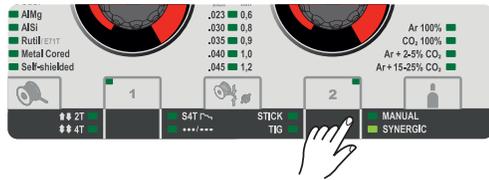




Safety

Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online. This document does not describe all the functions of the device. For a complete description of the device, refer to the Operating Instructions.

1 Set the synergic welding process



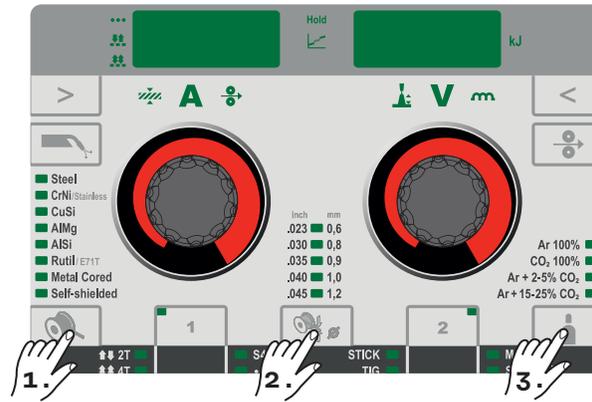
Synergic When setting a welding power parameter, the remaining parameters are set automatically.

Stick MMA welding

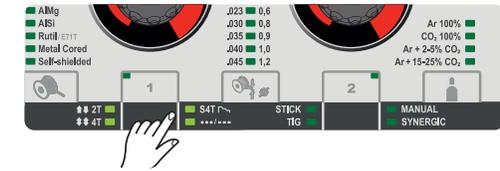
TIG TIG Welding

Manual The welding power parameters can be adjusted individually.

2 Set the filler metal and shielding gas



3 Set the operating mode



2T 2-step mode: short weld seams, tacking work

4T 4-step mode: longer weld seams, high level of comfort

S4T Special 4-step mode: additional settings for starting and final current

Spot welding: for overlapping sheets / stitch welding: light-gauge sheet metal welding and air-gap bridging

4 Set the welding power



Sheet thickness

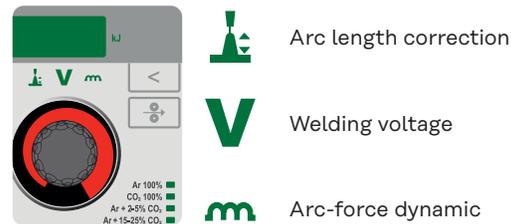
A Welding current

Wire speed

> select desired parameter

Rotary knob set desired parameter

5 Set the correction parameters



Arc length correction

V Welding voltage

m Arc-force dynamic

< select desired parameter

Rotary knob set desired parameter

6 Optimize welding results

1. Measure the welding circuit resistance r
2. Set the mains fuse so that the device switches off before the mains fuse trips.

The description of the aforementioned measures can be found in the Operating Instructions of the power source.

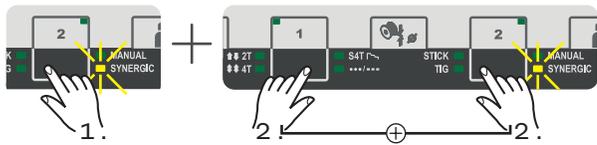
i Operating Instructions



<https://manuals.fronius.com/html/4204260241>



MIG/MAG Synergic Setup Menu



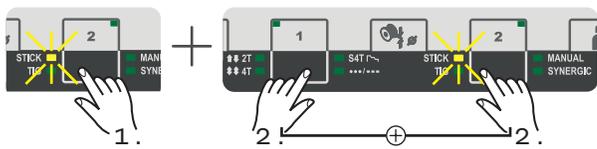
Setup Menu 1st Level

- G P r* Gas pre-flow time
- G P o* Gas post-flow time
- S L* Slope (2-step, special 4-step)
- I - S* Starting current (2-step, special 4-step)
- I - E* Final current (2-step, special 4-step)
- t - S* Starting current duration (2-step)
- t - E* Final current duration (2-step)
- F d i* Wire threading speed
- I t o* Length of wire that is fed before the safety cut-out trips
- S P t* Spot welding time/stitch welding time
- S P b* Interval pause time
- I n t* Operating mode for stitch welding
- F A C* Restore factory setup

2nd Setup Menu 2nd Level

- S E t* Country-specific setting
- r* Welding circuit resistance
- L* Welding circuit inductivity
- E n E* Real Energy Input
- F U S* Mains fuse protection
- A L C* Arc length correction display

MMA Setup Menu



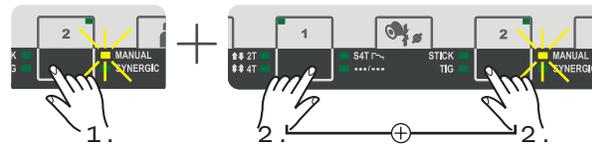
Setup Menu 1st Level

- H C U* HotStart current
- H t i* HotStart time
- A S t* Anti-Stick
- F A C* Restore factory setup

2nd Setup Menu 2nd Level

- S E t* Country-specific setting
- r* Welding circuit resistance
- L* Welding circuit inductivity
- F U S* Mains fuse protection

MIG/MAG Manual Setup Menu



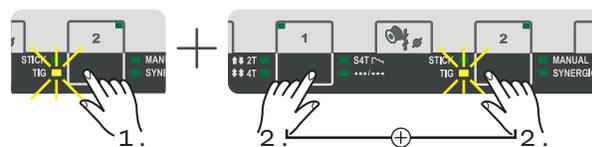
Setup Menu 1st Level

- G P r* Gas pre-flow time
- G P o* Gas post-flow time
- F d i* Wire threading speed
- I G c* Trigger current
- I t o* Length of wire that is fed before the safety cut-out trips
- S P t* Spot welding time/stitch welding time
- S P b* Interval pause time
- I n t* Operating mode for stitch welding
- F A C* Restore factory setup

2nd Setup Menu 2nd Level

- S E t* Country-specific setting
- r* Welding circuit resistance
- L* Welding circuit inductivity
- E n E* Real Energy Input
- F U S* Mains fuse protection

TIG Setup Menu



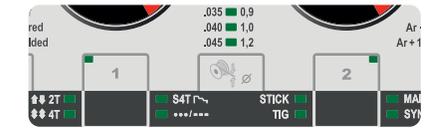
Setup Menu 1st Level

- F - P* Pulse frequency
- t U P* UpSlope
- t d o* DownSlope
- I - S* Starting current
- I - 2* Reduced current
- I - E* Final current
- G P o* Gas post-flow time
- t A C* Tacking
- F A C* Restore factory setup

2nd Setup Menu 2nd Level

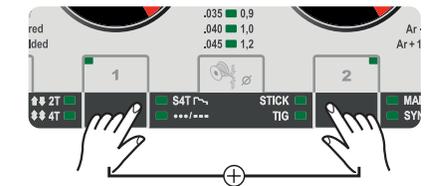
- S E t* Country-specific setting
- F U S* Mains fuse protection

EasyJobs

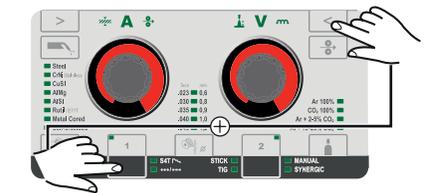


- Retrieve 1x 163
- Save Pro 180
- Delete CLR

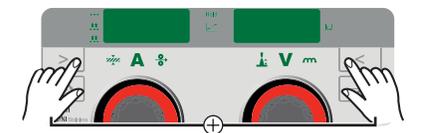
Exiting the Setup Menu



Activating/Deactivating the Key Lock



Displaying Service Parameters



- | Available parameters: | Example of display: |
|---|---------------------|
| Firmware version | 1.00 421 |
| Welding program configuration | 3 445 |
| Current welding program | r 2 290 |
| Arc time in hours | 654 321 |
| Motor current for wire drive in amperes | i Fd 00 |
| 2nd menu level (service) | 2nd |