time	0.0s to 20.0s
GASend:	Gas post-flow time	0.0s to 20.0s
RUECK	Wire burn-back length	2 to 500
PROC.SP.	Travel speed to determine the a-measurement*	10cm to 200cm

#### "P<sub>START</sub>" start program

Welding parameter	Meaning / explanation	Setting range
DVstart	Wire speed	0% to 200%
ustart	Arc length correction	-9.9V to +9.9V
tstart	Duration	0.0s to 20s

#### "P<sub>A</sub>" main program

Welding parameter	Meaning / explanation	Setting range
tS1	Slope duration from P <sub>START</sub> to P <sub>A</sub>	0.0s to 20s
DV3	Setting the wire speed	0% to 200%
t2	Duration	0.1s to 20s
tS3	Slope duration from P <sub>B</sub> to P <sub>A</sub>	0.0s to 20s

#### "P<sub>B</sub>" reduced main program

Welding parameter	Meaning / explanation	Setting range
tS2	Slope duration from P <sub>A</sub> to P <sub>B</sub>	0.0s to 20s
DV3	Wire speed	0% to 200%
U3	Arc length correction	-9.9V to +9.9V
t3	Duration	0.1s to 20s

#### "P<sub>END</sub>" end-crater program

Welding parameter	Meaning / explanation	Setting range
tSend	Slope duration from P <sub>A</sub> or P <sub>B</sub> to P <sub>END</sub>	0.0s to 20s
DVend	Wire speed	0% to 200%
Uend	Arc length correction	-9.9V to +9.9V
tend	Duration	0.0s to 20s

## 5.8.12.7 Welding process changeover

### NOTE



**This function can only be enabled with the PC300.NET software.**

- (See operating instructions for the software)

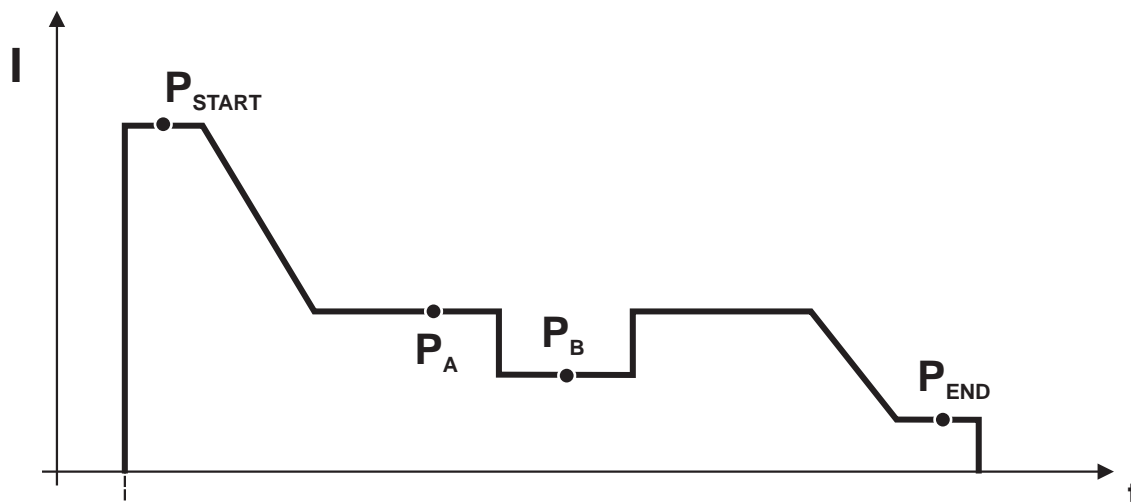


Figure 5-34

Program	Setting option	Relates to	Setting
P <sub>START</sub>	<b>Pulse arc welding process on/off</b> Changes using PC300.Net software	All special, non-latched All special, latched	1 (= on) 0 (= off)
P <sub>A</sub> /P <sub>B</sub>	<b>Welding process changeover</b> If P <sub>A</sub> contains a standard arc process, there is a changeover to the pulse arc process, and vice versa. Changes using PC300.Net software (EXPERT machine series: Can also be changed using M3.1x, see chapter "MIG/MAG parameter overview, M3.1x")	Non-latched/latched mode with alternating welding process Non-latched/latched special with alternating welding process Latched special with welding process changeover	1 (= active) 0 (= inactive)
P <sub>END</sub>	<b>Pulse arc welding process on/off</b> Changes using PC300.Net software (Switched on for all forceArc JOBs in factory settings)	All special, non-latched All special, latched	1 (= on) 0 (= off)

The settings are saved with the JOB and apply to all programs for that JOB.

### 5.8.13 Main program A mode

Different welding tasks or positions on a workpiece demand various welding performances (operating points) or welding programs. The following parameters are stored in each of the up to 16 programs:

- Operating mode
- Welding type
- Superpulses (ON/OFF)
- Wire feed speed (DV2)
- Voltage correction (U2)
- Dynamics (DYN2)

The user can change the welding parameters for the main programs using the following components.

	Program changeover	JOB switching	Program	Operating mode	Welding process	Superpulse	Wire speed	Voltage correction	Dynamics
<b>M3.71</b> Wire feed control	Yes	Yes	P0	Yes			Yes <sup>1)</sup>	Yes <sup>2)</sup>	
			P1...15				Yes		
<b>R20</b> Remote control	Yes <sub>3)</sub>	No	P0	No			Yes <sup>1)</sup>		No
			P1...9						
<b>R40</b> Remote control	Yes <sub>3)</sub>	No	P0	No	Yes <sup>2)</sup>		No		
			P1...15						
<b>PC 300.NET</b> Software	No	No	P0	Yes			No		
			P1...15						
<b>UP / DOWN</b> Welding torch	Yes	No	P0	No			Yes	No	
			P1...15						
<b>POWERCONTROL 1</b> Welding torch	Yes	No	P0	No			Yes	No	
			P1...15						
<b>POWERCONTROL 2</b> Welding torch	Yes	Yes	P0	No			Yes		No
			P1...15						

1) Setting carried out using rotary dial

2) Internal memory

3) POWERCONTROL torch not connected

## Example 1: Welding workpieces with different sheet metal thicknesses (non-latched)

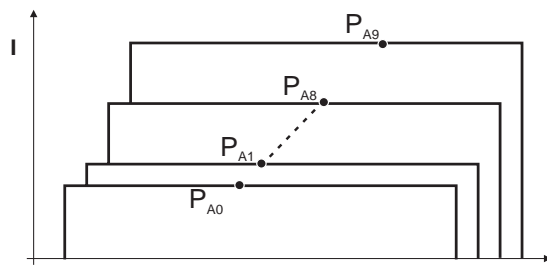


Figure 5-35

## Example 2: Welding different positions on a workpiece (latched)

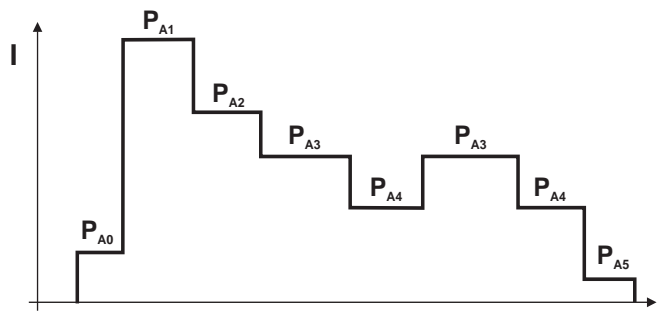


Figure 5-36

## Example 3: Aluminium welding of different sheet metal thicknesses (non-latched or latched special)

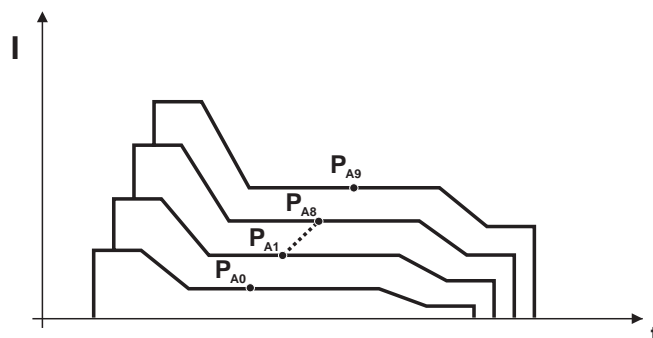


Figure 5-37

### NOTE



**Up to 16 programs (P<sub>A0</sub> to P<sub>A15</sub>) can be defined.**

An operating point (wire speed, arc length correction, dynamics/choke effect) can be defined permanently in each program.



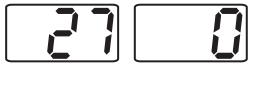


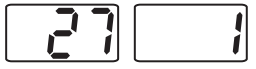


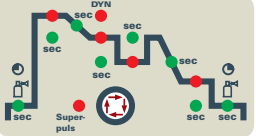





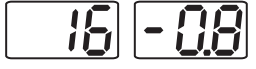


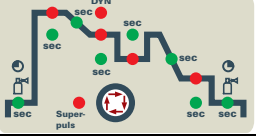



Program P0 is an exception: the settings for operating points are made manually here.

**Changes to the welding parameters are saved immediately!**

## 5.8.13.1 Selecting parameters (program A)


### NOTE

 Changes to the welding parameters can only be made when the key switch is in position "1".

Operating element	Action	Result	Display
	 <b>n x</b>	Change welding data display over to program display. (LED <b>PROG</b> is on)	
		Select program number. Display example: Program "1".	
	 <b>n x</b>	Select program sequence parameter "Main program (P <sub>A</sub> )". (LED is on)	
		Set wire speed. (Absolute value)	
		Set arc length correction. Display example: "-0.8 V" correction (Setting range: -9.9 V to +9.9 V)	
	 <b>1 x</b>	Select "Dynamic" program sequence parameter. (LED <b>DYN</b> is on)	
		Set dynamic. (Setting range 40 to -40) 40: Arc hard and narrow. -40: Arc soft and wide.	

## 5.8.14 Standard MIG/MAG torch

The MIG welding torch trigger is essentially used to start and stop the welding process.

Operating elements	Functions
 Torch trigger	<ul style="list-style-type: none"> <li>Start/stop welding</li> </ul>

Other functions are also possible by tapping the torch trigger, depending on the machine type and control configuration:

- Change over between welding programs (see "Program changeover with standard torches (P8)" chapter).
- Program selection before starting welding (see chapter entitled "Selecting programs with the standard torch trigger (P17)").
- Change over between pulse and standard welding in the special latched operating mode.
- Switching between wire feed units in dual operation mode (see chapter "single or double operation setting (P10)")

## 5.8.15 MIG/MAG special-torches

Function specifications and more indepth information can be found in the operating manual for the relevant welding torch!

The following special torches can be used together with this welding machine:

- UP/DOWN welding torch with one rocker
  - for setting the wire speed or
  - to change up to 10 welding programs
- POWERCONTROL 1 welding torch with one rocker and digital display
  - for calling up and displaying up to 10 welding programs, or
  - for infinite, percentage-based operating point setting and display
- POWERCONTROL 2 welding torch with four triggers and three-digit digital display
  - for setting and displaying the welding performance and voltage correction, or
  - for calling up programs and JOBs, as well as for displaying the corresponding parameters
- Push/pull welding torch with integrated wire feed unit
  - for even wire feeding with extra long tube packages
  - and potentiometer to control the wire-feed speed, where necessary

### 5.8.15.1 Program- and Up- / down operation

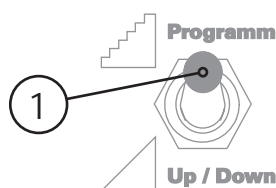





Figure 5-38

Item	Symbol	Description
1		<b>Welding torch function changeover switch</b> (special welding torch required)  Programm Changing over programs or JOBs  Up / Down Infinite adjustment of welding performance.



## 5.9 Remote control

### CAUTION



#### Using protective dust caps!

Protective dust caps protect the connection sockets and therefore the machine against dirt and damage.

- The protective dust cap must be fitted if there is no accessory component being operated on that connection.
- The cap must be replaced if faulty or if lost!

### NOTE



The remote controls are operated via the 19-pole remote control connection socket (analogue) or the 7-pole remote control connection socket (digital), depending on the model.



Please note the relevant documentation of the accessory components.

## 5.9.1 Advanced settings

The special parameters cannot be viewed directly since they are normally only set and stored once. The machine control offers the following special functions:

### 5.9.1.1 Selecting, changing and saving parameters

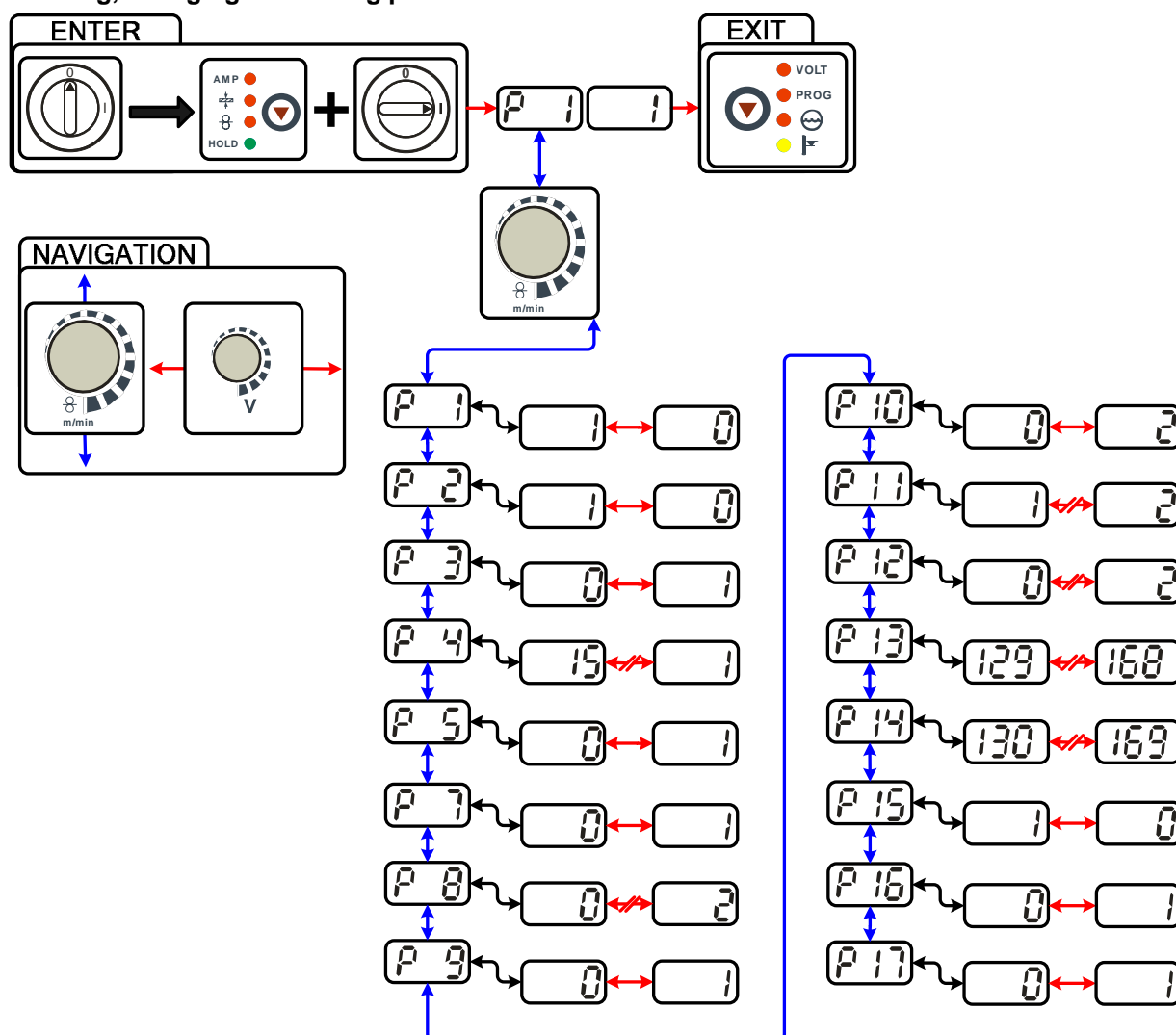


Figure 5-39

### NOTE



#### ENTER (Enter the menu)










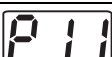




- Switch off machine at the main switch.
- Press and hold the "left parameter selection" button and switch the machine on again at the same time.



#### NAVIGATION (Navigate the menu)

- Select parameters by turning the "welding parameter setting" rotary dial.
- Set or change the parameters by turning the "arc length correction/select welding program" rotary dial.

#### EXIT (Exit the menu)

- Press the "right parameter selection" button (switch machine off and on again).















Display	Setting/selection
	<b>Ramp time for wire inching</b> 0 = normal inching (10s ramp time) 1 = fast inching (3s ramp time) (Ex works)
	<b>Block program "0"</b> 0 = P0 enabled (Ex works) 1 = P0 blocked
	<b>POWERCONTROL torch display mode</b> 0 = normal display (factory setting) program number/JOB or welding performance/welding voltage correction is displayed 1 = alternating display display alternates between program number and welding type
	<b>Program limitation</b> Programs 1 to max. 15 Ex works: 15
	<b>Special cycle in the special latched and non-latched operating modes</b> 0 = normal (previous) non-latched/latched (Ex works) 1 = WF3 cycle for non-latched/latched
	<b>Correction operation, threshold value setting</b> 0 = correction operation switched off (Ex works) 1 = correction operation on "Main program (PA)" flashing
	<b>Program changeover with standard torch</b> 0 = no program changeover (Ex works) 1 = special latched 2 = specific latched special (n cycle active)
	<b>Lat. and sp. lat. tapping start</b> 0 = no latched tapping start (Ex works) 1 = latched tapping start possible
	<b>One or two-wire feed operation</b> 0 = single operation (Ex works) 1 = dual operation, this unit is the "master" 2 = dual operation, this unit is the "slave"
	<b>Special latched tapping time</b> 0 = tapping function switched off 1 = 300ms (Ex works) 2 = 600ms
	<b>JOB list changeover</b> 0 = task-oriented JOB list 1 = actual JOB list (Ex works) 2 = actual JOB list, JOB changeover activated via accessories
	<b>Lower limit remote JOB changeover</b> Lowest JOB that can be selected using PowerControl 2 torches. Lower limit: 129 (Ex works)
	<b>Upper limit remote JOB changeover</b> JOB range of the POWERCONTROL2 torch Upper limit: 169 (Ex works)
	<b>HOLD function</b> 0 = HOLD values are not displayed 1 = HOLD values are displayed (Ex works)

Display	Setting/selection
	<b>Block JOB mode</b> 0 = Block JOB mode not enabled (Ex works) 1 = Block JOB mode enabled
	<b>Program selection with standard torch trigger</b> 0 = no program selection (Ex works) 1 = program selection possible

## 5.9.1.2 Reset to factory settings

### NOTE

 All special parameters saved by the user will be overwritten by the factory settings!

Operating element	Action	Result	Displays	
			Left	Right
		Switch off welding machine		
		Keep the button pressed		
		Switch on welding machine		
		Release the button, wait about 3 seconds		
		Switch off welding machine and restart in order to put the changes into effect		

### 5.9.1.3 The special parameters in detail

#### Ramp time for wire inching (P1)

The wire inching starts with a speed 1.0 m/min for 2 secs. It is subsequently increased to a ramp function to 6.0 m/min. The ramp time can be set between two ranges.

During wire inching, the speed can be changed by means of the welding parameter setting rotary dial. Changing the speed has no effect on the ramp time.

#### Program "0", releasing the program block (P2)

The program P0 (manual setting) is blocked. Only operation with P1-P15 is possible, irrespective of the key switch position.

#### Display mode torch power control (P3)

##### Normal display:

- Program operation: Program number
- Up/down operation: Up/down setting

##### Alternating display:

- Program operation: Change program number and welding process (pulse/non-pulse)
- Up/down operation: Change up/down setting and up/down symbol

#### Program limit (P4)

Program selection can be limited with the special parameter P4.

- The setting is adopted for all JOBS.
- Program selection depends on the position of the "welding torch function" changeover switch (see "Machine description"). Programs can only be switched when the changeover switch is in the "program" position.
- Programs can be switched by means of a connected remote control or special welding torch.
- If a special welding torch or a remote control is not connected, it is only possible to switch programs by means of the "arc length correction/select welding program" rotary dial (see "Machine description").

#### Special cycle in the operating modes special latched and non-latched (P5)

With the special sequence activated, the start of the welding process changes as follows:

##### Sequence for special non-latched mode/special latched mode:

- Start program "P<sub>START</sub>"
- Main program "P<sub>A</sub>"

##### Sequence for special non-latched mode/special latched mode with custom sequence activated:

- Start program "P<sub>START</sub>"
- Reduced main program "P<sub>B</sub>"
- Main program "P<sub>A</sub>"

## Correction operation, threshold value setting (P7)

The correction operation is switched on and off for all JOBS and their programs at the same time. A correction operation is specified for wire speed (DV) and welding voltage correction (U<sub>kor</sub>) for each JOB. The correction value is saved separately for each program. The correction range can be maximum 30% of the wire speed and +/-9.9 V welding voltage.

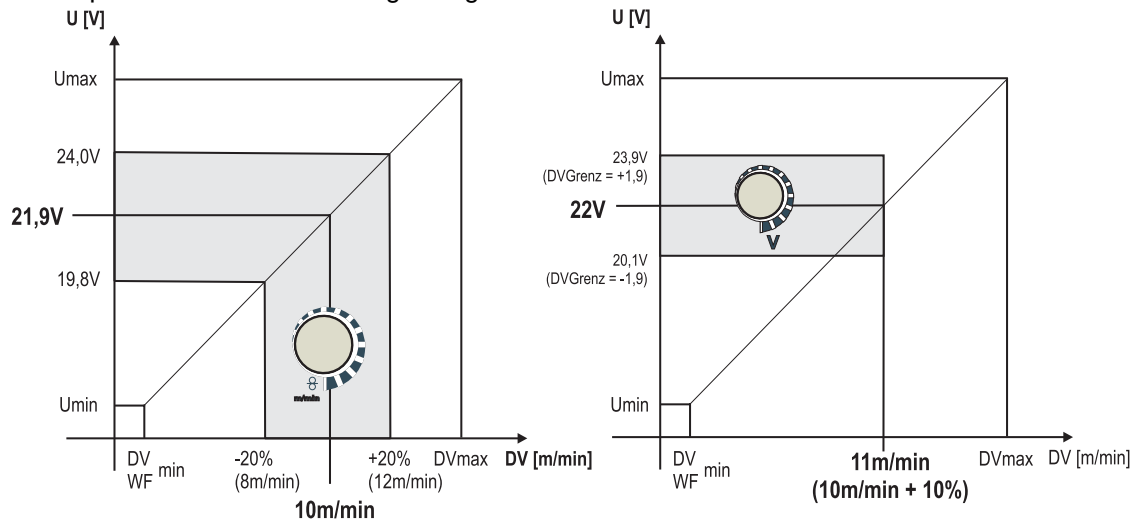


Figure 5-40

### Example for the operating point in correction mode:

The wire speed in one program (1 to 15) is set on 10.0 m/min.

This corresponds to a welding voltage (U) of 21,9 V. When the key switch is set to "0" position, welding in this program can only be carried out with these values.

To allow the welder also to perform wire and voltage correction in program mode, the correction mode must be switched on and limit values for wire and voltage must be specified.

Setting of the correction limit value = WFLimit = 20% / Ulimit = 1.9 V

Now the wire speed can be corrected by 20% (8.0 up to 12.0 m/min) and the welding voltage by +/-1.9 V (3.8 V).









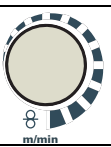



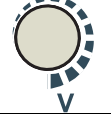





In the example the wire speed is set on 11.0 m/min. This corresponds to a welding voltage of 22 V

Now the welding voltage can be corrected by further 1.9 V (20.1 V and 23.9 V).

**The values for voltage and wire-speed correction will be reset if the key switch is moved to the "1" setting.**

### Setting the correction range:

- Switch on the "Correction operation" special parameter (P7=1) and save the setting. (See chapter entitled "Selecting, changing and saving parameters".)
- Key switch to position "1".
- Set correction range according to the following table:

Operating element	Action	Result	Display (examples)	
			Left	Right
		Press button until "PROG" LED comes on. Left: Wire feed speed Right: Program number		
		Press button and hold down for approx. 4 s Left: Current limit value of the wire feed speed correction Right: Current limit value of the voltage correction		
		Set limit value for the wire feed speed correction		
		Set limit value for voltage correction		
After approx. 5 s without further user intervention, the set values are adopted and the display switches back to the program display,				

- Key switch back to position "0"!

## Switching programs with the standard torch trigger (P8)

### Special latched (latched absolute program sequence)

- Cycle 1: absolute program 1 is run
- Cycle 2: absolute program 2 is run after completion of "tstart".
- Cycle 3: absolute program 3 is run until the "t3" time has elapsed. The program then switches automatically to absolute program 4.

**Accessory components such as remote controls or special torches may not be connected!**

**Program switching at the wire feed unit control is disabled.**

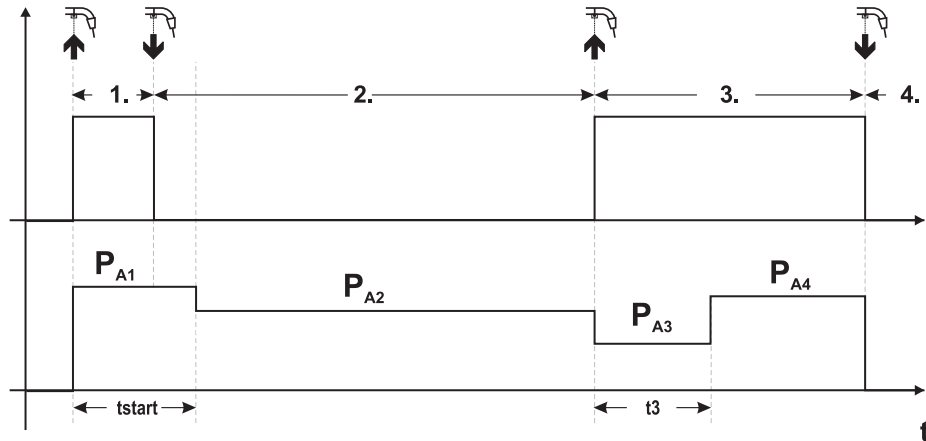


Figure 5-41

### Specific latched special (n cycle)

In the n cycle program sequence, the unit starts in the 1st cycle with start program  $P_{start}$  from  $P_1$ .

In the second cycle, the machine switches to absolute program 2, once the start time "tstart" has elapsed.

Tapping switches to other programs ( $P_{A1}$  to max.  $P_{A9}$ ).

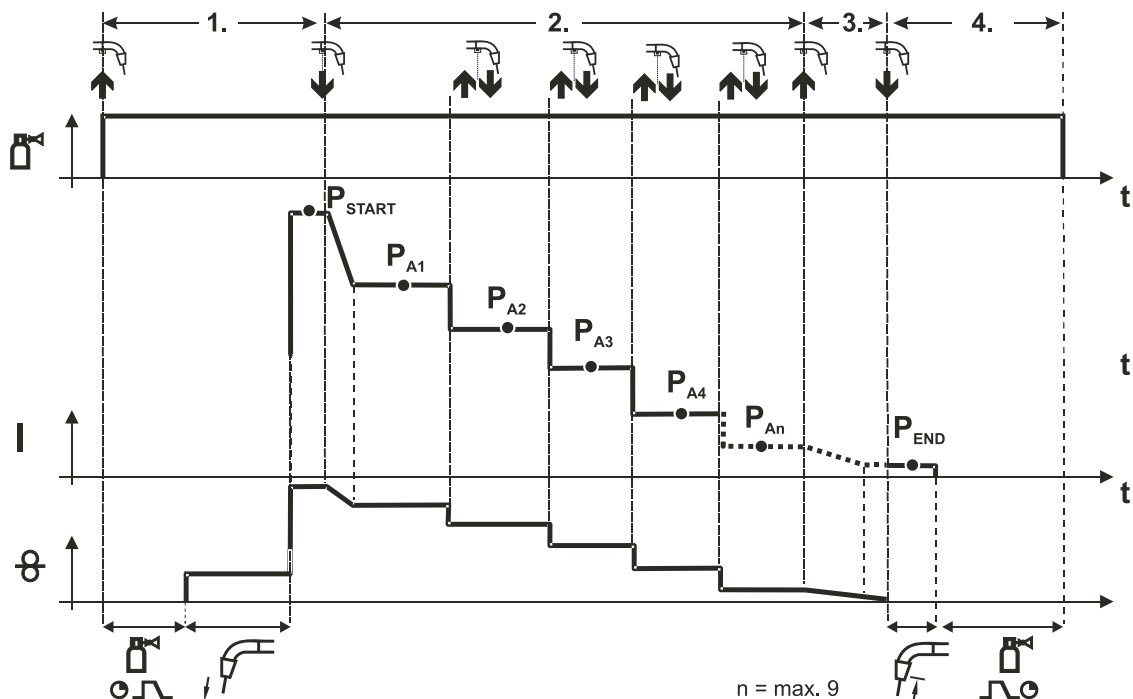


Figure 5-42



The number of programs ( $P_{An}$ ) corresponds to the cycle number specified under N cycle.

#### 1st cycle

- Press and hold torch trigger.
- Shielding gas is expelled (gas pre-flows).
- Wire feed motor runs at "creep speed".
- Arc ignites after the wire electrode makes contact with the workpiece, welding current is flowing (start program  $P_{START}$  from  $P_{A1}$ )

#### 2nd cycle

- Release torch trigger.
- Slope to main program  $P_{A1}$ .

The slope to main program  $P_{A1}$  is given at the earliest after the set time  $t_{START}$  elapses and at the latest when the torch trigger is released. Tapping (pressing briefly and releasing within 0.3 sec) can switch to other programs. Programs  $P_{A1}$  to  $P_{A9}$  are possible.

#### 3rd cycle

- Press and hold torch trigger.
- Slope to end program  $P_{END}$  from  $P_{AN}$ . The program can be stopped at any time by pressing the torch trigger longer than 0.3 sec.  $P_{END}$  from  $P_{AN}$  is then executed.

#### 4th cycle

- Release torch trigger.
- WF motor stops.
- Arc is extinguished after the pre-selected wire burn-back time elapses.
- Gas post-flow time elapses.

#### N cycle setting

#### NOTE



The n cycle function should always be activated before the n cycle setting (see "Program changeover with standard torch (P8)").

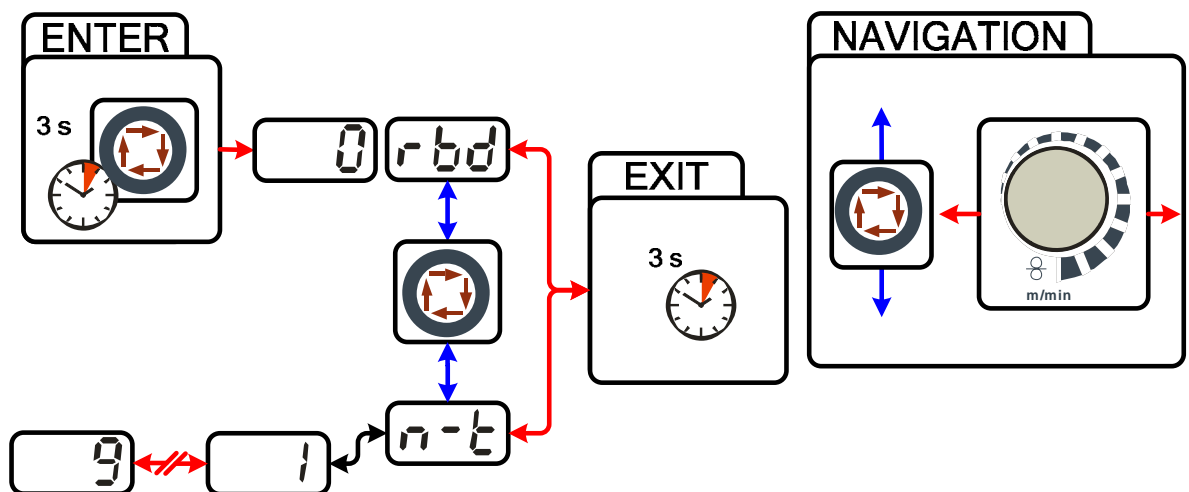


Figure 5-43

#### Latched/special-latched tap start (P9)

In latched – tap start – operating mode it is possible to switch straight to the second step by tapping the torch trigger; it is not necessary for current to be flowing.

The welding can be halted by pressing the torch trigger for a second time.

## "Single or dual operation" (P10) setting

### NOTE



If the system is fitted with two wire feeds, no further accessory components may be operated on the 7-pole connection socket (digital)!

This relates to digital remote controls, robot interfaces, documentation interfaces, welding torches with digital control lead connection, etc.

### No second wire feed may be connected in single operation (P10 = 0)!

- Remove connections to the second wire feed

**In dual operation (P10 = 1 or 2), both wire feed units must be connected and configured differently on the controls for this operating mode!**

- Configure one wire feed unit as the master (P10 = 1)
- Configure the other wire feed unit as a slave (P10 = 2)

**Wire feed units with key switches (optional, see Protecting welding parameters from unauthorised access chapter) must be configured as masters (P10 = 1).**

**The wire feed configured as the master is active after the welding machine is switched on. There are no other functional differences between the wire feeds.**

### Latched special tapping time setting (P11)

The tapping time for changing over between the main program and reduced main program can be set in three levels.

0 = no tapping

1 = 320ms (factory setting)

2 = 640ms

### JOB list switching (P12)

Value	Designation	Explanation
0	Task-oriented JOB list	The JOB numbers are sorted by welding wires and shielding gases. JOB numbers may be skipped during selection where relevant.
1	Actual JOB list	JOB numbers correspond to the actual memory cells. Each JOB can be selected; no memory cells are skipped during selection.
2	Actual JOB list, JOB changeover active	As for the actual JOB list. JOB changeover is also possible with accessory components, such as the PowerControl 2 torch.

### Creating user-defined JOB lists

A consecutive memory range where accessories such as the POWERCONTROL 2 torch can be used to switch between JOBS will be created.

- Set special parameter P12 to "2".
- Set "Program or Up/Down function" changeover switch to "Up/Down" position.
- Select an existing JOB which is closest to the required result.
- Copy JOB to one or more target JOB numbers.

If any JOB parameters need to be changed, select the target JOBS in sequence and change the parameters individually.



















- Set special parameter P13 to the lower limit and
- Set special parameter P14 to the upper limit of the target JOBS.
- Set "Program or Up/Down function" changeover switch to "Program" position.

JOBS can be changed over in the specified range using the accessory component.

### Copying JOBS, "Copy to" function

The possible target range is between 129 - 169.

- First configure special parameter P12 to P12 = 2 or P12 = 1!

Operating element	Action	Result	Display
	1 x 	Select JOB list	
		Select the source JOB	
-	-	Wait for around 3 seconds until the JOB has been transferred	
	1 x 	Keep button pressed for around 5s	
		Setting to copy function ("Copy to")	
		Select JOB number of the target JOB	
	1 x 	Save The JOB is copied to the new position	

By repeating the last two steps, the same source JOB can be copied to multiple target JOBS.

If the control does not register any user activity for longer than 5 seconds, the parameter display is shown once more and the copy process is complete.

### Lower and upper limits of the remote JOB changeover process (P13, P14)

The highest and lowest JOB numbers which can be selected using accessory components, such as the PowerControl 2 torch.

Avoids an accidental changeover into undesirable or undefined JOBS.

### Hold function (P15)

#### Hold function active (P15 = 1)

- Mean values for the last main program parameters used for welding are displayed.

#### Hold function not active (P15 = 0)

- Setpoint values for the main program parameters are displayed.

## Block JOB mode (P16)

**The following accessory components support block JOB mode:**

- R20 remote control and MT U/D welding torch

Program 0 is always active in JOB 0 and program 1 in all other JOBS

In this operating mode, a total of 27 JOBS (welding tasks) divided into three blocks can be called up using accessory components.

**The following settings must be made in order to be able to use block JOB mode:**

- Switch the "Program or Up/Down function" changeover switch to "Program" (see "Internal operating elements" chapter).
- Set the JOB list to actual JOB list (special parameter P12 = "1")
- Enable block JOB mode (special parameter P16 = "1")
- Change to block JOB mode by selecting one of the special JOBS 129, 130 or 131. (See the "Selecting MIG/MAG welding tasks" chapter.)

**Simultaneous operation with interfaces such as RINT X12, BUSINT X11, DVINT X11 or digital accessory components such as is the R40 remote control is not possible!**

**Allocation of JOB numbers to the display on the accessory components**

JOB no.	Display/selection on the accessory component									
	0	1	2	3	4	5	6	7	8	9
<b>Special JOB 1</b>	129	141	142	143	144	145	146	147	148	149
<b>Special JOB 2</b>	130	151	152	153	154	155	156	157	158	159
<b>Special JOB 3</b>	131	161	162	163	164	165	166	167	168	169

## JOB 0:

This JOB allows you to set the welding parameters manually.

Selection of JOB 0 can be prevented via the key switch or with the "block program 0" parameter (P2). (See "List of special parameters" chapter)

Key switch position 0, or special parameter P2 = 0: JOB 0 is blocked.

Key switch position 1, or special parameter P2 = 1: JOB 0 can be selected.

## JOBS 1-9:

Nine JOBS can be called up in each special JOB (see table).

Nominal values for wire speed, arc correction, dynamics etc must be defined in advance in these JOBS. This can be done easily with the PC300.NET software.

If the software is not available, user-defined JOB lists can be created in the special JOB areas with the "Copy to" function. (See explanations about this in the "Switching JOB lists (P12)" chapter)

## Selecting programs with the standard torch trigger (P17)

Allows you to select a program or switch a program before starting welding.

You switch to the next program by tapping the torch trigger. Once the last enabled program is reached, you start again at the beginning.

- Program 0 is the first enabled program, provided that it is not blocked. (see also special parameter P2).
- The last enabled program is P15.
  - If the programs are not limited by special parameter P4 (see special parameter P4).
  - Or if the programs are limited for the selected JOB by the n cycle setting (see parameter P8).
- Welding starts when the torch trigger is held for longer than 0.64 s.

You can select programs with the standard torch trigger in all operating modes (non-latched, special non-latched, latched and special latched).

## 5.9.1.4 Switching between Push/Pull and intermediate drive

**DANGER**

**Do not carry out any unauthorised repairs or modifications!**

**To avoid injury and equipment damage, the unit must only be repaired or modified by specialist, skilled persons!**

**The warranty becomes null and void in the event of unauthorised interference.**

- Appoint only skilled persons for repair work (trained service personnel)!

**CAUTION****Test!**

**Before re-commissioning, it is essential that an "inspection and test during operation" is carried out conforming to IEC / DIN EN 60974-4 "Arc welding devices - inspection and testing during operation"!**

- For detailed instructions, please see the standard operating instructions for the welding machine.

The plugs are located directly on the M3.7x printed circuit board.

Plug	Function
on X24	Operation with Push/Pull welding torch (factory setting)
on X23	Operation with intermediate drive

## 5.10 TIG welding

### 5.10.1 Welding torch and workpiece line connection

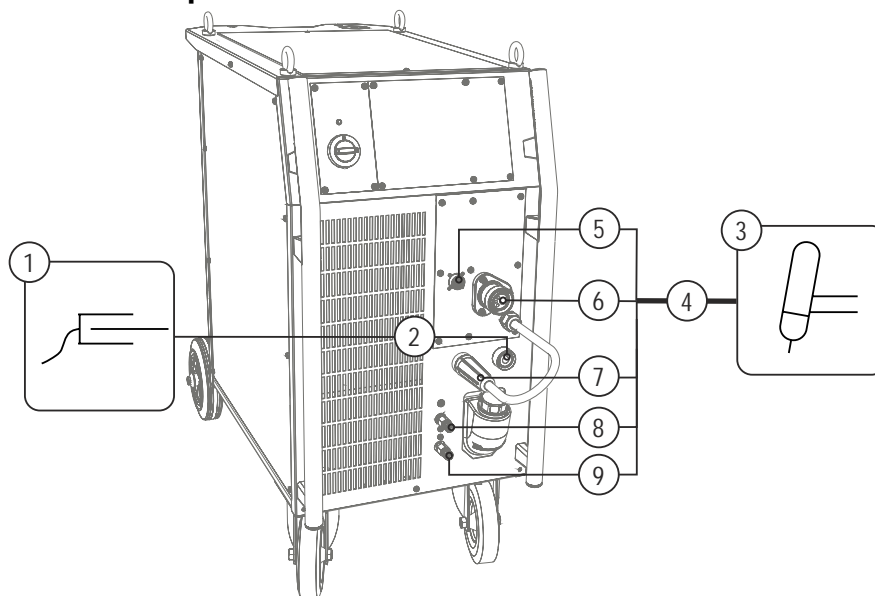


Figure 5-44

Item	Symbol	Description
1		<b>Workpiece</b>
2		<b>Connection socket, "+" welding current</b> • TIG welding: Workpiece connection
3		<b>Welding torch</b>
4		<b>Welding torch hose package</b>
5		<b>19-pole connection socket (analogue)</b> For connecting analogue accessory components (remote control, welding torch control lead, etc.)
6		<b>Euro torch connector</b> Integrated welding current, shielding gas and torch trigger
7		<b>Welding current cable, polarity selection</b> Welding current to the central connector/torch, enables polarity selection. • TIG: Connection socket for "-" welding current
8		<b>Quick connect coupling (red)</b> coolant return
9		<b>Quick connect coupling (blue)</b> coolant supply

- Insert the central plug for the welding torch into the central connector and screw together with crown nut.
- Insert the cable plug on the work piece lead into the "+" welding current connection socket and lock by turning to the right.
- Welding current lead, insert polarity selection into the "-" welding current connection socket and lock.

#### Where applicable:

- Lock connecting nipples of the cooling water tubes into the corresponding quick connect couplings:  
Return line red to quick connect coupling, red (coolant return) and  
supply line blue to quick connect coupling, blue (coolant supply).

#### Only MIG/MAG torches with special functions (additional control lead):

- Insert the torch control lead plug into the 19-pole connection socket and lock in place.

## 5.10.2 Welding task selection

- Select JOB 127 (TIG welding task).

It is only possible to change the JOB number when no welding current is flowing.

Operating element	Action	Result	Display
	1 x	Select JOB number input Material Gas Wire comes on	
		Set the JOB number The machine adopts the required setting after approx. 3 seconds	

## 5.10.3 Welding current setting

The welding current is normally set using the "Wire speed" rotary dial.

Operating element	Action	Result	Displays
		Welding current is set	Setpoint setting

## 5.10.4 TIG arc ignition

### 5.10.4.1 Liftarc ignition

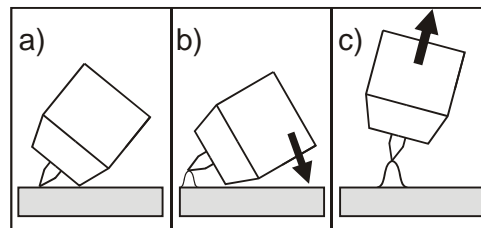


Figure 5-45











**The arc is ignited on contact with the workpiece:**

- Carefully place the torch gas nozzle and tungsten electrode tip onto the workpiece and press the torch trigger (liftarc current flowing, regardless of the main current set).
- Incline the torch over the torch gas nozzle to produce a gap of approx. 2-3 mm between the electrode tip and the workpiece. The arc ignites and the welding current is increased, depending on the operating mode set, to the ignition or main current set.
- Lift off the torch and swivel to the normal position.

**Ending the welding process: Release or press the torch trigger depending on the operating mode selected.**

## 5.10.5 Function sequences/operating modes

### 5.10.5.1 Explanation of signs and functions

Symbol	Meaning
	Press torch trigger
	Release torch trigger
	Tap torch trigger (press briefly and release)
	Shielding gas flowing
I	Welding output
	Gas pre-flows
	Gas post-flows
	Non-latched
	Special, non-latched
	Latched
	Special, latched
t	Time
P <sub>START</sub>	Ignition program
P <sub>A</sub>	Main program
P <sub>R</sub>	Reduced main program
P <sub>END</sub>	End program
tS1	Slope duration from PSTART to PA



## Non-latched mode

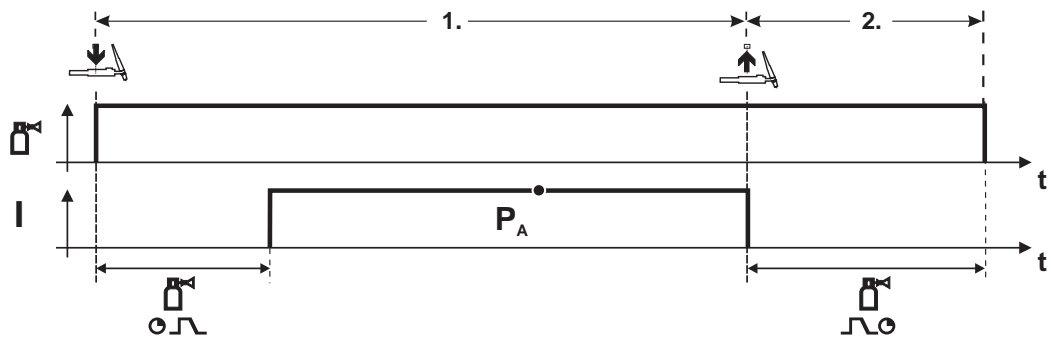



Figure 5-46

### Selection

- Select non-latched operating mode .

#### Step 1

- Press and hold torch trigger.
- Shielding gas is expelled (gas pre-flows).

#### The arc is ignited using liftarc.

- Welding current flows with pre-selected setting.

#### Step 2

- Release torch trigger.
- Arc is extinguished.
- Gas post-flow time elapses.

### Special, non-latched

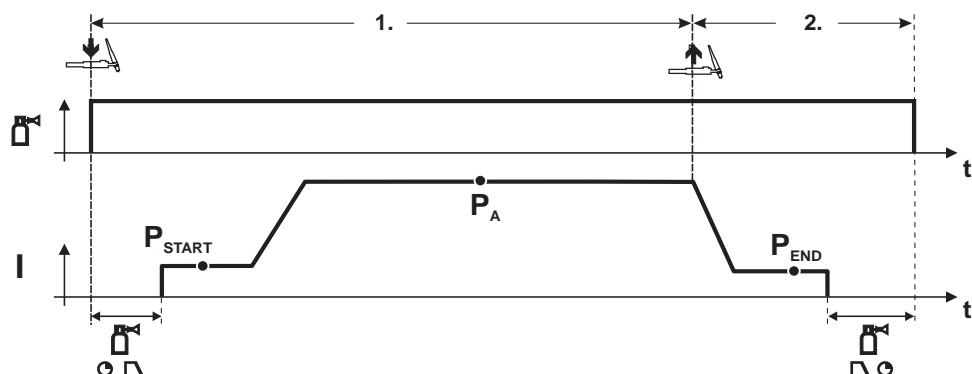


Figure 5-47

### Selection

- Select non-latched special mode .

#### Step 1

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)

#### The arc is ignited using liftarc.

- Welding gas flows with pre-selected setting in start program " $P_{START}$ ".
- After the " $t_{start}$ " ignition current time elapses, the welding current rises with the set upslope time " $t_{S1}$ " to the main program " $P_A$ ".

#### Step 2

- Release torch trigger.
- The welding current reduces with the downslope time " $t_{Se}$ " to the end program " $P_{END}$ ".
- After the end current time " $end$ " elapses, the arc will extinguish.
- Gas post-flow time elapses.

## Latched mode

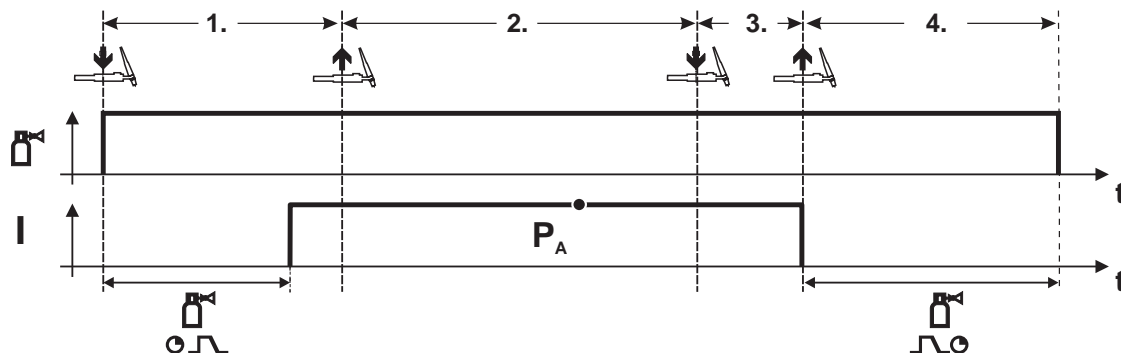


Figure 5-48

## Selection

- Select latched operating mode .

### Step 1

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)

### The arc is ignited using liftarc.

- Welding current flows with pre-selected setting.

### Step 2

- Release torch trigger (no effect)

### Step 3

- Press torch trigger (no effect)

### Step 4

- Release torch trigger
- Arc is extinguished.
- Gas post-flow time elapses.

## Latched special

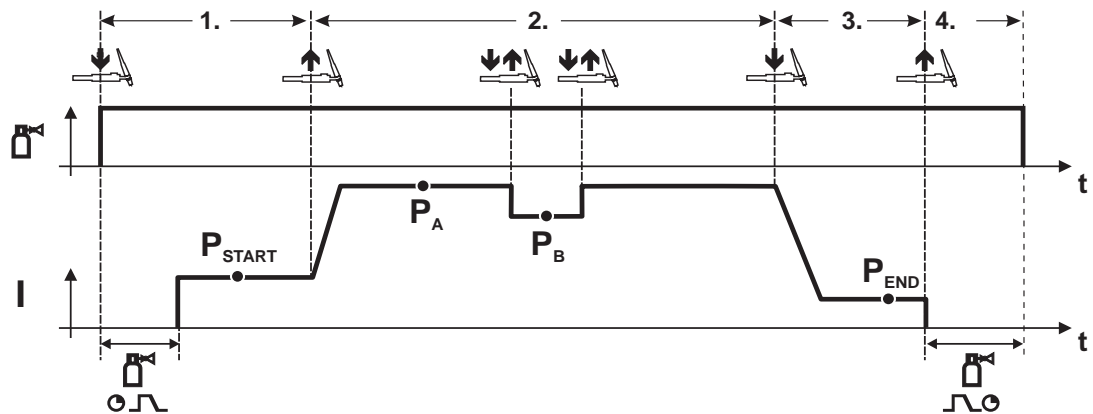


Figure 5-49

### Selection

- Select latched special mode

#### Step 1

- Press and hold torch trigger.
- Shielding gas is expelled (gas pre-flows).

The arc is ignited using liftarc.

- Welding gas flows at pre-selected setting in start program " $P_{START}$ ".

#### Step 2

- Release torch trigger.
- Slope on main program " $P_A$ ".

The slope on main program  $P_A$  is given at the earliest after the set time  $t_{START}$  elapses and at the latest when the torch trigger is released.

Tapping can be used to switch to the reduced main program " $P_B$ ". Repeated tapping will switch back to the main program " $P_A$ ".

#### Step 3

- Press the torch trigger.
- Slope to end program " $P_{END}$ ".

#### Step 4

- Release torch trigger.
- Arc is extinguished.
- Gas post-flow time elapses.

### 5.10.6 TIG automatic cut-out

#### NOTE



The welding machine ends the ignition process or the welding process with an

- ignition fault (no welding current flows within 5 s after the start signal)
- arc interruption (arc is interrupted for longer than 5 s)

## 5.10.7 TIG program sequence ("Program steps" mode)

### 5.10.7.1 TIG parameter overview

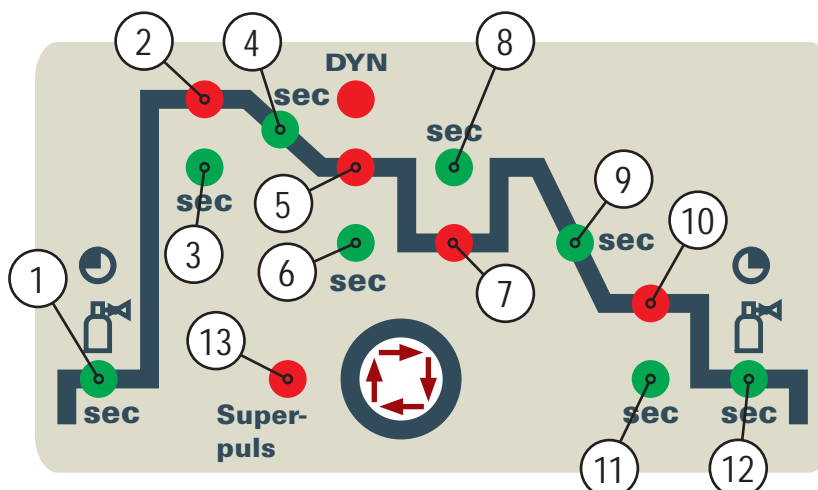


Figure 5-50

#### Basic parameters

Item	Meaning/explanation	Setting range
1	Gas pre-flow time	0 s to 0.9 s
2	$P_{START}$ Ignition current	0% to 200%
3	Duration (start program)	0 s to 20 s
4	Slope duration from $P_{START}$ to $P_A$	0 s to 20 s
5	$P_A$ (main program) Welding current, absolute	5 A to 550 A
6	Duration ( $P_A$ )	0.01 s to 20.0 s
7	$P_B$ (reduced main program) Welding current	1% to 100%
8	Duration (reduced main program)	0.01 s to 20.0 s
9	Slope duration from $P_A$ to $P_{END}$	0 s to 20 s
10	$P_{END}$ (end program) Welding current	1% to 100%
11	Duration (end program)	0 s to 20 s
12	Gas post-flow time	0 s to 20 s
13	Superpulsing	on/off

$P_{START}$ ,  $P_B$ , and  $P_{END}$  are relative programs whose welding current settings are a percentage based on the general welding current setting.

## 5.11 MMA welding

### CAUTION



**Risk of being crushed or burnt.**

**When replacing spent or new stick electrodes**

- Switch off machine at the main switch
- Wear appropriate safety gloves
- Use insulated tongs to remove spent stick electrodes or to move welded workpieces and
- Always put the electrode holder down on an insulated surface.

### 5.11.1 Connecting the electrode holder and workpiece lead

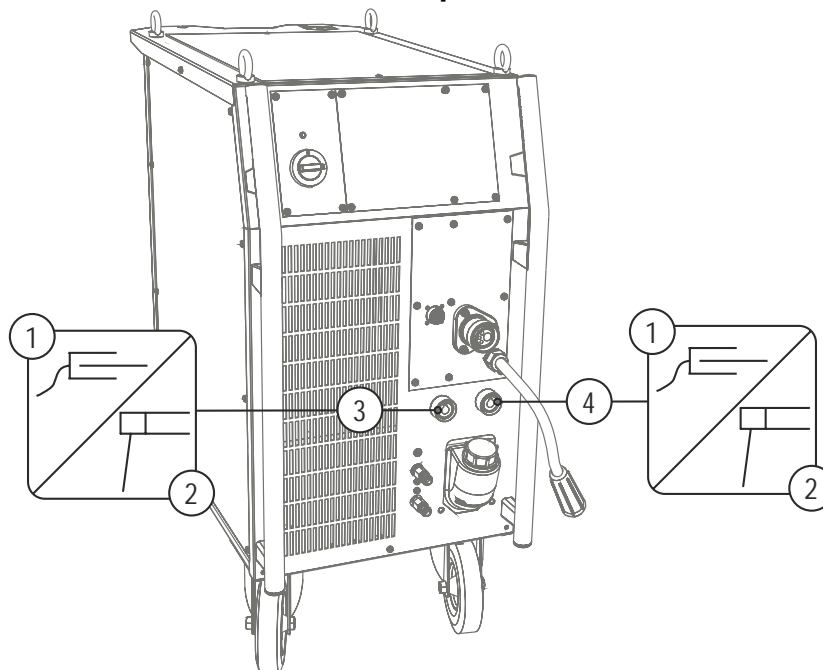


Figure 5-51

Item	Symbol	Description
1		Workpiece
2		Electrode holder
3		Connection socket, "-" welding current
4		Connection socket, "+" welding current

- Insert cable plug of the electrode holder into either the "+" or "-" welding current connection socket and lock by turning to the right.
- Insert cable plug of the workpiece lead into either the "+" or "-" welding current connection socket and lock by turning to the right.

### NOTE




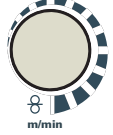




**Polarity depends on the instructions from the electrode manufacturer given on the electrode packaging.**

## 5.11.2 Welding task selection

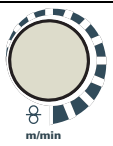

- Select JOB 128 (MMA welding task).

It is only possible to change the JOB number when no welding current is flowing.








Operating element	Action	Result	Display
	1 x 	Select JOB number input <div> <div>Material</div> <div>Gas</div> <div>Wire</div> <div>● comes on</div> </div>	
		Set the JOB number The machine adopts the required setting after approx. 3 seconds	

## 5.11.3 Welding current setting

The welding current is normally set using the "Wire speed" rotary dial.

Operating element	Action	Result	Displays
		Welding current is set	Setpoint setting

## 5.11.4 Arcforce

Operating element	Action	Result	Display
		Select arcforcing welding parameter LED for the button ● is on.	
		Arcforcing setting for electrode types: (Setting range -40 to 40) <div> <div>Negative values</div> <div>Values around zero</div> <div>Positive values</div> <div> <div>Rutile</div> <div>Basic</div> <div>Cellulose</div> </div> </div>	 

## 5.11.5 Hotstart

The hotstart device improves the ignition of the stick electrodes using an increased ignition current.

- a) = Hotstart time  
b) = Hotstart current  
I = Welding current  
t = Time

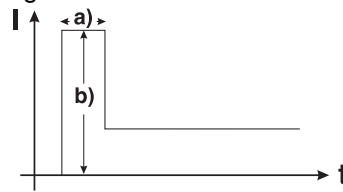
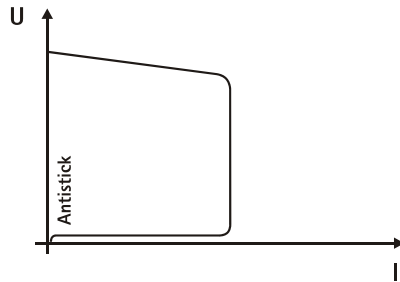


Figure 5-52

For hotstart parameter settings, see "parameter overview" chapter

## 5.11.6 Antistick



**Anti-stick prevents the electrode from annealing.**  
If the electrode sticks in spite of the Arcforce device, the machine automatically switches over to the minimum current within about 1 second to prevent the electrode from overheating. Check the welding current setting and correct according to the welding task!

Figure 5-53

## 5.11.7 Parameter overview

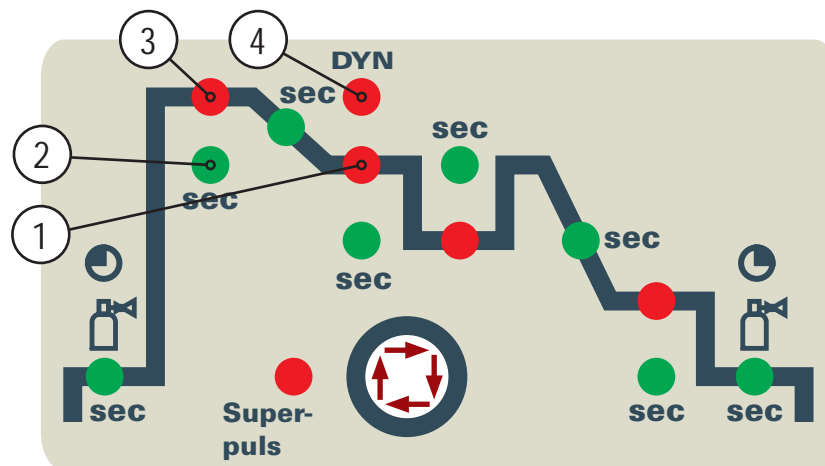


Figure 5-54

### Basic parameters

Item	Meaning/explanation	Setting range
1	Welding current	5 A to maximum welding current
2	Hotstart time	0 to 20 s
3	Hotstart current	0 to 200 %
4	Arcforce	-40 to 40

### NOTE



The hotstart current is a percentage based on the welding current selected.

## 5.12 Interfaces

### CAUTION



#### Damage due to the use of non-genuine parts!

**The manufacturer's warranty becomes void if non-genuine parts are used!**

- Only use system components and options (power sources, welding torches, electrode holders, remote controls, spare parts and replacement parts, etc.) from our range of products!
- Only insert and lock accessory components into the relevant connection socket when the machine is switched off.



#### Damage due to incorrect connection!

**Accessory components and the power source itself can be damaged by incorrect connection!**

- Only insert and lock accessory components into the relevant connection socket when the machine is switched off.
- Comprehensive descriptions can be found in the operating instructions for the relevant accessory components.
- Accessory components are detected automatically after the power source is switched on.

### 5.12.1 Automation interface

#### NOTE



**These accessory components can be retrofitted as an option, see Accessories chapter.**

Pin	Input / output	Description	Diagram
A	Output	PE Connection for cable shielding	
D	Output (open collector)	IGRO Current flows signal I>0 (maximum load 20 mA / 15 V) 0 V = welding current flows	
E + R	Input	Not/Aus Emergency stop for higher level shut-down of the power source. To use this function, jumper 1 must be unplugged on PCB M320/1 in the welding machine. Contact open = welding current off	
F	Output	0 V Reference potential	
G/P	Output	I>0 Power relay contact, galvanically isolated (max. +/-15 V / 100 mA)	
H	Output	Uist Welding voltage, measured against pin F, 0-10 V (0 V = 0 V; 10 V = 100 V)	
L	Input	Str/Stp Start = 15 V / Stop = 0 V <sup>1)</sup>	
M	Output	+15 V Voltage supply (max. 75 mA)	
N	Output	-15 V Voltage supply (max. 25 mA)	
S	Output	0 V Reference potential	
T	Output	list Welding current, measured on pin F; 0-10 V (0 V = 0 A, 10 V = 1000 A)	

<sup>1)</sup> The operating mode is given by the wire feed unit (the start / stop function equates to pressing the torch trigger and is used in mechanised applications, for example).



### 5.12.2 RINT X12 robot interface

The standard digital interface for mechanised applications•  
(optional, retrofitting on the machine or external fitting by the customer)

#### Functions and signals:

- Digital inputs: start/stop, operating modes, JOB and program selection, inching, gas test
- Analogue inputs: control voltages, e.g. for welding performance, welding current, etc.
- Relay outputs: process signal, ready for welding, system composite fault, etc.

### 5.12.3 BUSINT X10 Industrial bus interface

The solution for easy integration into automated production lines, with for example

- Profi bus
- CAN bus and
- Interbus systems

(optional, external installation by customer)

### 5.12.4 DVINT X11 Wire feed interface

For the flexible connection of special wire feed units (optional, retrofitting on the machine or externally by the customer).

As examples: Binzel (APD system), Dinse wire feed systems.

### 5.12.5 PC Interfaces

#### CAUTION



**Equipment damage or faults may occur if the PC is connected incorrectly!**

**Not using the SECINT X10USB interface results in equipment damage or faults in signal transmission. The PC may be destroyed due to high frequency ignition pulses.**

- Interface SECINT X10USB must be connected between the PC and the welding machine!
- The connection must only be made using the cables supplied (do not use any additional extension cables)!

#### PC 300 welding parameter software

Create all welding parameters quickly on the PC and easily transfer them to one or more welding machines (accessories: set consisting of software, interface, connection leads).

#### Q-DOC 9000 welding data documentation software

(Accessories: set consisting of software, interface, connection leads)

The ideal tool for welding data documentation of, for example:  
welding voltage and current, wire speed and motor current.

#### WELDQAS welding data monitoring and documentation system

Network-compatible welding data monitoring and documentation system for digital machines

### 5.12.6 Setting options, internal

#### 5.12.6.1 Switching between Push/Pull and intermediate drive

The plugs are located directly on PCB M3.70 in the wire feed unit.

Plug	Function
on X24	Operation with Push/Pull welding torch (factory setting)
on X23	Operation with intermediate drive

## 5.13 Protecting welding parameters from unauthorised access

To protect against unauthorised or unintentional adjustment of the welding parameters on the machine, the control input can be locked with the aid of a key switch.

In key switch position 1 all functions and parameters can be set without restriction.

In key switch position 0 the following functions and parameters cannot be changed:

- JOB switching function, welding task selection  
(block JOB mode possible with Power-control torch)
- JOB Manager mode
- Program Steps mode
- Program A mode
- JOB Info mode
- Super pulse function

## 6 Maintenance, care and disposal



### DANGER



#### Risk of injury from electric shock!

**Cleaning machines that are not disconnected from the mains can lead to serious injuries!**

- Disconnect the machine completely from the mains.
- Remove the mains plug!
- Wait for 4 minutes until the capacitors have discharged!

### 6.1 General

When used in the specified environmental conditions and under normal operating conditions, this machine is largely maintenance-free and requires a minimum of care.

There are some points, which should be observed, to guarantee fault-free operation of your welding machine. Among these are regular cleaning and checking as described below, depending on the pollution level of the environment and the length of time the unit is in use.

### 6.2 Maintenance work, intervals

#### CAUTION



#### Electric current!

**Repairs may only be carried out by authorised specialist staff!**

- Do not remove the torch from the tube package!
- Never clamp the torch body in a vice or similar, as this can cause the torch to be irreparably destroyed!
- If damage occurs to the torch or to the tube package which cannot be corrected as part of the maintenance work, the entire torch must be returned to the manufacturer

#### 6.2.1 Daily maintenance tasks

- Check that all connections and wearing parts are hand-tight and tighten if necessary.
- Check that all screw and plug connections and replaceable parts are secured correctly, tighten if necessary.
- Remove any spatter.
- Clean the wire feed rollers on a regular basis (depending on the degree of soiling).

##### 6.2.1.1 Visual inspection

- Check hose package and power connections for exterior damage and replace or have repaired by specialist staff as necessary!
- Mains supply lead and its strain relief
- Gas tubes and their switching equipment (solenoid valve)
- Other, general condition

##### 6.2.1.2 Functional test

- Check correct mounting of the wire spool.
- Welding current cables (check that they are fitted correctly and secured)
- Gas cylinder securing elements
- Operating, message, safety and adjustment devices (Functional test)

## 6.2.2 Monthly maintenance tasks

### 6.2.2.1 Visual inspection

- Casing damage (front, rear and side walls)
- Wheels and their securing elements
- Transport elements (strap, lifting lugs, handle)
- Check coolant tubes and their connections for impurities

### 6.2.2.2 Functional test

- Selector switches, command devices, emergency stop devices, voltage reducing devices, message and control lamps
- Check that the wire guide elements (inlet nipple, wire guide tube) are fitted securely.

## 6.2.3 Annual test (inspection and testing during operation)

### NOTE



**The welding machine may only be tested by competent, capable persons!**

A capable person is one who, because of his training, knowledge and experience, is able to recognise the dangers that can occur while testing welding power sources as well as possible subsequent damage and who is able to implement the required safety procedures.



**For further information, please see the accompanying supplementary sheets "Machine and Company Data, Maintenance and Testing, Warranty"!**

A periodic test according to IEC 60974-4 "Periodic inspection and test" has to be carried out. In addition to the regulations on testing given here, the relevant local laws and regulations must also be observed.

## 6.3 Maintenance work



### DANGER



**Do not carry out any unauthorised repairs or modifications!**

**To avoid injury and equipment damage, the unit must only be repaired or modified by specialist, skilled persons!**

**The warranty becomes null and void in the event of unauthorised interference.**

- Appoint only skilled persons for repair work (trained service personnel)!

Repair and maintenance work may only be performed by qualified authorised personnel; otherwise the right to claim under warranty is void. In all service matters, always consult the dealer who supplied the machine. Return deliveries of defective equipment subject to warranty may only be made through your dealer. When replacing parts, use only original spare parts. When ordering spare parts, please quote the machine type, serial number and item number of the machine, as well as the type designation and item number of the spare part.

## 6.4 Disposing of equipment

### NOTE



#### Proper disposal!

**The machine contains valuable raw materials, which should be recycled, and electronic components, which must be disposed of.**

- Do not dispose of in household waste!
- Observe the local regulations regarding disposal!



### 6.4.1 Manufacturer's declaration to the end user

- According to European provisions (guideline 2002/96/EG of the European Parliament and the Council of January, 27th 2003), used electric and electronic equipment may no longer be placed in unsorted municipal waste. It must be collected separately. The symbol depicting a waste container on wheels indicates that the equipment must be collected separately.  
This machine is to be placed for disposal or recycling in the waste separation systems provided for this purpose.
- According to German law (law governing the distribution, taking back and environmentally correct disposal of electric and electronic equipment (ElektroG) from 16.03.2005), used machines are to be placed in a collection system separate from unsorted municipal waste. The public waste management utilities (communities) have created collection points at which used equipment from private households can be disposed of free of charge.
- Information about giving back used equipment or about collections can be obtained from the respective municipal administration office.
- EWM participates in an approved waste disposal and recycling system and is registered in the Used Electrical Equipment Register (EAR) under number WEEE DE 57686922.
- In addition to this, returns are also possible throughout Europe via EWM sales partners.

## 6.5 Meeting the requirements of RoHS

We, EWM HIGHTEC Welding GmbH Mündersbach, hereby confirm that all products supplied by us which are affected by the RoHS Directive, meet the requirements of the RoHS (Directive 2002/95/EC).

## 7 Rectifying faults

All products are subject to rigorous production checks and final checks. If, despite this, something fails to work at any time, please check the product using the following flowchart. If none of the fault rectification procedures described leads to the correct functioning of the product, please inform your authorised dealer.

### 7.1 Checklist for rectifying faults

#### NOTE



**The correct machine equipment for the material and process gas in use is a fundamental requirement for perfect operation!**

Legend	Symbol	Description
	↗	Fault/Cause
	✕	Remedy

#### Coolant error/no coolant flowing

- ↗ Insufficient coolant flow
  - ✕ Check coolant level and refill if necessary
- ↗ Air in the coolant circuit
  - ✕ see chapter "Vent coolant circuit"

#### Wire feed problems



- ↗ Contact tip blocked
  - ✕ Clean, spray with anti-spatter spray and replace if necessary
- ↗ Setting the spool brake (see "Setting the spool brake" chapter)
  - ✕ Check settings and correct if necessary
- ↗ Setting pressure units (see "Inching wire electrodes" chapter)
  - ✕ Check settings and correct if necessary
- ↗ Worn wire rolls
  - ✕ Check and replace if necessary
- ↗ Wire feed motor without supply voltage (automatic cutout triggered by overloading)
  - ✕ Reset triggered fuse (rear of the power source) by pressing the key button
- ↗ Kinked hose packages
  - ✕ Extend and lay out the torch hose package
- ↗ Wire guide core or spiral is dirty or worn
  - ✕ Clean core or spiral; replace kinked or worn cores

#### Functional errors

- ↗ Machine control without displaying the signal lights after switching on
  - ✕ Phase failure > check mains connection (fuses)
- ↗ No welding performance
  - ✕ Phase failure > check mains connection (fuses)
- ↗ Various parameters cannot be set
  - ✕ Entry level is blocked, disable access lock (see chapter entitled "Lock welding parameters against unauthorised access")
- ↗ Connection problems
  - ✕ Make control lead connections and check that they are fitted correctly.
- ↗ Loose welding current connections
  - ✕ Tighten power connections on the torch and/or on the workpiece
  - ✕ Tighten contact tip correctly

## 7.2 Error messages (power source)

### NOTE

-  A welding machine error is indicated by an error code being displayed (see table) on the display on the machine control.  
In the event of a machine error, the power unit is shut down.
-  The display of possible error numbers depends on the machine version (interfaces/functions).




- Document machine errors and inform service staff as necessary.
- If multiple errors occur, these are displayed in succession.

Error	Category			Possible cause	Remedy
	a)	b)	c)		
Error 1 (Ov.Vol)	-	-	x	Mains overvoltage	Check the mains voltages and compare with the connection voltages of the welding machine
Error 2 (Un.Vol)	-	-	x	Mains undervoltage	
Error 3 (Temp)	x	-	-	Welding machine excess temperature	Allow the machine to cool down (mains switch to "1")
Error 4 (Water)	-	x	x	Low coolant level	Top off the coolant Leak in the coolant circuit > rectify the leak and top off the coolant Coolant pump is not working > check excess current trigger on air cooling unit
Error 5 (Wi.Spe)	x	-	-	Wire feeder, speedometer error	Check the wire feeder speedometer is not issuing a signal, M3.00 defective > inform Service
Error 6 (gas)	x	-	-	Shielding gas error	Check shielding gas supply (for machines with shielding gas monitoring)
Error 7 (Se.Vol)	-	-	x	Secondary excess voltage	Inverter error > inform Service
Error 8 (no PE)	-	-	x	Earth fault between welding wire and earth line •(Phoenix 330 only)	Separate the connection between the welding wire and casing or an earthed object
Error 9 (fast stop)	x	-	-	Fast cut-out triggered by BUSINT X11 or RINT X12	Rectify error on robot
Error 10 (no arc)	-	x	-	Arc break triggered by BUSINT X11 or RINT X12	Check wire feeding
Error 11 (no ign)	-	x	-	Ignition fault after 5 s triggered by BUSINT X11 or RINT X12	Check wire feeding
Error 14 (no DV)	-	x	-	Wire feeder not detected. Control cable not connected.	Check cable connections
				Incorrect ID numbers assigned during operation with multiple wire feeders.	Check assignment of ID numbers (see the "Changing ID number of wire feeder" chapter)
Error 15 (DV2?)	-	x	-	Wire feeder 2 not detected. Control cable not connected.	Check cable connections
Error 16 (VRD)	-	-	x	VRD (open circuit voltage reduction error)	Inform Service
Error 17 (WF. Ov.)	-	x	x	Wire feed mechanism overcurrent detection	Check the wire feeding

### Legend for categories (error reset)

a) The error message will disappear once the error has been rectified.

b) The error message can be reset by pressing a key button:

Welding machine control	Key button
RC1 / RC2	
Expert	
CarExpert / Progress (M3.11)	
alpha Q / Concept / Basic / Basic S / Synergic / Synergic S / Progress (M3.71) Picomig 305	not possible

c) The error message can only be reset by switching the machine off and on again.


The shielding gas error (Err 6) can be reset by pressing the "Welding parameters" key button.



## 7.3 Resetting JOBs (welding tasks) to the factory settings

### 7.3.1 Resetting a single JOB

#### NOTE

 All customised welding parameters that are stored will be replaced by the factory settings.

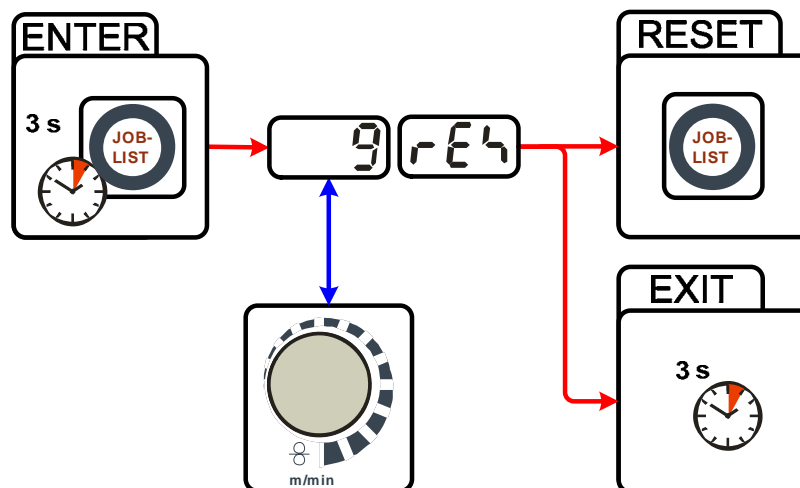





Figure 7-1

Display	Setting/selection
	<b>Reset to factory settings</b> The RESET will be done after pressing the button. The menu will be ended when no changes are done after 3 sec.
	<b>JOB-number (example)</b> The shown JOB will be set to ex works.

7.3.2 Resetting all JOBs

NOTE

 **JOBs 1–128 and 170–256 will be reset.**  
**Custom JOBs 129–169 are maintained.**

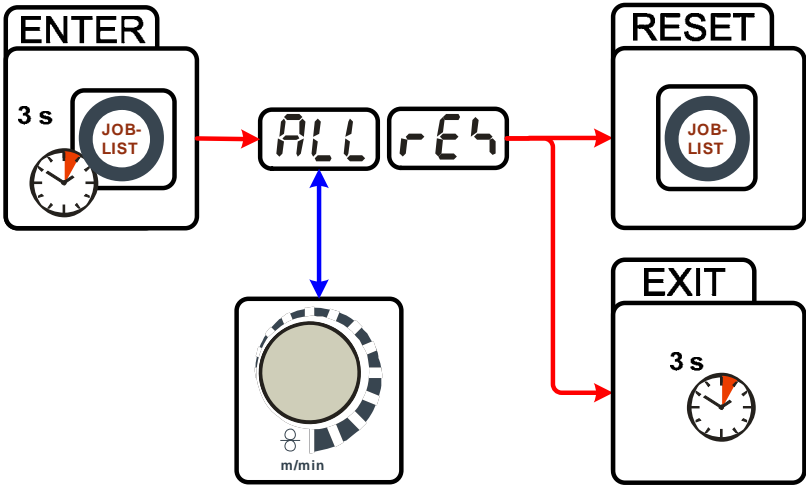





Figure 7-2

Display	Setting/selection
	<b>Reset to factory settings</b> The RESET will be done after pressing the button. The menu will be ended when no changes are done after 3 sec.

7.4 General operating problems

7.4.1 Interface for automated welding

 **WARNING**





**No function of the external interrupt equipment (emergency stop switch)!**  
If the emergency stop circuit has been realised using an external interrupt equipment via the interface for automated welding, the machine must be configured for this setup. If this is not observed, the power source will ignore the external interrupt equipment and will not shut down!

- Disconnect jumper 1 on PCB T320/1 (Tetrix) or M320/1 (Phoenix / alpha Q)!

## 7.5 Vent coolant circuit

### NOTE

-  Coolant tank and quick connect coupling of coolant supply and return are only fitted in machines with water cooling.
-  To vent the cooling system always use the blue coolant connection, which is located as deep as possible inside the system (close to the coolant tank)!

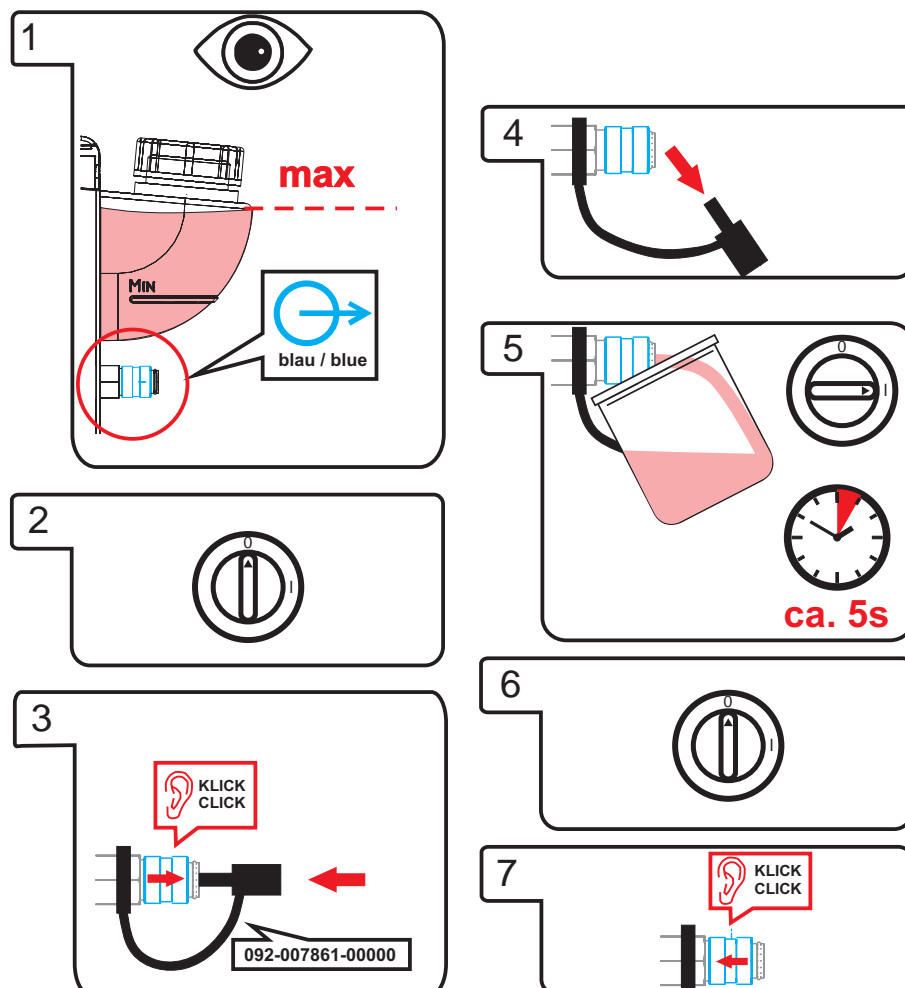


Figure 7-3

## 8 Technical data

### NOTE



Performance specifications and guarantee only in connection with original spare and replacement parts!

### 8.1 Phoenix 401 Progress FKG

Setting range for welding current/voltage:

<b>TIG</b>	5 A/10.2 V to 400 A/26.0 V
<b>MMA</b>	5 A/20.2 V to 400 A/36.0 V
<b>MIG/MAG</b>	5 A/14.3 V to 400 A/34.0 V
<b>Duty cycle at 40 °C</b>	
<b>100%</b>	400 A
<b>Load alternation</b>	10 min. (60% DC $\Delta$ 6 min. welding, 4 min. pause)
<b>Open circuit voltage</b>	79 V
<b>Mains voltage (tolerances)</b>	3 x 400 V (-25% to +20%)
<b>Frequency</b>	50/60 Hz
<b>Mains fuse (safety fuse, slow-blow)</b>	3 x 35 A
<b>Mains connection lead</b>	H07RN-F4G4
<b>Maximum connected load</b>	
<b>MIG/MAG</b>	17.2 kVA
<b>TIG</b>	13.1 kVA
<b>MMA</b>	18.2 kVA
<b>Recommended generator rating</b>	25.0 kVA
<b>cos<math>\phi</math></b>	0.99
<b>Insulation class/protection classification</b>	H/IP 23
<b>Ambient temperature</b>	-20 °C to +40 °C
<b>Machine/torch cooling</b>	Fan/gas
<b>Welding lead</b>	70 mm <sup>2</sup>
<b>Dimensions L x W x H in mm</b>	1100 x 455 x 950
<b>Weight</b>	105 kg
<b>Wire feed speed</b>	0.5 m/min to 24 m/min
<b>Standard roller installation</b>	1.0 mm + 1.2 mm (for steel wire)
<b>Drive type</b>	4-roller (37 mm)
<b>Welding torch connection</b>	Euro central connection
<b>EMC class</b>	A
<b>Constructed to standards</b>	IEC 60974-1, -5, -10 S / C E

## 8.2 Phoenix 401 Progress FKW

Setting range for welding current/voltage:

<b>TIG</b>	5 A/10.2 V to 400 A/26.0 V
<b>MMA</b>	5 A/20.2 V to 400 A/36.0 V
<b>MIG/MAG</b>	5 A/14.3 V to 400 A/34.0 V
<b>Duty cycle at 40 °C</b>	
<b>100%</b>	400 A
<b>Load alternation</b>	10 min. (60% DC $\Delta$ 6 min. welding, 4 min. pause)
<b>Open circuit voltage</b>	79 V
<b>Mains voltage (tolerances)</b>	3 x 400 V (-25% to +20%)
<b>Frequency</b>	50/60 Hz
<b>Mains fuse (safety fuse, slow-blow)</b>	3 x 35 A
<b>Mains connection lead</b>	H07RN-F4G4
<b>Maximum connected load</b>	
<b>MIG/MAG</b>	17.2 kVA
<b>TIG</b>	13.1 kVA
<b>MMA</b>	18.2 kVA
<b>Recommended generator rating</b>	25.0 kVA
<b>cos<math>\phi</math></b>	0.99
<b>Insulation class/protection classification</b>	H/IP 23
<b>Ambient temperature</b>	-20 °C to +40 °C
<b>Machine/torch cooling</b>	Fan/gas or water
<b>Cooling capacity at 1 l/min</b>	1500 W
<b>Max. flow rate</b>	5 l/min
<b>Max. coolant outlet pressure</b>	3.5 bar
<b>Max. tank capacity</b>	12 l
<b>Coolant</b>	Ex works: KF 23E (-10 °C to +40 °C) or KF 37E (-20 °C to +10 °C)
<b>Welding lead</b>	70 mm <sup>2</sup>
<b>Dimensions L x W x H in mm</b>	1100 x 455 x 950
<b>Weight</b>	120 kg
<b>Wire feed speed</b>	0.5 m/min to 24 m/min
<b>Standard roller installation</b>	1.0 mm + 1.2 mm (for steel wire)
<b>Drive type</b>	4-roller (37 mm)
<b>Welding torch connection</b>	Euro central connection
<b>EMC class</b>	A
<b>Constructed to standards</b>	IEC 60974-1, -2, -5, -10 S / C E

## 8.3 Phoenix 501 Progress FKW

	TIG		MIG/MAG		MMA	
Setting range for welding current	5 A–500 A					
Setting range for welding voltage	10.2 V–30.0 V		14.3 V–39.0 V		20.2 V–40.0 V	
Duty cycle	40 °C	25 °C	40 °C	25 °C	40 °C	25 °C
60%	500 A	-	500 A	-	500 A	-
65%	-	500 A	-	500 A	-	500 A
100%	430 A	460 A	430 A	460 A	430 A	460 A
Load alternation	10 min. (60% DC $\triangle$ 6 min. welding, 4 min. pause)					
Open circuit voltage	79 V					
Mains voltage (tolerances)	3 x 400 V (-25% to +20%)					
Frequency	50/60 Hz					
Mains fuse (safety fuse, slow-blow)	3 x 35 A					
Mains connection lead	H07RN-F4G4					
Maximum connected load						
Max. connected load	18.9 kVA		24.6 kVA		25.3 kVA	
Recommended generator rating	35.0 kVA					
Cos $\phi$	0.99					
Insulation class/protection classification	H/IP 23					
Ambient temperature	-20 °C to +40 °C					
Machine/torch cooling	Fan/gas or water					
Cooling capacity at 1 l/min	1500 W					
Max. flow rate	5 l/min					
Max. coolant outlet pressure	3.5 bar					
Max. tank capacity	12 l					
Coolant	Ex works: KF 23E (-10 °C to +40 °C) or KF 37E (-20 °C to +10 °C)					
Workpiece lead	95 mm <sup>2</sup>					
Dimensions L x W x H in mm	1100 x 455 x 950					
Weight	124 kg					
Wire feed speed	0.5 m/min. to 24 m/min.					
Standard roller installation	1.0 mm + 1.2 mm (for steel wire)					
Drive type	4-roller (37 mm)					
Welding torch connection	Euro torch connector					
EMC class	A					
Constructed to standards	IEC 60974-1, -2, -5, -10 S / C E					

## 9 Accessories

### NOTE



Performance-dependent accessories like torches, workpiece leads, electrode holders or intermediate hose packages are available from your authorised dealer.

### 9.1 General accessories

Type	Designation	Item no.
AK300	Wire spool adapter K300	094-001803-00001
TYP 1	Frost protection tester	094-014499-00000
KF 23E-10	Coolant (-10 °C), 9.3 l	094-000530-00000
KF 23E-200	Coolant (-10 °C), 200 litres	094-000530-00001
KF 37E-10	Coolant (-20 °C), 9.3 l	094-006256-00000
KF 37E-200	Coolant (-20 °C), 200 l	094-006256-00001
DM1 35L/MIN	Manometer pressure regulator	094-000009-00000
5POLE/CEE/32A/M	Machine plug	094-000207-00000
HOSE BRIDGE	Tube bridge	092-007843-00000

### 9.2 Remote control / connection cable

Type	Designation	Item no.
R10 19POL	Remote control	090-008087-00000
RG10 19POL 5M	Remote control to set the wire speed and welding voltage correction	090-008108-00000
RA5 19POL 5M	Remote control e.g. connection cable	092-001470-00005
RA10 19POL 10M	Remote control e.g. connection cable	092-001470-00010
RA20 19POL 20M	Remote control e.g. connection cable	092-001470-00020
R20 19POL	Program changeover remote control	090-008263-00000
R40 7POL	Remote control, 10 programs	090-008088-00000
R50 7POL	Remote control, all welding machine functions can be set directly at the workplace	090-008776-00000
FRV5-L 7POL	Extension/connecting cable	092-000201-00003
FRV10-L 7POL	Extension/connecting cable	092-000201-00000
FRV20-L 7POL	Extension/connecting cable	092-000201-00001

## 9.3 Options

Type	Designation	Item no.
ON LB Wheels 160x40MM	Retrofit option for locking brake for machine wheels	092-002110-00000
ON Holder Gas Bottle <50L	Holding plate for gas cylinders smaller than 50 litres	092-002151-00000
ON Shock Protect	Ram protection retrofit option	092-002154-00000
ON Hose/FR Mount	Optional holder for tubes and remote control for machines without pivot support	092-002116-00000
ON Filter T/P	Retrofit option contamination filter for air inlet	092-002092-00000
ON Tool Box	Retrofit option tool box	092-002138-00000

## 9.4 Computer communication

Type	Designation	Item no.
PC300.Net	PC300.Net welding parameter software set incl. cable and SECINT X10 USB interface	090-008265-00000
CD PC300.Net update	PC300.Net Update on CD-ROM	092-008172-00001
QDOC9000 V2.0	Set consisting of interface, documentation software, connection lead	090-008713-00000
PC300.Net	PC300.Net welding parameter software set incl. cable and SECINT X10 USB interface	090-008265-00000
FRV5-L 7POL	Extension/connecting cable	092-000201-00003
FRV10-L 7POL	Extension/connecting cable	092-000201-00000
FRV20-L 7POL	Extension/connecting cable	092-000201-00001
PC INTX10 SET	Q-DOC 9000 documentation interface	090-008093-00000
PCV10-L 10M 9POL	Cable between PC/interface	094-001206-00002



## 10 Replaceable parts

### CAUTION



**Damage due to the use of non-genuine parts!**

**The manufacturer's warranty becomes void if non-genuine parts are used!**

- Only use system components and options (power sources, welding torches, electrode holders, remote controls, spare parts and replacement parts, etc.) from our range of products!
- Only insert and lock accessory components into the relevant connection socket when the machine is switched off.

### 10.1 Wire feed rollers

#### 10.1.1 Wire feed rollers for steel wire

Type	Designation	Item no.
FE 2DR4R 0,6+0,8	Drive rollers, 37 mm, steel	092-000839-00000
FE 2DR4R 0,8+1,0	Drive rollers, 37 mm, steel	092-000840-00000
FE 2DR4R 0,9+1,2	Drive rollers, 37 mm, steel	092-000841-00000
FE 2DR4R 1,0+1,2	Drive rollers, 37 mm, steel	092-000842-00000
FE 2DR4R 1,2+1,6	Drive rollers, 37 mm, steel	092-000843-00000
FE/AL 2GR4R	Pressure rollers, smooth, 37mm	092-000844-00000

#### 10.1.2 Wire feed rollers for aluminium wire

Type	Designation	Item no.
AL 4ZR4R 0,8+1,0	Twin rollers, 37 mm, for aluminium	092-000869-00000
AL 4ZR4R 1,0+1,2	Twin rollers, 37 mm, for aluminium	092-000848-00000
AL 4ZR4R 1,2+1,6	Twin rollers, 37 mm, for aluminium	092-000849-00000
AL 4ZR4R 2,4+3,2	Twin rollers, 37 mm, for aluminium	092-000870-00000

#### 10.1.3 Wire feed rollers for cored wire

Type	Designation	Item no.
ROE 2DR4R 0,8/0,9+0,8/0,9	Drive rollers, 37 mm, cored wire	092-000834-00000
ROE 2DR4R 1,0/1,2+1,4/1,6	Drive rollers, 37 mm, cored wire	092-000835-00000
ROE 2DR4R 1,4/1,6+2,0/2,4	Drive rollers, 37 mm, cored wire	092-000836-00000
ROE 2DR4R 2,8+3,2	Drive rollers, 37 mm, cored wire	092-000837-00000
ROE 2GR4R	Pressure rollers, knurled, 37mm	092-000838-00000

## 10.1.4 Conversion sets

Type	Designation	Item no.
URUE VERZ>UNVERZ FE/AL 4R	Conversion kit, 37mm, 4-roller drive on non-toothed rollers (steel/aluminium)	092-000845-00000
URUE AL 4ZR4R 0,8+1,0	Conversion kit, 37mm, 4-roller drive for aluminium	092-000867-00000
URUE AL 4ZR4R 1,0+1,2	Conversion kit, 37mm, 4-roller drive for aluminium	092-000846-00000
URUE AL 4ZR4R 1,2+1,6	Conversion kit, 37mm, 4-roller drive for aluminium	092-000847-00000
URUE AL 4ZR4R 2,4+3,2	Conversion kit, 37mm, 4-roller drive for aluminium	092-000868-00000
URUE ROE 2DR4R 0,8/0,9+0,8/0,9	Conversion kit, 37mm, 4-roller drive for cored wire	092-000830-00000
URUE ROE 2DR4R 1,0/1,2+1,4/1,6	Conversion kit, 37mm, 4-roller drive for cored wire	092-000831-00000
URUE ROE 2DR4R 1,4/1,6+2,0/2,4	Conversion kit, 37mm, 4-roller drive for cored wire	092-000832-00000
URUE ROE 2DR4R 2,8+3,2	Conversion kit, 37mm, 4-roller drive for cored wire	092-000833-00000

<div> <b>Verschleißteile</b>  <b>4 Rollen-Antrieb</b>  <b>Ø = 37mm</b> </div> <div>           St= Stahl            Al= Aluminium            CrNi= Edelstahl            Cu= Kupfer         </div>		<div> <b>Wear parts</b>  <b>4-Roller drive system</b>  <b>Ø = 37mm</b> </div> <div>           St= Steel            Al= Aluminium            CrNi= Stainless steel            Cu= Copper         </div>	
<b>V-Nut: St-, CrNi-, Cu-Draht</b> „Standard V-Nut“, oben unverzahnt und glatt, Rollenbezeichnung: „1,0“		<b>V-groove: St-, CrNi-, Cu wire</b> "Standard V-groove", on the top ungeared and plane, rolls description: "1,0"	
<b>Antriebsrollen- Ø (b):</b> <b>Drive rolls- Ø (b):</b> 0,6 + 0,8 0,8 + 1,0 0,9 + 1,2 1,0 + 1,2 1,2 + 1,6	<b>Ersatzset:</b> <b>Spare set:</b> 092-000839-00000 092-000840-00000 092-000841-00000 092-000842-00000 092-000843-00000		
Gegendruckrollenset (a) <i>Set of counter pressure rolls (a)</i> 092-000844-00000 Umrüstung verzahnt → unverzahnt: <i>conversion geared → ungeared:</i> 092-000845-00000			
<b>U-Nut: Al-, Cu-Draht</b> „Option U-Nut“, oben verzahnt, Rollenbezeichnung: „1,0 A2“		<b>U-groove: Al-, Cu wire</b> "Option U-groove", on the top geared-twin rolls, rolls description: "1,0 A2"	
<b>Antriebsrollen- Ø (a+b):</b> <b>Drive rolls- Ø (a+b):</b> 0,8 + 1,0 1,0 + 1,2 1,2 + 1,6 2,4 + 3,2	<b>Ersatzset:</b> <b>Spare set:</b> 092-000869-00000 092-000848-00000 092-000849-00000 092-000870-00000	<b>Umrüstset:</b> <b>Conversion set:</b> 092-000867-00000 092-000846-00000 092-000847-00000 092-000868-00000	
<b>U-Nut gerändelt: Füll-/Röhrchendraht</b> „Option U-Nut gerändelt“, oben verzahnt, ohne Nut gerändelt, Rollenbezeichnung: „1,0-1,2 R“		<b>knurled U-groove: Cored wire</b> "Option knurled U-groove", on the top geared, without knurled groove, rolls description: "1,0-1,2 R"	
<b>Antriebsrollen- Ø (b):</b> <b>Drive rolls- Ø (b):</b> 0,8 / 0,9 + 0,8 / 0,9 1,0 / 1,2 + 1,4 / 1,6 1,4 / 1,6 + 2,0 / 2,4 2,8 + 3,2	<b>Ersatzset:</b> <b>Spare set:</b> 092-000834-00000 092-000835-00000 092-000836-00000 092-000837-00000	<b>Umrüstset:</b> <b>Conversion set:</b> 092-000830-00000 092-000831-00000 092-000832-00000 092-000833-00000	
Gegendruckrollenset (a): <i>Set of counterpressure rolls (a):</i> 092-000838-00000			

Figure 10-1

## 11 Appendix A

### 11.1 JOB-List

ewm® JOB-LIST 094-015122-00502						
● Massivdraht / Solid Wire	Material	Gas	Ø Wire			
			0,8	1,0	1,2	1,6
	Job-Nr.					
SG2/3 G3/4 Si1	CO <sub>2</sub> 100 / C1		1	3	4	5
	Ar80-90 / M2		6	8	9	10
CrNi	Ar91-99 / M12-M13		34	35	36	37
	Ar/He / I3		42	43	44	45
CuSi	Ar100 / I1		98	99	100	101
CuAl	Ar100 / I1		106	107	108	109
CuSi Löten / Brazing	Ar100 / I1		114	115	116	117
	Ar91-99 / M12-M13		110	111	112	113
CuAl Löten / Brazing	Ar100 / I1		122	123	124	125
	Ar91-99 / M12-M13		118	119	120	121
AlMg	Ar100 / I1		74	75	76	77
	Ar/He / I3		78	79	80	81
AlSi	Ar100 / I1		82	83	84	85
	Ar/He / I3		86	87	88	89
Al99	Ar100 / I1		90	91	92	93
	Ar/He / I3		94	95	96	97
● Fülldraht / Flux-Cored	Material	Gas	Ø Wire			
			0,8	1,0	1,2	1,6
	Job-Nr.					
SG2/3 G3/4 Si1 Metal	Ar80-90 / M2		235	237	238	239
SG2/3 G3/4 Si1 Rutil / Basic	Ar80-90 / M2		240	242	243	244
CrNi Metal	Ar91-99 / M12-M13		227	228	229	230
CrNi Rutil / Basic	Ar98/2 / M13		231	232	233	234
	Ar92/8 / M22		210	211	212	213
● forceArc	Material	Gas	Ø Wire			
			0,8	1,0	1,2	1,6
	Job-Nr.					
SG2/3 G3/4 Si1	Ar91-99 / M12-M13		190	254	255	256
	Ar80-90 / M2		189	179	180	181
CrNi	Ar91-99 / M12-M13		251	252	253	
AlMg	Ar100 / I1				247	248
AlSi	Ar100 / I1				249	250
Al99	Ar100 / I1				245	246
SP1			129			
SP2			130			
SP3			131			
GMAW non synergic <8m / min			188			
GMAW non synergic >8m / min			187			
Fugen / gouging			126			
WIG / TIG			127			
E-Hand / MMA			128			

ewm® JOB-LIST 094-015723-00500						
● rootArc	Material	Gas	Ø Wire			
			0,8	1,0	1,2	1,6
	Job-Nr.					
SG2/3 G3/4 Si1	CO <sub>2</sub> 100 / C1		204	205		
	Ar80-90 / M2		206	207		

Figure 11-1

## 12 Appendix B

### 12.1 Overview of EWM branches

#### Headquarters

**EWM HIGHTEC WELDING GmbH**

Dr. Günter-Henle-Straße 8  
56271 Mündersbach · Germany  
Tel: +49 2680 181-0 · Fax: -244  
www.ewm-group.com · info@ewm-group.com

#### Technology centre

**EWM HIGHTEC WELDING GmbH**

Forststr. 7-13  
56271 Mündersbach · Germany  
Tel: +49 2680 181-0 · Fax: -144  
www.ewm-group.com · info@ewm-group.com



#### Production, Sales and Service

**EWM HIGHTEC WELDING GmbH**

Dr. Günter-Henle-Straße 8  
56271 Mündersbach · Germany  
Tel: +49 2680 181-0 · Fax: -244  
www.ewm-group.com · info@ewm-group.com

**EWM HIGHTEC WELDING (Kunshan) Ltd.**

10 Yuanshan Road, Kunshan · New & High-tech Industry Development Zone  
Kunshan · Jiangsu · 215300 · People's Republic of China  
Tel: +86 512 57867-188 · Fax: -182  
www.ewm-kunshan.cn · info@ewm-kunshan.cn

**EWM HIGHTEC WELDING AUTOMATION GmbH**

Boxbachweg 4  
08606 Oelsnitz/V. · Germany  
Tel: +49 37421 20-300 · Fax: -318  
www.ewm-automation.de · info@ewm-automation.de

**EWM HIGHTEC WELDING s.r.o.**

Tr. 9. května 718 / 31  
407 53 Jiríkov · Czech Republic  
Tel: +420 412 358-551 · Fax: -504  
www.ewm-jiríkov.cz · info@ewm-jiríkov.cz

#### Sales and Service Germany

**EWM HIGHTEC WELDING GmbH**

Vertriebs- und Technologiezentrum  
Grünauer Fenn 4  
14712 Rathenow · Tel: +49 3385 49402-0 · Fax: -20  
www.ewm-rathenow.de · info@ewm-rathenow.de

**EWM HIGHTEC WELDING GmbH**

Lindenstraße 1a  
38723 Seesen-Rhüden · Tel: +49 5384 90798-0 · Fax: -20  
www.ewm-seesen.de · info@ewm-seesen.de

**EWM HIGHTEC WELDING GmbH**

Sachsstraße 28  
50259 Pulheim · Tel: +49 2234 697-047 · Fax: -048  
www.ewm-pulheim.de · info@ewm-pulheim.de

**EWM HIGHTEC WELDING GmbH**

In der Florinskaul 14-16  
56218 Mülheim-Kärlich · Tel: +49 261 988898-0 · Fax: -20  
www.ewm-muelheim-kaerlich.de · info@ewm-muelheim-kaerlich.de

**EWM HIGHTEC WELDING GmbH**

Sälzerstr. 20  
56235 Ransbach-Baumbach · Tel: +49 261 2623 9276-0 · Fax: -244  
www.ewm-ransbach-baumbach.de · info@ewm-ransbach-baumbach.de

**EWM HIGHTEC WELDING GmbH**

Eiserfelder Straße 300  
57080 Siegen · Tel: +49 271 3878103-0 · Fax: -9  
www.ewm-siegen.de · info@ewm-siegen.de

**EWM HIGHTEC WELDING GmbH**

Vertriebs- und Technologiezentrum  
Draisstraße 2a  
69469 Weinheim · Tel: +49 6201 84557-0 · Fax: -20  
www.ewm-weinheim.de · info@ewm-weinheim.de

**EWM Schweißtechnik Handels GmbH**

Rittergasse 1  
89143 Blaubeuren · Tel: +49 7344 9191-75 · Fax: -77  
www.ewm-blaubeuren.de · info@ewm-blaubeuren.de

**EWM Schweißtechnik Handels GmbH**

Heinkelstraße 8  
89231 Neu-Ulm · Tel: +49 731 7047939-0 · Fax: -15  
www.ewm-neu-ulm.de · info@ewm-neu-ulm.de

**EWM HIGHTEC WELDING AUTOMATION GmbH**

Steinfeldstrasse 15  
90425 Nürnberg · Tel: +49 911 3841-727 · Fax: -728  
www.ewm-automation.de · info@ewm-automation.de

#### Sales and Service International

**EWM HIGHTEC WELDING GmbH**

Fichtenweg 1  
4810 Gmunden · Austria · Tel: +43 7612 778 02-0 · Fax: -20  
www.ewm-gmunden.at · info@ewm-gmunden.at

**EWM HIGHTEC WELDING UK Ltd.**

Unit 2B Coopies Way · Coopies Lane Industrial Estate  
Morpeth · Northumberland · NE61 6JN · Great Britain  
Tel: +44 1670 505875 · Fax: -514305  
www.ewm-morpeth.co.uk · info@ewm-morpeth.co.uk

**EWM HIGHTEC WELDING (Kunshan) Ltd.**

10 Yuanshan Road, Kunshan · New & High-tech Industry Development Zone  
Kunshan · Jiangsu · 215300 · People's Republic of China  
Tel: +86 512 57867-188 · Fax: -182  
www.ewm-kunshan.cn · info@ewm-kunshan.cn

**EWM HIGHTEC WELDING Sales s.r.o. / Prodejní a poradenské centrum**

Týršova 2106  
256 01 Benešov u Prahy · Czech Republic  
Tel: +420 317 729-517 · Fax: -712  
www.ewm-benesov.cz · info@ewm-benesov.cz

**EWM HIGHTEC WELDING FZCO / Regional Office Middle East**

LOB 21 G 16 · P.O. Box 262851  
Jebel Ali Free Zone · Dubai, UAE · United Arab Emirates  
Tel: +971 48870-322 · Fax: -323  
www.ewm-dubai.ae · info@ewm-dubai.ae

