

TransSteel 3500/5000 Syn

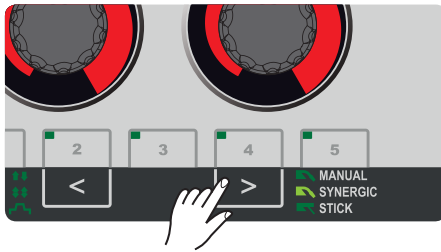
Quick guide to synergic welding



SAFETY

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

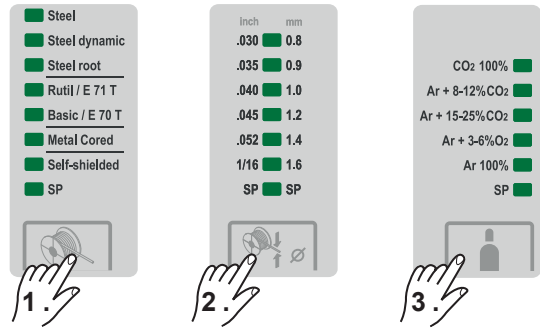
1 Setting the welding process



- MANUAL
- SYNERGIC
- STICK

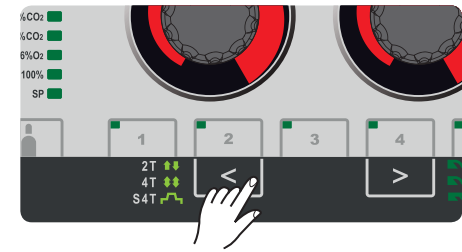
The welding power parameters can be adjusted individually
 When setting a welding power parameter, the remaining parameters are set automatically
 MMA welding

2 Setting the filler metal and shielding gas



- Steel Standard welding
- Steel dynamic Fast welding, concentrated arc
- Steel root Root pass welding, powerful arc

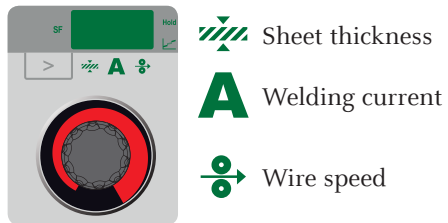
3 Setting the operating mode



- 2T
- 4T
- S4T

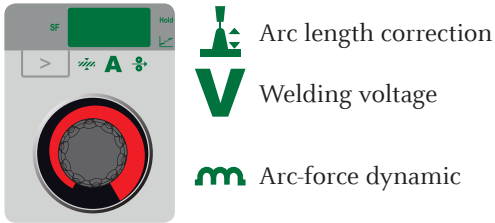
2-step mode: for short weld seams, tacking work
 4-step mode: for longer weld seams, high level of comfort
 Special 4-step mode: offers settings for starting and final current in addition to 4-step mode

4 Setting the welding power



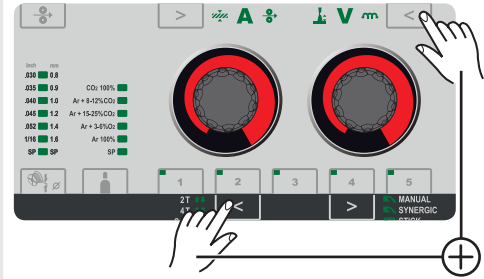
- Sheet thickness
- Welding current
- Wire speed
- select desired parameter
- set desired parameter

5 Adjusting parameters for correction



- Arc length correction
- Welding voltage
- Arc-force dynamic
- select desired parameter
- set desired parameter

Activating/deactivating the key lock

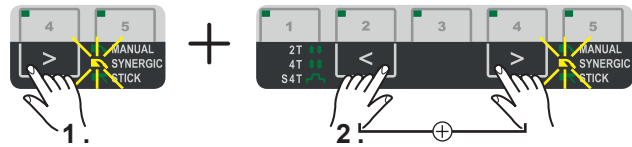


Operating Instructions:

www.fronius.com/transsteel



MIG/MAG Synergic Setup menu



Parameter:

- $G P r$ Gas pre-flow time
- $G P o$ Gas post-flow time
- $S L$ Slope (2-step, special 4-step)
- $i - S$ Starting current (2-step, special 4-step)
- $i - E$ Final current (2-step, special 4-step)
- $t - S$ Starting current duration (2-step)
- $t - E$ Final current duration (2-step)
- $F d ,$ Feeder inching speed
- $b b c$ Burn-back effect
- $i t o$ Length of wire that is fed before the safety cut-out trips
- $S P t$ Spot welding time / interval welding time
- $S P b$ Interval pause time
- $F A C$ Restore factory setup

2nd menu level

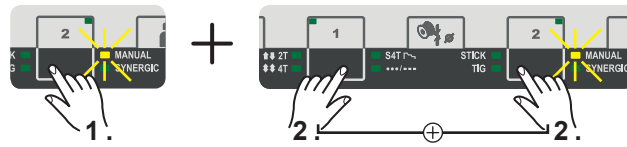
- $C - C$ Cooling unit control
- $C - t$ Cooling unit monitoring
- $S E t$ Country-specific setting
- $F U S$ Mains fuse protection
- r Welding circuit resistance
- L Welding circuit inductivity
- $E n E$ Real Energy Input
- $A L C$ Arc length correction display

Operating points



- retrieve: **1x** \Rightarrow \leftarrow
- save: \Rightarrow \leftarrow
- delete: \Rightarrow \leftarrow

MIG/MAG Manual Setup menu



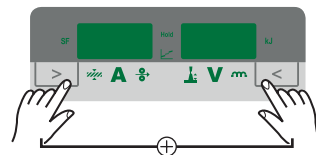
Parameters:

- $G P r$ Gas pre-flow time
- $G P o$ Gas post-flow time
- $F d ,$ Feeder inching speed
- $b b c$ Burn-back effect
- $i C C$ Ignition current
- $i t o$ Length of wire that is fed before the safety cut-out trips
- $S P t$ Spot welding time / interval welding time
- $S P b$ Interval pause time
- $F A C$ Restore factory setup

2nd menu level

- $C - C$ Cooling unit control
- $C - t$ Cooling unit monitoring
- $S E t$ Country-specific setting
- $F U S$ Mains fuse protection
- r Welding circuit resistance
- L Welding circuit inductivity
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Service parameters



Parameters:

Firmware version

Example of display:

Welding program configuration

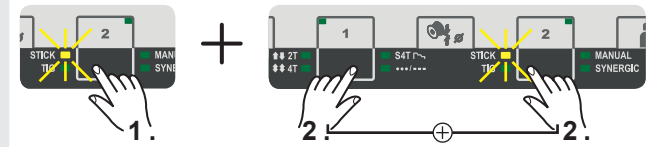
Current welding program

Motor current for wire drive in A

Arc time

2nd menu level (Service)

MMA Setup menu



Parameters:

- $H C U$ HotStart current
- $H t ,$ Hot current time
- $A S t$ Anti-stick
- $F A C$ Restore factory setup

2nd menu level

- r Welding circuit resistance
- L Welding circuit inductivity

Exiting the Setup menu

