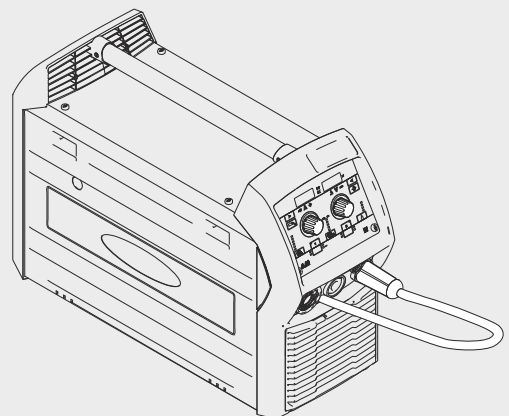




## TransSteel 2200

EN-US

Operating instructions



42,0426,0241,EA 018-19012022



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# Safety Instructions

## Explanation of Safety Instructions

### **DANGER!**

Indicates an immediate danger.

- ▶ Death or serious injury may result if appropriate precautions are not taken.

### **WARNING!**

Indicates a possibly dangerous situation.

- ▶ Death or serious injury may result if appropriate precautions are not taken.

### **CAUTION!**

Indicates a situation where damage or injury could occur.

- ▶ Minor injury or damage to property may result if appropriate precautions are not taken.

### **NOTE!**

Indicates the possibility of flawed results and damage to the equipment.

## General

The device has been manufactured using state-of-the-art technology and according to recognized safety standards. If used incorrectly or misused, however, it can cause

- Injury or death to the operator or a third party
- Damage to the device and other material assets belonging to the operating company
- Inefficient operation of the equipment

All persons involved in the commissioning, operation, maintenance, and servicing of the device must

- Be suitably qualified
- Have knowledge of welding
- Have completely read and followed these Operating Instructions

The Operating Instructions must always be at hand wherever the device is being used. In addition to the Operating Instructions, all applicable local rules and regulations regarding accident prevention and environmental protection must also be followed.

All safety and danger notices on the device must

- Be kept in a legible state
- Not be damaged/marked
- Not be removed
- Not be covered, pasted, or painted over

For the location of the safety and danger notices on the device, refer to the section headed "General" in the Operating Instructions for the device.

Before switching on the device, remove any faults that could compromise safety.

**Your personal safety is at stake!**

## Intended Use

The device is to be used exclusively for its intended purpose.

The device is intended exclusively for the welding process specified on the rating plate. Utilization for any other purpose, or in any other manner, shall be deemed to be "not in accordance with the intended purpose." The manufacturer is not responsible for any damage resulting from improper use.

---

Proper use also means

- Completely reading and obeying all instructions in the Operating Instructions
  - Completely reading and obeying all safety instructions and danger notices
  - Carrying out all the specified inspection and servicing work
- 

Never use the device for the following applications:

- Thawing pipes
  - Charging batteries
  - Starting motors
- 

The device is designed for operation in industry and business. The manufacturer shall not be liable for any damage resulting from use in a living area.

---

The manufacturer shall also not be liable for faulty or incorrect work results.

---

## Grid Connection

Devices with a high output can influence the energy quality of the grid due to their current consumption.

---

This may affect a number of device types in terms of:

- connection restrictions
- criteria regarding maximum permissible grid impedance \*)
- criteria regarding the minimum required short-circuit power \*)

\*) both at the interface with the public grid

See technical data

---

In this case, the operator or the person using the device should check whether or not the device is allowed to be connected, where appropriate through discussion with the power supply company.

---

**IMPORTANT!** Ensure secure grounding of the grid connection!

---

## Environmental Conditions

Operation or storage of the device outside the stipulated area will be deemed as not in accordance with the intended purpose. The manufacturer accepts no liability for any damage resulting from improper use.

---

Temperature range of the ambient air:

- During operation: -10°C to +40°C (14°F to 104°F)
  - During transport and storage: -20°C to +55°C (-4°F to 131°F)
- 

Relative humidity:

- Up to 50% at 40°C (104°F)
  - Up to 90% at 20°C (68°F)
- 

Ambient air: free of dust, acids, corrosive gases or substances, etc.

Altitude above sea level: up to 2000 m (6561 ft. 8.16 in.)

---



<b>Obligations of the Operating Company</b>	<p>The operating company must only allow persons to work with the device if they</p> <ul style="list-style-type: none"> <li>- Are familiar with the basic occupational safety and accident prevention regulations and are trained in handling the device</li> <li>- Have read and understood these Operating Instructions, especially the section "Safety Rules," and have confirmed this with their signature</li> <li>- Are trained according to the requirements for the work results</li> </ul> <hr/> <p>The safety-conscious work of the personnel must be checked regularly.</p>
<b>Obligations of Personnel</b>	<p>All persons who are assigned to work with the device must do the following before beginning the work:</p> <ul style="list-style-type: none"> <li>- Follow the basic regulations for occupational safety and accident prevention</li> <li>- Read these Operating Instructions, especially the section "Safety Rules," and confirm that they have understood and will follow them by signing</li> </ul> <hr/> <p>Before leaving the workplace, ensure that no personal injury or property damage can occur in one's absence.</p>
<b>Residual current circuit breaker</b>	<p>Local regulations and national guidelines may mean that a residual current circuit breaker is required when connecting a device to the public grid.</p> <p>The residual current circuit breaker recommended for the device by the manufacturer can be found in the technical data.</p>
<b>Personal Protection and Protection of Others</b>	<p>You are exposed to numerous hazards while handling the device, for example:</p> <ul style="list-style-type: none"> <li>- Flying sparks and pieces of hot metal</li> <li>- Arc radiation that poses a risk of injury to the eyes and skin</li> <li>- Hazardous electromagnetic fields that pose a risk of death for individuals with pacemakers</li> <li>- Electrical risks from grid current and welding current</li> <li>- Increased noise exposure</li> <li>- Harmful welding fumes and gases</li> </ul> <hr/> <p>Wear suitable protective clothing when dealing with the device. The protective clothing must have the following properties:</p> <ul style="list-style-type: none"> <li>- Flame resistant</li> <li>- Insulating and dry</li> <li>- Covering the entire body and in good condition with no damage</li> <li>- Safety helmet</li> <li>- Cuffless pants</li> </ul> <hr/> <p>Protective clothing involves the following:</p> <ul style="list-style-type: none"> <li>- Protecting the face and eyes from UV radiation, heat and flying sparks with a face guard featuring a regulation-compliant filter</li> <li>- Wearing regulation-compliant protective goggles with side protection behind the face guard</li> <li>- Wearing rigid, wet-insulating footwear</li> <li>- Protecting hands with appropriate gloves (featuring electrical insulation and thermal protection)</li> <li>- Wearing ear protection to reduce noise exposure and protect against injury</li> </ul>

Keep persons, especially children, away during the operation of the devices and during the welding process. If persons are in the vicinity, however:

- Instruct them about all hazards (blinding hazard due to arcs, risk of injury from flying sparks, welding fumes hazardous to health, noise exposure, possible hazard due to grid current or welding current, etc.)
- Provide suitable protective equipment or
- Construct suitable protective walls and curtains.

---

**Data on noise emission values**

The device produces a maximum noise level of <80 dB(A) (ref. 1pW) when idling and in the cooling phase following operation in relation to the maximum permitted operating point at standard loading in accordance with EN 60974-1.

---

A workplace-specific emission value for welding (and cutting) cannot be specified because this value depends on the welding process and the environmental conditions. It is influenced by a wide range of parameters, such as the welding process itself (MIG/MAG, TIG welding), the selected current type (direct current, alternating current), the power range, the type of weld metal, the resonance properties of the workpiece, the workplace environment, and many other factors.

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**Danger from toxic gases and vapors**

The fumes produced during welding contain toxic gases and vapors.

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Welding fumes contain substances that cause cancer, as stated in monograph 118 from the International Agency for Research on Cancer.

---

Use at-source extraction source and a room extraction system.  
If possible, use a welding torch with an integrated extraction device.

---

Keep your head out of the welding fumes and gases.

---

Take the following precautionary measures for fumes and harmful gases:

- Do not breathe them in.
- Extract them from the work area using appropriate equipment.

---

Ensure that there is a sufficient supply of fresh air. Ensure that there is a ventilation flow rate of at least 20 m<sup>3</sup> per hour.

---

Use a welding helmet with air supply if there is insufficient ventilation.

---

If there is uncertainty as to whether the extraction capacity is sufficient, compare the measured toxic emission values against the permissible limit values.

---

The following components are factors that determine how toxic the welding fumes are:

- The metals used for the workpiece
- Electrodes
- Coatings
- Cleaning agents, degreasers, and the like
- The welding process used

---

Consult the corresponding material safety data sheets and manufacturer's instructions for the components listed above.

---

Recommendations for exposure scenarios, risk management measures and identifying working conditions can be found on the European Welding Association website under Health & Safety (<https://european-welding.org>).

---

Keep flammable vapors (such as solvent vapors) out of the arc radiation range.

---

When no welding is taking place, close the valve of the shielding gas cylinder or the main gas supply.

---

## Danger from Flying Sparks

Flying sparks can cause fires and explosions.

Never undertake welding near flammable materials.

Flammable materials must be kept at least 11 meters (36 ft. 1.07 in.) from the arc or protected with a certified cover.

Keep suitable, tested fire extinguishers on hand.

Sparks and pieces of hot metal may also get into surrounding areas through small cracks and openings. Take appropriate measures to ensure that there is no risk of injury or fire.

Do not undertake welding in areas at risk of fire and explosion, or on sealed tanks, drums, or pipes if these have not been prepared in accordance with corresponding national and international standards.

Do not undertake welding on containers in which gases, fuels, mineral oils, and the like are/were stored. Residues pose a risk of explosion.

## Risks from grid current and welding current

An electric shock can be fatal.

Do not touch voltage-carrying parts inside or outside the device.

During MIG/MAG welding and TIG welding, the welding wire, the wirepool, the feed rollers, as well as all pieces of metal that are in contact with the welding wire, are live.

Always place the wirefeeder on a sufficiently insulated base or use a suitable insulating wirefeeder holder.

Ensure suitable personal protection with dry temporary backing or cover with sufficient insulation against the ground potential. The temporary backing or cover must completely cover the entire area between the body and the ground potential.

All cables and leads must be secured, undamaged, insulated, and adequately dimensioned. Replace loose connections and scorched, damaged, or inadequately dimensioned cables and leads immediately.

Before every use, check power connections for secure fit by hand.

In the case of power cables with bayonet connectors, turn the power cable by at least 180° around the longitudinal axis and pretension.

Do not wrap cables or leads around your body or parts of the body.

Concerning the electrode (rod electrode, tungsten electrode, welding wire, etc.)

- Never immerse it in liquids to cool it
- Never touch it when the power source is switched on.

The open circuit voltage of a welding system may double, for example, between the electrodes of two welding systems. Touching the potentials of both electrodes at the same time may be life-threatening in some cases.

Have the grid and device supply lead regularly inspected by an electrician to ensure that the ground conductor is functioning properly.

Protection class I devices require a grid with a ground conductor and a connector system with ground conductor contact for proper operation.

Operation of the device on a grid without a ground conductor and on a socket without a ground conductor contact is only permitted if all national regulations for protective separation are observed.

Otherwise, this is considered gross negligence. The manufacturer accepts no liability for any damage resulting from improper use.

Use suitable equipment to ensure that the workpiece is sufficiently grounded if necessary.

---

Switch off unused devices.

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When working at elevated heights, wear a safety harness to prevent falls.

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Before working on the device, switch off the device and remove the grid plug.

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Secure the device to prevent the grid plug from being connected and switched on again by applying a clearly legible and understandable warning sign.

---

After opening the device:

- Discharge all electrically charged components
  - Ensure that all components are disconnected from the power supply.
- 

If work is needed on voltage-carrying parts, bring in a second person who will switch off the main switch at the correct time.

---

### **Stray welding currents**

If the following instructions are not observed, stray welding currents may occur, which pose a risk of the following:

- Fire
  - Overheating of components connected to the workpiece
  - Destruction of ground conductors
  - Damage to the device and other electrical equipment
- 

Ensure that the workpiece terminal is securely connected to the workpiece.

---

Secure the workpiece terminal as close to the spot to be welded as possible.

---

Position the device with sufficient insulation against electrically conductive environments, e.g., insulation against electrically conductive floors or electrically conductive mounts.

---

Observe the following when using electrical distributors, double-headed retainers, etc.: Even the electrode of the welding torch/electrode holder not in use carries electric potential. Ensure that there is sufficient insulation when the unused welding torch/electrode holder is stored.

---

In automated MIG/MAG applications, only guide the wire electrode from the welding wire drum, large spool or wirepool to the wirefeeder with insulation.

---

### **EMC Device Classifications**

Devices in emission class A:

- Are only designed for use in industrial settings
  - Can cause line-bound and radiated interference in other areas
- 

Devices in emission class B:

- Satisfy the emissions criteria for residential and industrial areas. This is also true for residential areas in which the energy is supplied from the public low-voltage grid.
- 

EMC device classification as per the rating plate or technical data.

---

### **EMC measures**

In certain cases, even though a device complies with the standard limit values for emissions, it may affect the application area for which it was designed (e.g., when there is sensitive equipment at the same location, or if the site where the device is installed is close to either radio or television receivers).

If this is the case, then the operating company is obliged to take appropriate action to rectify the situation.

---

Test and assess the immunity of equipment in the vicinity of the device in accordance with national and international provisions. Examples of interference-prone equipment that could be affected by the device:

- Safety devices
- Grid power lines, signal lines, and data transfer lines
- IT and telecommunications equipment
- Devices for measuring and calibrating

---

Supporting measures to avoid EMC problems:

1. Grid power supply
  - If electromagnetic interference occurs despite a grid connection that complies with regulations, take additional measures (e.g., use a suitable grid filter).
2. Welding power-leads
  - Keep them as short as possible
  - Route them close together (also to avoid EMF problems)
  - Route them far from other lines
3. Equipotential bonding
4. Workpiece grounding
  - If necessary, establish grounding using suitable capacitors.
5. Shield, if necessary
  - Shield other devices in the vicinity
  - Shield the entire welding installation

---

#### EMF measures

Electromagnetic fields may cause health problems that are not yet known:

- Effects on the health of persons close by, e.g., those with pacemakers and hearing aids
- Persons with pacemakers must seek advice from their doctor before staying in the immediate vicinity of the device and the welding process
- Keep distances between welding power-leads and the head/torso of the welder as great as possible for safety reasons
- Do not carry welding power-leads and hosepacks over your shoulder or wrap them around your body or body parts

---

#### Particular hazard areas

Keep hands, hair, loose clothing, and tools away from moving parts, such as:

- Fans
- Gears
- Rollers
- Shafts
- Wirespools and welding wires

---

Do not reach into rotating gears of the wire drive or into rotating drive parts.

---

Covers and side panels must only be opened/removed during maintenance and repair work.

---

During operation

- Ensure that all covers are closed, and all side parts have been mounted properly.
- Keep all covers and side parts closed.

---

The protrusion of welding wire from the welding torch represents a high risk of injury (cuts to the hand, facial and eye injuries, etc.).

---

Therefore, always hold the welding torch away from the body (devices with wirefeeder) and use suitable protective goggles.

---

Do not touch the workpiece during or after welding – risk of burns.

---

Slag may fly off cooling workpieces. Therefore, also wear regulation-compliant protective equipment when reworking workpieces and ensure that other persons are sufficiently protected.

---

Leave the welding torch and other parts with a high operating temperature to cool before working on them.

---

Special regulations apply in areas at risk of fire or explosion  
– follow the appropriate national and international regulations.

---

Power sources for work in areas with increased electrical hazard (e.g., boilers) must be labeled with the symbol (Safety). However, the power source may not be located in such areas.

---

Risk of scalding due to leaking coolant. Switch off the cooling unit before disconnecting connections for the coolant supply or return.

---

When handling coolant, observe the information on the coolant safety data sheet. The coolant safety data sheet can be obtained from your service center or via the manufacturer's website.

---

Only use suitable load-carrying equipment from the manufacturer to transport devices by crane.

- Attach chains or ropes to all designated attachments of the suitable load-carrying equipment.
  - Chains or ropes must be the smallest angle possible from vertical.
  - Remove gas cylinder and wirefeeder (MIG/MAG and TIG devices).
- 

In the event of crane attachment of the wirefeeder during welding, always use a suitable, insulating wirefeeder hoisting attachment (MIG/MAG and TIG devices).

---

If the device is equipped with a carrier belt or handle, then this is used exclusively for transport by hand. The carrier belt is not suitable for transport by crane, counterbalanced lift truck, or other mechanical lifting tools.

---

All lifting equipment (belts, buckles, chains, etc.), which is used in association with the device or its components, must be checked regularly (e.g., for mechanical damage, corrosion, or changes due to other environmental influences).

The test interval and scope must at least comply with the respective valid national standards and guidelines.

---

There is a risk of colorless, odorless shielding gas escaping without notice if an adapter is used for the shielding gas connection. Use suitable Teflon tape to seal the thread of the shielding gas connection adapter on the device side before installation.

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### **Requirement for the shielding gas**

Especially with ring lines, contaminated shielding gas can cause damage to equipment and reduce welding quality.

Meet the following requirements regarding shielding gas quality:

- Solid particle size < 40 µm
  - Pressure condensation point < -20 °C
  - Max. oil content < 25 mg/m<sup>3</sup>
- 

Use filters if necessary.

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### **Danger from Shielding Gas Cylinders**

Shielding gas cylinders contain compressed gas and may explode if damaged. Shielding gas cylinders are an integral part of the welding equipment, so they must be handled very carefully.

---

Protect shielding gas cylinders with compressed gas from excessive heat, mechanical impact, slag, open flames, sparks, and arcs.

---

---

Mount the shielding gas cylinders vertically and secure them in accordance with instructions so they cannot fall over.

---

Keep shielding gas cylinders away from welding or other electrical circuits.

---

Never hang a welding torch on a shielding gas cylinder.

---

Never touch a shielding gas cylinder with an electrode.

---

Risk of explosion: Never weld on a compressed shielding gas cylinder.

---

Always use suitable shielding gas cylinders for the application in question and the correct matching accessories (controller, hoses, and fittings, etc.) Only use shielding gas cylinders and accessories that are in good condition.

---

If a valve on a shielding gas cylinder is open, turn your face away from the outlet.

---

When no welding is taking place, close the valve of the shielding gas cylinder.

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Leave the cap on the valve of the shielding gas cylinder when the cylinder is not connected.

---

Follow the manufacturer's instructions and applicable national and international provisions for shielding gas cylinders and accessories.

---

### **Danger Posed by Shielding Gas Leak**

Risk of asphyxiation due to uncontrolled shielding gas leak

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Shielding gas is colorless and odorless and may suppress the oxygen in the ambient air in the event of leakage.

- Ensure there is a sufficient supply of fresh air with a ventilation flow rate of at least 20 m<sup>3</sup> per hour.
  - Please observe the safety and maintenance information for the shielding gas cylinder or the main gas supply.
  - When no welding is taking place, close the valve of the shielding gas cylinder or the main gas supply.
  - Always check the shielding gas cylinder or main gas supply for uncontrolled gas leakage before each start-up.
- 

### **Safety Measures at the Setup Location and During Transport**

A toppling device can be deadly! Set up the device securely on an even, solid surface

- The maximum permitted tilt angle is 10°.

---

Special regulations apply in areas at risk of fire or explosion

- Follow the appropriate national and international regulations.
- 

Use instructions and checks within the company to ensure that the vicinity of the workplace is always clean and organized.

---

Only set up and operate the device in accordance with the protection class shown on the rating plate.

---

When setting up the device, ensure that there is an all-round clearance of 0.5 m (1 ft. 7.69 in.) to allow cooling air to circulate unhindered.

---

Take care to ensure that the applicable national and regional guidelines and accident prevention regulations are observed when transporting the device, especially guidelines concerning hazards during transport and shipment.

---

Do not lift or transport any active devices. Switch off devices before transport or lifting.

---

Before transporting the device, completely drain the coolant and dismantle the following components:

- wirefeeder
  - wirespool
  - shielding gas cylinder
- 

It is essential to conduct a visual inspection of the device to check for damage after it has been transported but before commissioning. Have any damage repaired by trained service technicians before commissioning the device.

---

### **Safety Measures in Normal Operation**

Only operate the device when all safety devices are fully functional. If the safety devices are not fully functional, there is a danger of:

- Injury or death to the operator or a third party
  - Damage to the device and other material assets belonging to the operating company
  - Inefficient operation of the device
- 

Safety devices that are not fully functional must be repaired before the device is switched on.

---

Never bypass or disable safety devices.

---

Before switching on the device, ensure that no one can be put in danger.

---

The device must be examined at least once a week for externally detectable damage and functionality of the safety devices.

---

Always secure the shielding gas cylinder well and remove before transporting by crane.

---

Only the original coolant from the manufacturer is suitable for use in our devices due to its properties (electrical conductivity, anti-freeze, material compatibility, flammability, etc.)

---

Only use appropriate original coolant from the manufacturer.

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Do not mix original coolant from the manufacturer with other coolants.

---

Only connect system components from the manufacturer to the cooling unit circuit.

---

If there is damage due to use of other system components or other coolants, the manufacturer accepts no liability for this and all warranty claims are forfeited.

---

Cooling Liquid FCL 10/20 is not flammable. The ethanol-based coolant is flammable in certain conditions. Only transport the coolant in closed original containers and keep away from sources of ignition.

---

Properly dispose of used coolant according to national and international regulations. The coolant safety data sheet can be obtained from your service center or via the manufacturer's website.

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When the system is cool, always check the coolant level before starting welding.

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### **Maintenance and repair**

It is impossible to guarantee that bought-in parts are designed and manufactured to meet the demands made of them, or that they satisfy safety requirements.

- Use only original spare and wearing parts (also applies to standard parts).
  - Do not carry out any modifications, alterations, etc. to the device without the manufacturer's consent.
  - Components that are not in perfect condition must be replaced immediately.
  - When ordering, please give the exact designation and part number as shown in the spare parts list, as well as the serial number of your device.
- 

The housing screws provide the ground conductor connection for earthing the housing parts.



Only use original housing screws in the correct number and tightened to the specified torque.

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<b>Safety Inspection</b>	<p>The manufacturer recommends that a safety inspection of the device be performed at least every 12 months.</p> <hr/> <p>The manufacturer recommends calibrating power sources within the same 12-month interval.</p> <hr/> <p>A safety inspection by a certified electrician is recommended:</p> <ul style="list-style-type: none"> <li>- After changes</li> <li>- After alterations</li> <li>- After repair, care, and maintenance</li> <li>- At least every 12 months</li> </ul> <hr/> <p>For the safety inspection, follow the appropriate national and international standards and guidelines.</p> <hr/> <p>You can obtain more information about the safety inspection and calibration from your service center. The service center will provide the necessary documents upon request.</p>
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<b>Disposal</b>	<p>Do not dispose of this device with normal domestic waste! To comply with the European Directive on Waste Electrical and Electronic Equipment and its implementation as national law, electrical equipment that has reached the end of its life must be collected separately and returned to an approved recycling facility. Any device that you no longer require must be returned to your dealer, or you must locate the approved collection and recycling facilities in your area. Ignoring this European Directive may have potentially adverse effects on the environment and your health!</p>
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<b>Safety symbols</b>	<p>Devices with the CE label satisfy the essential requirements of the low-voltage and electromagnetic compatibility directive (e.g., relevant product standards of the EN 60974 series).</p> <p>Fronius International GmbH declares that the device complies with Directive 2014/53/EU. The full text of the EU Declaration of Conformity is available on the following website: <a href="http://www.fronius.com">http://www.fronius.com</a></p> <hr/> <p>Devices marked with the CSA test mark satisfy the requirements of the relevant standards for Canada and the USA.</p>
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<b>Data backup</b>	<p>The user is responsible for backing up any changes made to the factory settings. The manufacturer accepts no liability for any deleted personal settings.</p>
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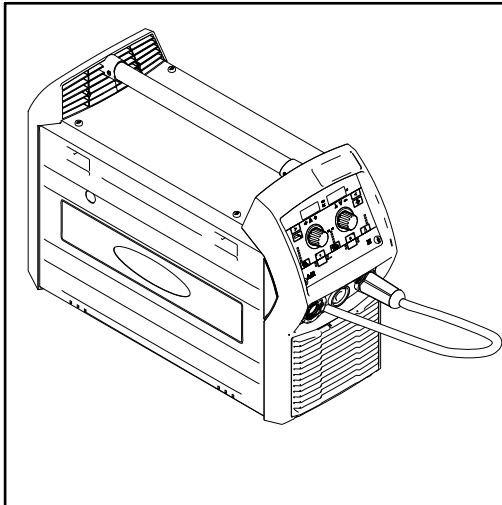
<b>Copyright</b>	<p>Copyright of these Operating Instructions remains with the manufacturer.</p> <hr/> <p>Text and illustrations were accurate at the time of printing. Fronius reserves the right to make changes. The contents of the Operating Instructions shall not provide the basis for any claims whatsoever on the part of the purchaser. If you have any suggestions for improvement, or can point out any mistakes that you have found in the Operating Instructions, we will be most grateful for your comments.</p>
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# **General information**



## Device concept



The TransSteel (TSt) 2200 power source is a completely digitized, microprocessor-controlled power source.

This power source is designed for the welding of steel and can be used for the following welding processes:

- MIG/MAG welding
- SMAW
- TIG welding with touch-down ignition

The central control and regulation unit of the power source is coupled with a digital signal processor. The central control and regulation unit and signal processor control the entire welding process.

During the welding process, the actual data is measured continuously and the device responds immediately to any changes. Control algorithms ensure that the desired target state is maintained.

## "Power limitation" function

The power source has a "Power limitation" safety feature.

This function is only available for the MIG/MAG standard synergic welding process.

### Mode of operation:

If necessary, the power source reduces the welding power to prevent the arc from being extinguished during welding at the power limit of the power source. The reduced parameters are displayed on the control panel until welding starts again or until the next parameter change.

This results in:

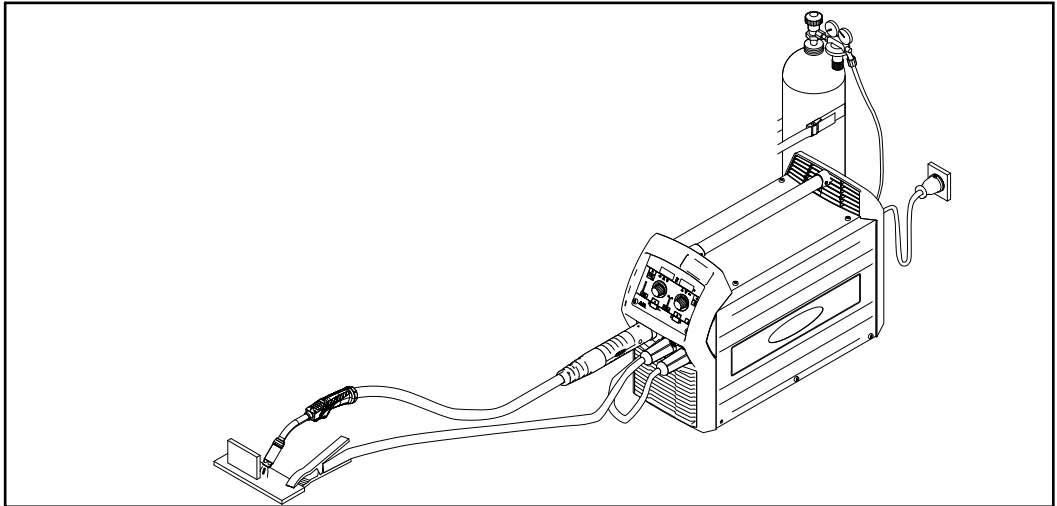
- A more precise welding process
- A high degree of reproducibility of all results
- Exceptional weld properties

As soon as the function is active, the indicator for the wire speed parameter on the control panel flashes.

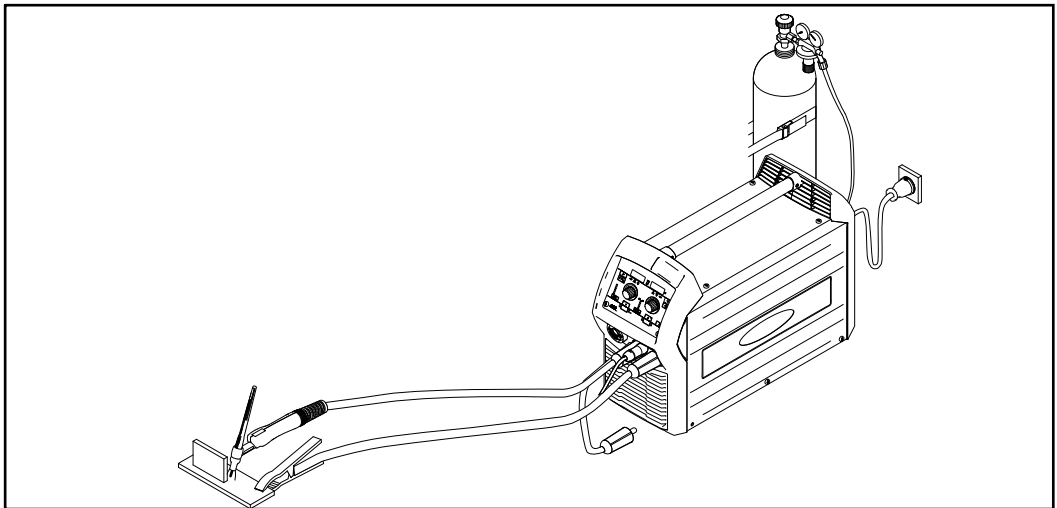


The flashing continues until the next welding start-up, or until the next parameter change.

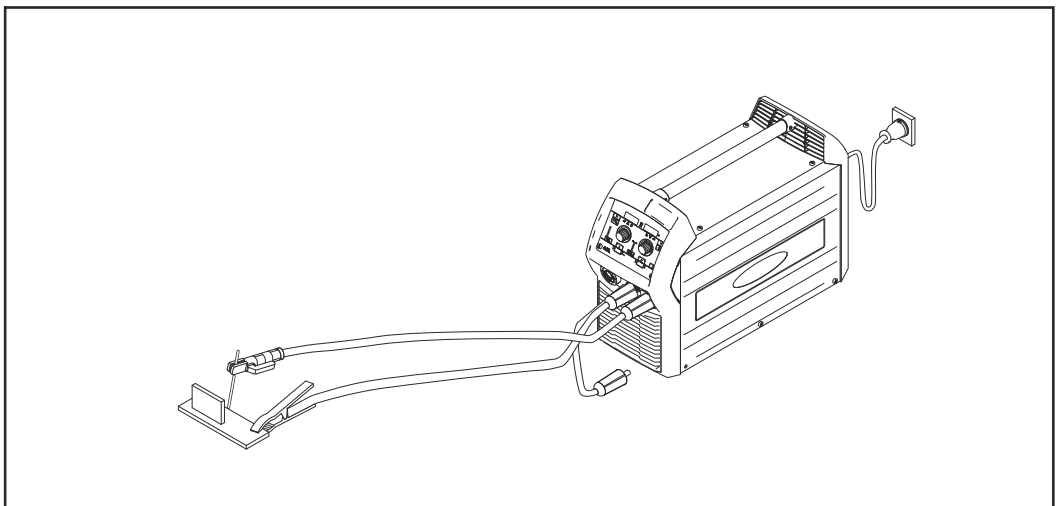
**Application areas**



*MIG/MAG welding*




*TIG welding*



*Manual metal arc welding*


**Warning notices on the device**

Warning notices and safety symbols are affixed to the power source. These warning notices and safety symbols must not be removed or painted over. They warn against incorrect operation, as this may result in serious injury and property damage.

<b>⚠ WARNING</b>			<b>ARC RAYS can burn eyes and skin; NOISE can damage hearing.</b> <ul style="list-style-type: none"> <li>Wear welding helmet with correct filter.</li> <li>Wear correct eye, ear and body protection.</li> </ul>	Read American National Standard Z49.1, "Safety in Welding and Cutting" From American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126; OSHA Safety and Health Standards, 29 CFR 1910, from U.S. Government Printing Office, Washington, DC 20402. CSA, W117-2, M87, Code for Safety in Welding and Cutting. 42.0409.5074
<b>Do not Remove, Destroy, Or Cover This Label</b>			<b>EXPLODING PARTS can injure.</b> <ul style="list-style-type: none"> <li>Failed parts can explode or cause other parts to explode when power is applied.</li> <li>Always wear a face shield and long sleeves when servicing.</li> </ul>	
<b>ARC WELDING can be hazardous.</b> <ul style="list-style-type: none"> <li>Read and follow all labels and the Owner's Manual carefully</li> <li>Only qualified persons are to install, operate, or service this unit according to all applicable codes and safety practices.</li> <li>Keep children away.</li> <li>Pacemaker wearers keep away.</li> <li>Welding wire and drive parts may be at welding voltage.</li> </ul>			<b>ELECTRIC SHOCK can kill; SIGNIFICANT DC VOLTAGE exists after removal of input power</b> <ul style="list-style-type: none"> <li>Always wait 60 seconds after power is turned off before working on unit.</li> <li>Check input capacitor voltage, and be sure it is near 0 before touching parts.</li> </ul>	
	<b>ELECTRIC SHOCK can kill.</b> <ul style="list-style-type: none"> <li>Always wear dry insulating gloves.</li> <li>Insulate yourself from work and ground.</li> <li>Do not touch live electrical parts.</li> <li>Disconnect input power before servicing.</li> <li>Keep all panels and covers securely in place.</li> </ul>	<b>⚠ AVERTISSEMENT</b>		
	<b>FUMES AND GASES can be hazardous.</b> <ul style="list-style-type: none"> <li>Keep your head out of the fumes.</li> <li>Ventilate area, or use breathing device.</li> <li>Read Material Safety Data Sheets (MSDSs) and manufacturer's instructions for materials used.</li> </ul>	<b>UN CHOC ELECTRIQUE peut etre mortel.</b> <ul style="list-style-type: none"> <li>Installation et raccordement de cette machine doivent etre conformes a tous les pertinents.</li> </ul>		
	<b>WELDING can cause fire or explosion.</b> <ul style="list-style-type: none"> <li>Do not weld near flammable material.</li> <li>Watch for fire: keep extinguisher nearby.</li> <li>Do not locate unit over combustible surfaces.</li> <li>Do not weld on closed containers.</li> </ul>	<b>SOUDEAGE A L'ARC peut etre hasardeux.</b> <ul style="list-style-type: none"> <li>Lire le manuel d' instructions avant utilisation.</li> <li>Ne pas installer sur une surface combustible.</li> <li>Les fils de soudage et pieces conductrices peuvent etre a la tension de soudage.</li> </ul>		



						42.0409.0160
1.1	1.2	1.3	1.4	1.5	1.6	
2	2.1	2.2	2.3	2.4	2.5	
3	3.1	3.2	3.3	3.4	3.5	
4	4.1	4.2	4.3	4.4	4.5	
5	5.1	5.2	5.3	5.4	5.5	
Steel: 3-4		CrNi: 3-4				
FCW: 3		Al: 1-3				
.023		0.6				
.030		0.8				
.035		0.9				
.040		1.0				
.045		1.2				



Welding is dangerous. To ensure that this device can be used correctly and safely, the following basic requirements must be met:

- Adequate welding qualifications
- Appropriate protective equipment
- Keep unauthorized people away from the power source and the welding process



Do not use the functions described here until you have fully read and understood the following documents:

- These Operating Instructions
- All system component Operating Instructions, especially the safety rules



Dispose of old devices in accordance with safety rules and not in normal domestic waste.



Keep hands, hair, loose clothing, and tools away from moving parts, such as:

- Gears
- Feed rollers
- Wirespools and wire electrodes

Do not reach into rotating gears of the wire drive or into rotating drive parts.

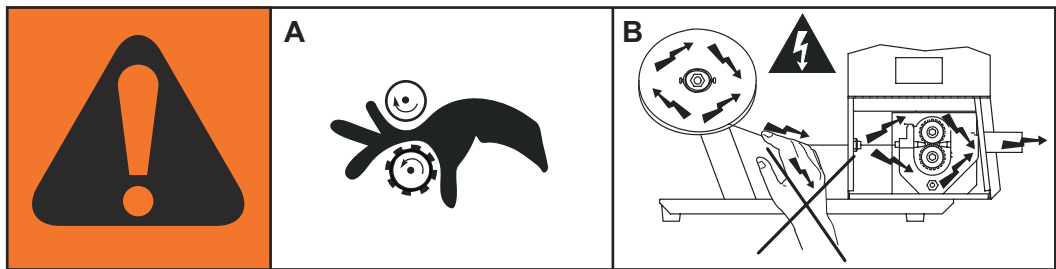
Covers and side panels must only be opened/removed during maintenance and repair work.



**Description of the warnings on the device**

Warning notices are attached to the device for certain device versions.

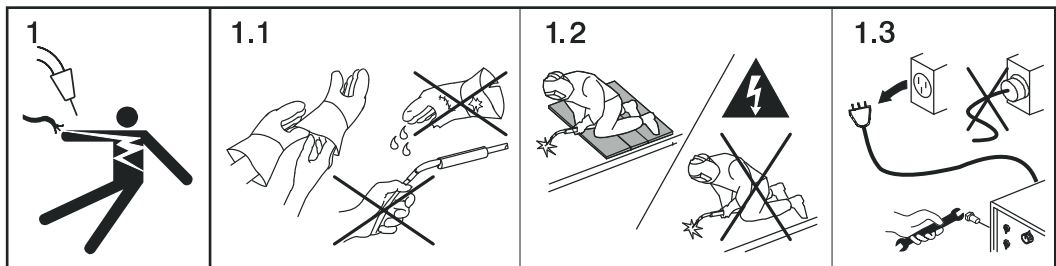
The arrangement of the symbols may vary.



**! Warning! Caution!**  
**The symbols represent possible dangers.**

A Drive rollers can injure fingers.

B The welding wire and drive parts are under welding voltage during operation. Keep hands and metal objects away!

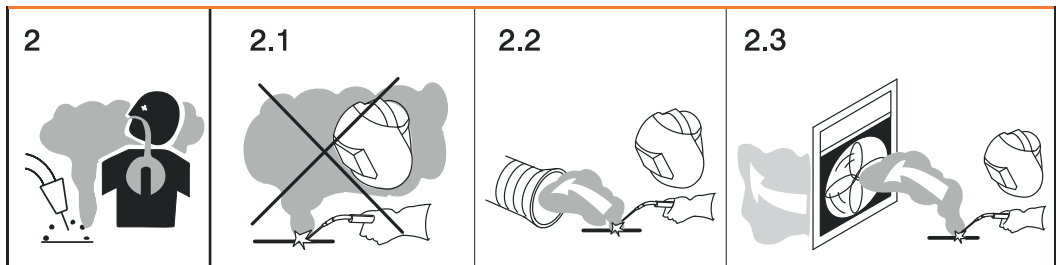


1. An electric shock can be fatal.

1.1 Wear dry, insulating gloves. Do not touch the wire electrode with bare hands. Do not wear wet or damaged gloves.

1.2 Use a base that is insulated from the floor and work area to protect against electric shock.

1.3 Before working on the device, switch off the device and remove the mains plug or disconnect the power supply.

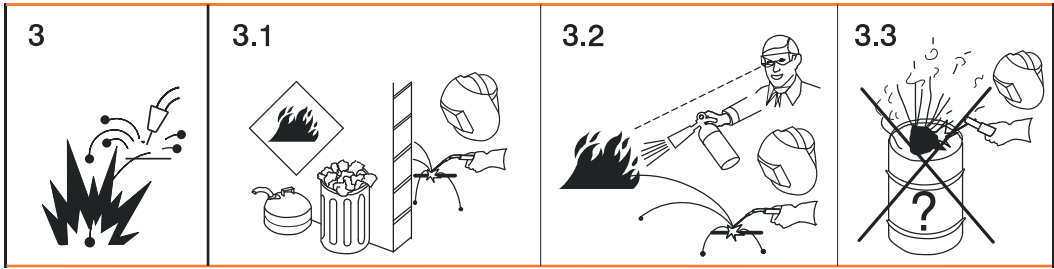


2. Inhalation of welding fumes can be harmful to health.

2.1 Keep your face away from any welding fumes.

2.2 Use forced-air ventilation or local extraction to remove welding fumes.

2.3 Remove welding fumes with a fan.

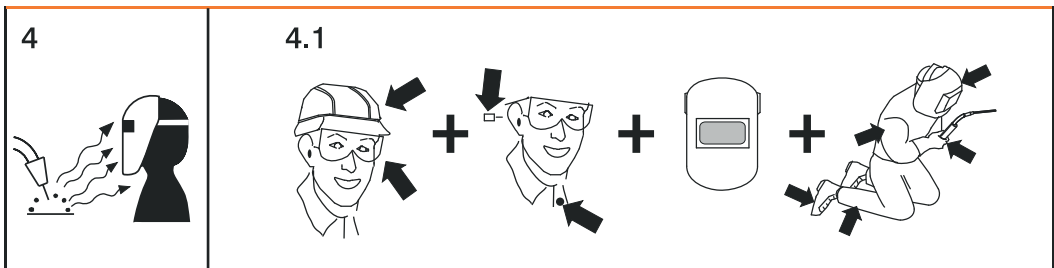


3. Welding sparks can cause an explosion or fire.

3.1 Keep flammable materials away from the welding process. Do not perform welding near flammable materials.

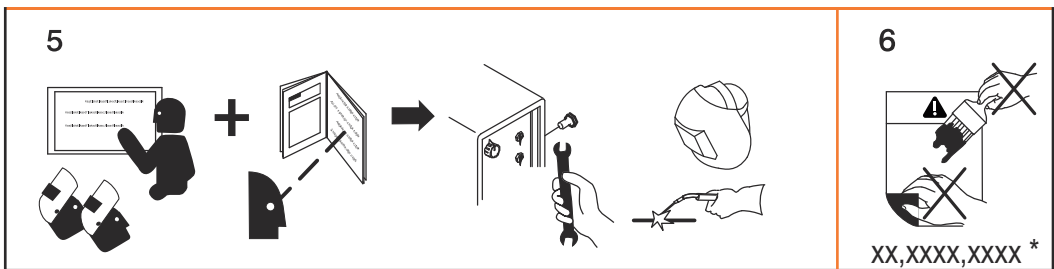
3.2 Welding sparks can cause a fire. Have fire extinguishers ready. If necessary, have a supervisor ready who can operate the fire extinguisher.

3.3 Do not weld on drums or closed containers.



4. Arc rays can burn the eyes and injure the skin.

4.1 Wear headgear and protective goggles. Use ear protection and wear a shirt collar with button. Use a welding helmet with the correct tinting. Wear suitable protective clothing over the entire body.



5. Before working on the machine or welding: undertake training on the device and read the instructions!

6. Do not remove or paint over the sticker with the warnings.

\* Manufacturer order number of the sticker

# **Operating controls and connections**



# Control Panel

## General

As a result of software updates, you may find that there are functions available on your device that are not described in these Operating Instructions, or vice versa. Certain illustrations may also differ slightly from the actual controls on your device, but these controls function in exactly the same way.

## Safety

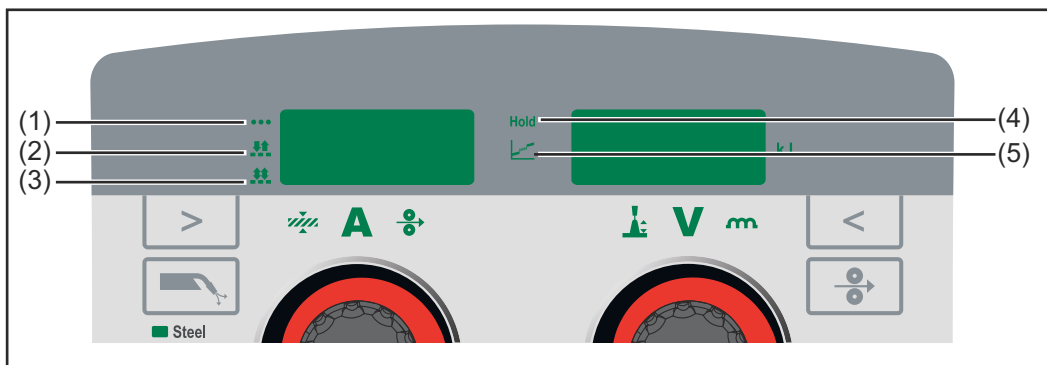
### **WARNING!**

#### **Danger from incorrect operation and work that is not carried out properly.**

Serious personal injury and damage to property may result.

- ▶ Read and understand this document.
- ▶ Read and understand all the Operating Instructions for the system components, especially the safety rules.

## Control panel



### (1) **Spot welding indicator**

The spot welding indicator lights up if:

- Spot welding/stitch welding mode is selected
- The SPt parameter (spot welding time/stitch welding time) in the Setup menu is not set to OFF

### (2) **2-step stitch welding indicator**

The 2-step stitch welding indicator lights up if:

- Spot welding/stitch welding mode is selected and
- The SPb parameter (spot welding/stitch welding pause time) is set to a value greater than 0 and
- The Int (interval) parameter is set to 2T

### (3) **4-step stitch welding indicator**

The 4-step stitch welding indicator lights up if:

- Spot welding/stitch welding mode is selected and
- The SPb parameter (spot welding/stitch welding pause time) is set to a value greater than 0 and
- The Int (interval) parameter is set to 4T

---

**(4) Hold indicator**

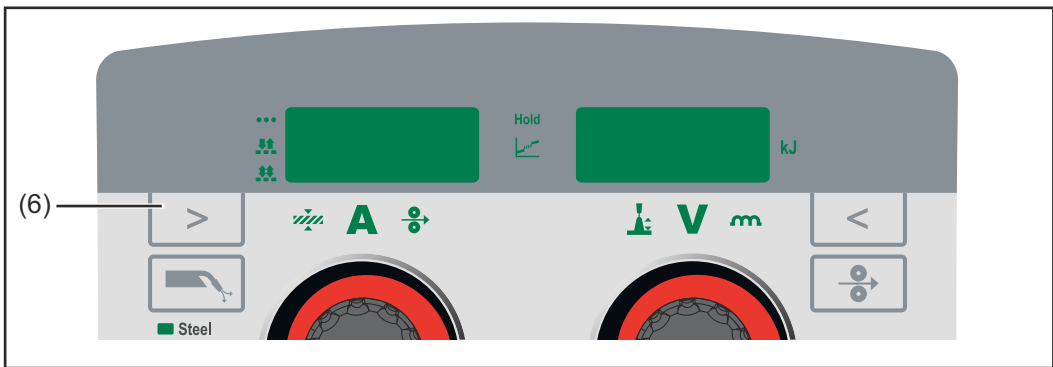
At the end of each welding operation, the actual values for welding current and welding voltage are stored - the "HOLD" indicator lights up

---

**(5) Intermediate arc indicator**

A spatter-prone intermediate arc occurs between the dip transfer arc and the spray arc. The intermediate arc indicator lights up to alert you to this critical range

---



**(6) "Parameter selection" button (left)**

For selecting the parameters listed below

The relevant symbol lights up when a welding parameter is selected.



**Sheet thickness in mm or inch (synergic parameter)<sup>1</sup>**

If, for example, the welding current to be selected is not known, entering the sheet thickness alone is sufficient. Entering one synergic parameter means that all other synergic parameters are set automatically.



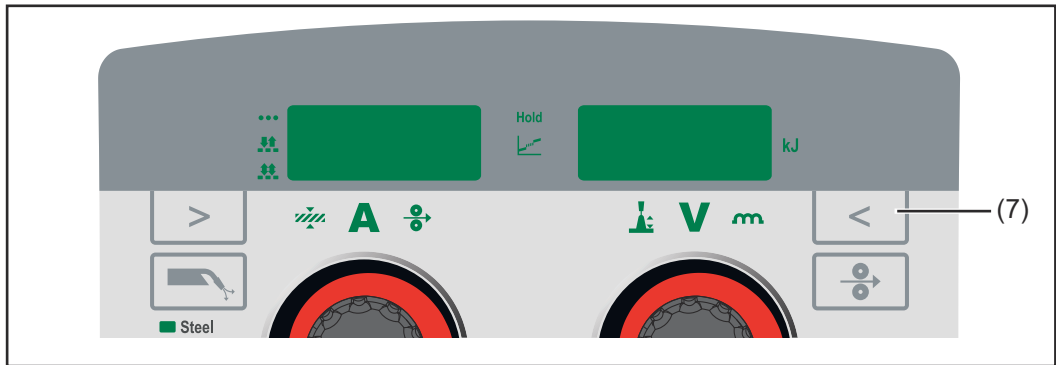
**Welding current in amperes (synergic parameter)<sup>1</sup>**

Before welding begins, the device automatically displays a standard value based on the programmed parameters. The actual value is displayed during welding.



**Wire speed in m/min or ipm (synergic parameter)<sup>1</sup>**

<sup>1</sup> If one of these parameters is selected in the MIG/MAG standard synergic welding process, then the synergic function ensures that all other synergic parameters are adjusted automatically.



(7) **"Parameter selection" button (right)**

For selecting the parameters listed below

The relevant symbol lights up when a welding parameter is selected.



**Arc length correction**

For correcting the arc length



**Welding voltage in V (synergic parameter)<sup>1</sup>**

Before welding begins, the device automatically displays a standard value based on the programmed parameters. The actual value is displayed during welding.



**Arc-force dynamic**

For influencing the short-circuiting dynamic at the moment of droplet transfer

- ... Harder and more stable arc

0 ... Neutral arc

+ ... Soft and low-spatter arc

**kJ**

**Real Energy Input<sup>2</sup>**

For displaying the energy applied during the welding operation

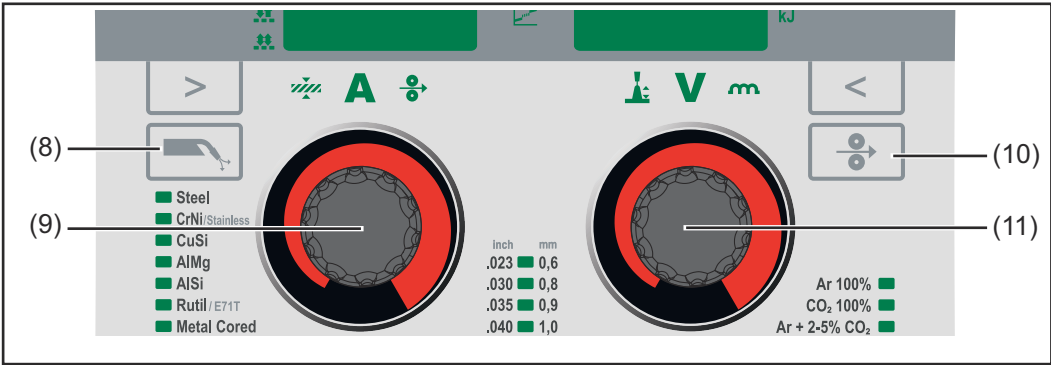
<sup>1</sup> If one of these parameters is selected in the MIG/MAG standard synergic welding process, then the synergic function ensures that all other synergic parameters are adjusted automatically.

<sup>2</sup> This parameter can only be selected if the EnE parameter is set to ON in the Setup menu 2nd level.

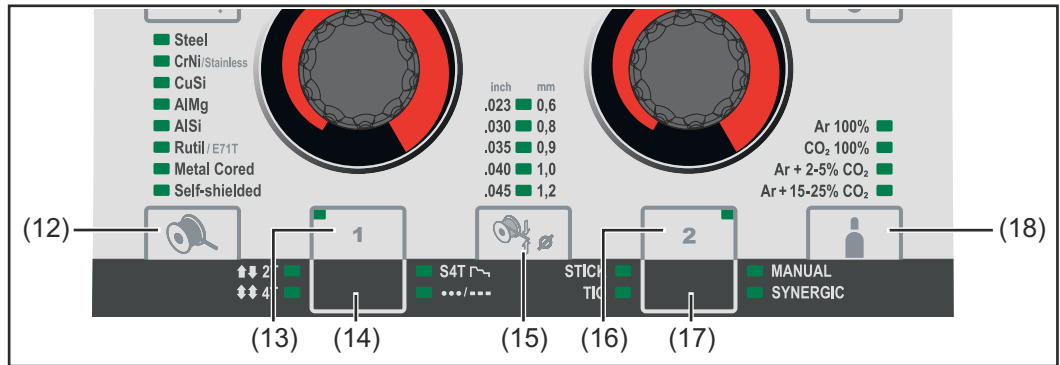
The value continuously rises during welding in line with the permanently increasing energy input.

The final value is stored after the end of welding until welding starts again or the power source is switched back on - the HOLD indicator lights up.





- (8) "Gas-test" button**  
 For setting the required gas flow rate on the gas pressure regulator/for filling the torch hosepack with shielding gas.  
 When the "Gas-test" button is pressed, shielding gas will flow for 30 seconds.  
 Press the button again to stop the gas flow prematurely.
- (9) Selection dial (left)**  
 For changing the sheet thickness, welding current, and wire speed parameters, and for changing parameters in the Setup menu
- (10) "Wire threading" button**  
 For threading the wire into the torch hosepack with no accompanying flow of gas.  
 While the button is being held down, the wire drive runs at feeder inching speed
- (11) Selection dial (right)**  
 For changing the arc length correction, welding voltage, and arc-force dynamic parameters, and for changing parameters in the Setup menu




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**(12) "Material" button**

For selecting the filler metal to be used

---

**(13) "Save" button 1**

For saving an EasyJob

---

**(14) "Mode" button**

For selecting the operating mode

↑↓ 2 T = 2-step mode

↕↕ 4 T = 4-step mode

S4T ⌒ S 4 T = Special 4-step mode

●●● / ■■■ Spot welding/stitch welding

---

**(15) "Wire diameter" button**

For selecting the wire diameter to be used

---

**(16) "Save" button 2**

For saving an EasyJob

---

**(17) "Process" button**

For selecting the welding process

MANUAL = MIG/MAG standard manual welding

SYNERGIC = MIG/MAG standard synergic welding

STICK = Stick welding (SMAW)

TIG = TIG welding

---

**(18) "Shielding gas" button**

For selecting the shielding gas to be used

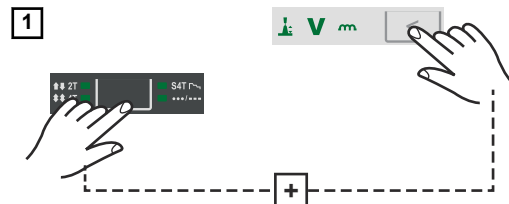
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## Keylock

A keylock can be activated to prevent the settings from being inadvertently changed on the control panel. As long as the keylock is active:

- Settings cannot be adjusted on the control panel
- Parameter settings can be displayed
- It is possible to switch between EasyJobs if an EasyJob was selected before the keylock was activated

### Activating/deactivating the keylock:



Keylock activated:  
The message "CLO | SEd" appears on the displays.

Keylock deactivated:  
The message "OP | En" appears on the displays.

# Connections, Switches, and Mechanical Components

## Safety



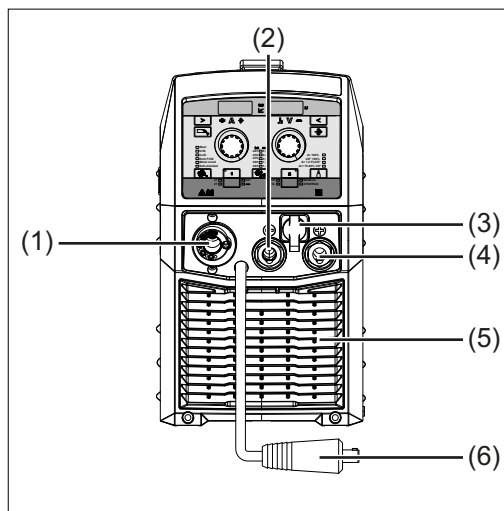
### WARNING!

**Danger from incorrect operation and work that is not carried out properly.**

Serious personal injury and damage to property may result.

- ▶ Read and understand this document.
- ▶ Read and understand all the Operating Instructions for the system components, especially the safety rules.

## Front and rear of the power source



**(1) Welding torch connection**  
For connecting the welding torch

**(2) (-) Current socket with bayonet latch**

Used for

- Connecting the grounding cable or polarity reverser for MIG/MAG welding (depending on the wire electrode used)
- Connecting the electrode cable or grounding cable for manual metal arc welding (depending on the type of electrode used)
- Connecting the TIG welding torch

**(3) TMC connection (TIG Multi Connector)**  
For connecting the TIG welding torch

**(4) (+) Current socket with bayonet latch**

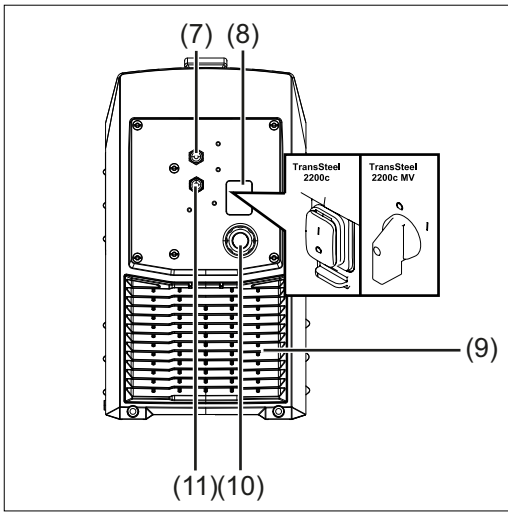
Used for

- Connecting the polarity reverser or grounding cable for MIG/MAG welding (depending on the wire electrode used)
- Connecting the electrode cable or grounding cable for manual metal arc welding (depending on the type of electrode used)
- Connecting the grounding cable for TIG welding

**(5) Ventilation openings (air outlet vents)**  
For device cooling

**(6) Polarity reverser**

For selecting the welding potential on the MIG/MAG welding torch



- (7) MIG/MAG shielding gas connection socket**  
For the shielding gas supply to the welding torch connection (1)

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- (8) Power switch**  
For switching the power source on and off

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- (9) Ventilation openings (air inlet vents)**  
For device cooling, the air filter is located behind these vents

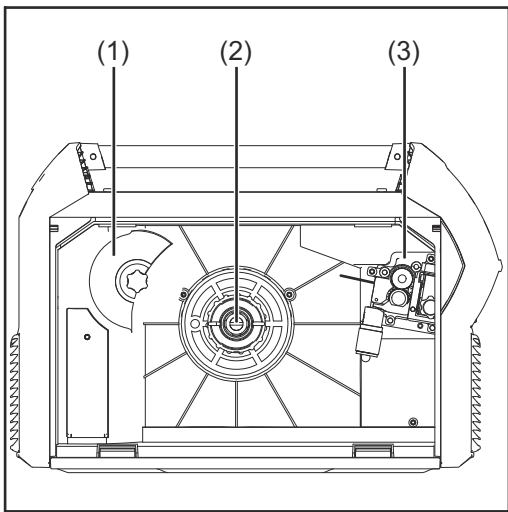
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- (10) Mains cable with strain relief**  
Not prefitted on all models

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- (11) TIG shielding gas connection socket**  
For the shielding gas supply for the (-) current socket (2)

**Side view**



- (1) D100 wire spool holder with brake**  
For holding standard wire spools with a max. diameter of 100 mm (3.94 in)

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- (2) D200 wire spool holder with brake**  
For holding standard wire spools with a max. diameter of 200 mm (7.87 in.) and a max. weight of 6.8 kg (14.99 lbs.)

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- (3) 2-roller drive**



# **Before installation and initial operation**





## Safety



### WARNING!

#### **Danger from incorrect operation and work that is not carried out properly.**

This can result in serious personal injury and damage to property.

- ▶ All the work and functions described in this document must only be carried out by technically trained and qualified personnel.
- ▶ Read and understand this document in full.
- ▶ Read and understand all safety rules and user documentation for this equipment and all system components.

## Intended use

The power source is intended exclusively for MIG/MAG, rod electrode, and TIG welding. Utilization for any other purpose, or in any other manner, shall be deemed to be not in accordance with the intended purpose.

The manufacturer shall not be held liable for any damages arising from such use.

Intended use also means:

- Following all the instructions in these Operating Instructions
- Carrying out all the specified inspection and maintenance work

## Setup regulations

The device has been tested according to degree of protection IP 23. This means:

- Protection against penetration by solid foreign bodies with diameters > 12 mm (0.49 in.)
- Protection against spraywater at any angle up to 60° from the vertical

The device can be set up and operated outdoors in accordance with protection class IP 23.

Direct moisture (e.g., from rain) must be avoided.



### WARNING!

#### **Danger from machines falling or toppling over.**

This can result in severe personal injury and damage to property.

- ▶ Always place the device on a solid, level surface.



### WARNING!

#### **Danger of electrical current due to electrically conductive dust in the device.**

This can result in severe personal injury and damage to property.

- ▶ Only operate the device if an air filter is fitted. The air filter is a very important safety device for achieving IP 23 protection.

The ventilation channel is a very important safety device. When choosing the device location, ensure that the cooling air can enter and exit unhindered through the ventilation openings on the front and back of the device. Electroconductive metallic dust (e.g., from grinding work) must not be allowed to get sucked into the device.

---

**Grid Connection**

The devices are designed for the grid voltage stated on the rating plate. If the mains cable or mains plug has not been attached to your version of the appliance, these must be installed according to national standards. Fuse protection for the grid lead can be found in the technical data.

**CAUTION!****Danger due inadequately dimensioned electrical installations.**

This can lead to serious damage

- ▶ The grid lead and its fuse protection should be designed to suit the existing power supply.  
The technical data on the rating plate should be followed.
-

# Generator-Powered Operation

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## Required generator output

The power source is generator-compatible.

The maximum apparent power  $S_{1\max}$  of the power source must be known in order to select the correct generator output.

The maximum apparent power  $S_{1\max}$  of the power source is calculated as follows:

$$S_{1\max} = I_{1\max} \times U_1$$

$I_{1\max}$  and  $U_1$  according to the device rating plate or technical data.

The generator apparent power  $S_{\text{GEN}}$  needed is calculated using the following rule of thumb:

$$S_{\text{GEN}} = S_{1\max} \times 1.35$$

A smaller generator may be used when not welding at full power.

### **NOTE!**

**The generator apparent power  $S_{\text{GEN}}$  must not be less than the maximum apparent power  $S_{1\max}$  of the power source!**

---

When single phase devices are being operated with a three-phase generator, note that the stated apparent power of the generator is often just the total that can be present across all three phases of the generator. If necessary, obtain further information about the single-phase power of the generator from the generator manufacturer.

### **NOTE!**

**The voltage delivered by the generator must never fall outside of the mains voltage tolerance range.**

The mains voltage tolerance is specified in the "Technical data" section.

---

# Mains Fuse Protection

## Adjustable mains fuse protection

The mains fuse protection selected on the power source limits the power drawn in from the grid and in turn the possible welding current. This prevents the automatic circuit breaker (e.g., in the fuse box) from tripping straight away.

The desired mains fuse protection can be selected on the power source depending on the grid voltage and automatic circuit breaker used.

The following table shows which grid voltages and fuse ratings limit the welding current.

### TSSt 2200:

Grid voltage Country-specific setting Power source fuse rating	Welding current limitation
230 V Std 10 A	<b>MIG/MAG welding:</b> max. 145 A; 110 A at 100%* <b>SMAW:</b> max. 125 A; 90 A at 100%* <b>TIG welding:</b> max. 180 A; 135 A at 100%*
230 V Std 13 A	<b>MIG/MAG welding:</b> max. 170 A; 140 A at 100%* <b>SMAW:</b> max. 150 A; 120 A at 100%* <b>TIG welding:</b> max. 200 A; 160 A at 100%*
230 V Std 16 A	<b>MIG/MAG welding:</b> max. 210 A; 150 A at 100%* <b>SMAW:</b> max. 180 A; 130 A at 100%* <b>TIG welding:</b> max. 230 A; 170 A at 100%*

### TSSt 2200 MV:

Grid voltage Country-specific setting Power source fuse rating	Welding current limitation
120 V Std 10 A	<b>MIG/MAG welding:</b> max. 100 A; 75 A at 100%* <b>SMAW:</b> max. 85 A; 55 A at 100%* <b>TIG welding:</b> max. 130 A; 95 A at 100%*
120 V Std 13 A	<b>MIG/MAG welding:</b> max. 105 A; 80 A at 100%* <b>SMAW:</b> max. 90 A; 70 A at 100%* <b>TIG welding:</b> max. 135 A; 105 A at 100%*

Grid voltage Country-specific setting Power source fuse rating	Welding current limitation
120 V US 15 A	<b>MIG/MAG welding:</b> max. 105 A; 80 A at 100%* <b>SMAW:</b> max. 90 A; 70 A at 100%* <b>TIG welding:</b> max. 135 A; 105 A at 100%*
120 V Std 16 A	<b>MIG/MAG welding:</b> max. 115 A; 105 A at 100%* <b>SMAW:</b> max. 100 A; 85 A at 100%* <b>TIG welding:</b> max. 140 A; 130 A at 100%*
120 V US 20 A	<b>MIG/MAG welding:</b> max. 135 A; 105 A at 100%* <b>SMAW:</b> max. 110 A; 90 A at 100%* <b>TIG welding:</b> max. 160 A; 130 A at 100%*
230 V Std 10 A	<b>MIG/MAG welding:</b> max. 145 A; 110 A at 100%* <b>SMAW:</b> max. 125 A; 90 A at 100%* <b>TIG welding:</b> max. 180 A; 135 A at 100%*
230 V Std 13 A	<b>MIG/MAG welding:</b> max. 170 A; 140 A at 100%* <b>SMAW:</b> max. 150 A; 120 A at 100%* <b>TIG welding:</b> max. 200 A; 160 A at 100%*
230 V Std 16 A	<b>MIG/MAG welding:</b> max. 210 A; 150 A at 100%* <b>SMAW:</b> max. 180 A; 130 A at 100%* <b>TIG welding:</b> max. 230 A; 170 A at 100%*
240 V US 15 A	<b>MIG/MAG welding:</b> max. 210 A; 150 A at 100%* <b>SMAW:</b> max. 180 A; 130 A at 100%* <b>TIG welding:</b> max. 230 A; 170 A at 100%*

A 20 A fuse can only be selected if:

- The country-specific setting has been set to "US"
- The grid lead has a 20 A fuse
- The power source is supplied with a grid voltage of 120 V

\* 100% values = welding with no time limits and without cooling breaks.

The welding current data applies at an ambient temperature of 40 °C (104 °F).

A safety cut-out prevents the automatic circuit breaker from tripping at higher welding powers. The safety cut-out defines the possible welding duration without the automatic

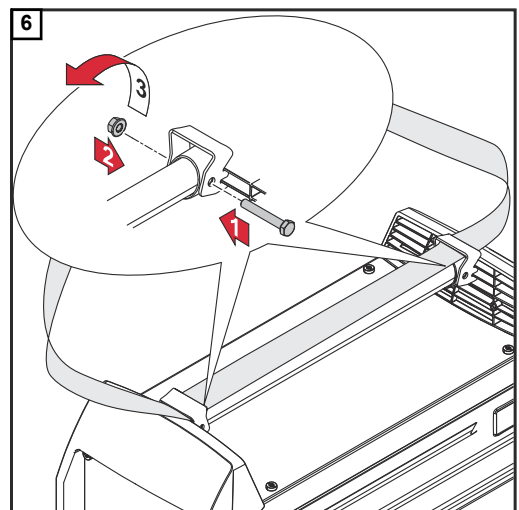
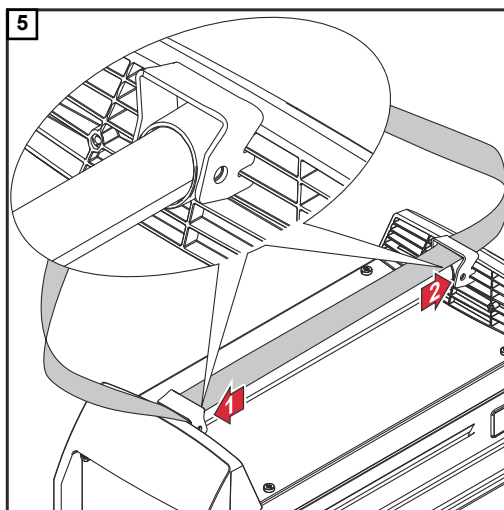
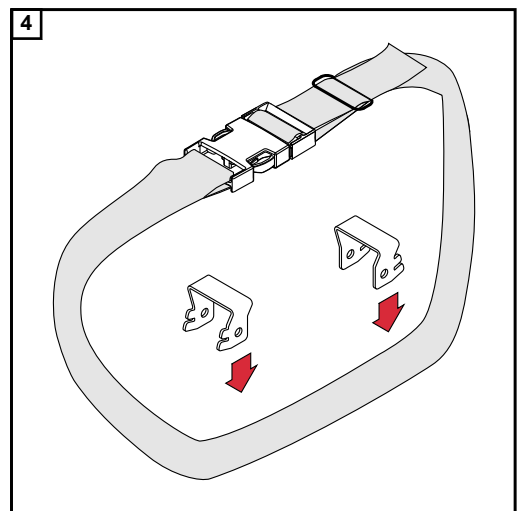
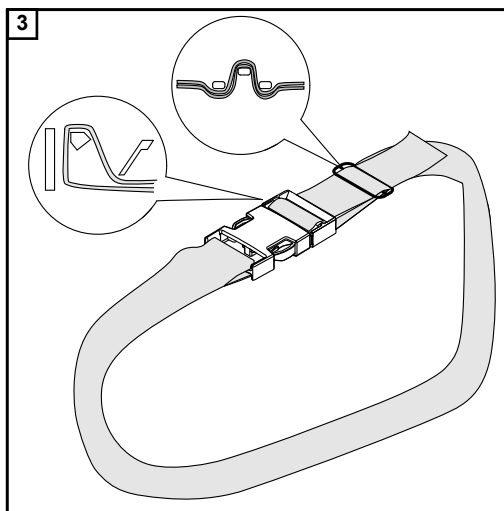
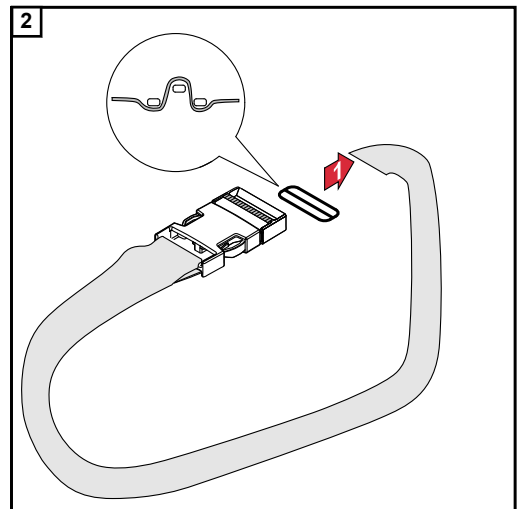
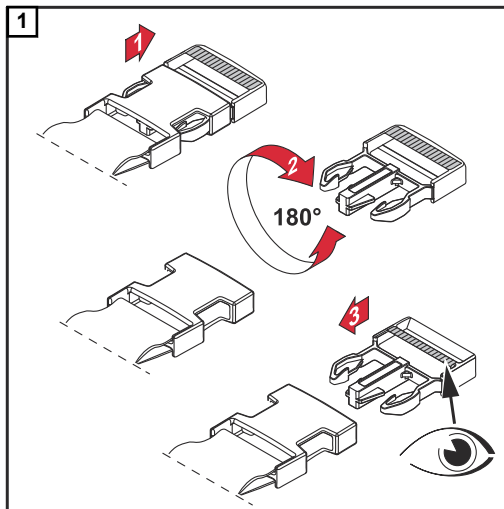
circuit breaker tripping. If the precalculated weld time is exceeded, thus causing the welding current to switch off, the service code "toF" is displayed. A countdown immediately appears next to the "toF" indicator, which shows the remaining time until the power source is ready for welding again. After this time, the message disappears, and the power source is ready for operation again.

Depending on the selected fuse, the safety cut-out limits the maximum currents of the selected process. As a result, it is possible that welding can no longer occur at the saved operating points if these were saved before selecting the fuse.

If welding is nevertheless carried out at one of these operating points, the power source operates at the limit value of the selected fuse – the power limitation is active. The operating point should be re-saved in accordance with the power limitation.

# Fitting the Carrying Strap

Fitting the carrying strap to the power source







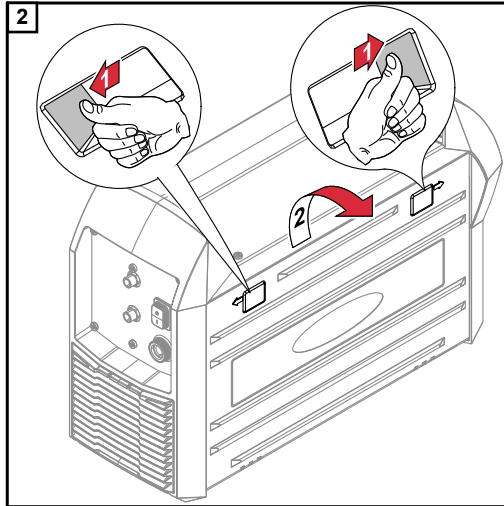
# **MIG/MAG**



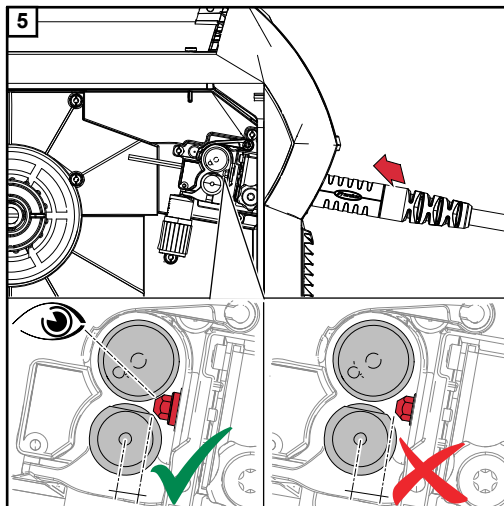
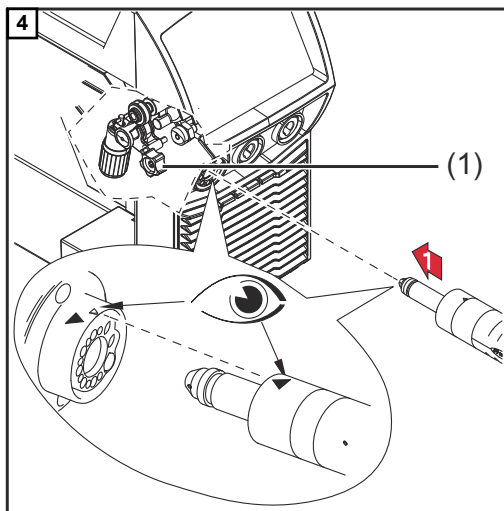
# Commissioning

## Connecting a MIG/MAG welding torch

- 1 Before connecting the welding torch to the power source, equip the welding torch according to the welding torch Operating Instructions: Fit wearing parts to the torch body, fit the inner liner.



- 3 Unscrew the knurled screw (1) slightly so that the welding torch can be easily pushed into the welding torch connection.

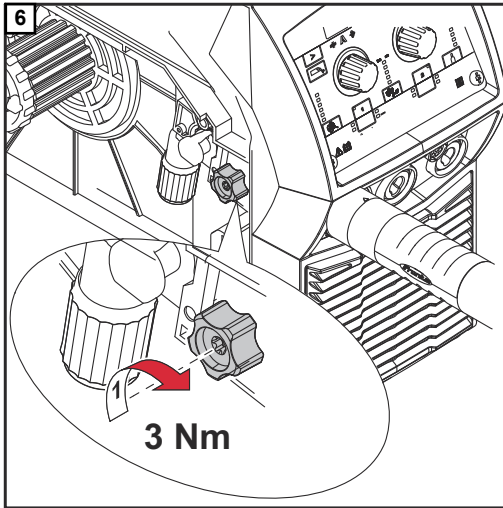


### CAUTION!

**Danger if the welding torch is not fully inserted.**

The device may be damaged.

- After inserting the welding torch, ensure it is in the correct end position.



**CAUTION!**

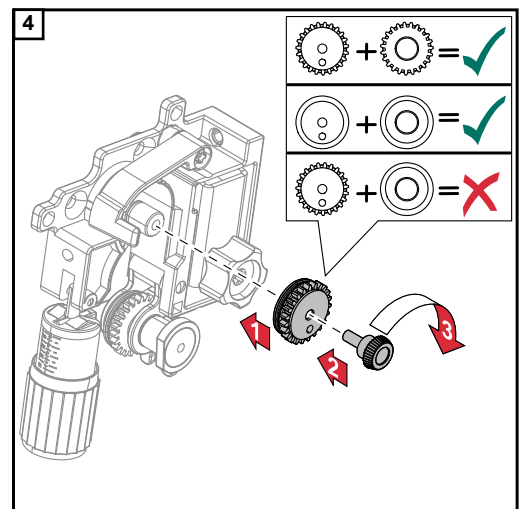
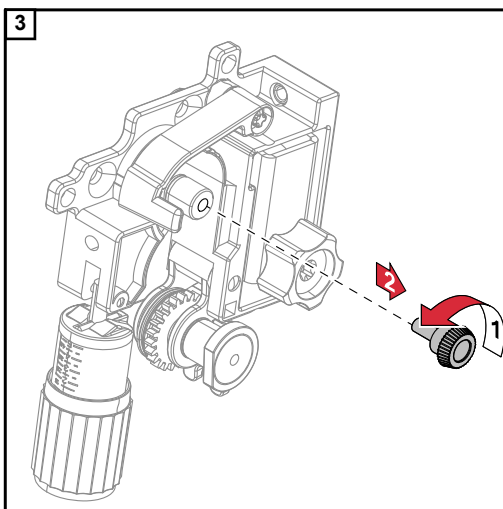
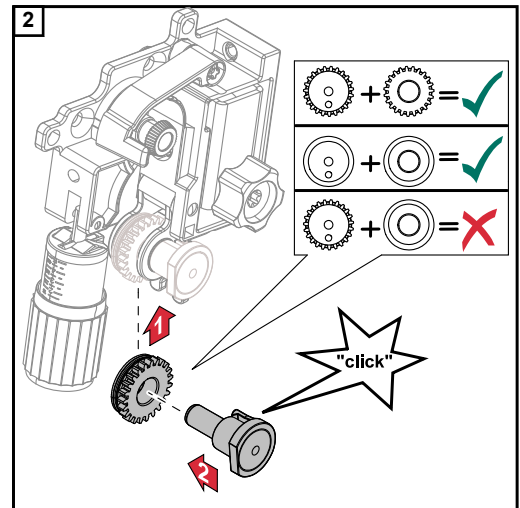
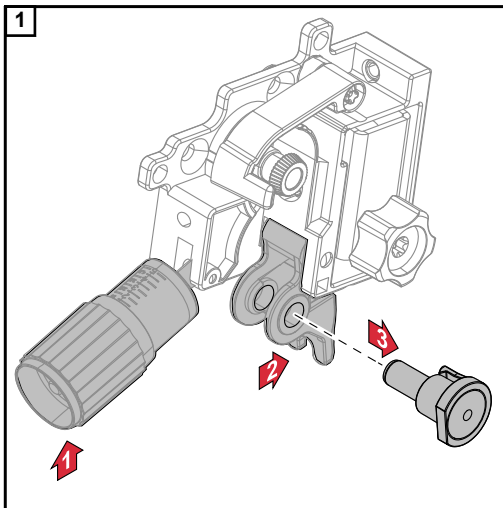
**Danger if welding torch is not screwed tight.**

The device may be damaged.

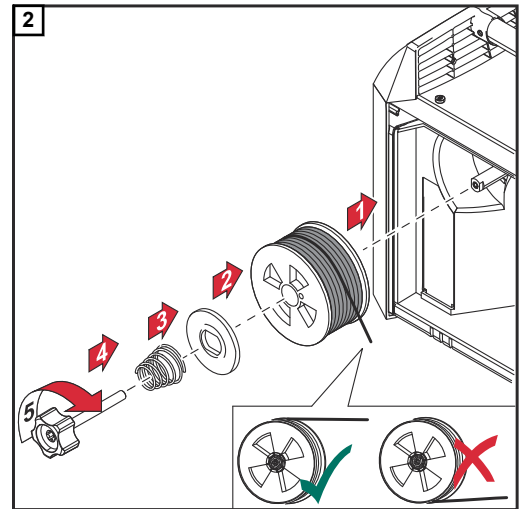
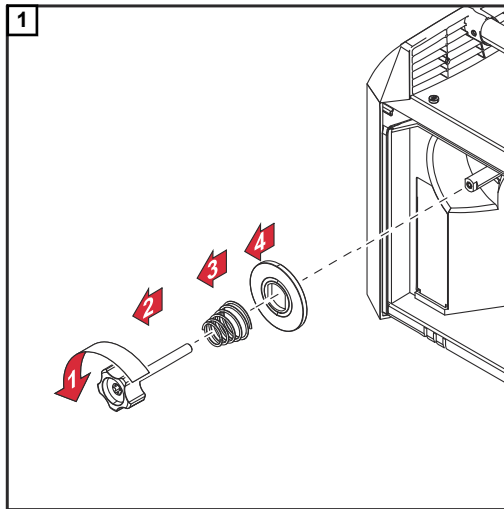
- ▶ Always tighten the welding torch to the specified tightening torque.

**Inserting the feed rollers**

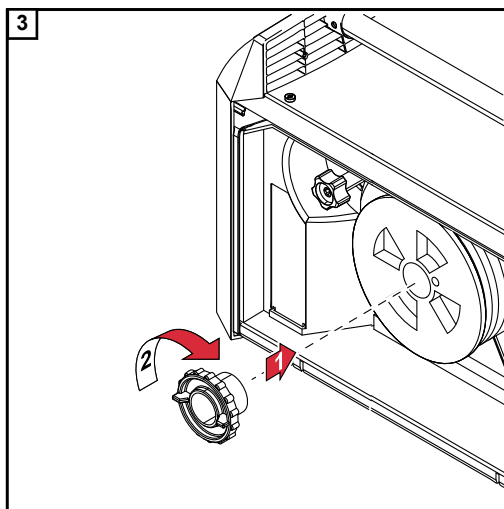
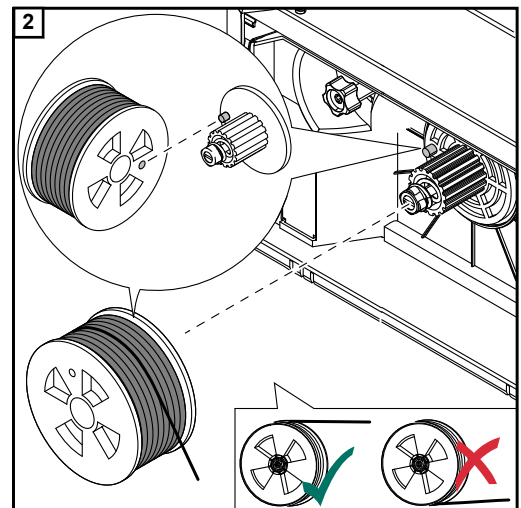
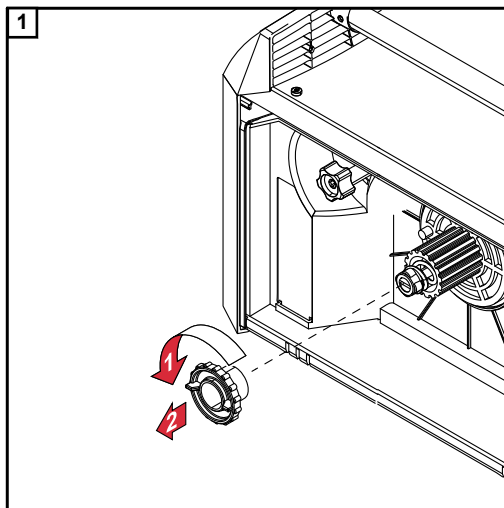
In order to achieve optimum wire electrode feed, the feed rollers must be suitable for the diameter and alloy of the wire being welded.



### Inserting the D100 wirespool



### Inserting the D200 wirespool



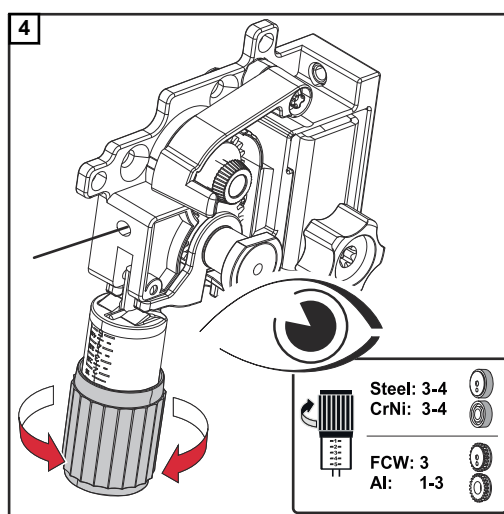
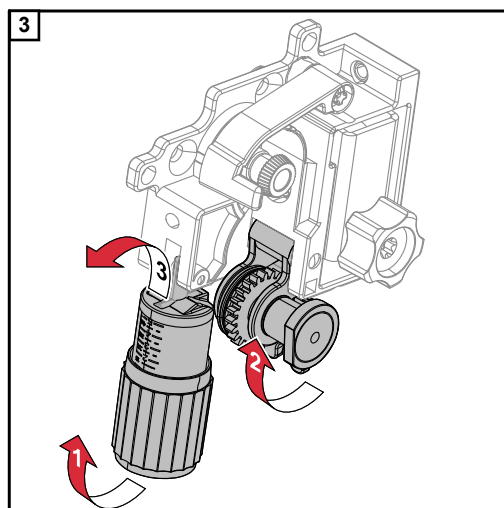
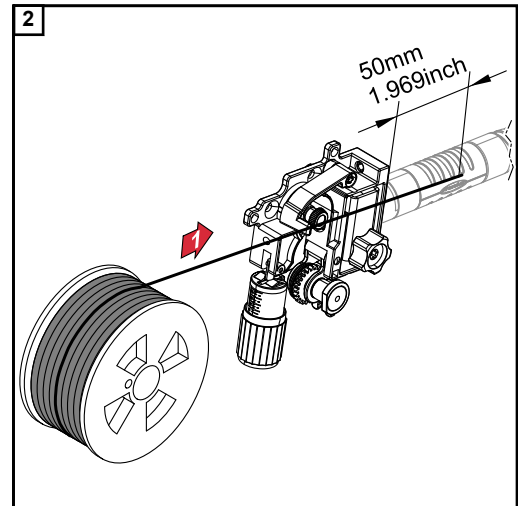
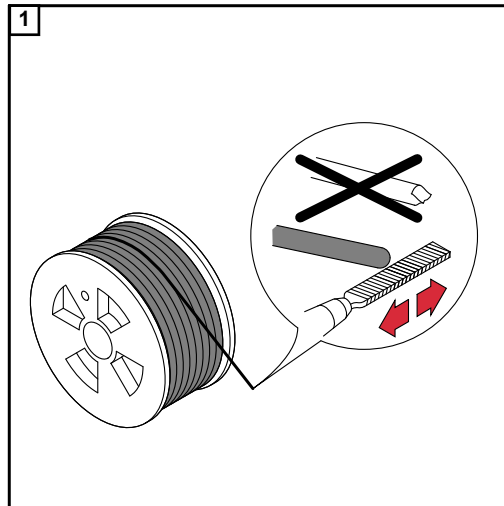
**Feeding in the wire electrode**

**⚠ CAUTION!**

**Danger from springiness of spooled wire electrode.**

It can cause injuries.

- ▶ When inserting the wire electrode into the wire drive, hold the end of the wire electrode firmly.



Adjust the contact pressure as shown below

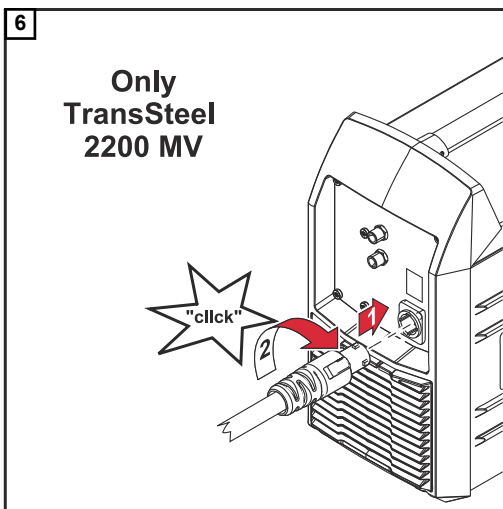
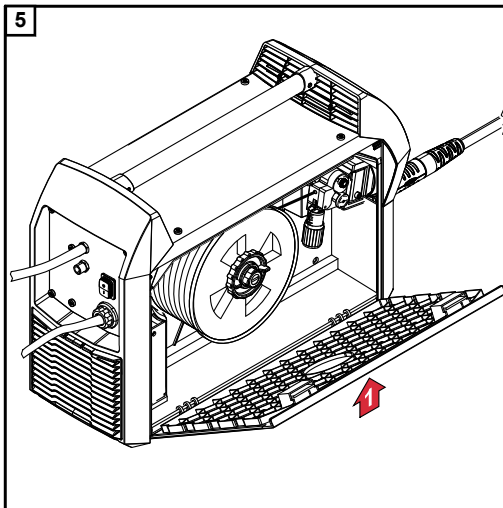
- Doing so will prevent deformation of the wire electrode and ensure that the wire is transported properly

Standard values for contact pressure with smooth feed rollers:

- Steel = 3 - 4
- CrNi = 3 - 4

Standard values for contact pressure with toothed feed rollers:

- Tubular covered electrodes = 3
- Aluminum = 1 - 3

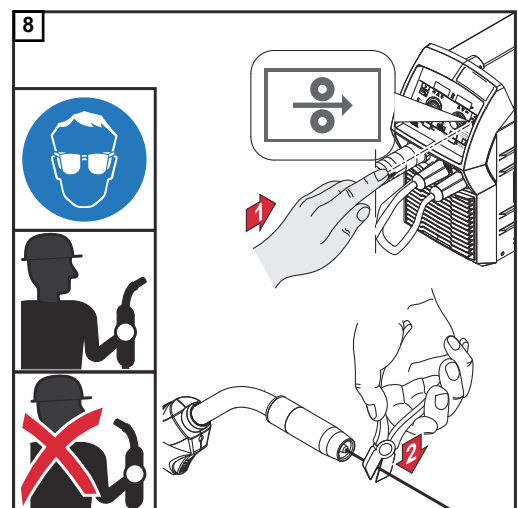
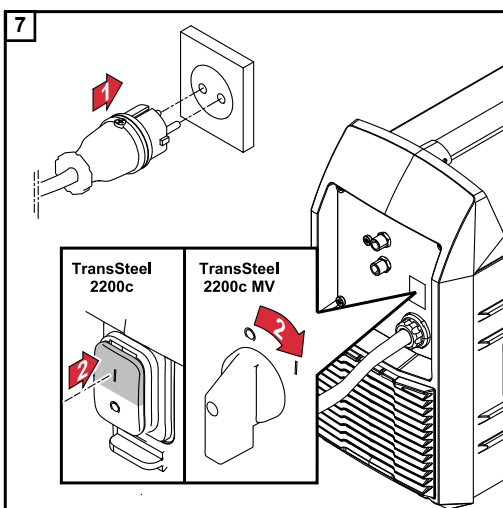


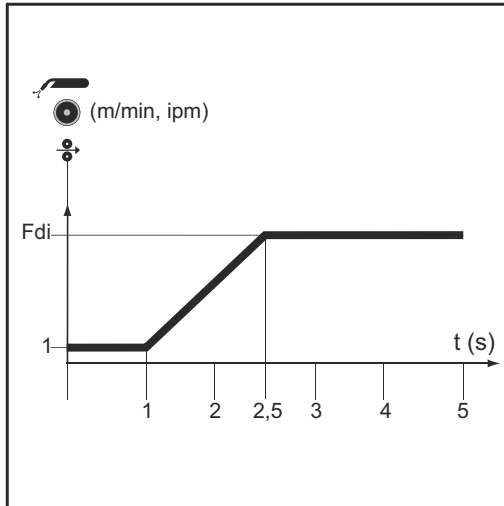
It is only necessary to connect the mains cable to the power source for multivoltage power sources.

**⚠ CAUTION!**

**Danger from wire electrode emerging unexpectedly as it is being threaded.**  
It can cause injuries.

- ▶ Wear suitable protective goggles
- ▶ Keep the tip of the welding torch away from your face and body
- ▶ Do not point the tip of the welding torch at people
- ▶ Make sure that the wire electrode does not touch any conductive or grounded parts (e.g., housing)





**Wire threading process (press the "Wire threading" button on the control panel):**

- Hold down the button for up to **one second** (briefly press the button): the wire speed stays at 1 m/min (39.37 ipm) for the first second
- Hold down the button for up to **2.5 seconds**: after one second, the wire speed increases over the next 1.5 seconds.
- Hold down the button for **longer than 2.5 seconds**: after 2.5 seconds, the wire is fed at a constant rate equal to the wire speed set for the Fdi welding parameter.

**Selecting the desired country-specific setting**

- The country-specific setting of the power source defines the unit (cm + mm or inch) in which the set welding parameters are displayed
- The country-specific setting can be changed in the Setup menu 2nd level (Parameter SEt)
  - A description of the SEt parameter and how to adjust the SEt parameter can be found in section [Setup Menu 2nd Level](#) from page 98

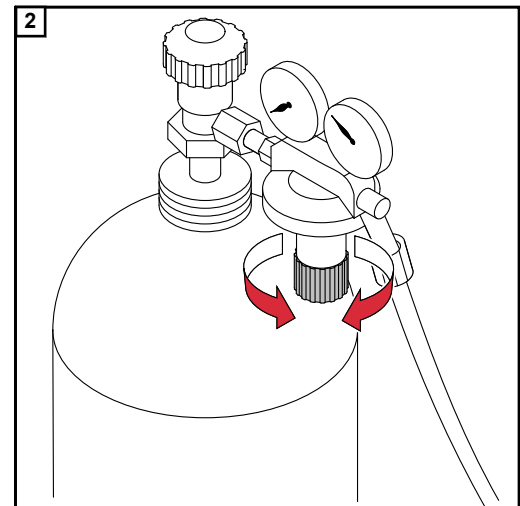
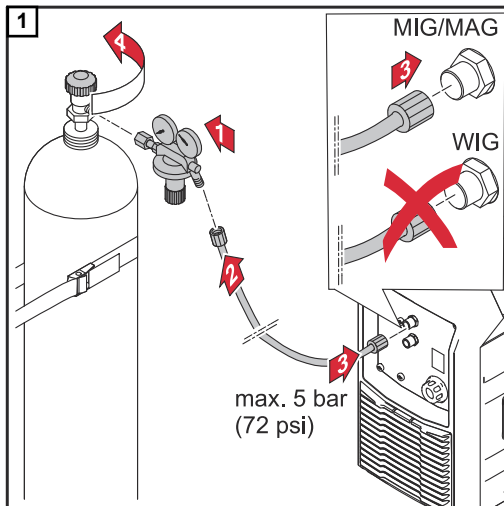
**Connecting the gas cylinder**

**WARNING!**

**Danger from gas cylinders falling over.**

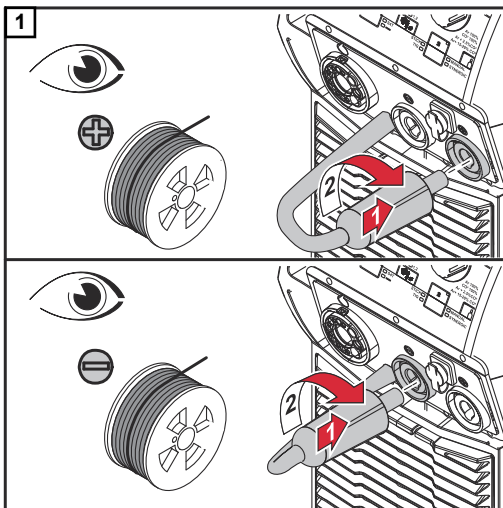
Serious personal injury and damage to property may result.

- ▶ Place the gas cylinders on a level and stable surface.
- ▶ Secure the gas cylinders to prevent them from falling over
- ▶ Observe the safety rules of the gas cylinder manufacturer.





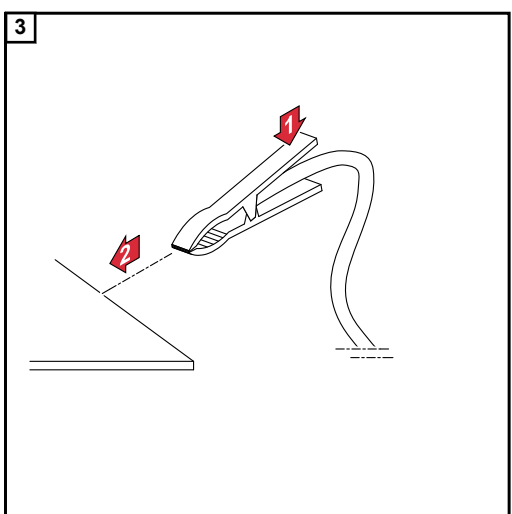
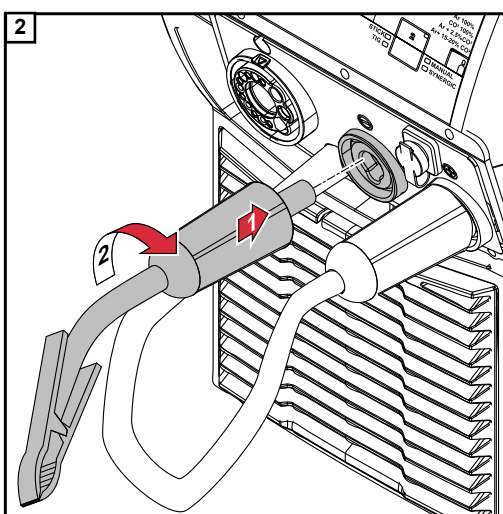
### Connecting the polarity reverser and establishing a ground earth connection



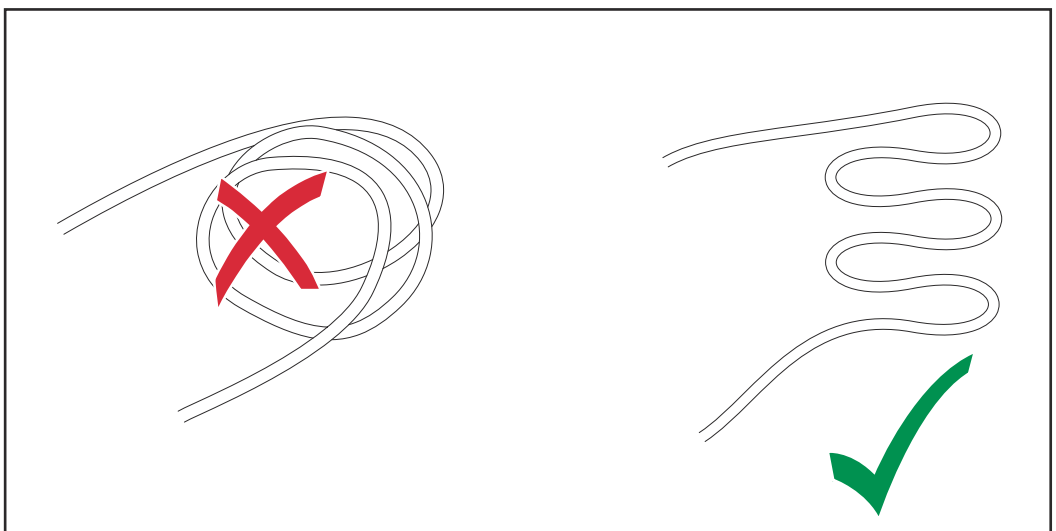
### NOTE!

**Risk from incorrectly connected polarity reverser.**  
This can result in poor-quality weld properties.

- ▶ Connect the polarity reverser according to the wire electrode being used. Check the wire electrode packaging to determine whether the wire electrode is for (+) or (-) welding



### Laying the hosepacks correctly



# Adjusting the Brake of the Wirespool Holders

---

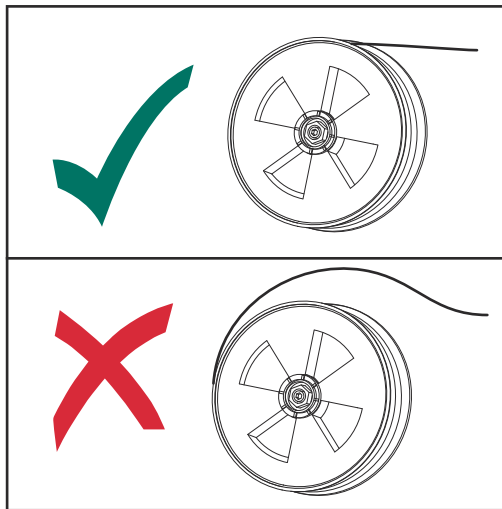
## General

### D200 wirespool holder:

Adjust the brake when using the wirespool holder for the first time and after changing the wirespool. To do so, proceed as described in the following section [Adjusting the brake of the D200 wirespool holder](#).

### D100 wirespool holder:

Adjust the brake when using the wirespool holder for the first time and after changing the wirespool. To do so, proceed as described in the following section [Adjusting the brake of the D100 wirespool holder](#)



After releasing the torch trigger (end of welding, end of wirefeeding), the wirespool must stop unreeing. If it fails to do so, adjust the brake.

**Adjusting the brake of the D200 wirepool holder**

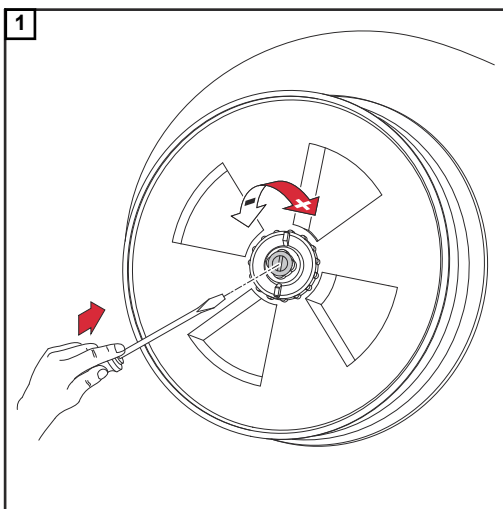
**⚠ CAUTION!**

**Danger from emerging wire electrode and moving parts.**

Personal injury and damage to property may result.

- ▶ Before starting work, turn the mains switch of the power source to - O - and disconnect the power source from the mains
- ▶ Secure all devices and components involved so they cannot be switched back on.

To adjust the brake:



- Turn the brake to the right = increase braking force
- Turn the brake to the left = decrease braking force

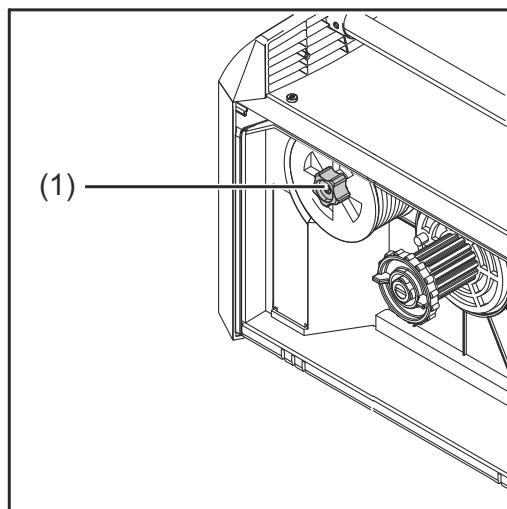
**Adjusting the brake of the D100 wirepool holder**

**⚠ CAUTION!**

**Danger from emerging wire electrode and moving parts.**

Personal injury and damage to property may result.

- ▶ Before starting work, turn the mains switch of the power source to - O - and disconnect the power source from the mains
- ▶ Secure all devices and components involved so that they cannot be switched back on.



Adjust the brake:

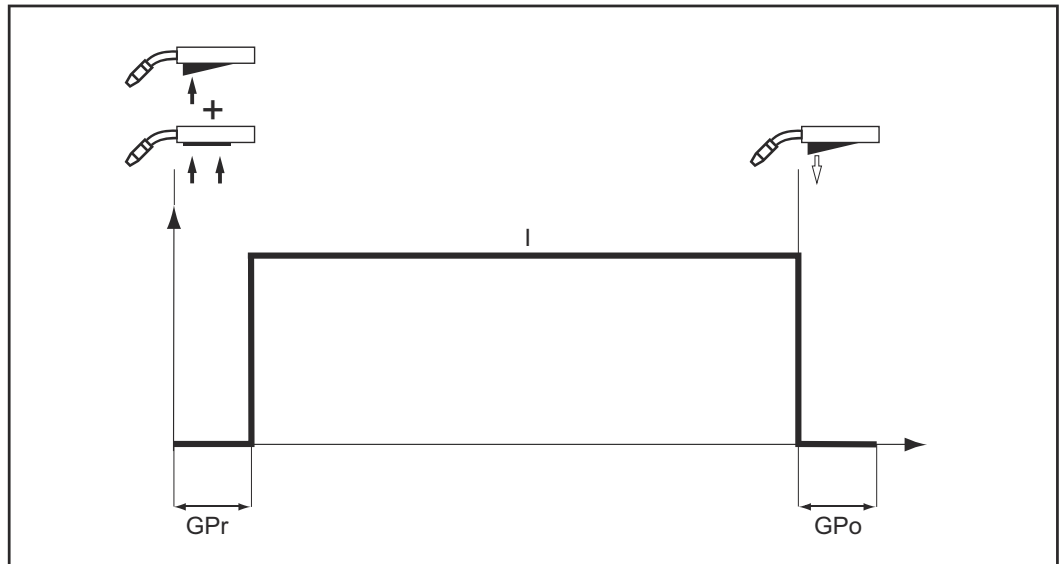
- 1** Tighten the knurled screw (1)
  - Knurled screw fully tightened = high braking force
  - Knurled screw slightly tightened = low braking force

# Description of MIG/MAG Operating Modes

## 2-step mode

"2-step mode" is suitable for

- Tacking work
- Short weld seams

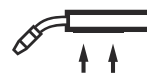


2-step mode

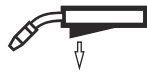
Explanation of symbols:



Press the torch trigger



Hold the torch trigger



Release the torch trigger

Abbreviations used:

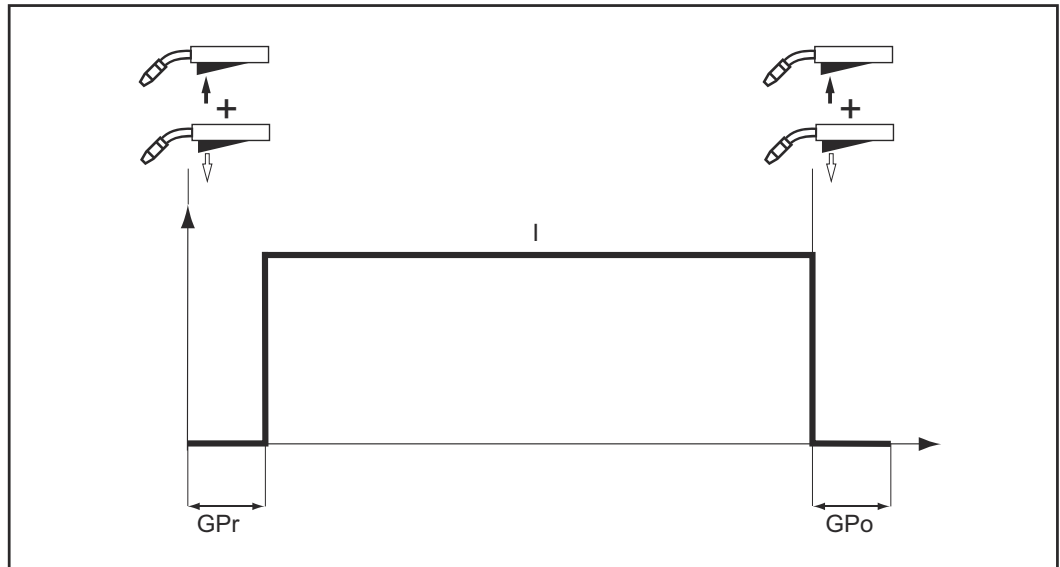
GPr Gas pre-flow time

I Welding current

GPo Gas post-flow time

### 4-step mode

"4-step mode" is suitable for longer weld seams.

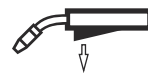


4-step mode

Explanation of symbols:



Press the torch trigger



Release the torch trigger

Abbreviations used:

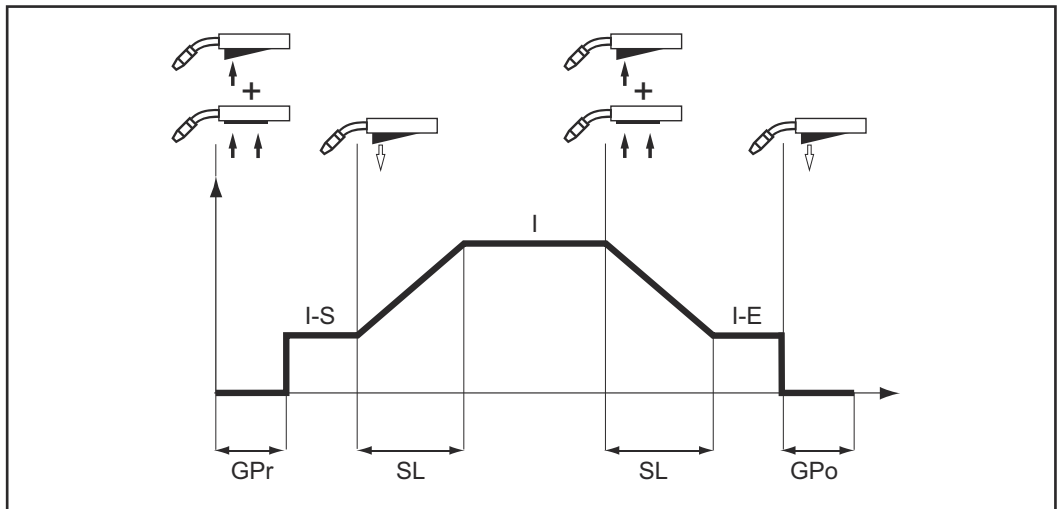
GPr Gas pre-flow time

I Welding current

GPo Gas post-flow time

**Special 4-step mode**

"Special 4-step mode" is ideal for welding in higher power ranges. In special 4-step mode, the arc starts at a lower power, which makes it easier to stabilize.



*Special 4-step mode*

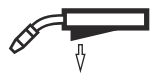
Explanation of symbols:



*Press the torch trigger*



*Hold the torch trigger*



*Release the torch trigger*

Abbreviations used:

GPr Gas pre-flow time

I-S Starting current

SL Slope: continuous increasing / lowering of welding current

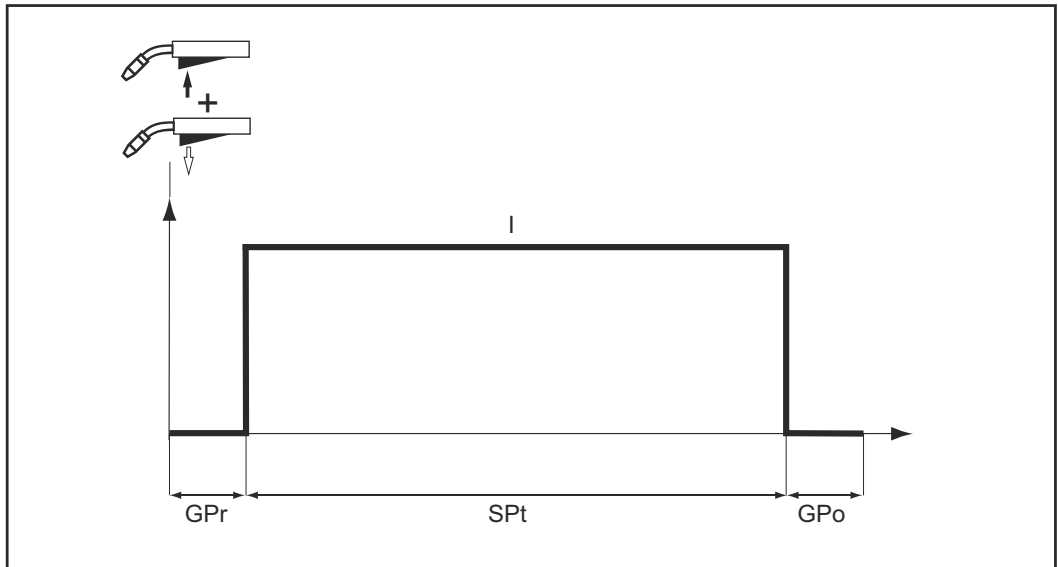
I Main current

I-E Final current

GPo Gas post-flow time

**Spot welding**

The "Spot welding" mode is suitable for welded joints on overlapped sheets.

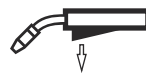


*Spot welding*

Explanation of symbols:



*Press the torch trigger*



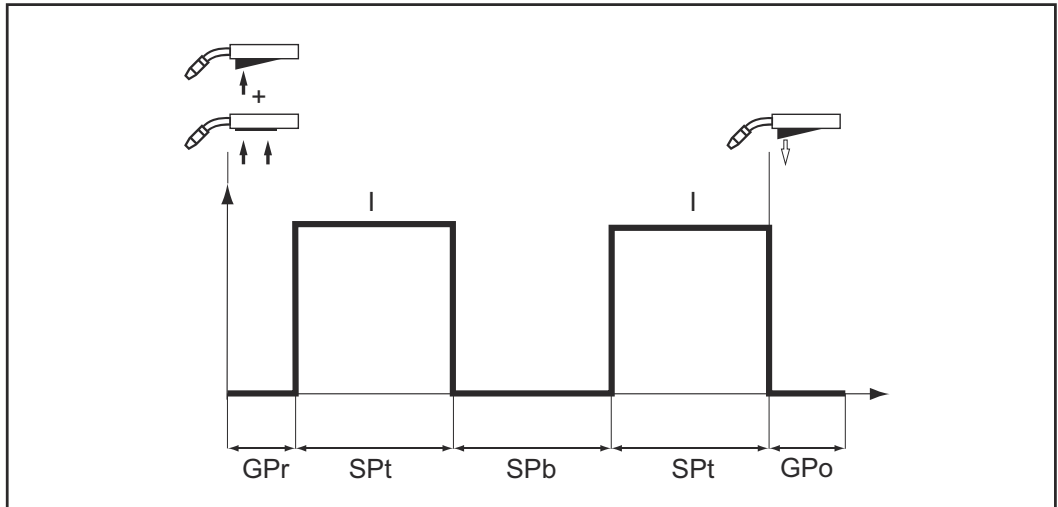
*Release the torch trigger*

Abbreviations used:

- GPr Gas pre-flow time
- I Welding current
- SPt Spot welding time / stitch welding time
- GPo Gas post-flow time

**2-step stitch welding**

The "2-step stitch welding" mode is suitable for welding short weld seams on thin sheets, to prevent the weld seams from dropping through the parent material.



*2-step stitch welding*

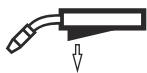
Explanation of symbols:



*Press the torch trigger*



*Hold the torch trigger*



*Release the torch trigger*

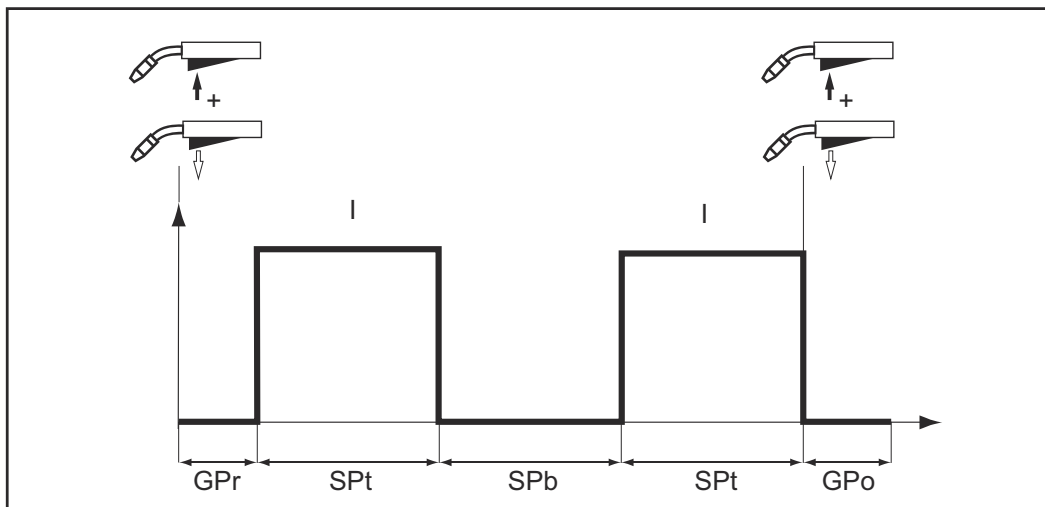
Abbreviations used:

- GPr Gas pre-flow time
- I Welding current
- SPt Spot welding time / stitch welding time
- SPb Stitch pause time
- GPo Gas post-flow time



**4-step stitch welding**

The "4-step stitch welding" mode is suitable for welding longer weld seams on thin sheets, to prevent the weld seams from dropping through the parent material.

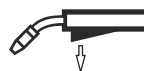


*4-step stitch welding*

Explanation of symbols:



*Press the torch trigger*



*Release the torch trigger*

Abbreviations used:

- GPr Gas pre-flow time
- I Welding current
- SPt Spot welding time / stitch welding time
- SPb Stitch pause time
- GPo Gas post-flow time


# MIG/MAG Standard Manual Welding

## General

The MIG/MAG standard manual welding process is a MIG/MAG welding process with no synergic function. Changing one parameter does not result in any automatic adjustments to the other parameters – all variable parameters must be adjusted individually.

## Adjustable welding parameters:

The following parameters are available for MIG/MAG manual welding:

 Wire speed

**V** Welding voltage

**m** Arc-force dynamic - for influencing the short-circuiting dynamic at the instant of droplet transfer

## MIG/MAG standard manual welding

1 Press the "Process" button to select MANUAL




2 Press the "Mode" button



to select the desired MIG/MAG mode:

 2-step mode

 4-step mode

 Spot welding/stitch welding

3 Select and set the wire speed parameter



4 Select and set the welding voltage parameter



All parameter set values remain stored until the next time they are changed. This applies even if the power source is switched off and on again.

5 Ensure that the ground earth connection has been established

6 Ensure that the shielding gas supply has been established  
- Power source is ready for welding

## Corrections during welding

The arc-force dynamic parameter can be used to optimize the welding result.

The arc-force dynamic parameter is used to influence the short-circuiting dynamic at the moment of droplet transfer:

- = hard, stable arc

0 = neutral arc

+ = soft, low-spatter arc

# MIG/MAG Standard Synergic Welding

## MIG/MAG standard synergic welding

- 1 Press the "Process" button to select SYNERGIC



- 2 Press the "Mode" button



to select the desired MIG/MAG mode:

↑↓ 2-step mode

↕↕ 4-step mode

**S4T** S 4 T = Special 4-step mode

●●● / ■■■ Spot welding/stitch welding

Under certain circumstances, it may not be possible to change welding parameters that have been set for a system component (remote control, etc.) on the control panel of the power source.

- 3 Press the "Material" button to select the filler metal being used



- 4 Press the "Wire diameter" button to select the diameter of the wire electrode being used



- 5 Press the "Shielding gas" button to select the shielding gas being used



- 6 Press the "Parameter selection" buttons



to select the welding parameter with which the welding power is to be specified:

Sheet thickness

**A** Welding current

Wire speed

**V** Welding voltage

- 7 Set the welding parameters

All parameter set values remain stored until the next time they are changed. This applies even if the power source is switched off and on again.

- 8 Ensure that the ground earth connection has been established

- 9 Ensure that the shielding gas supply has been established
  - Power source is ready for welding

---

**Corrections during welding**

The arc length correction and arc-force dynamic parameters can be used to optimize the welding result.

**Arc length correction:**

- = shorter arc, reduced welding voltage
- 0 = neutral arc
- + = longer arc, increased welding voltage

**Arc-force dynamic:**

For influencing the short-circuiting dynamic at the instant of droplet transfer

- = hard, stable arc
- 0 = neutral arc
- + = soft, low-spatter arc

# Spot welding and stitch welding

## General

The spot and stitch welding modes are MIG/MAG welding processes.

Spot welding is used on welded joints on overlapping sheets that are only accessible on one side.

Stitch welding is used for light-gage sheets.

As the wire electrode is not fed continuously, the weld pool can cool down during the intervals. Local overheating leading to the parent material being melted through is largely avoided.

## Spot welding

- 1 Press the "Process" button to select MANUAL or SYNERGIC



- 2 Press the "Mode" button



to select spot welding/stitch welding mode



- 3 Set the SPt parameter in the Setup menu (spot welding time/stitch welding time) to the desired value
- 4 Set the desired parameters depending on the process (MANUAL or SYNERGIC)
- 5 Ensure that the ground earth connection has been established
- 6 Ensure that the shielding gas supply has been established
  - Power source is ready for welding

## Stitch welding

- 1 Press the "Process" button to select MANUAL or SYNERGIC



- 2 Press the "Mode" button



to select spot welding/stitch welding mode



- 3 Set the SPt parameter in the Setup menu (spot welding time/stitch welding time) to the desired value
- 4 Set the SPb parameter in the Setup menu (spot welding/stitch pause time) to the desired value
- 5 Set the Int parameter (interval) in the Setup menu to the desired value
- 6 Set the desired parameters depending on the process (MANUAL or SYNERGIC)

- 7 Ensure that the ground earth connection has been established
- 8 Ensure that the shielding gas supply has been established
  - Power source is ready for welding

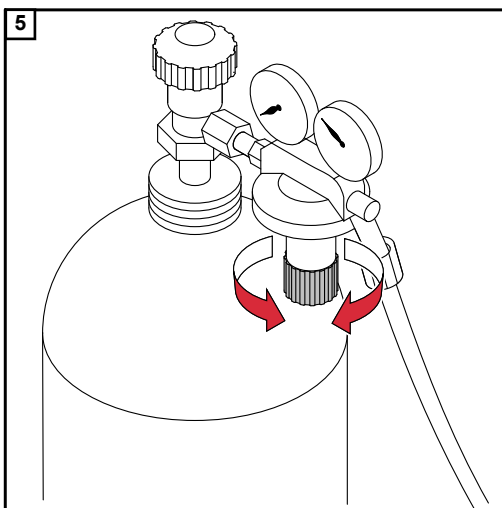
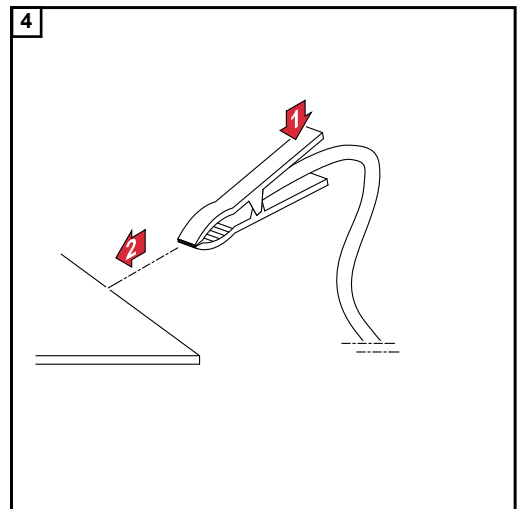
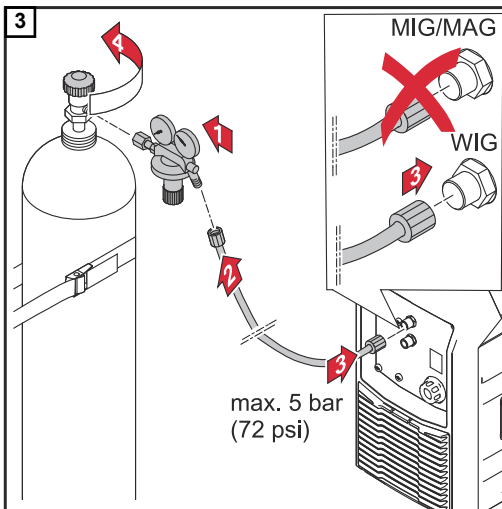
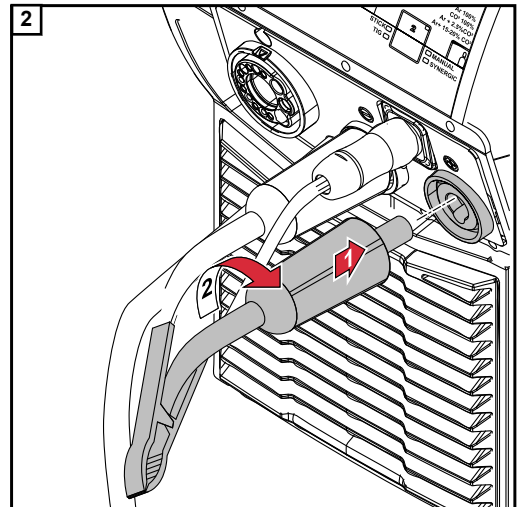
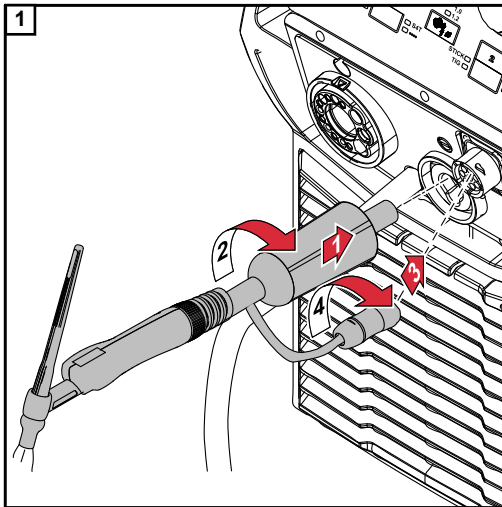
**TIG**

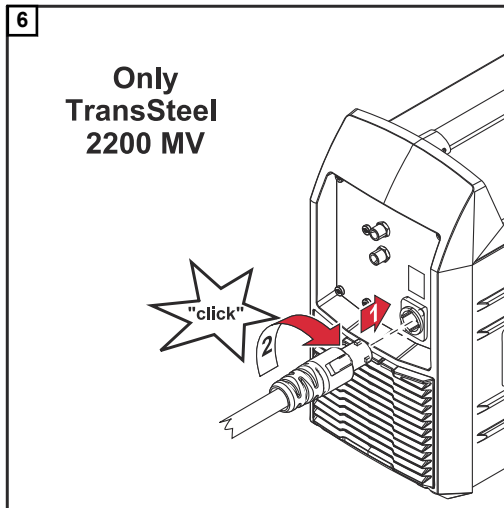




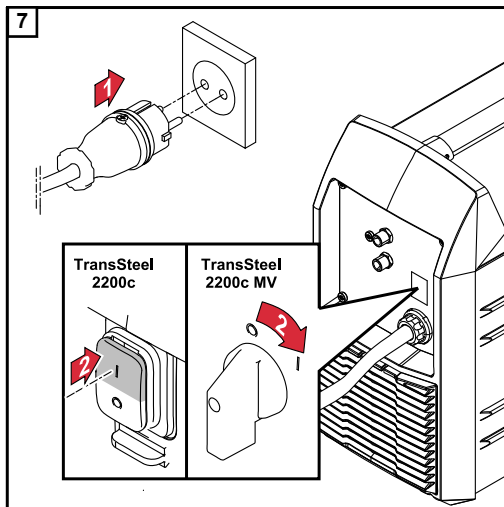
# Commissioning

## Start-Up





It is only necessary to connect the mains cable to the power source for multivoltage power sources.



**⚠ CAUTION!**

**Danger due to welding processes starting unintentionally.**

Personal injury and damage to property may result.

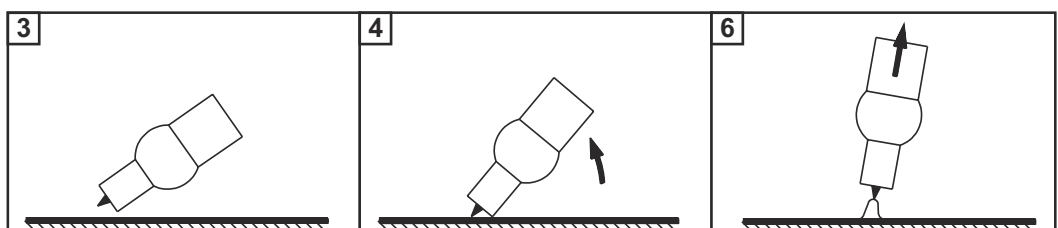
- ▶ As soon as the power source is switched on, ensure that the tungsten electrode does not accidentally, or in an uncontrolled manner, touch any electrically conductive or grounded parts (e.g., the housing, etc.).

**TIG welding**

- 1 Press the "Process" button to select TIG
- 2 Set the desired welding current

**When using a welding torch with a torch trigger and TIG Multi Connector plug (with 2-step mode factory setting):**

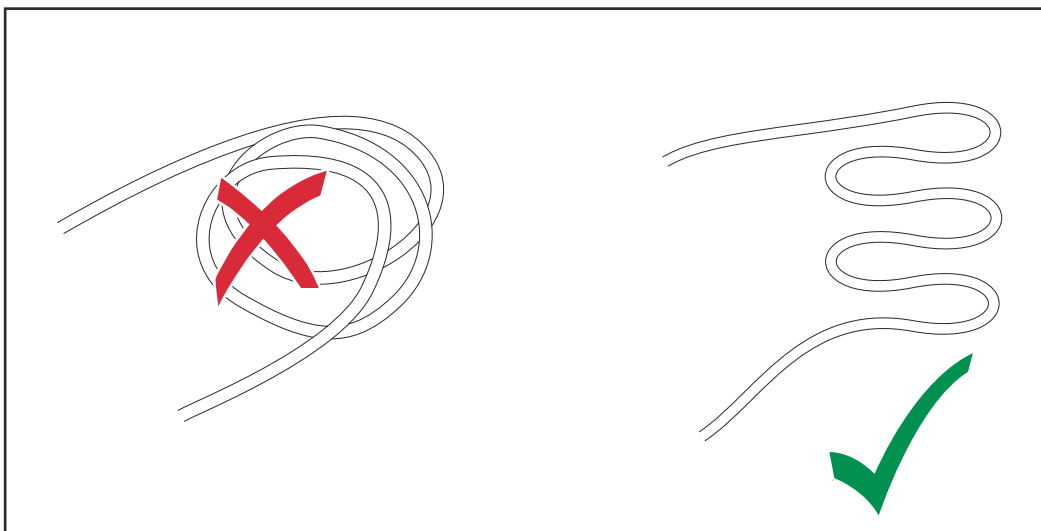
- 3 Position the gas nozzle at the ignition point so that there is a distance of approximately 2 to 3 mm (0.078 to 0.118 in.) between the tungsten electrode and the workpiece
- 4 Gradually tilt the welding torch up until the tungsten electrode touches the workpiece
- 5 Pull back the torch trigger and hold it in this position
  - Shielding gas flows
- 6 Raise the welding torch and rotate it into its normal position
  - The arc ignites
- 7 Carry out welding



**Selecting the desired country-specific setting**

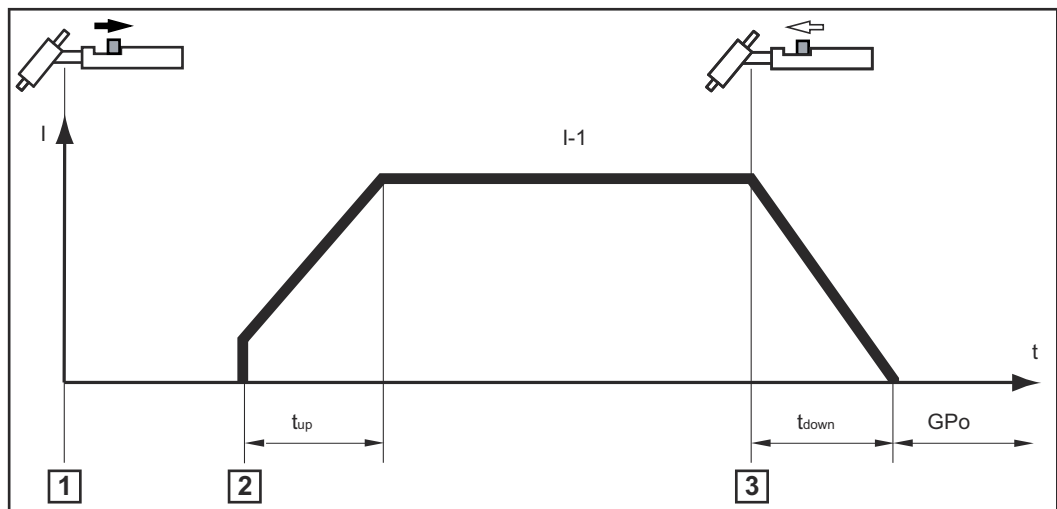
- The country-specific setting of the power source defines the unit (cm + mm or inch) in which the set welding parameters are displayed
- The country-specific setting can be changed in the Setup menu 2nd level (Parameter SEt)
  - A description of the SEt parameter and how to adjust the SEt parameter can be found in section [Setup Menu 2nd Level](#) from page [98](#)

**Laying the hosepacks correctly**



# Description of TIG Operating Modes

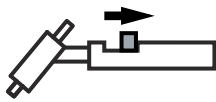
## 2-step mode



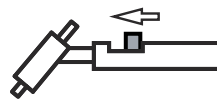
Welding with 2-step mode:

- 1** Place the tungsten electrode onto the workpiece and then pull the torch trigger back and hold => shielding gas flows
- 2** Raise the tungsten electrode => arc ignites
- 3** Release torch trigger => end of welding

Explanation of symbols:



*Pull back the torch trigger and hold it in this position*



*Release the torch trigger forwards*

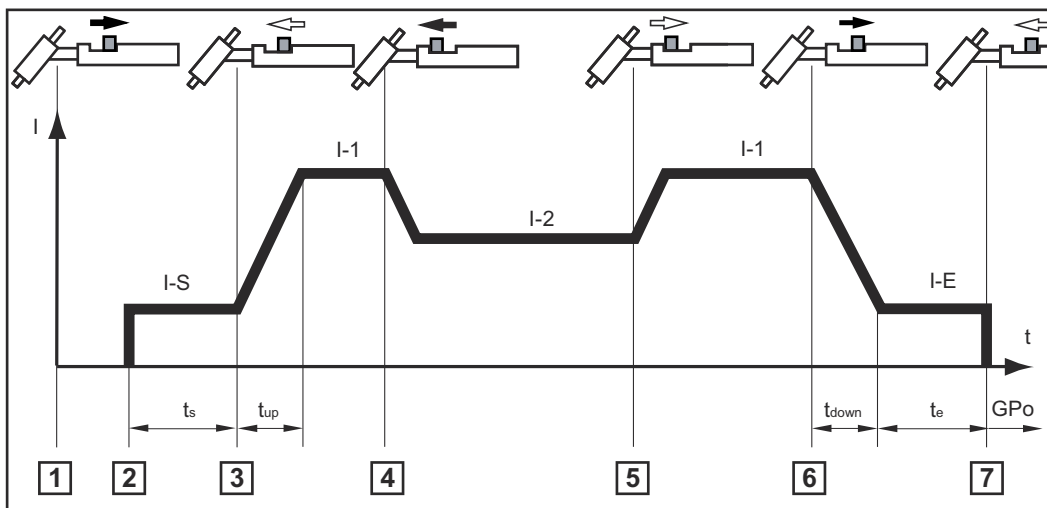
Abbreviations used:

GPo Gas post-flow time

$t_{up}$  UpSlope phase: the welding current is continually increased  
Duration: 0.5 seconds

$t_{down}$  DownSlope phase: the welding current is continuously reduced  
Duration: 0.5 seconds

4-step mode



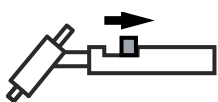
4-step mode with intermediate lowering I-2

Intermediate lowering means that the welder uses the torch trigger during the main current phase to lower the welding current to the specified reduced current I-2.

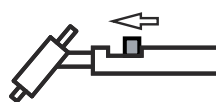
Welding with 4-step mode:

- 1 Place the tungsten electrode onto the workpiece and then pull the torch trigger back and hold => shielding gas flows
- 2 Raise the tungsten electrode => start of welding with starting current I-S
- 3 Release torch trigger => welding with main current I-1
- 4 Push forward and hold the torch trigger => activation of intermediate lowering with reduced current I-2
- 5 Release torch trigger => welding with main current I-1
- 6 Pull back and hold the torch trigger => lowering to final current I-E
- 7 Release torch trigger => end of welding

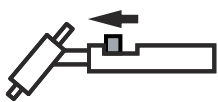
Explanation of symbols:



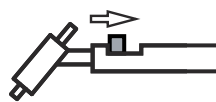
Pull back the torch trigger and hold it in this position



Release the torch trigger forwards



Pull back the torch trigger and hold it in this position



Release the torch trigger forwards

Abbreviations used:

GPo Gas post-flow time

I-S Starting-current phase: the temperature is raised gently at low welding current, so that the filler metal can be positioned correctly

I-1 Main current phase (welding current phase): uniform thermal input into the parent material, whose temperature is raised by the advancing heat

I-E Final current phase: to prevent crater cracks or shrink holes

- I-2 Reduced current phase: intermediate lowering of the welding current in order to prevent any local overheating of the parent material
- $t_s$  Starting current duration
- $t_{up}$  UpSlope phase: the welding current is continually increased  
Duration: 0.5 seconds
- $t_E$  Final current duration
- $t_{down}$  DownSlope phase: the welding current is continuously reduced  
Duration: 0.5 seconds

# Pulse welding

## Applications

Pulsed welding is welding with a pulsing welding current. It is used to weld steel pipes out-of-position or to weld thin sheet metal.

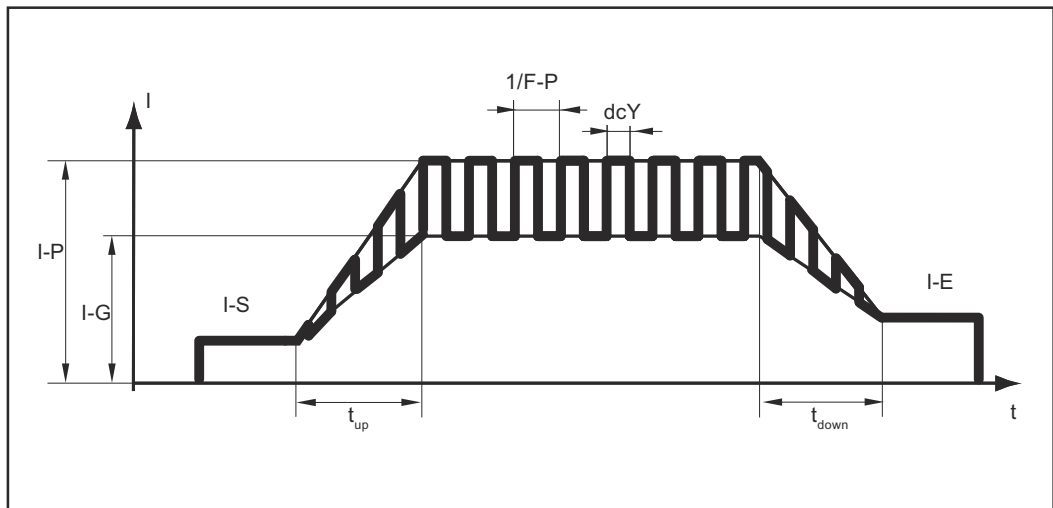
In these applications, the welding current set at the start of welding is not always optimum for the entire welding process:

- If the amperage is too low, the parent material will not be melted enough
- If overheating occurs, there is a danger that the liquid weld pool may drip.

## Operating principle

- A low base current I-G rises steeply to the significantly higher pulse current I-P and drops back to the base current I-G after the Duty cycle dcY time.
- This results in an average current that is lower than the set pulse current I-P.
- During pulse welding, small sections of the welding location melt quickly and then rapidly re-solidify.

The power source controls the "Duty cycle dcY" and "Base current I-G" parameters according to the set pulse current (welding current) and pulse frequency.



Welding current progression curve

### Adjustable parameters:

I-S Starting current

I-E Final current

F-P Pulse frequency ( $1/F-P = \text{Time between two pulses}$ )

I-P Pulse current (set welding current)

### Fixed parameters:

$t_{up}$  UpSlope

$t_{down}$  DownSlope

dcY Duty cycle

I-G Base current

---

**Activating pulse  
welding**

- 1 Set a value for the F-P setup parameter (pulse frequency)
  - Setting range: 1 - 990 Hz

For a parameter description see section [Parameters for TIG welding](#) from page **96**.

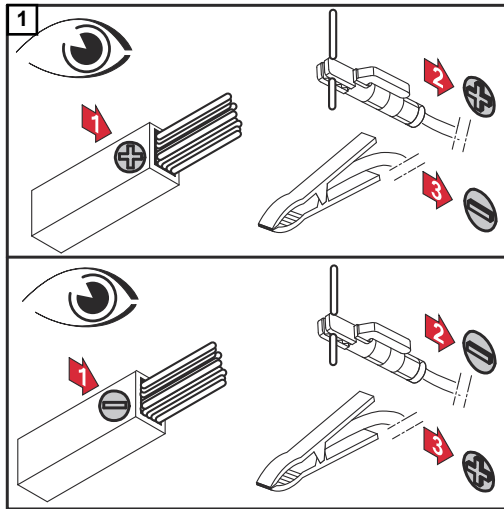


# Rod Electrode

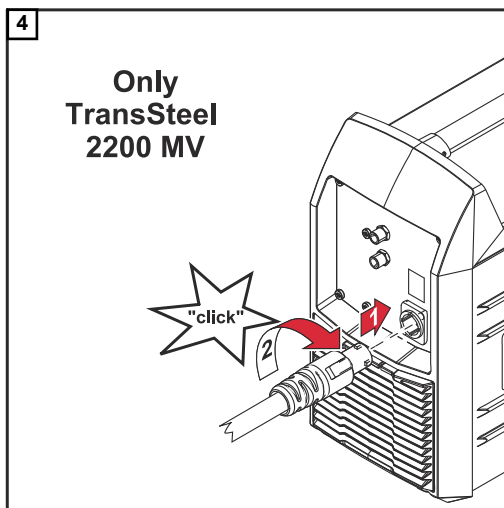
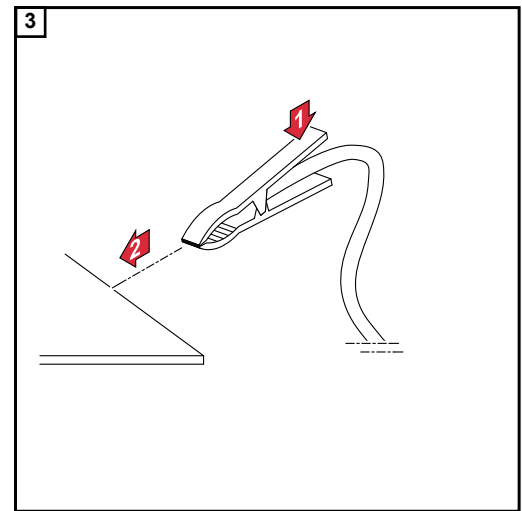
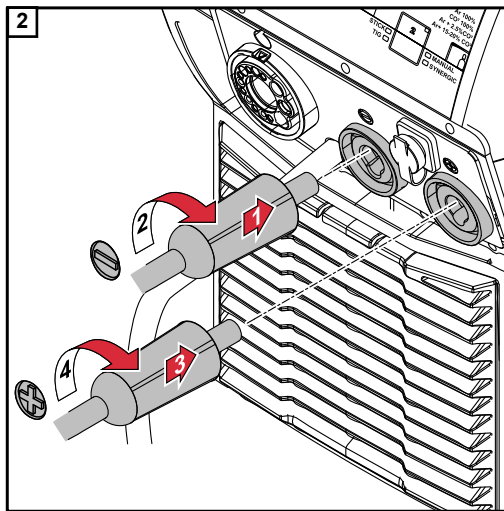


# Commissioning

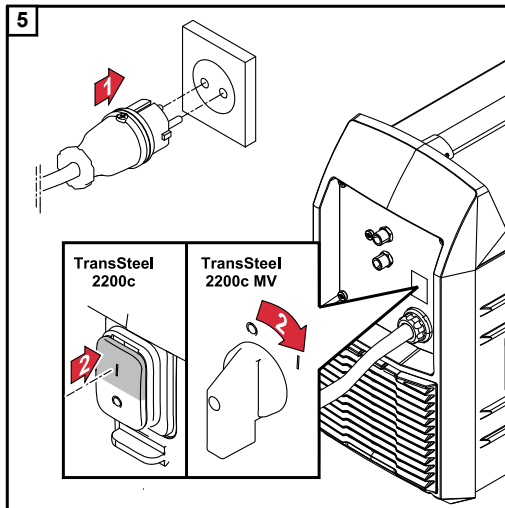
## Preparation



Check the rod electrode packaging to determine whether the rod electrode is for (+) or (-) welding.



It is only necessary to connect the mains cable to the power source for multivoltage power sources.



**CAUTION!**

**Danger due to welding processes starting unintentionally.**

Personal injury and damage to property may result.

- ▶ As soon as the power source is switched on, ensure that the rod electrode does not unintentionally touch electrically conductive or grounded parts (such as housing).

**Selecting the desired country-specific setting**

- The country-specific setting of the power source defines the unit (cm + mm or inch) in which the set welding parameters are displayed
- The country-specific setting can be changed in the Setup menu 2nd level (Parameter SEt)
  - A description of the SEt parameter and how to adjust the SEt parameter can be found in section [Setup Menu 2nd Level](#) from page 98

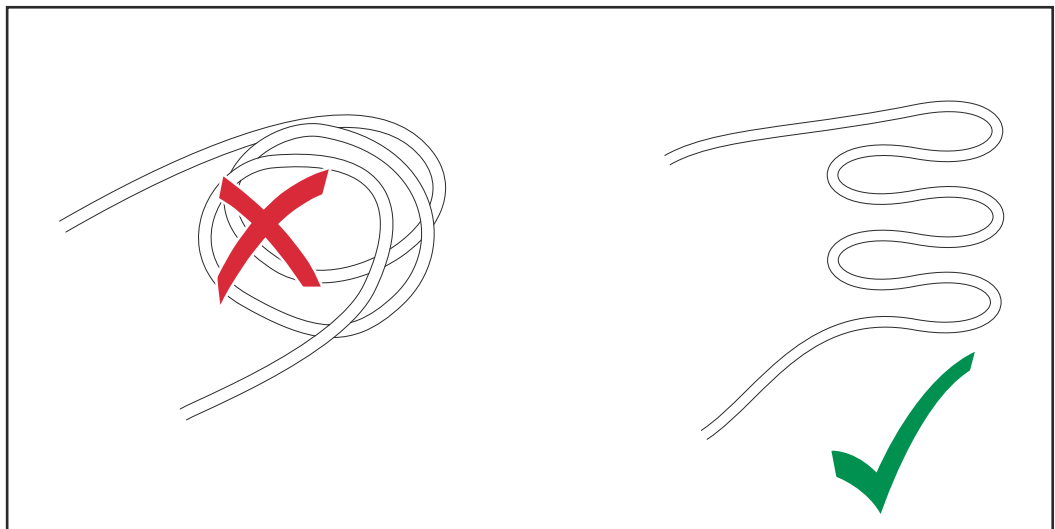
**Manual metal arc welding**

- 1 Press the "Process" button to select STICK



- 2 Set the desired welding current
  - Power source is ready for welding

**Laying the hosepacks correctly**



# Functions for Optimizing the Welding Process

## Arc-Force Dynamic

### Arc-force dynamic:

For influencing the short-circuiting dynamic at the instant of droplet transfer

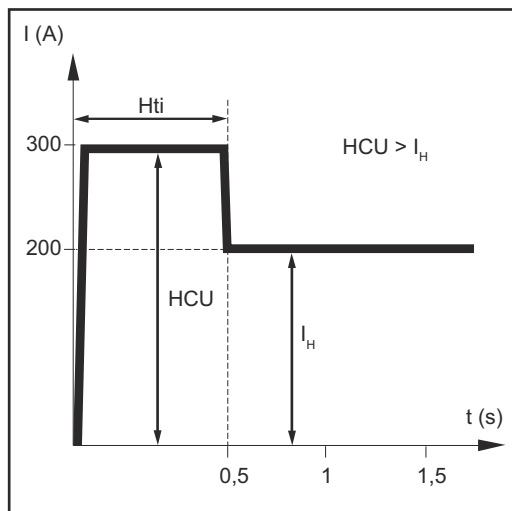
- = hard, stable arc
- 0 = neutral arc
- + = soft, low-spatter arc

## HotStart (Hti) function

This function is activated at the factory.

### Advantages

- Improved ignition properties, even when using electrodes with poor ignition properties
- Better fusion of the parent material during the start-up phase, meaning fewer cold-shut defects
- Slag inclusions largely avoided



### Key

- Hti Hot-current time, 0 - 2 s, factory setting 0.5 s
- HCU HotStart current, 100 - 200%, factory setting 150%
- $I_H$  Main current = set welding current

The Hti and HCU parameters can be set in the Setup menu. For a parameter description see section [Parameters for MMA Welding](#) from page 97.

### Function

During the specified hot-current time (Hti), the welding current is increased to a certain value. This value (HCU) is higher than the selected welding current ( $I_H$ ).

## Anti-stick (Ast) function

This function is activated at the factory.

As the arc becomes shorter, the welding voltage may also fall so that the rod electrode is more likely to stick to the workpiece. This may also cause the rod electrode to burn out.

Electrode burn-out is prevented by activating the anti-stick function. If the rod electrode begins to stick, the power source immediately switches the welding current off. The welding process can be resumed without problems once the rod electrode has been detached from the workpiece.

Deactivating the function:

- 1 Set the Ast (anti-stick) setup parameter to OFF

For a parameter description see section [Parameters for MMA Welding](#) from page 97.



# EasyJobs





# Saving and Retrieving EasyJobs

---

## General

- The "Save" buttons allow two EasyJobs to be saved
  - The adjustable parameters on the control panel are saved
  - Setup parameters are not saved at this time
- 

## Saving an Easy-Job

- 1 Press and hold one of the "Save" buttons to save the current settings on the control panel, e.g., Number 1



- The left indicator displays "Pro"
- After a short time, the left indicator switches to the original value

- 2 Release the "Save" button



## Retrieving an EasyJob

- 1 To retrieve saved settings, press the corresponding "Save" button briefly, e.g., Number 1



- The control panel will show the saved settings
- 

## Deleting an Easy-Job

- 1 Press and hold the relevant "Save" button to delete the memory content of that "Save" button, e.g., Number 1



- The left indicator displays "Pro"
- After a short time, the left indicator switches to the original value

- 2 Keep the "Save" button held down



- The left indicator displays "CLr"
- After a while, both indicators display "---"

- 3 Release the "Save" button





# Setup Menu

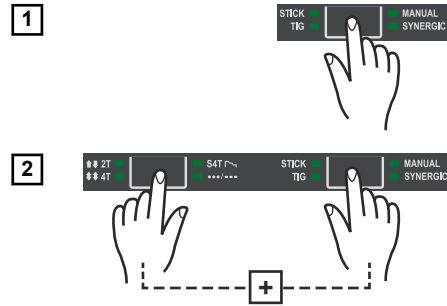


# Setup Menu Level 1

## Accessing and exiting the Setup menu, changing parameters

Accessing the Setup menu is described with reference to the MIG/MAG standard synergic (SYNERGIC) welding process. Access is the same for the other welding processes.

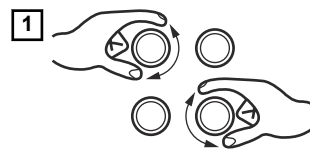
### Accessing the Setup menu:



Press the "Process" button to select the SYNERGIC welding process

The control panel is now located in the Setup menu of the "MIG/MAG standard synergic welding" process - the last selected setup parameter is displayed.

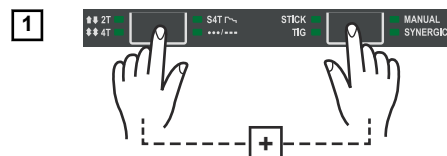
### To change a parameter:



Select the desired setup parameter using the left-hand selection dial

Change the setup parameter value using the right-hand selection dial

### To exit the Setup menu:



## Parameters for MIG/MAG Standard Manual Welding

GPr	<b>Gas pre-flow time</b> Unit: seconds Setting range: 0 - 9.9 Factory setting: 0.1
GPo	<b>Gas post-flow time</b> Unit: seconds Setting range: 0 - 9.9 Factory setting: 0.5
Fdi	<b>Feeder inching speed</b> Unit: m/min (ipm) Setting range: 1 - 18.5 (39.37 - 728.35) Factory setting: 10 (393.7)
IGc	<b>Ignition current</b> Unit: Ampere Setting range: 100 - 390 Factory setting: 300

Ito	<p><b>Length of wire that is fed before the safety cut-out trips</b>  Unit: mm (in.)  Setting range: OFF, 5 - 100 (OFF, 0.2 - 3.94)  Factory setting: OFF</p> <p>The ignition time-out function (Ito) is a safety feature.  If the power source determines that no ignition has occurred after the preset wire length has been fed, wirefeeding is stopped.</p>
SPt	<p><b>Spot welding time</b>  Unit: seconds  Setting range: OFF, 0.3 - 5  Factory setting: 1</p>
SPb	<p><b>Spot pause time</b>  Unit: seconds  Setting range: OFF, 0.3 - 10 (in 0.1 s increments)  Factory setting: OFF</p>
Int	<p><b>Interval</b>  Unit: -  Setting range: 2T (2-step), 4T (4-step)  Factory setting: 2T (2-step)</p>
FAC	<p><b>Reset power source to factory settings</b>  Press and hold one of the "Parameter selection" buttons for two seconds to restore the factory settings  - when "PrG" appears on the digital display, the power source has been reset</p> <p>When the power source is reset, the majority of the applied settings are deleted.  The following values remain:</p> <ul style="list-style-type: none"> <li>- Welding circuit resistance and welding circuit inductivity</li> <li>- Country-specific setting</li> </ul>
2nd	<p><b>Second level of the Setup menu (see "Setup Menu 2nd Level")</b></p>

**Parameters for  
MIG/MAG stand-  
ard synergic  
welding**

GPr	<p><b>Gas pre-flow time</b>  Unit: seconds  Setting range: 0 - 9.9  Factory setting: 0.1</p>
GPo	<p><b>Gas post-flow time</b>  Unit: seconds  Setting range: 0 - 9.9  Factory setting: 0.5</p>
SL	<p><b>Slope</b>  Unit: seconds  Setting range: 0 - 9.9  Factory setting: 1</p>
I-S	<p><b>Starting current</b>  Unit: % of welding current</p>

Setting range: 0 - 200

Factory setting: 100

---

I-E **Final current**

Unit: % of welding current

Setting range: 0 - 200

Factory setting: 50

---

t-S **Start current duration**

Unit: seconds

Setting range: 0 - 9.9

Factory setting: 0

---

t-E **Final current duration**

Unit: seconds

Setting range: 0 - 9.9

Factory setting: 0

---

Fdi **Feeder inching speed**

Unit: m/min (ipm)

Setting range: 1 - 18.5 (39.37 - 728.35)

Factory setting: 10 (393.7)

---

Ito **Length of wire that is fed before the safety cut-out trips**

Unit: mm (in.)

Setting range: OFF, 5 - 100 (OFF, 0.2 - 3.94)

Factory setting: OFF

The "Ignition time-out" function (Ito) is a safety function. If the power source determines that no ignition has occurred after the preset wire length has been fed, wirefeeding is stopped.

---

SPt **Spot welding time**

Unit: seconds

Setting range: 0.3 - 5

Factory setting: 1

---

SPb **Spot pause time**

Unit: seconds

Setting range: OFF, 0.3 - 10 (in 0.1 s increments)

Factory setting: OFF

---

Int **Interval**

Unit: -

Setting range: 2T (2-step), 4T (4-step)

Factory setting: 2T (2-step)

---

FAC **Reset power source to factory settings**

Press and hold one of the "Parameter selection" buttons for two seconds to restore the factory settings

- when "PrG" appears on the digital display, the power source has been reset.

When the power source is reset, the majority of the applied settings are deleted.

The following values remain:

- Welding circuit resistance and welding circuit inductivity
- Country-specific setting

---

2nd **Second level of the Setup menu (see "Setup Menu 2nd Level")**

---

---

**Parameters for  
TIG welding**

---

F-P **Pulse frequency**

Unit: Hertz

Setting range: OFF; 1 - 990

(up to 10 Hz: in 0.1 Hz increments)

(up to 100 Hz: in 1 Hz increments)

(over 100 Hz: in 10 Hz increments)

Factory setting: OFF

---

tUP **UpSlope**

Unit: seconds

Setting range: 0.01 - 9.9

Factory setting: 0.5

---

tdo **DownSlope**

Unit: seconds

Setting range: 0.01 - 9.9

Factory setting: 1

---

I-S **Starting current**

Unit: % of main current

Setting range: 1 - 200

Factory setting: 35

---

I-2 **Lowering current**

Unit: % of main current

Setting range: 1 - 100

Factory setting: 50

---

I-E **Final current**

Unit: % of main current

Setting range: 1 - 100

Factory setting: 30

---

GPO **Gas post-flow time**

Unit: seconds

Setting range: 0 - 9.9

Factory setting: 9.9

---

tAC **Tacking**

Unit: seconds

Setting range: OFF, 0.1 - 9.9

Factory setting: OFF

---

FAC **Reset power source to factory settings**

Press and hold one of the "Parameter selection" buttons for two seconds to restore the factory settings

- when "PrG" appears on the digital display, the power source has been reset.



When the power source is reset, the majority of the applied settings are deleted.

The following values remain:

- Welding circuit resistance and welding circuit inductivity
- Country-specific setting

---

2nd **Second level of the Setup menu (see "Setup Menu 2nd Level")**

---

**Parameters for  
MMA Welding**

---

HCU **HotStart current**  
 Unit: %  
 Setting range: 100 - 200  
 Factory setting: 150

---

Hti **Hot current time**  
 Unit: seconds  
 Setting range: 0 - 2.0  
 Factory setting: 0.5

---

Ast **Anti-stick function**  
 Unit: -  
 Setting range: On, OFF  
 Factory setting: On

---

FAC **Reset power source to factory settings**  
 Press and hold one of the "Parameter selection" buttons for two seconds to re-  
 store the factory settings  
 - when "PrG" appears on the digital display, the power source has been reset.

When the power source is reset, the majority of the applied settings are deleted.

The following values remain:

- Welding circuit resistance and welding circuit inductivity
- Country-specific setting

---

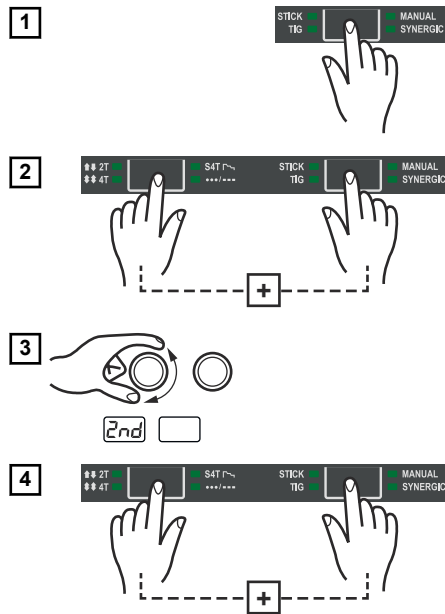
2nd **Second level of the Setup menu (see "Setup Menu 2nd Level")**

---

# Setup Menu 2nd Level

## Accessing and exiting the 2nd level of the Setup menu, changing parameters

### Accessing the 2nd level of the Setup menu:



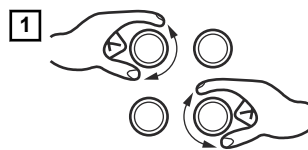
Press the "Process" button to select the "MIG/MAG standard synergic welding" process

The control panel is now located in the Setup menu of the "MIG/MAG standard synergic welding" process - the last selected setup parameter is displayed.

Select the "2nd" setup parameter using the left-hand selection dial

The control panel is now located in the 2nd level of the Setup menu of the "MIG/MAG standard synergic welding" process - the last selected setup parameter is displayed.

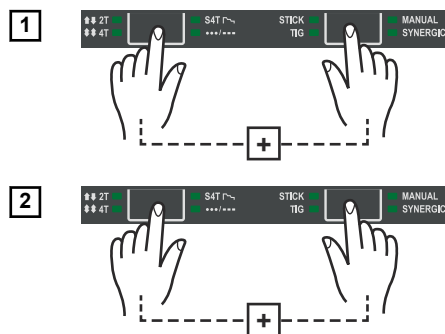
### To change a parameter:



Select the desired setup parameter using the left-hand selection dial

Change the setup parameter value using the right-hand selection dial

### To exit the Setup menu:



A parameter is displayed in the first level of the Setup menu.

A parameter is displayed in the first level of the Setup menu.

## Parameters for MIG/MAG standard manual welding

SEt **Country-specific setting (Standard/USA) ... Std/US**  
 Unit: -  
 Setting range: Std, US (Standard/USA)  
 Factory setting:  
 Standard device: Std (measurements in cm/mm)

USA device: US (measurements: inches)

- FUS **Mains fuse protection**  
 The maximum possible welding power is limited by the rating of the mains fuse protection used.  
 Unit: A  
 The available mains fuse ratings are determined by the SEt parameter setting:  
 SEt parameter set as Std: OFF / 10 / 13 / 16  
 SEt parameter set as US: OFF / 15 / 20 (only for 120 V grid voltage)  
 Factory setting: OFF

---

- r **Welding circuit resistance (in mOhm)**  
 See section [Measuring the welding circuit resistance \(MIG/MAG welding\)](#) from page [105](#)

---

- L **Welding circuit inductivity (in microhenrys)**  
 See section [Displaying the welding circuit inductivity](#) from page [107](#)

---

- EnE **Real Energy Input**  
 Unit: kJ  
 Setting range: ON / OFF  
 Factory setting: OFF  
 Since the full range of values (1 kJ - 99999 kJ) cannot be displayed on the three-digit display, the following display format has been selected:  
 Value in kJ: 1 to 999 / indicator on display: 1 to 999  
 Value in kJ: 1000 to 9999 / indicator on display: 1.00 to 9.99 (without unit digit, e.g., 5270 kJ -> 5.27)  
 Value in kJ: 10,000 to 99,999 / indicator on display: 10.0 to 99.9 (without unit digit or tens digit, e.g., 23580 kJ -> 23.6)

**Parameters for MIG/MAG standard synergic welding**

- SEt **Country-specific setting (Standard/USA) ... Std/US**  
 Unit: -  
 Setting range: Std, US (Standard/USA)  
 Factory setting:  
 Standard device: Std (measurements in cm/mm)  
 USA device: US (measurements: inches)

---

- FUS **Mains fuse protection**  
 The maximum possible welding power is limited by the rating of the mains fuse protection used.  
 Unit: A  
 The available mains fuse ratings are determined by the SEt parameter setting:  
 SEt parameter set as Std: OFF / 10 / 13 / 16  
 SEt parameter set as US: OFF / 15 / 20 (only for 120 V grid voltage)  
 Factory setting: OFF

---

- r **Welding circuit resistance (in mOhm)**  
 See section [Measuring the welding circuit resistance \(MIG/MAG welding\)](#) from page [105](#)

---

- L **Welding circuit inductivity (in microhenrys)**  
 See section [Displaying the welding circuit inductivity](#) from page [107](#)

---

- EnE **Real Energy Input**

Unit: kJ

Setting range: ON / OFF

Factory setting: OFF

Since the full range of values (1 kJ - 99999 kJ) cannot be displayed on the three-digit display, the following display format has been selected:

Value in kJ: 1 to 999 / indicator on display: 1 to 999

Value in kJ: 1000 to 9999 / indicator on display: 1.00 to 9.99 (without unit digit, e.g., 5270 kJ -> 5.27)

Value in kJ: 10,000 to 99,999 / indicator on display: 10.0 to 99.9 (without unit digit or tens digit, e.g., 23580 kJ -> 23.6)

---

ALC **Arc length correction display**

(For setting how the arc length correction parameter is displayed)

Setting range: ON / OFF

Factory setting: OFF

**Set to ON if the welding voltage parameter is selected and set on the control panel**

- The left-hand display shows the arc correction value for three seconds
  - The right-hand display shows the value for the welding voltage at the same time
- 

---

**Parameters for TIG welding**

SEt **Country-specific setting (Standard/USA) ... Std/US**

Unit: -

Setting range: Std, US (Standard/USA)

Factory setting:

Standard device: Std (measurements in cm/mm)

USA device: US (measurements: inches)

---

FUS **Mains fuse protection**

The maximum possible welding power is limited by the rating of the mains fuse protection used.

Unit: A

The available mains fuse ratings are determined by the SEt parameter setting:

SEt parameter set as Std: OFF / 10 / 13 / 16

SEt parameter set as US: OFF / 15 / 20 (only for 120 V grid voltage)

Factory setting: OFF

---

---

**Parameters for stick welding (SMAW)**

SEt **Country-specific setting (Standard/USA) ... Std/US**

Unit: -

Setting range: Std, US (Standard/USA)

Factory setting:

Standard device: Std (measurements in cm/mm)

USA device: US (measurements: inches)

---

r **Welding circuit resistance (in mOhm)**

See section [Measuring the welding circuit resistance \(stick welding\)](#) from page **106**

---

L **Welding circuit inductivity (in microhenrys)**  
See section [Displaying the welding circuit inductivity](#) from page [107](#)

---

FUS **Mains fuse protection**  
The maximum possible welding power is limited by the rating of the mains fuse protection used.  
Unit: A  
The available mains fuse ratings are determined by the SEt parameter setting:  
SEt parameter set as Std: OFF / 10 / 13 / 16  
SEt parameter set as US: OFF / 15 / 20 (only for 120 V grid voltage)  
Factory setting: OFF

---



# Optimizing Weld Quality





# Measuring the welding circuit resistance

## General

Measuring the welding circuit resistance makes it possible to have a constant welding result at all times, even with hosepacks of different lengths. The welding voltage at the arc is then always precisely regulated, regardless of the length and cross-sectional area of the hosepack. The use of arc length correction is no longer required.

The calculated welding circuit resistance is shown on the display.

$r$  = welding circuit resistance in milliohm (mOhm)

If the welding circuit resistance has been measured correctly, the set welding voltage will correspond exactly to the welding voltage at the arc. If you manually measure the voltage on the output jacks of the power source, this voltage will be higher than the welding voltage at the arc - that is, higher by the same amount as the voltage drop of the hosepack.

The welding circuit resistance depends on the hosepack used:

- If the length or cross-sectional area of the hosepack has changed, measure the welding circuit resistance again
- Measure the welding circuit resistance for every welding process separately with the appropriate welding power-leads

## Measuring the welding circuit resistance (MIG/MAG welding)

### NOTE!

#### Risk of incorrect measurement of the welding circuit resistance.

This can have a negative effect on the welding results.

- ▶ Ensure that the workpiece has an optimum contact surface in the area of the earthing clamp (clean surface, no rust, etc.).

- 1 Ensure that either the MANUAL or SYNERGIC welding process is selected
- 2 Establish a ground earth connection to the workpiece
- 3 Access the Setup menu 2nd level (2nd)
- 4 Select parameter "r"
- 5 Remove the gas nozzle from the welding torch
- 6 Screw on the contact tip
- 7 Ensure that the wire electrode does not protrude from the contact tip

### NOTE!

#### Risk of incorrect measurement of the welding circuit resistance.

This can have a negative effect on the welding results.

- ▶ Ensure that the workpiece has an optimum contact surface for the contact tip (clean surface, no rust, etc.).

- 8 Place the contact tip flush against the workpiece surface
- 9 Press the torch trigger briefly
  - The welding circuit resistance is calculated. "run" is shown on the display during the measurement

The measurement is finished when the welding circuit resistance is shown on the display in mOhm (for example 11.4).

- 10 Fit the gas nozzle back onto the welding torch
- 

### Measuring the welding circuit resistance (stick welding)

#### **NOTE!**

#### **Risk of incorrect measurement of the welding circuit resistance.**

This can have a negative effect on the welding results.

- ▶ Ensure that the workpiece has an optimum contact surface in the area of the earthing clamp (clean surface, no rust, etc.).
- 

- 1 Ensure that the STICK welding process is selected
- 2 Establish a ground earth connection to the workpiece
- 3 Access the Setup menu 2nd level (2nd)
- 4 Select parameter "r"

#### **NOTE!**

#### **Risk of incorrect measurement of the welding circuit resistance.**

This can have a negative effect on the welding results.

- ▶ Ensure that the workpiece has an optimum contact surface for the electrode flush (clean surface, no rust, etc.).
- 

- 5 Place the electrode flush against the workpiece surface
- 6 Press the "Parameter selection" button (right)
  - The welding circuit resistance is calculated. "run" is shown on the display during the measurement



The measurement is finished when the welding circuit resistance is shown on the display in mOhm (for example 11.4).

# Displaying the welding circuit inductivity

---

## General

The way that the hosepack is arranged has a very significant effect on the welding circuit inductivity and therefore affects the welding process. It is important to lay the hosepacks correctly in order to obtain the best possible welding result.

---

## Displaying the welding circuit inductivity

The setup parameter "L" is used to display the most recently calculated welding circuit inductivity. The welding circuit inductivity is adjusted when the welding circuit resistance is measured. Detailed information in this regard can be found under the "Welding circuit resistance" chapter.

- 1 Access the Setup menu 2nd level (2nd)
- 2 Select parameter "L"

The most recently calculated welding circuit inductivity L is shown on the right-hand digital display.

L ... Welding circuit inductivity (in microhenrys)



# **Troubleshooting and Maintenance**

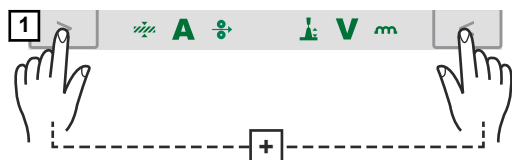


# Displaying Service Parameters

## Service parameters

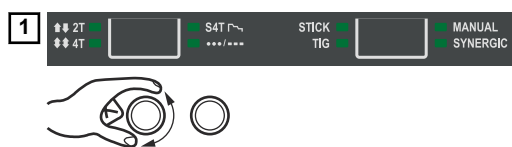
Various service parameters can be retrieved by pressing the left and right-hand "Parameter selection" buttons at the same time.

### Opening the display:



The first parameter "Firmware version" will be displayed, e.g., "1.00 | 4.21"

### Selecting parameters:



Use the "Mode" and "Process" buttons or the left-hand selection dial to select the required setup parameter

### Available parameters

Example: 1.00   4.21	Firmware version
Example: 2   491	Welding program configuration
Example: r 2   290	Number of the currently selected welding program
Example: 654   32.1 = 65,432.1 hours = 65,432 hours 6 mins	Indicates the actual arc time since first use. Note: The arc time indicator is not suitable as a basis for calculating hiring fees, warranty services, etc.
Example: iFd   0.0	Motor current for wire drive in A The value changes as soon as the motor is running.
2nd	Second menu level for service technicians

# Troubleshooting

---

## Safety

### **WARNING!**

#### **Danger from incorrect operation and work that is not carried out properly.**

This can result in serious personal injury and damage to property.

- ▶ All the work and functions described in this document must only be carried out by technically trained and qualified personnel.
  - ▶ Read and understand this document in full.
  - ▶ Read and understand all safety rules and user documentation for this equipment and all system components.
- 

### **WARNING!**

#### **Danger from electrical current.**

This can result in serious personal injury and damage to property.

- ▶ Before starting work, switch off all devices and components involved, and disconnect them from the grid.
  - ▶ Secure all devices and components involved so they cannot be switched back on.
  - ▶ After opening the device, use a suitable measuring instrument to check that electrically charged components (such as capacitors) have been discharged.
- 

### **WARNING!**

#### **Danger due to insufficient ground conductor connection.**

This can result in serious personal injury and damage to property.

- ▶ The housing screws provide a suitable ground conductor connection for grounding the housing.
  - ▶ The housing screws must not under any circumstances be replaced by other screws without a reliable ground conductor connection.
- 

## Troubleshooting

Make a note of the serial number and configuration of the device, and provide the service team with a detailed error description if:

- Errors occur that are not covered in this document
  - The troubleshooting measures provided in this document are unsuccessful
- 

#### **Power source not working**

Power source switched on, displays do not illuminate

Cause: Grid lead damaged or broken, grid plug not inserted

Remedy: Check grid lead, if necessary insert grid plug

Cause: Grid socket or grid plug faulty

Remedy: Replace faulty parts

Cause: Grid fuse

Remedy: Replace grid fuse



---

**Nothing happens when the torch trigger is pressed**

Power source mains switch is ON and indicators are lit up

Cause: Welding torch or welding torch control line faulty

Remedy: Replace welding torch

---

**No welding current**

Power switch is on, one of the overtemperature service codes "to" is displayed. Detailed information on the service codes "to0" to "to6" can be found in the section **Displayed Service Codes** from page **115**.

Cause: Overloading

Remedy: Observe the duty cycle

Cause: Thermal automatic circuit breaker has tripped

Remedy: Wait until the power source automatically comes back on after the end of the cooling phase

Cause: Limited supply of cooling air

Remedy: Clean the air filter, ensure accessibility to the ventilation openings - see section **Maintenance as required, at least every two months** from page **120**

Cause: Fan in the power source is faulty

Remedy: Contact After-Sales Service

---

**No welding current**

Power source switched on, displays illuminate

Cause: Incorrect ground connection

Remedy: Check ground connection for polarity

Cause: Power cable in welding torch damaged or broken.

Remedy: Replace welding torch

---

**No shielding gas**

All other functions are OK

- Cause: Gas hose is not connected to the correct connection socket for the current welding process  
Remedy: Connect the gas hose to the correct connection socket for the current welding process
- Cause: Gas cylinder empty  
Remedy: Change gas cylinder
- Cause: Gas pressure regulator faulty  
Remedy: Replace gas pressure regulator
- Cause: Gas hose is not fitted or is damaged  
Remedy: Fit or change gas hose
- Cause: Welding torch faulty  
Remedy: Change welding torch
- Cause: Gas solenoid valve faulty  
Remedy: Inform service team

---

**Irregular wire speed**

- Cause: Braking force has been set too high  
Remedy: Loosen the brake
- Cause: Contact tip hole too narrow  
Remedy: Use suitable contact tip
- Cause: Faulty inner liner in welding torch  
Remedy: Check the inner liner for kinks, dirt, etc. and replace if necessary
- Cause: Feed rollers not suitable for wire electrode used  
Remedy: Use suitable feed rollers
- Cause: Incorrect contact pressure of feed rollers  
Remedy: Optimize contact pressure

---

**Wirefeed problems**

- Cause: Incorrect arrangement of welding torch hosepack  
Remedy: Arrange the welding torch hosepack in as straight a line as possible, avoiding bends

---

**Welding torch gets very hot**

- Cause: Welding torch is inadequately sized  
Remedy: Observe duty cycle and load limits

---

**Poor-quality weld properties**

Cause: Incorrect welding parameters

Remedy: Check settings

Cause: Poor ground earth connection

Remedy: Establish good contact with workpiece

Cause: Too little or no shielding gas

Remedy: Check gas pressure regulator, gas hose, gas solenoid valve, welding torch gas connection, etc.

Cause: Welding torch leaks

Remedy: Change welding torch

Cause: Incorrect or heavily worn contact tip

Remedy: Change contact tip

Cause: Incorrect wire alloy or incorrect wire diameter

Remedy: Check wire electrode in use

Cause: Incorrect wire alloy or incorrect wire diameter

Remedy: Check weldability of the base material

Cause: Shielding gas not suitable for wire alloy

Remedy: Use correct shielding gas

---

---

**Displayed Service Codes**

If an error message that is not described here appears on the displays, first try to resolve the problem as follows:

- 1 Switch the power source power switch to the -O- position
- 2 Wait ten seconds
- 3 Switch the power switch to the -I- position

If the error occurs again despite several attempts to eliminate it, or if the troubleshooting measures listed here are unsuccessful:

- 1 Make a note of the error message displayed
  - 2 Note down the configuration of the power source
  - 3 Contact our After-Sales Service team with a detailed description of the error
- 

**ELn | 13**

Cause: Impermissible change of welding process during welding

Remedy: During welding do not make any impermissible change to the welding process, reset error message by pressing any button

---

**Err | IP**

Cause: The power source control has detected a primary overvoltage

Remedy: Check the grid voltage.

If the service code persists, switch off the power source, wait for 10 seconds and then switch the power source on again.

If the error still persists, contact the After-Sales Service team

---

**Err | 51**

Cause: Mains undervoltage: Mains voltage has fallen below the tolerance range

Remedy: Check the mains voltage. If the service code remains, contact After-Sales Service

---

**Err | 52**

Cause: Mains overvoltage: the grid voltage has risen above the tolerance range

Remedy: Check the grid voltage.  
If the service code persists, contact After-Sales Service

---

**EFd | 14, EFd | 81, EFd | 83**

Cause: Fault in the wirefeed system - overcurrent in the wirefeeder motor (2-roller drive)

Remedy: Arrange the hosepack in as straight a line as possible; check that there are no kinks or dirt in the inner liner; check the contact pressure on the 2-roller drive; check that there is no entangled wire in the 2-roller drive

Cause: Wirefeeder motor is sticking or defective

Remedy: Check the wirefeeder motor or contact After-Sales Service

---

**to0 | xxx**

Note: xxx stands for a temperature value

Cause: Overtemperature on the PC board LSTMAG20 (secondary circuit)

Remedy: Allow power source to cool down, check air filter and clean if necessary, check that fan is on

---

**to2 | xxx**

Note: xxx stands for a temperature value

Cause: Overtemperature in the secondary circuit of the power source

Remedy: Allow power source to cool down, check air filter and clean if necessary (see section **Maintenance as required, at least every two months** on page **120**), check whether the fan is running

---

**to3 | xxx**

Note: xxx stands for a temperature value

Cause: Overtemperature on the PC board LSTMAG20 (wirefeeder)

Remedy: Allow power source to cool down, check air filter and clean if necessary (see section **Maintenance as required, at least every two months** on page **120**), check whether the fan is running

---

**to6 | xxx**

Note: xxx stands for a temperature value

Cause: Overtemperature on the PC board LSTMAG20 (voltage doubler)

Remedy: Allow power source to cool down, check air filter and clean if necessary (see section **Maintenance as required, at least every two months** on page **120**), check whether the fan is running

---

**to7 | xxx**

Note: xxx stands for a temperature value

Cause: Overtemperature in the power source

Remedy: Allow power source to cool down, check air filter and clean if necessary, check that fan is on

---

**to8 | xxx**

Note: xxx stands for a temperature value

Cause: Overtemperature on the power module

Remedy: Allow power source to cool down, check that fan is on

---

**to9 | xxx**

Note: xxx stands for a temperature value

Cause: Overtemperature on the PFC module

Remedy: Allow power source to cool down, check that fan is on

---

**toA | xxx**

Note: xxx stands for a temperature value

Cause: Overtemperature on the PC board LSTMAG20 (PFC)

Remedy: Allow power source to cool down, check that fan is on

---

**toF | xxx**

Cause: The power source's safety cut-out reacted in order to prevent tripping of the mains fuse.

Remedy: After a pause in welding of around 90 s, the message disappears and the power source is operational again.

---

**tu0 | xxx**

Note: xxx stands for a temperature value

Cause: Undertemperature on the PC board (secondary circuit)

Remedy: Place power source in a heated room and allow it to warm up

---

**tu2 | xxx**

Note: xxx stands for a temperature value

Cause: Undertemperature in the power source secondary circuit

Remedy: Place power source in a heated room and allow it to warm up

---

**tu3 | xxx**

Note: xxx stands for a temperature value

Cause: Undertemperature on the PC board LSTMAG20 (wirefeeder)

Remedy: Place power source in a heated room and allow it to warm up

---

**tu6 | xxx**

Note: xxx stands for a temperature value

Cause: Undertemperature on the PC board LSTMAG20 (voltage doubler)

Remedy: Place power source in a heated room and allow it to warm up

---

**tu7 | xxx**

Note: xxx stands for a temperature value

Cause: Undertemperature in power source

Remedy: Place power source in a heated room and allow it to warm up

---

**tu8 | xxx**

Note: xxx stands for a temperature value

Cause: Undertemperature on the power module

Remedy: Place power source in a heated room and allow it to warm up

---

**tu9 | xxx**

Note: xxx stands for a temperature value

Cause: Undertemperature on the PFC module

Remedy: Place power source in a heated room and allow it to warm up

---

**tuA | xxx**

Note: xxx stands for a temperature value

Cause: Undertemperature on the PC board LSTMAG20 (PFC)

Remedy: Place power source in a heated room and allow it to warm up

---

**no | Prg**

Cause: No saved program selected

Remedy: Select saved program

---

**no | IGn**

Cause: "Ignition time-out" function is active; current did not start flowing before the length of wire specified in the Setup menu had been fed. The power source safety cut-out has tripped

Remedy: Shorten the wire stick-out; press the torch trigger again; clean the surface of the workpiece; if necessary, set the "lto" parameter in the Setup menu

---

**no | ARC**

Cause: Arc break during TIG welding

Remedy: Press the torch trigger repeatedly, clean the surface of the workpiece

---

**EPG | 17**

Cause: The selected welding program is invalid

Remedy: Select a valid welding program

---

**EPG | 35**

Cause: Measurement of the welding circuit resistance failed

Remedy: Check grounding cable, current cable, or hosepack and replace if necessary, re-measure the welding circuit resistance

---

# Service, maintenance and disposal

## General

Under normal operating conditions, the welding system requires only a minimum of care and maintenance. However, several points must be observed in order for the welding system to remain operational for years to come.

## Safety



### WARNING!

#### **Danger from incorrect operation and work that is not carried out properly.**

This can result in serious personal injury and damage to property.

- ▶ All the work and functions described in this document must only be carried out by technically trained and qualified personnel.
- ▶ Read and understand this document in full.
- ▶ Read and understand all safety rules and user documentation for this equipment and all system components.



### WARNING!

#### **Danger from electrical current.**

This can result in serious personal injury and damage to property.

- ▶ Before starting work, switch off all devices and components involved, and disconnect them from the grid.
- ▶ Secure all devices and components involved so they cannot be switched back on.
- ▶ After opening the device, use a suitable measuring instrument to check that electrically charged components (such as capacitors) have been discharged.



### WARNING!

#### **Danger due to insufficient ground conductor connection.**

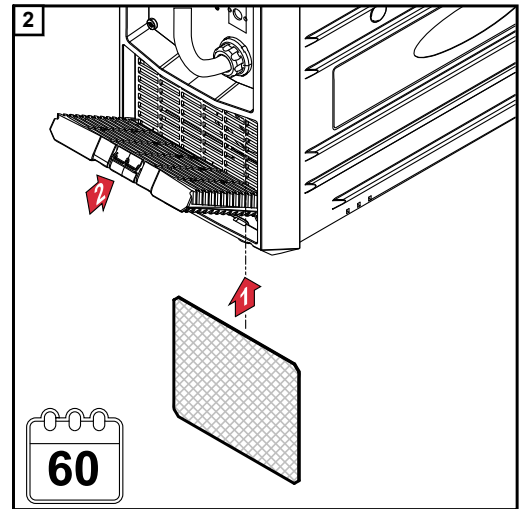
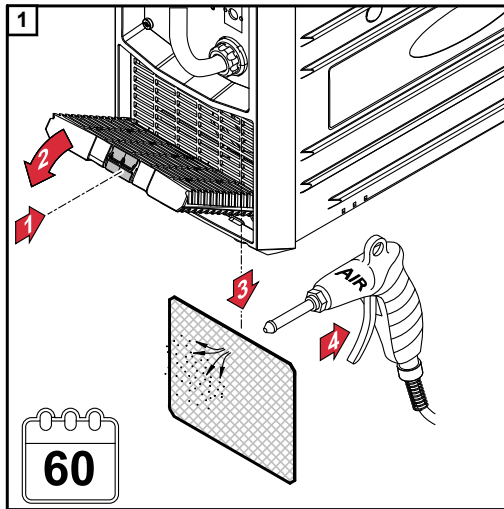
This can result in serious personal injury and damage to property.

- ▶ The housing screws provide a suitable ground conductor connection for grounding the housing.
- ▶ The housing screws must not under any circumstances be replaced by other screws without a reliable ground conductor connection.

## Maintenance at every start-up

- Ensure that the mains plug and mains cable as well as the welding torch / electrode holder are undamaged. Replace any damaged components.
- Ensure that the welding torch / electrode holder and the grounding cable are properly connected to the power source and screwed/locked in place as described in this document
- Ensure a proper ground earth connection to the component.
- Ensure that the all-round clearance of the device is 0.5 m (1 ft. 8 in.) so that cooling air can circulate unimpeded. Air inlet and outlet openings must not be blocked or even partially covered.

Maintenance as required, at least every two months



**⚠ CAUTION!**

**Danger from wet air filter.**

This can result in damage to property.

- ▶ Ensure that the air filter is dry when it is fitted.

Maintenance every 6 months

**⚠ CAUTION!**

**Danger due to the effect of compressed air.**

This can result in damage to property.

- ▶ Do not bring the air nozzle too close to electronic parts.

- 1 Remove the right-hand device side panel (as viewed from the front) and blow the inside of the device clean with dry, reduced compressed air
- 2 Also clean the ventilation openings if there is a large accumulation of dust

**Disposal**

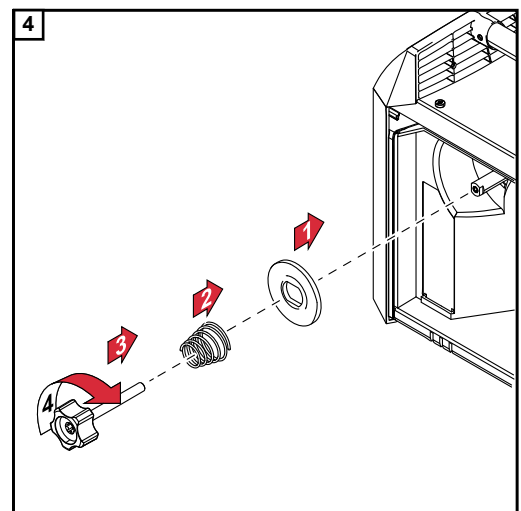
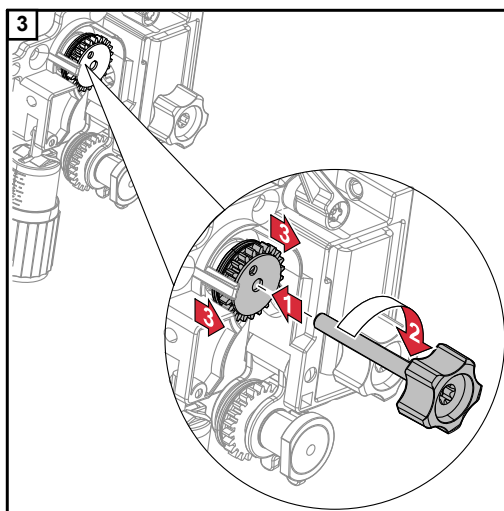
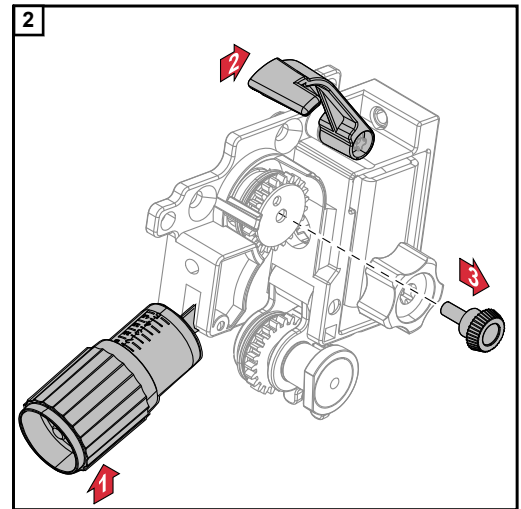
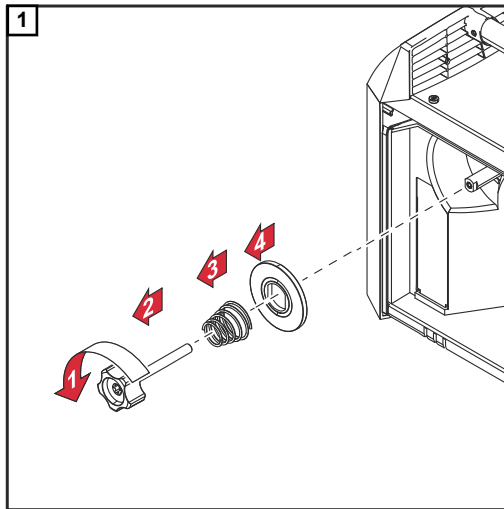
Materials should be disposed of according to valid local and national regulations.



# Removing Stiff Drive Rollers

## Removing a stiff drive roller

If a drive roller is difficult to remove by hand, the knurled screw on the D100 brake can be used to remove it.





# Appendix



# Average consumption values during welding

**Average wire electrode consumption during MIG/MAG welding**

<b>Average wire electrode consumption at a wire speed of 5 m/min</b>			
	1.0 mm wire electrode diameter	1.2 mm wire electrode diameter	1.6 mm wire electrode diameter
Steel wire electrode	1.8 kg/h	2.7 kg/h	4.7 kg/h
Aluminum wire electrode	0.6 kg/h	0.9 kg/h	1.6 kg/h
CrNi wire electrode	1.9 kg/h	2.8 kg/h	4.8 kg/h

<b>Average wire electrode consumption at a wire speed of 10 m/min</b>			
	1.0 mm wire electrode diameter	1.2 mm wire electrode diameter	1.6 mm wire electrode diameter
Steel wire electrode	3.7 kg/h	5.3 kg/h	9.5 kg/h
Aluminum wire electrode	1.3 kg/h	1.8 kg/h	3.2 kg/h
CrNi wire electrode	3.8 kg/h	5.4 kg/h	9.6 kg/h

**Average shielding gas consumption during MIG/MAG welding**

Wire electrode diameter	1.0 mm	1.2 mm	1.6 mm	2.0 mm	2 x 1.2 mm (TWIN)
Average consumption	10 l/min	12 l/min	16 l/min	20 l/min	24 l/min

**Average shielding gas consumption during TIG welding**

Gas nozzle size	4	5	6	7	8	10
Average consumption	6 l/min	8 l/min	10 l/min	12 l/min	12 l/min	15 l/min

# Technical data

## Overview with critical raw materials, year of production of the device

### Overview with critical raw materials:

An overview of which critical raw materials are contained in this device can be found at the following Internet address.

[www.fronius.com/en/about-fronius/sustainability](http://www.fronius.com/en/about-fronius/sustainability).

### To calculate the year of production of the device:

- Each device is provided with a serial number
- The serial number consists of 8 digits - for example 28020099
- The first two digits give the number from which the year of production of the device can be calculated
- This figure minus 11 gives the year of production
  - For example: Serial number = **28**020065, calculation of the year of production = **28** - 11 = 17, year of production = 2017

## Special voltage

For devices designed for special voltages, the technical data on the rating plate applies.

## Explanation of the Term Duty Cycle

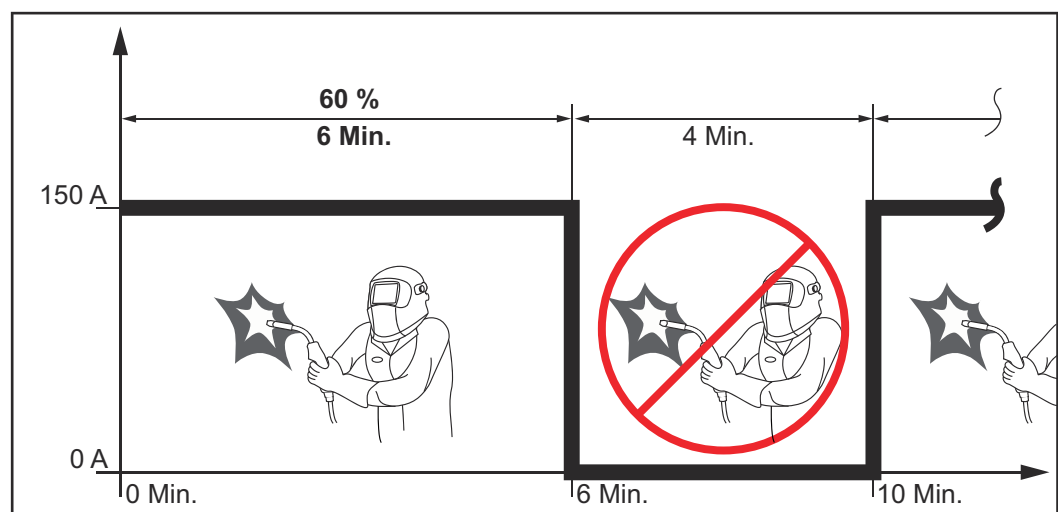
The duty cycle (D.C.) is the period of a ten minute cycle in which the device may be operated at the stated power without overheating.

### NOTE!

**The D.C. values cited on the rating plate relate to an ambient temperature of 40 °C. If the ambient temperature is higher, the D.C. or power must be lowered accordingly.**

Example: Welding with 150 A at 60% D.C.

- Welding phase = 60% of 10 mins = 6 mins
- Cool-down phase = rest time = 4 mins
- Following the cool-down phase, the cycle begins again.



To use the device without interruptions:

- 1 Search for a 100% D.C. value in the technical data, which corresponds to the existing ambient temperature.

- 2 Reduce the power or amperage value correspondingly so that the device can operate without a cool-down phase.

**TransSteel 2200**

Grid voltage ( $U_1$ )	1 x	230 V		
Max. effective primary current ( $I_{1\text{eff}}$ )			16 A	
Max. primary current ( $I_{1\text{max}}$ )			26 A	
Mains fuse protection			16 A slow-blow	
Max. apparent power ( $S_{1\text{max}}$ )			5.98 kVA	
Mains voltage tolerance			-20 / +15%	
Grid frequency			50 / 60 Hz	
Cos phi (1)			0.99	
Max. permitted grid impedance $Z_{\text{max}}$ on PCC <sup>1)</sup>			250.02 mOhm	
Recommended residual-current circuit breaker			Type B	
Welding current range ( $I_2$ )				
MIG/MAG			10 - 210 A	
MMA			10 - 180 A	
TIG			10 - 230 A	
Welding current at	10 min / 40 °C (104 °F)	30%	60%	100%
MIG/MAG	$U_1$ 230 V	210 A	170 A	150 A
Welding current at	10 min / 40 °C (104 °F)	35%	60%	100%
MMA	$U_1$ 230 V	180 A	150 A	130 A
Welding current at	10 min / 40 °C (104 °F)	35%	60%	100%
TIG	$U_1$ 230 V	230 A	200 A	170 A
Output voltage range according to standard characteristic ( $U_2$ )				
MIG/MAG			14.5 - 24.5 V	
MMA			20.4 - 27.2 V	
TIG			10.4 - 19.2 V	
Open circuit voltage ( $U_0$ peak / $U_0$ r.m.s)			90 V	
Protection class			IP 23	
Type of cooling			AF	
Overvoltage category			III	
Pollution degree according to IEC60664			3	
EMC device class			A <sup>2)</sup>	
Safety markings			S, CE	
Dimensions l x w x h			560 x 215 x 370 mm 22.05 x 8.46 x 14.57 in.	

Weight	15 kg 33.07 lb.
Max. shielding gas pressure	5 bar 72.52 psi
Wire speed	1.5 - 18 m/min 59.06 - 708.66 ipm
Wire drive	2-roller drive
Wire diameter	0.6 - 1.2 mm 0.025 - 0.047 in.
Wirespool diameter	max. 200 mm max. 7.87 in.
Wirespool weight	max. 6.8 kg max. 14.99 lb.
Max. noise emission (LWA)	65.5 dB
Idle state power consumption at 230 V	17.4 W
Power source efficiency at 210 A / 24.5 V	89 %

- 1) Interface to a 230 V, 50 Hz public grid
- 2) A device in emissions class A is not intended for use in residential areas in which the electrical power is supplied via a public low-voltage grid.  
The electromagnetic compatibility may be influenced by conducted or radiated radio frequencies.

### TransSteel 2200 MV

Grid voltage ( $U_1$ )	1 x 120 V
Max. effective primary current ( $I_{1\text{eff}}$ )	15 A
Max. primary current ( $I_{1\text{max}}$ )	20 A
Mains fuse protection	15 A slow-blow
Max. apparent power ( $S_{1\text{max}}$ )	2.40 kVA
Grid voltage ( $U_1$ )	1 x 120 V
Max. effective primary current ( $I_{1\text{eff}}$ )	20 A
Max. primary current ( $I_{1\text{max}}$ )	29 A
Mains fuse protection	20 A slow-blow
Max. apparent power ( $S_{1\text{max}}$ )	3.48 kVA
Grid voltage ( $U_1$ )	1 x 230 V
Max. effective primary current ( $I_{1\text{eff}}$ )	16 A
Max. primary current ( $I_{1\text{max}}$ )	26 A



Mains fuse protection	16 A slow-blow			
Max. apparent power ( $S_{1max}$ )	5.98 kVA			
Grid voltage ( $U_1$ )	1 x 240 V			
Max. effective primary current ( $I_{1eff}$ )	15 A			
Max. primary current ( $I_{1max}$ )	26 A			
Mains fuse <sup>2)</sup>	20 A time-delay fuse <sup>3)</sup>			
Max. apparent power ( $S_{1max}$ )	6.24 kVA			
Mains voltage tolerance	-20 / +15%			
Grid frequency	50 / 60 Hz			
Cos phi	0.99			
Max. permitted grid impedance $Z_{max}$ on PCC <sup>1)</sup>	250.02 mOhm			
Recommended residual-current circuit breaker	Type B			
Welding current range ( $I_2$ )				
MIG/MAG	10 - 210 A			
MMA	10 - 180 A			
TIG	10 - 230 A			
Welding current at	10 min / 40 °C (104 °F)	30%	60%	100%
MIG/MAG	$U_1$ 120 V (15 A)	105 A	95 A	80 A
	$U_1$ 120 V (20 A)	135 A	120 A	105 A
	$U_1$ 230 V	210 A	170 A	150 A
Welding current at	10 min / 40 °C (104 °F)	35%	60%	100%
MMA	$U_1$ 120 V (15 A)	90 A	80 A	70 A
	$U_1$ 120 V (20 A)	110 A	100 A	90 A
	$U_1$ 230 V	180 A	150 A	130 A
Welding current at	10 min / 40 °C (104 °F)	35%	60%	100%
TIG	$U_1$ 120 V (15 A)	135 A	120 A	105 A
	$U_1$ 120 V (20 A)	160 A	150 A	130 A
	$U_1$ 230 V	230 A	200 A	170 A
Output voltage range according to standard characteristic ( $U_2$ )				
MIG/MAG	14.5 - 24.5 V			
MMA	20.4 - 27.2 V			
TIG	10.4 - 19.2 V			
Open circuit voltage ( $U_0$ peak / $U_0$ r.m.s)	90 V			
Protection class	IP 23			


Type of cooling	AF
Overvoltage category	III
Pollution degree according to IEC60664	3
EMC device class	A <sup>4)</sup>
Safety markings	S, CE, CSA
Dimensions l x w x h	560 x 215 x 370 mm 22.05 x 8.46 x 14.57 in.
Weight	15.2 kg 33.51 lb.
Max. shielding gas pressure	5 bar 72.52 psi
Wire speed	1.5 - 18 m/min 59.06 - 708.66 ipm
Wire drive	2-roller drive
Wire diameter	0.6 - 1.2 mm 0.025 - 0.047 in.
Wirespool diameter	max. 200 mm max. 7.87 in.
Wirespool weight	max. 6.8 kg max. 14.99 lb.
Max. noise emission (LWA)	65.5 dB
Idle state power consumption at 230 V	17.4 W
Power source efficiency at 210 A / 24.5 V	89 %

- 1) Interface to a 230 V, 50 Hz public grid.
- 2) Only applies to USA:  
If an automatic circuit breaker is used instead of a fuse, the current/time characteristic of the automatic circuit breaker must match that of the mains fuse specified above.  
It is permitted for the tripping current of the automatic circuit breaker to be higher than the tripping current of the mains fuse specified above.
- 3) Only applies to USA:  
Time-delay fuse conforming to UL Class RK5 (see UL 248).
- 4) A device in emissions class A is not intended for use in residential areas in which the electrical power is supplied via a public low-voltage grid.  
The electromagnetic compatibility may be influenced by conducted or radiated radio frequencies.

# Welding program tables

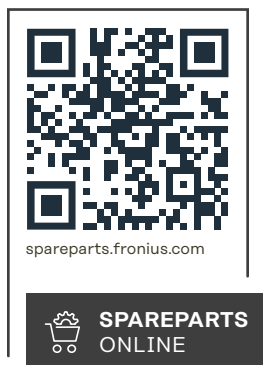
## TSt 2200 welding program table

<input checked="" type="checkbox"/> Steel	inch	mm	
<input checked="" type="checkbox"/> CrNi/Stainless	.023	<input checked="" type="checkbox"/> 0,6	
<input checked="" type="checkbox"/> CuSi	.030	<input checked="" type="checkbox"/> 0,8	
<input checked="" type="checkbox"/> AlMg	.035	<input checked="" type="checkbox"/> 0,9	<input checked="" type="checkbox"/> Ar 100%
<input checked="" type="checkbox"/> AlSi	.040	<input checked="" type="checkbox"/> 1,0	<input checked="" type="checkbox"/> CO <sub>2</sub> 100%
<input checked="" type="checkbox"/> Rutil/E71T	.045	<input checked="" type="checkbox"/> 1,2	<input checked="" type="checkbox"/> Ar + 2-5% CO <sub>2</sub>
<input checked="" type="checkbox"/> Metal Cored			<input checked="" type="checkbox"/> Ar + 15-25% CO <sub>2</sub>
<input checked="" type="checkbox"/> Self-shielded			



Welding program database: DB 3815

Material	Gas	Diameter				
		0,6 mm .025"	0,8 mm .030"	0,9 mm .035"	1,0 mm .040"	1,2 mm .045"
Steel	CO <sub>2</sub> 100%	3814	3813	3812	3811	
Steel	Ar + 15-20% CO <sub>2</sub>	3810	3809	3808	3806	
CrNi/Stainless	Ar + 2-5% CO <sub>2</sub>		2427	2402	2426	
CuSi	Ar 100%		2496	2495	2493	
AlMg	Ar 100%				3639	3643
AlSi	Ar 100%				3640	3643
Rutil/E71T	CO <sub>2</sub> 100%			2410		2321
Rutil/E71T	Ar + 15-20% CO <sub>2</sub>			2411		2320
Metall Cored	Ar + 15-20% CO <sub>2</sub>			2421		2536
Self-shielded	(no Gas)			2350		2349



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