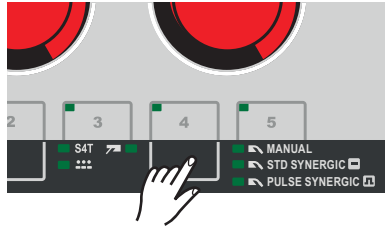


TRANSSTEEL 4000/5000 PULSE

Quick Guide to Synergic Welding

1 Set the welding process

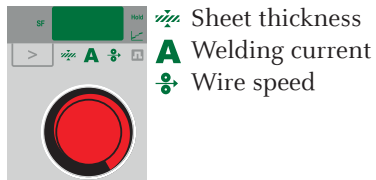


MANUAL The parameters for the welding power can be set individually.

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

PULSE SYNERGIC Manual metal arc welding

4 Set the welding power



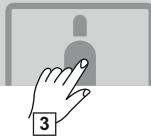
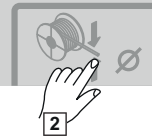
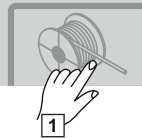
> select desired parameter

set desired parameter

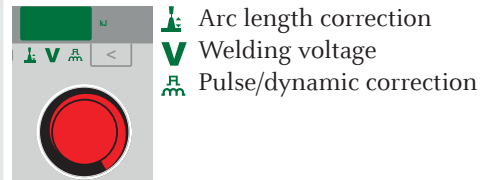


2 Set the filler metal and shielding gas

1	Steel/ER 70-120	inch	mm		
2	CrNi/Stainless	.030	0,8		
3	CuSi/ER CuSi-A	.035	0,9	CO ₂ 100%	A
4	AlMg/ER 5xxx	.040	1,0	Ar + 2-12% CO ₂	B
5	AlSi/ER 4xxx	.045	1,2	Ar + 13-25% CO ₂	C
6	Metal Cored	.052	1,4	Ar + 2-8% O ₂	D
7	Self-shielded	1/16	1,6	Ar 100%	E
8	SP	SP	SP	SP	F



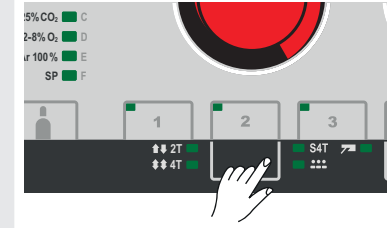
5 Set the correction parameters



< select desired parameter

set desired parameter

3 Set the operating mode



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

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

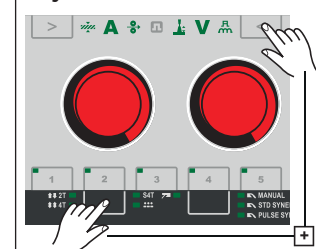
S4T Special 4-step mode:
in addition to 4-step mode, offers settings for starting and final current

SPE Settings for spot welding and stitch welding

Measuring the welding circuit resistance r

According to the Operating Instructions of the power source

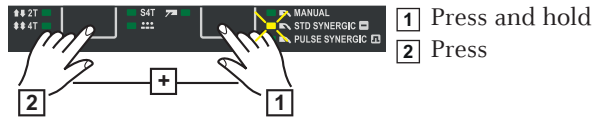
Activating/deactivating the key lock



TRANSSTEEL 4000/5000 PULSE

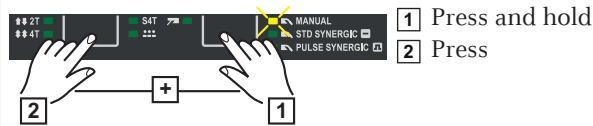
Description of Setup Parameters

MIG/MAG Synergic Setup menu



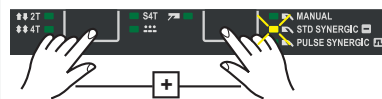
- GP_r** Gas pre-flow time
- GP_o** Gas post-flow time
- SL** Slope (2-step, special 4-step)
- I-S** Starting current (2-step, special 4-step)
- I-E** Final current (2-step, special 4-step)
- t-S** Starting current duration (2-step)
- t-E** Final current duration (2-step)
- Fd_i** Feeder inching speed
- bbC** Burnback effect
- i_{to}** Length of wire fed before the safety cut-out trips
- SP_t** Spot welding time / interval welding time
- SP_b** Interval pause time
- i_{nt}** Interval
- F** Frequency (SynchroPulse)
- dFd** Delta wire feed (SynchroPulse)
- RL₂** Upper arc length correction (SynchroPulse)
- FRC** Reset power source to factory settings
- 2nd** 2nd menu level
- SEt** Country-specific setting (metric/imperial)
- Syn** Synergic characteristics (EUr/US)
- C-C** Cooling unit control
- C-t** Cooling unit monitoring
- r** Welding circuit resistance
- L** Welding circuit inductivity
- EnE** Electrical energy of the arc
- RL_C** Arc length correction

MIG/MAG Manual Setup menu

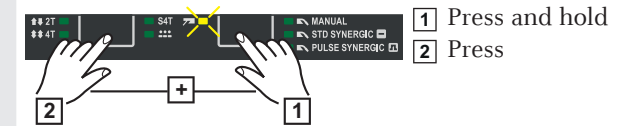


- GP_r** Gas pre-flow time
- GP_o** Gas post-flow time
- Fd_i** Feeder inching speed
- bbC** Burnback effect
- i_{CC}** Ignition current
- i_{to}** Length of wire fed before the safety cut-out trips
- SP_t** Spot welding time / interval welding time
- SP_b** Interval pause time
- i_{nt}** Interval
- FRC** Reset power source to factory settings
- 2nd** 2nd menu level
- SEt** Country-specific setting (metric/imperial)
- C-C** Cooling unit control
- C-t** Cooling unit monitoring
- r** Welding circuit resistance
- L** Welding circuit inductivity
- EnE** Electrical energy of the arc

Exiting the Setup menu



Rod electrode Setup menu



- HCU** HotStart current
- Ht_i** Hot current time
- RS_t** Anti-stick
- FRC** Reset power source to factory settings
- 2nd** 2nd menu level
- SEt** Country-specific setting (metric/imperial)
- r** Welding circuit resistance
- L** Welding circuit inductivity

EasyJobs



- Retrieve: **1x**
- Save: **Pro** **180**
- Delete: **CLr**

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.

