



EN

Control

Expert XQ 2.0 (L1.04)

Expert XQ 2.0 (L1.05)

099-00L105-EW501

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13.01.2022

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General instructions

WARNING



Read the operating instructions!

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

- Read and observe the operating instructions for all system components, especially the safety instructions and warning notices!
- Observe the accident prevention regulations and any regional regulations!
- The operating instructions must be kept at the location where the machine is operated.
- Safety and warning labels on the machine indicate any possible risks. Keep these labels clean and legible at all times.
- The machine has been constructed to state-of-the-art standards in line with any applicable regulations and industrial standards. Only trained personnel may operate, service and repair the machine.
- Technical changes due to further development in machine technology may lead to a differing welding behaviour.

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

A list of authorised sales partners can be found at www.ewm-group.com/en/specialist-dealers.

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

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

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

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Data security

The user is responsible for backing up data of all changes from the factory setting. The user is liable for erased personal settings. The manufacturer does not assume any liability for this.

1 Contents

1	Contents	3
2	For your safety	6
2.1	Notes on using these operating instructions	6
2.2	Explanation of icons	7
2.3	Safety instructions	8
2.4	Transport and installation	11
3	Intended use	13
3.1	Use and operation solely with the following machines	13
3.2	Software version	13
3.3	Applications	14
3.4	Documents which also apply	14
3.4.1	Part of the complete documentation	15
4	Quick overview	16
4.1	Machine control – Operating elements	16
4.2	Screen icons	17
4.3	Machine display	18
4.3.1	Actual values, nominal values, hold values	18
4.3.2	Main screen	19
4.3.3	Main screen variants	20
4.3.4	Initial screen	20
4.3.4.1	Basic settings for operation with two wire feeders (P10)	21
4.3.4.2	Change system language	21
5	Operating the machine control	22
5.1	Welding power setting	22
5.2	Direct access keys	22
5.3	Context-dependent push-buttons	23
5.3.1	Changing basic settings (machine configuration menu)	23
5.3.2	Lock function	23
5.4	Machine configuration (system)	24
5.4.1	Power-saving mode (Standby)	24
5.4.2	Access permission (Xbutton)	25
5.4.2.1	User information	25
5.4.2.2	Activating the Xbutton rights	25
5.4.3	Status information	26
5.4.3.1	Errors and warnings	26
5.4.3.2	Running time	27
5.4.3.3	System components	27
5.4.3.4	Temperatures	27
5.4.3.5	Sensor values	27
5.4.4	System settings	28
5.4.4.1	Date	28
5.4.4.2	Time	28
5.4.4.3	Water block	28
5.4.4.4	Special parameter	29
5.4.5	Control	37
5.4.6	Operating panel settings	38
5.4.7	Aligning the cable resistance	39
5.4.8	Xnet machine	41
5.4.8.1	Coupling mobile machines	41
5.4.9	Component identification	41
5.4.9.1	Component details	41
5.4.9.2	Errors and warnings	42
5.4.10	Status information	42
5.4.10.1	Network	42
5.4.11	Clear system memory	42
5.4.12	Reset to factory settings	42
5.5	Offline data transfer (USB)	42
5.5.1	Save JOB(s)	43

5.5.2	Load JOB(s).....	43
5.5.3	Save configuration	43
5.5.3.1	System.....	43
5.6	Xnet machine	43
5.6.1	Load configuration	43
5.6.1.1	System.....	43
5.6.1.2	Xnet machine	43
5.6.2	Load languages and texts.....	43
5.6.3	Record on USB drive	44
5.6.3.1	Register USB drive.....	44
5.6.3.2	Start recording.....	44
5.6.3.3	Stop recording.....	44
5.7	Welding task administration (Menu).....	44
5.7.1	JOB selection (material/wire/gas).....	45
5.7.2	JOB favourites	45
5.7.2.1	Saving current settings to Favourites	45
5.7.2.2	Loading saved Favourites	46
5.7.2.3	Deleting saved Favourites	46
5.7.3	JOB manager.....	46
5.7.3.1	Copy JOB to number.....	46
5.7.3.2	Reset current JOB	46
5.7.3.3	Reset all JOBs.....	46
5.7.4	Program sequence	47
5.7.4.1	Programs (P _A 1-15)	48
5.7.4.2	Overview of the welding parameter switching options	49
5.7.4.3	MIG/MAG welding	51
5.7.4.4	Advanced settings	52
5.7.4.5	TIG welding	53
5.7.4.6	MMA welding.....	54
5.7.5	Setup mode.....	54
5.7.6	WPQR welding data assistant	55
5.7.7	Welding monitoring	55
5.7.8	JOB display setting	56
5.8	Change welding procedure (Arc)	57
5.9	Online data transfer (network).....	57
5.9.1	Wired local network (LAN).....	57
5.9.2	Wireless local network (WiFi)	58
6	Welding procedure.....	59
6.1	MIG/MAG welding	59
6.1.1	Welding type	59
6.1.2	Welding power (operating point).....	59
6.1.2.1	Accessory components for operating point setting	59
6.1.2.2	Arc length	59
6.1.2.3	Arc dynamics (choke effect).....	59
6.1.2.4	superPuls	60
6.1.3	Operating modes	60
6.1.3.1	Explanation of signs and functions.....	60
6.1.3.2	Automatic cut-out	72
6.1.4	coldArc XQ / coldArc puls XQ.....	73
6.1.5	forceArc XQ / forceArc puls XQ	73
6.1.6	rootArc XQ / rootArc pulse XQ.....	74
6.1.7	acArc puls XQ	74
6.1.8	wiredArc	75
6.1.9	Standard MIG/MAG torch	76
6.2	TIG welding	77
6.2.1	Operating modes (functional sequences).....	77
6.2.1.1	Explanation of signs and functions.....	77
6.2.1.2	Automatic cut-out	77
6.2.2	Arc ignition	81
6.2.2.1	Liftarc.....	81

6.3	MMA welding	82
6.3.1	Hotstart	82
6.3.2	Antistick	82
6.4	Air arc gouging	82
7	Maintenance, care and disposal	83
7.1	General	83
7.2	Disposing of equipment	84
8	Rectifying faults	85
8.1	Display machine control software version	85
8.2	Warnings	85
8.3	Error messages	87
8.4	Resetting JOBs (welding tasks) to the factory settings	90
9	Appendix	91
9.1	Parameter overview – setting ranges	91
9.2	JOB-List	92
9.3	Searching for a dealer	99

2 For your safety

2.1 Notes on using these operating instructions

DANGER

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

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

WARNING

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

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

CAUTION

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

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



Technical aspects which the user must observe to avoid material or equipment damage.

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

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

2.2 Explanation of icons

Symbol	Description	Symbol	Description
	Indicates technical aspects which the user must observe.		Activate and release / Tap / Tip
	Switch off machine		Release
	Switch on machine		Press and hold
			Switch
	Incorrect / Invalid		Turn
	Correct / Valid		Numerical value – adjustable
	Input		Signal light lights up in green
	Navigation		Signal light flashes green
	Output		Signal light lights up in red
	Time representation (e.g.: wait 4 s / actuate)		Signal light flashes red
	Interruption in the menu display (other setting options possible)		
	Tool not required/do not use		
	Tool required/use		

2.3 Safety instructions

WARNING



Risk of accidents due to non-compliance with the safety instructions!

Non-compliance with the safety instructions can be fatal!

- Carefully read the safety instructions in this manual!
- Observe the accident prevention regulations and any regional regulations!
- Inform persons in the working area that they must comply with the regulations!



Risk of injury from electrical voltage!

Voltages can cause potentially fatal electric shocks and burns on contact. Even low voltages can cause a shock and lead to accidents.

- Never touch live components such as welding current sockets or stick, tungsten or wire electrodes!
- Always place torches and electrode holders on an insulated surface!
- Wear the full personal protective equipment (depending on the application)!
- The machine may only be opened by qualified personnel!
- The device must not be used to defrost pipes!



Hazard when interconnecting multiple power sources!

If a number of power sources are to be connected in parallel or in series, only a technical specialist may interconnect the sources as per standard IEC 60974-9:2010: Installation and use and German Accident Prevention Regulation BVG D1 (formerly VBG 15) or country-specific regulations.

Before commencing arc welding, a test must verify that the equipment cannot exceed the maximum permitted open circuit voltage.

- Only qualified personnel may connect the machine.
- When taking individual power sources out of operation, all mains and welding current leads must be safely disconnected from the welding system as a whole. (Hazard due to reverse polarity voltage!)
- Do not interconnect welding machines with pole reversing switch (PWS series) or machines for AC welding since a minor error in operation can cause the welding voltages to be combined, which is not permitted.



Risk of injury due to radiation or heat!

Arc radiation can lead to skin and eye injuries.

Contact with hot workpieces and sparks can lead to burns.

- Use hand shield or welding helmet with the appropriate safety level (depends on the application).
- Wear dry protective clothing (e.g. hand shield, gloves, etc.) in accordance with the applicable regulations of your country.
- Persons who are not directly involved should be protected with a welding curtain or suitable safety screen against radiation and the risk of blinding!

 WARNING**Risk of injury due to improper clothing!**

During arc welding, radiation, heat and voltage are sources of risk that cannot be avoided. The user has to be equipped with the complete personal protective equipment at all times. The protective equipment has to include:

- Respiratory protection against hazardous substances and mixtures (fumes and vapours); otherwise implement suitable measures such as extraction facilities.
- Welding helmet with proper protection against ionizing radiation (IR and UV radiation) and heat.
- Dry welding clothing (shoes, gloves and body protection) to protect against warm environments with conditions comparable to ambient temperatures of 100 °C or higher and arcing and work on live components.
- Hearing protection against harming noise.

**Explosion risk!**

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

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

**Fire hazard!**

Due to the high temperatures, sparks, glowing parts and hot slag that occur during welding, there is a risk of flames.

- Be watchful of potential sources of fire in the working area!
- Do not carry any easily inflammable objects, e.g. matches or lighters.
- Ensure suitable fire extinguishers are available in the working area!
- Thoroughly remove any residue of flammable materials from the workpiece prior to starting to weld.
- Only further process workpieces after they have cooled down. Do not allow them to contact any flammable materials!

CAUTION



Smoke and gases!

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

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



Noise exposure!

Noise exceeding 70 dBA can cause permanent hearing damage!

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



According to IEC 60974-10, welding machines are divided into two classes of electromagnetic compatibility (the EMC class can be found in the Technical data):

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



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



Setting up and operating

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

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

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

Recommendations for reducing interference emission

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



Electromagnetic fields!

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



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

 CAUTION**Obligations of the operator!**

The respective national directives and laws must be complied with when operating the machine!

- Implementation of national legislation relating to framework directive 89/391/EEC on the introduction of measures to encourage improvements in the safety and health of workers at work and associated individual guidelines.
- In particular, directive 89/655/EEC concerning the minimum safety and health requirements for the use of work equipment by workers at work.
- The regulations applicable to occupational safety and accident prevention in the country concerned.
- Setting up and operating the machine as per IEC 60974.-9.
- Brief the user on safety-conscious work practices on a regular basis.
- Regularly inspect the machine as per IEC 60974.-4.



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

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

Requirements for connection to the public mains network

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

2.4 Transport and installation

 WARNING**Risk of injury due to improper handling of shielding gas cylinders!**

Improper handling and insufficient securing of shielding gas cylinders can cause serious injuries!

- Observe the instructions from the gas manufacturer and any relevant regulations concerning the use of compressed air!
- Do not attach any element to the shielding gas cylinder valve!
- Prevent the shielding gas cylinder from heating up.

CAUTION



Risk of accidents due to supply lines!

During transport, attached supply lines (mains leads, control cables, etc.) can cause risks, e.g. by causing connected machines to tip over and injure persons!

- Disconnect all supply lines before transport!



Risk of tipping!

There is a risk of the machine tipping over and injuring persons or being damaged itself during movement and set up. Tilt resistance is guaranteed up to an angle of 10° (according to IEC 60974-1).

- Set up and transport the machine on level, solid ground.
- Secure add-on parts using suitable equipment.



Risk of accidents due to incorrectly installed leads!

Incorrectly installed leads (mains, control and welding leads or intermediate hose packages) can present a tripping hazard.

- Lay the supply lines flat on the floor (avoid loops).
- Avoid laying the leads on passage ways.



Risk of injury from heated coolant and its connections!

The coolant used and its connection or connection points can heat up significantly during operation (water-cooled version). When opening the coolant circuit, escaping coolant may cause scalding.

- Open the coolant circuit only when the power source or cooling unit is switched off!
- Wear proper protective equipment (protective gloves)!
- Seal open connections of the hose leads with suitable plugs.



The units are designed for operation in an upright position!

Operation in non-permissible positions can cause equipment damage.

- ***Only transport and operate in an upright position!***



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

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



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

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

3 Intended use

WARNING



Hazards due to improper usage!

The machine has been constructed to the state of the art and any regulations and standards applicable for use in industry and trade. It may only be used for the welding procedures indicated at the rating plate. Hazards may arise for persons, animals and material objects if the equipment is not used correctly. No liability is accepted for any damages arising from improper usage!

- The equipment must only be used in line with its designated purpose and by trained or expert personnel!
- Do not improperly modify or convert the equipment!

3.1 Use and operation solely with the following machines

The following system components can be combined:

This description may be applied only to machines with the Expert XQ 2.0 machine control.

Machine control	Expert XQ 2.0	Expert XQ 2.0 LG	Expert XQ 2.0 WLG
Description	No network connection	Version with LAN	Version with Wi-Fi and LAN

3.2 Software version

These instructions apply to the following software version:

2.1.0.0

The machine control software version is shown on the screen during the start process > see 4.3.4 chapter.

3.3 Applications

Multi-process welding machine for arc welding covering the following welding procedures:

Machine series	Main procedure for MIG/MAG welding											Secondary procedure			
	Standard arc					Pulsed arc						TIG welding (Liftarc)	MMA welding	Gouging	Positionweld
	MIG/MAG XQ	forceArc XQ	rootArc XQ	coldArc XQ	wiredArc XQ	MIG/MAG pulse XQ	forceArc puls XQ	rootArc puls XQ	coldArc puls XQ	acArc puls XQ	wiredArc puls XQ				
Titan XQ AC	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
Titan XQ / XQ C	✓	✓	✓	✓	✓	✓	✓	✓	✓	✗	✓	✓	✓	✓	✓
Phoenix XQ / XQ C	✓	✓	✓	✗	✗	✓	✓	✓	✗	✗	✗	✓	✓	✓	✓ ^[1]
Taurus XQ / XQ C	✓	✓	✓	✗	✗	✗	✗	✗	✗	✗	✗	✓	✓	✓	✗
Taurus XQ Basic	✓	✗	✗	✗	✗	✗	✗	✗	✗	✗	✗	✓	✓	✓	✗

^[1] Aluminium-welding tasks

3.4 Documents which also apply

- Operating instructions for the connected welding machines
- Documents of the optional expansions

3.4.1 Part of the complete documentation

This document is part of the complete documentation and valid only in combination with all other parts of these instructions! Read and observe the operating instructions for all system components, especially the safety instructions!

The illustration shows a general example of a welding system.

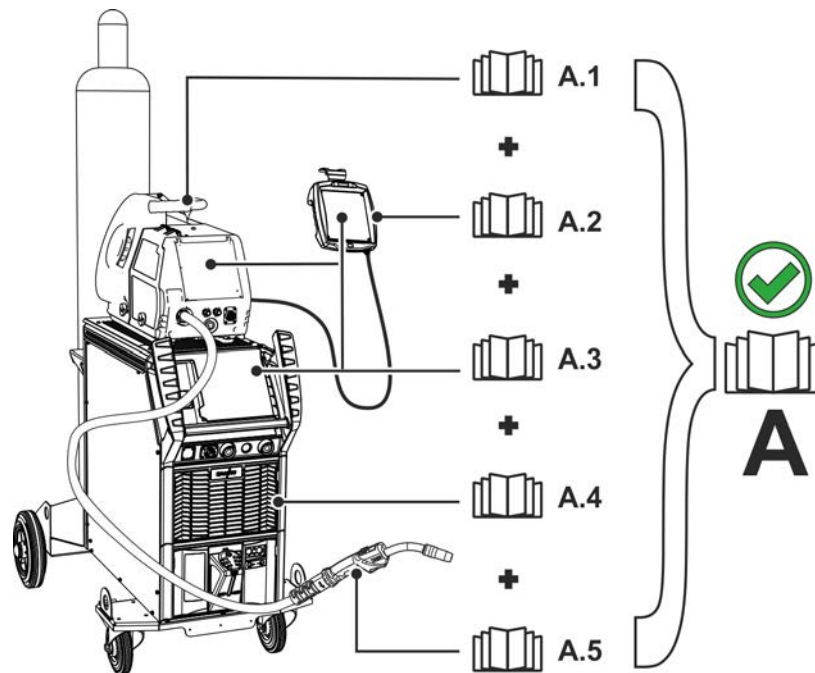


Figure 3-1

The illustration shows a general example of a welding system.

Item	Documentation
A.1	Wire feeder
A.2	Remote adjuster
A.3	Controller
A.4	Power source
A.5	Welding torch
A	Complete documentation

4 Quick overview

4.1 Machine control – Operating elements

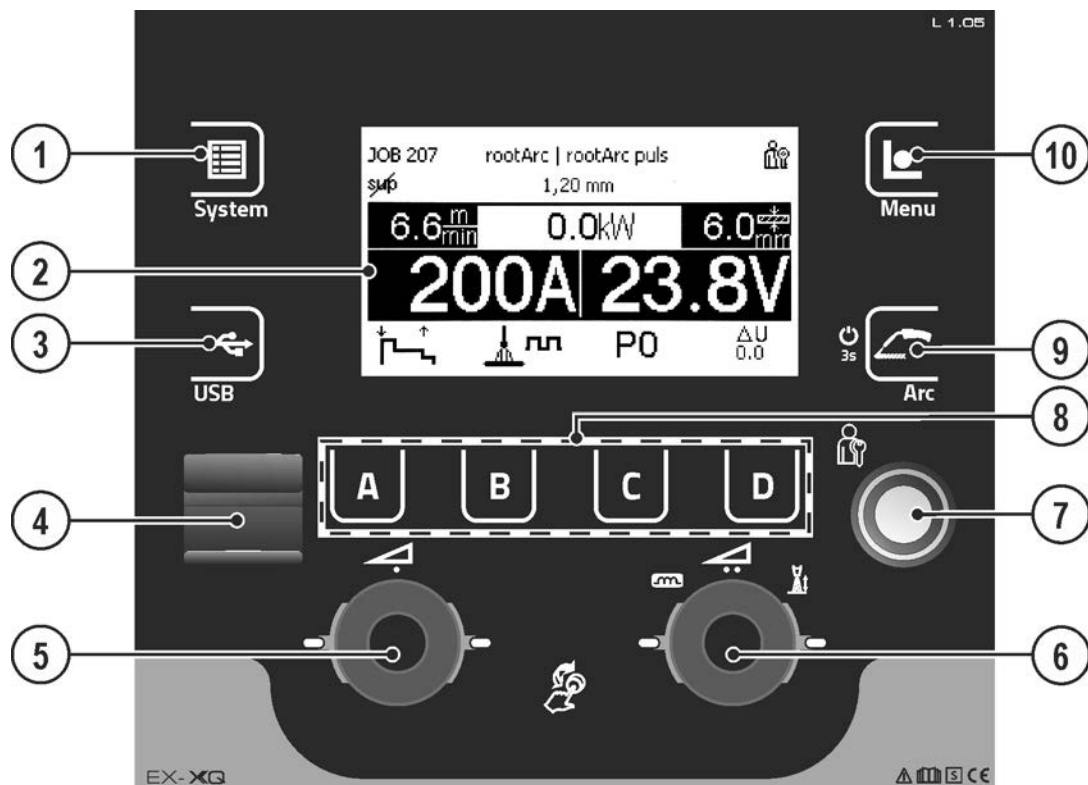


Figure 4-1

Item	Symbol	Description
1		Push-button for system settings Display for system and configuration of system settings > see 5.4.4 chapter.
2		Machine display Machine display showing all machine functions, menus and parameters with their values > see 4.3 chapter.
3		Push-button for USB interface Operation and settings of the USB interface > see 5.5 chapter.
4		USB interface USB for offline data transfer Connection capability for a USB flash drive - industrial USB flash drive recommended (FAT 32).
5		Rotary knob (click wheel) for welding power ----- Setting the welding power > see 5.1 chapter ----- Setting various parameters values depending on the preselection. (Settings can be made when the backlight is activated.)
6		Rotary knob (click wheel) for correction of arc ----- Setting the correction of arc length > see 6.1.2.2 chapter ----- Setting the arc dynamics > see 6.1.2.3 chapter Settings can be made when the backlight is activated.
7		Interface - Xbutton Welding release with user-defined rights to protect against unauthorised use > see 5.4.2 chapter.
8	A B C D	Push-buttons A B C D (depending on context) > see 5.3 chapter

Item	Symbol	Description
9		Arc push-button - Initial state of main screen: Switching of the welding procedure based on the selected material, gas and welding consumable. - Initial state of any sub-menu: Display switches back to the main screen. - Press and hold: After 3 s, the machine switches into locked mode > see 5.3.2 chapter. To unlock, press and hold again for 3 s > see 5.3.2 chapter.
10		Push-button for menu > see 5.7 chapter

4.2 Screen icons

Symbol	Description
	Shielding gas
	Material type
	Wire inching
	Wire return
	Advanced settings
	Set-up mode
	Non-latched operating mode
	Special non-latched operating mode
	Latched operating mode
	Special latched operating mode
JOB	Welding task
sup	superPuls
	superPuls switched off
	Interference
	Temperature error
	Spot welding operating mode
	Material thickness
	Disabled; selected function is not available with the current access rights - check access rights.
	Wire feed speed
	Arc length correction
kW	Welding power
P	Programs (P0 - P15) > see 5.7.4.1 chapter
	Warning; could be an imminent interference
	Wired local network (LAN)
	Wireless local network (WiFi)
	User logged in
	Not possible, check priorities
	Xbutton login

Symbol	Description
	Xbutton logout
	Arc dynamics
	Xbutton version number not recognised
	Cancel operation
	Confirm operation
	Wire diameter (welding consumable)
	Menu navigation; one menu back
	Menu navigation; expanding the content of the display
	Save data to USB medium
	Load data from USB medium
	USB data recording
	Screen type 3/4, switching buttons
	Pulse arc welding
	Standard arc welding
	Welding procedure
	Refresh
	After welding, the last weld values (hold values) from the main program are displayed
	Information
	Welding current
	Welding voltage
	Motor current, wire feed motor
	Welding duration
	Plasma gas
	Wire feed speed
	Value correct or applicable

4.3 Machine display

The machine display shows all the information relevant to the user as text and/or graphics.

4.3.1 Actual values, nominal values, hold values

Parameter	Before welding	During welding		After welding	
	Nominal value	Actual value	Nominal value	Hold value	Nominal value
Welding current	☒	☒	☐	☒	☐
Material thickness	☒	☐	☒	☐	☒
Wire feed speed	☒	☒	☐	☒	☐
Welding voltage	☒	☒	☐	☒	☐

4.3.2 Main screen

The main screen shows all the information relevant for the welding process before, while and after it is carried out. In addition, it shows status information on the machine state. The assignment of the context-dependent push-buttons is also shown on the main screen.

The user can choose between different main screens > see 4.3.3 chapter.

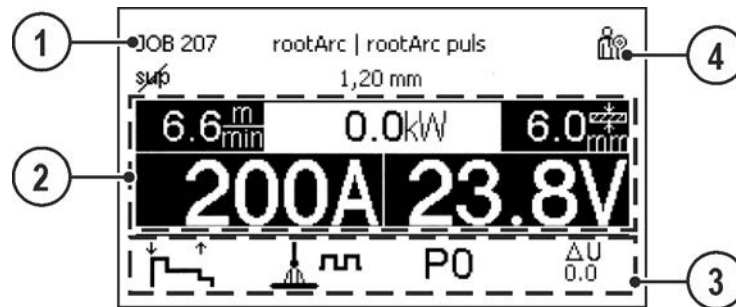


Figure 4-2

Item	Symbol	Description
1		Information on the welding task selected JOB number, process etc.
2		Display area for welding data Welding current, welding voltage, wire feed speed, material thickness etc.
3		Display area for process parameters Operating mode, voltage correction, program, welding method etc.
4		Display area for system status Network status, error status etc. > see 4.2 chapter

By pressing push-button A for a prolonged time (on the operating mode main screen) it is possible to directly switch to the program sequence.

4.3.3 Main screen variants

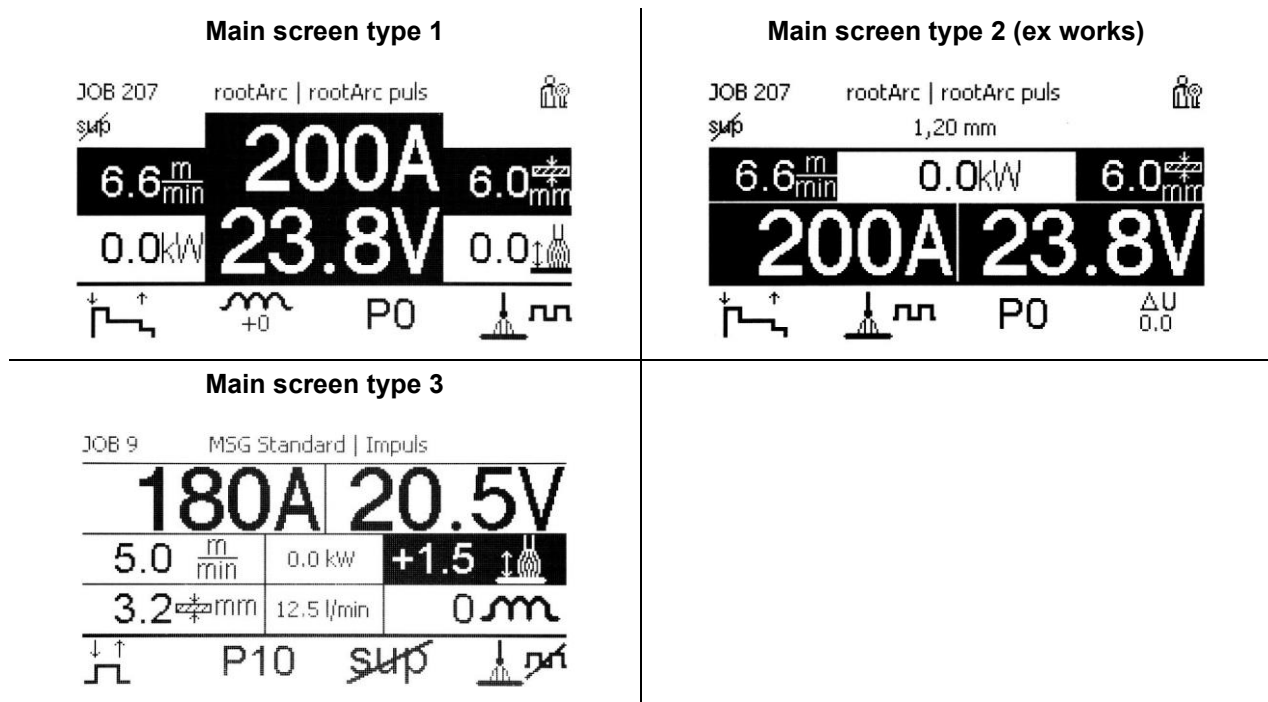


Figure 4-3

You can select the required variant (type of main screen) in the Machine configuration (system) menu > see 5.4.6 chapter.

4.3.4 Initial screen

During the start process the control name, machine software version and selected language are shown on the screen.



Figure 4-4

Item	Symbol	Description
1		Machine control name
2		Loading bar Shows the load progress during the start process
3	⚙️	Advanced settings Display and setting of advanced system parameters > see 4.3.4.1 chapter
4		Indication of the system language selected The system language can be changed during the start process > see 4.3.4.2 chapter.
5		Control software version

4.3.4.1 Basic settings for operation with two wire feeders (P10)

The setting is available/required in the following cases only:

- the control is integrated in the wire feeder
- the control is integrated in the power source (compact design)

Menu item/parameter	Value	Comment
DVX (single)	0	
DVX-Unit 1 (master)	1	
DVX-Unit 2 (slave)	2	

With single unit operation (P10 = 0) a second wire feeder may not be connected!

- Remove any connections to the second wire feeder

With double unit operation (P10 = 1 or 2) both wire feeders have to be connected and be set up for this operation at the control with different configurations.

- Configure one wire feeder as master (P10 = 1)
- Configure the other wire feeder as slave (P10 = 2)

Access control

If one of the wire feeders in the welding system is equipped with an access control key switch, it has to be configured as master (P10 = 1). With double unit operation, if more than one wire feeder is equipped with an access control key switch, either one can be configured as master. The wire feeder configured as master is active as soon as the welding machine has been switching on. There are no other functional differences between the wire feeders.

4.3.4.2 Change system language

During the start process the user can select or change the system language at the machine control.

- Switch the machine off and on again.
- Press the context-dependent push-button [D] during the start phase (the word WELDING 4.0 is displayed).
- Select the required language by turning the control button.
- Confirm the selected language by pressing the control button (the user can exit the menu by pressing the context-dependent push-button [A] without making any changes).

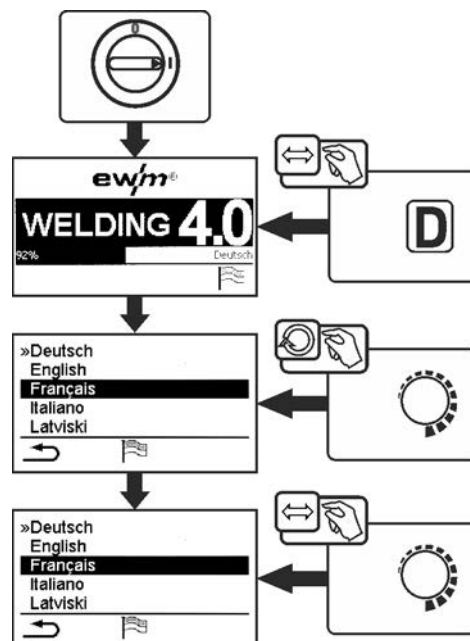


Figure 4-5

5 Operating the machine control

In general the control is operated with the central control button below the machine display.

Select the required menu item by turning (navigate) and pressing (confirm) the central control button. In addition, the context-dependent push-buttons below the machine display can be used for confirmation.

5.1 Welding power setting

The welding power is adjusted with the rotary knob (click wheel) for welding power. You can also adjust the parameters in the operation sequence or settings in the various machine menus.

MIG/MAG settings

The welding power (heat input into the material) can be changed by setting the following three parameters:

- wire feed speed ⚙
- material thickness ⚙
- welding current A

These three parameters are interdependent and always change together. The significant parameter is the wire feed speed in m/min. The wire feed speed can be adjusted in increments of 0.1 m/min (4.0 ipm). The associated welding current and material thickness are determined from the wire feed speed.

The welding current displayed and material thickness are to be understood as guide values for the user and rounded to full amperage and 0.1 mm material thickness.

A change in the wire feed speed, for example by 0.1 m/min, leads to a more or less large change in the welding current displayed or in the material thickness displayed depending on the selected welding wire diameter. The display of the welding current and the material thickness are also dependent on the selected wire diameter.

For example, a change in wire feed speed of 0.1 m/min and a selected wire diameter of 0.8 mm results in a smaller change in the current or thickness of material than a change in wire feed speed of 0.1 m/min and a selected wire diameter of 1.6 mm.

Depending on the diameter of the wire to be welded, it is possible that smaller or larger jumps in the display of material thickness or welding current take place or changes of these values become visible only after several “clicks” on the rotary transducer. As described above, the reason for this is the change in the wire feed speed by 0.1 m/min per click and the resulting change in the current or material thickness as a function of the preselected welding wire diameter.

Please note also that the guide value of the welding current displayed before welding may deviate from the guide value during welding depending on the actual stick-out (free wire end used for welding).

The reason lies in the preheating of the free wire end by the welding current. For example, the preheating in the welding wire increases with the length of the stick-out. This means if the stick-out (free wire end) increases, the actual welding current decreases due to larger preheating in the wire. If the free wire end decreases, the actual welding current increases. This enables the welder to influence the heat input in the component within limits by changing the distance of the welding torch.

Setting of TIG/MMA:

The welding power is set with the parameter “welding current” that can be adjusted in increments of 1 ampere.

5.2 Direct access keys

Several push-buttons on the right and left of the display can be used to directly access the most important menus.

5.3 Context-dependent push-buttons

The bottom push-buttons are so-called context-dependent operating elements. The selection options of these buttons depend on each screen content.

If the  icon is shown on the display the user can skip back to the previous menu item (often assigned to the [A] push-button).

5.3.1 Changing basic settings (machine configuration menu)

The basic welding system functions can be adjusted in the machine configuration menu. Only experienced users should change the settings > see 5.4 chapter.

5.3.2 Lock function

The lock function protects against accidental adjustment of the device settings.

The user can switch the lock function on or off by pressing the button for a long time from each machine control or accessory component with the symbol .

5.4 Machine configuration (system)

In the System menu the user can set the basic machine configuration.

Enter the menu:

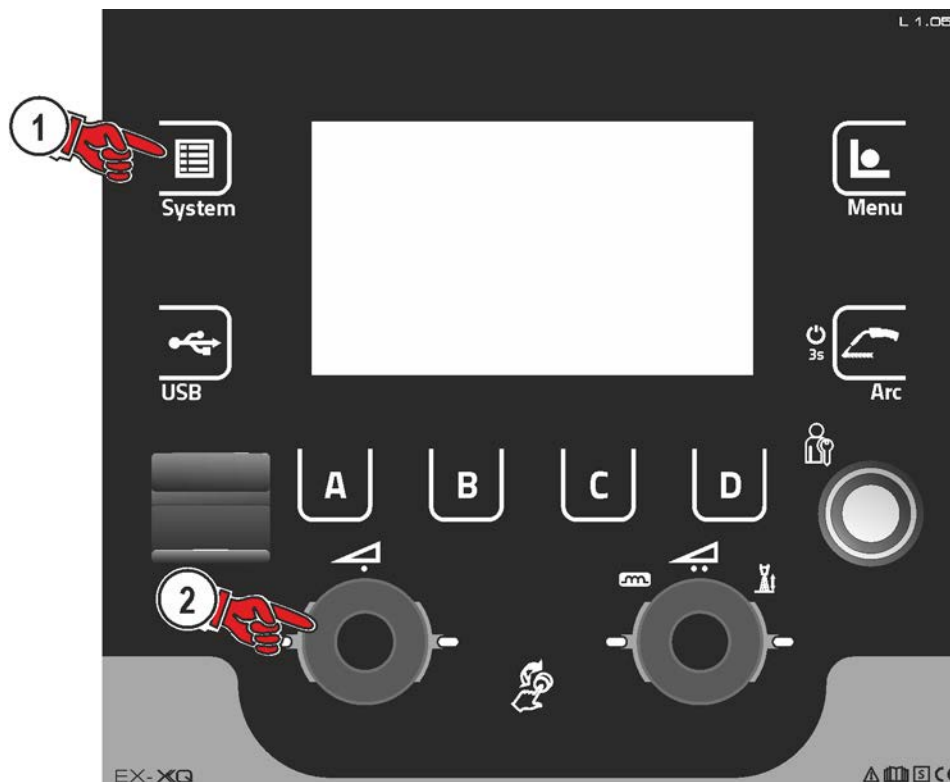


Figure 5-1

5.4.1 Power-saving mode (Standby)

You can activate the power-saving mode by setting a parameter in the configuration menu (time-controlled power-saving mode). When power-saving mode is active, the Expert XQ 2.0 machine controller display is dimmed and only the middle digit of the display is shown in the wire feed unit. Pressing any operating element (e.g. tapping the torch trigger) deactivates power-saving mode and the machine is ready for welding again.

Menu item/parameter	Value	Comment
Time automatic [min.]	Off	Function switched off
	5-60	Time to activation of the power-saving mode in case of inactivity.
Log off user in standby mode	Yes	The user will be logged off when the power-saving mode is active.
	No	The user will not be logged off when the power-saving mode is active.

5.4.2 Access permission (Xbutton)

The welding system offers two options to prevent unauthorised access to welding parameters or unintentional reconfiguration.

- 1 Key switch (available depending on machine version). With the key switch in position 1 all functions and parameters can be configured without any restriction. In position 0 certain predefined welding parameters or functions cannot be modified (see relevant documentation).
- 2 Xbutton. With this function, permissions can be assigned to users to access those areas of the machine control defined for them. To do so, the user needs a digital key (Xbutton) to log on to the machine via the Xbutton interface. The key itself is configured by the system user (welding supervisor).

If the Xbutton function is activated, the key switch/key switch function is deactivated.

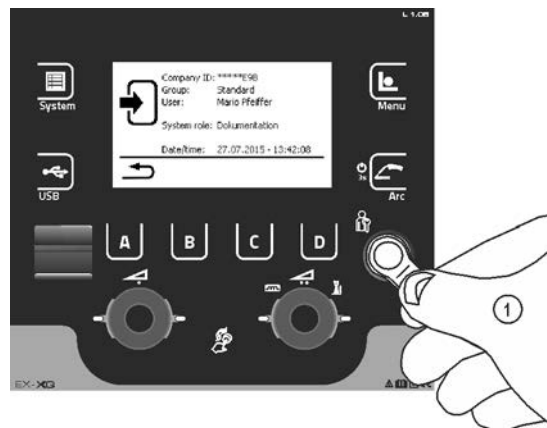


Figure 5-2

To activate Xbutton rights follow these instructions:

1. Set key switch to position "1".
2. Log on with a Xbutton and administrator rights.
3. Set menu option "Xbutton rights active" to "yes".

By following these instructions you make sure not to inadvertently block your access while not owning an Xbutton with administrator rights.

5.4.2.1 User information

User information such as company ID, user name, group etc. are shown.

5.4.2.2 Activating the Xbutton rights

Menu navigation:

Menu item/parameter	Value	Comment
Xbutton rights active:	Yes	Access rights active
	No	Key switch active
Reset Xbutton configuration:	Yes	Company ID, group and access rights when logged off will be reset to the factory settings. Xbutton rights will be deactivated.
	No	

5.4.3 Status information

This menu provides the user with information on current system interferences and warnings..

5.4.3.1 Errors and warnings

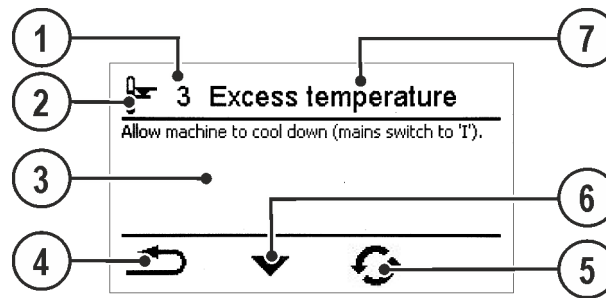


Figure 5-3

Item	Symbol	Description
1		Error number > see 8.3 chapter
2		Error icons  ----- Warning (prior to interference)  ----- Interference (welding process will be stopped)  ----- Specific (e.g. temperature error)
3		Long error description
4		Menu navigation Skip back to previous menu
5		Reset message The message can be reset
6		Menu navigation (if available) Scroll to next page or message
7		Error name

5.4.3.2 Running time

Menu item/parameter	Value	Comment
Duty cycle can be reset:	0:00 h	Values can be reset by pressing or turning the main control button
Arc time can be reset:	0:00 h	
Overall duty cycle:	0:00 h	
Overall arc time:	0:00 h	

5.4.3.3 System components

A list of all components available in the system is displayed, along with ID number, software version and name.

5.4.3.4 Temperatures

Menu item / parameter	Value	Comment
Housing inside	-	-
Transformer secondary	-	-
RCC heatsink	-	-
Coolant return	-	-
Primary heatsink	-	-
Wire heater, unit 1	-	Display of "---" if no wire heater is installed
Wire heater, unit 2	-	
Temperature 8	-	free
Temperature 9	-	free
Temperature 10	-	free

5.4.3.5 Sensor values

Menu item / parameter	Value	Comment
Coolant flow	-	-
Wire reserve, unit 1	0-100%	Display of "---" if no wire sensor is installed or value could not yet be determined (at least one reel revolution required).
Wire reserve, unit 2		

5.4.4 System settings

In this area the user can configure advanced system settings.

5.4.4.1 Date

Menu item/parameter	Value	Comment
Year:	2014	
Month:	10	
Day:	28	
Date format:	DD.MM.YYYY	
	YYYY.MM.DD	

5.4.4.2 Time

Menu item/parameter	Value	Comment
Hour:	0–24	
Minute:	0–59	
Time zone (UTC +/-):	-12h to +14h	
Summer time:	Yes	
	No	
Time format:	24 h	
	12 h AM/PM	

5.4.4.3 Water block

Permanently switching off the water block may damage the welding torch.

Menu item / parameter	Value	Comment
Cooling unit postflow time [min.]:	1-60 min	
Cooling unit control:	Automatic	
	Permanently ON	
	Permanently OFF	
Temperature error limit	50-80 °C	
Flow monitoring	On	
	Off	
Flow error limit	0.5-2.0 l/min	
Reset to factory setting	No	
	Yes	Resets the water block parameters to factory settings.

5.4.4.4 Special parameter

The special parameters of the wire feeder control are used to customize the machine function configuration.

The number of selectable special parameters can deviate between the machine controls used in the welding system.

It may be required to restart the machine in order to apply a parameter change.

Systems with two wire feeder controls show the parameters of the active wire feeder only (special parameter U1 or special parameter U2).

Menu item/parameter	Value	Comment
P1	1-0	Wire inching / wire return ramp time 0 = ----- normal inching (10 s ramp time) 1 = ----- fast inching (3 s ramp time) (ex works)
P2	0-1	Block program "0" 0 = ----- Enabled (ex works) 1 = ----- P0 blocked
P3	0-1	Display mode for Up/Down welding torch with one-digit 7-segment display (two keys) 0 = ----- Normal display (ex works) program number/welding power (0–9) 1 = ----- Display toggles between program number/welding type
P7	0-1	Correction operation, limit value setting 0 = ----- Correction operation switched off (ex works) 1 = ----- Correction operation switched on
P8	0-1	Program switching with standard welding torch 0 = ----- No program switching (ex works) 1 = ----- Special latched 2 = ----- Special latched (n-cycle active)
P9	0-1	Tapping start for latched and special latched operation 0 = ----- no 4-cycle inching start 1 = ----- 4-cycle inching start possible (ex works)
P11	0-1	Special latched tapping time 0 = ----- Tapping function switched off. 1 = ----- 300 ms (ex works) 2 = ----- 600 ms
P12	1-2	JOB list switching 1 = ----- Real JOB list (ex works) 2 = ----- Real JOB list and JOB switching activated via accessories
P13	129	Lower limit remote JOB switching JOB range of the function torches (MT PC2, PM 2U/D, PM RD2) Lower limit: 129 (ex works)
P14	169	Upper limit remote JOB switching JOB range of the function torches (MT PC2, PM 2U/D, PM RD2) Upper limit: 169 (ex works)
P16	0-1	JOB batch mode 0 = ----- Block JOB mode not enabled (ex works) 1 = ----- Block JOB mode enabled
P17	0-1	Program selection with standard torch trigger 0 = ----- No program selection (ex works) 1 = ----- Program selection possible
P23	0-1	Program settings for relative programs 0 = ----- Combined setting of relative programs possible (ex works). 1 = ----- Individual setting of relative programs possible.
P26	45 °C	Nominal value of wire spool heater (OW WHS) 0 = ----- off = switched off 1 = ----- setting range temperature: 25°C - 50°C (45°C ex works)
P27	0-1	Operating mode switching at welding start 0 = ----- Not enabled (factory setting) 1 = ----- Enabled
P28	30 %	Error threshold of electronic gas flow control Error output in case of gas nominal value deviation

Menu item/parameter	Value	Comment
Reset to factory setting:	No	
	Yes	All special parameters are reset to the corresponding factory setting.

Wire inching ramp time (P1)

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

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

Program "0", release of program block (P2)

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

Display mode for Up/Down welding torch with one-digit 7-segment display (P3)

Normal display:

- Program mode: Program number
- Up/down operation: Welding power (0=minimum current/9=maximum current)

Toggling display:

- Program mode: Program number and welding procedure (P=pulse/n=not pulse) are toggled
- Up/down operation: Welding power (0=minimum current/9=maximum current) and symbol for up/down operation are toggled

Switching on/off correction operation (P7)

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

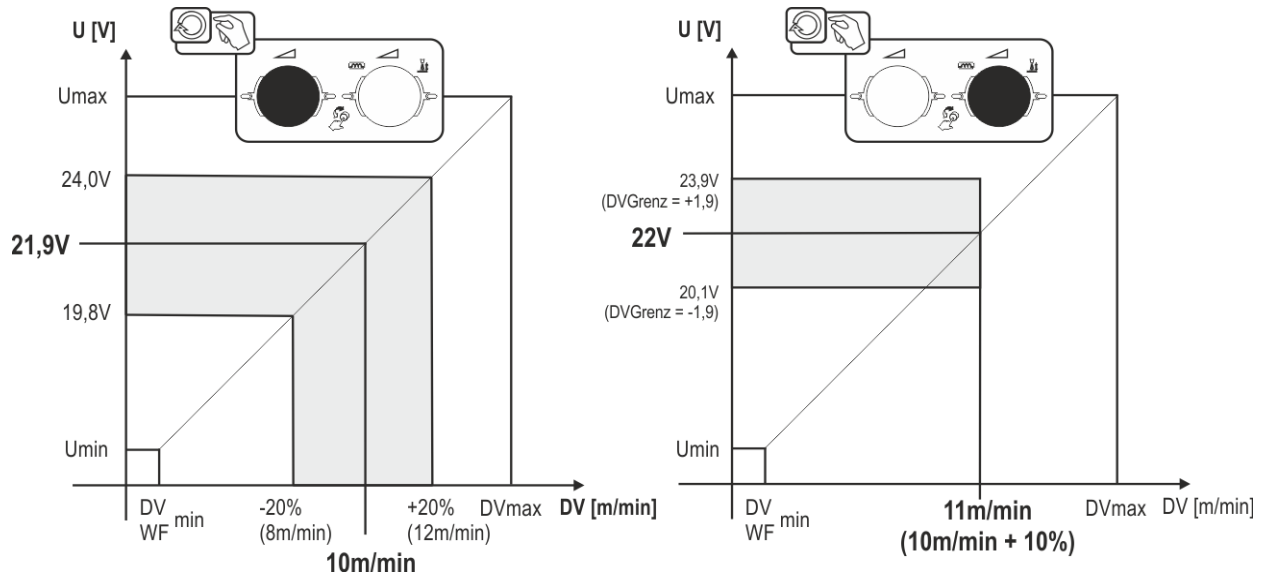


Figure 5-4

Example for the operating point in correction operation:

The wire feed speed in a program (1 to 15) is set to 10.0 m/min. This corresponds to a welding voltage (U) of, for example, 21.9 V. When the key switch is now turned to position , welding can only be carried out with these values in this program.

If the welder is also to carry out wire and voltage correction in program mode, correction operation must be switched on and limit values for wire and voltage must be specified.

Setting the correction limit for wire = 20 %.

Setting the correction limit for voltage = 1.9 V.

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

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

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

When the key switch is turned to position , the values for voltage and wire feed speed correction are reset.

Program switching with standard welding torch (P8)

Special latched (latched absolute program sequence)

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

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

Program switching at the wire feed unit control is disabled.

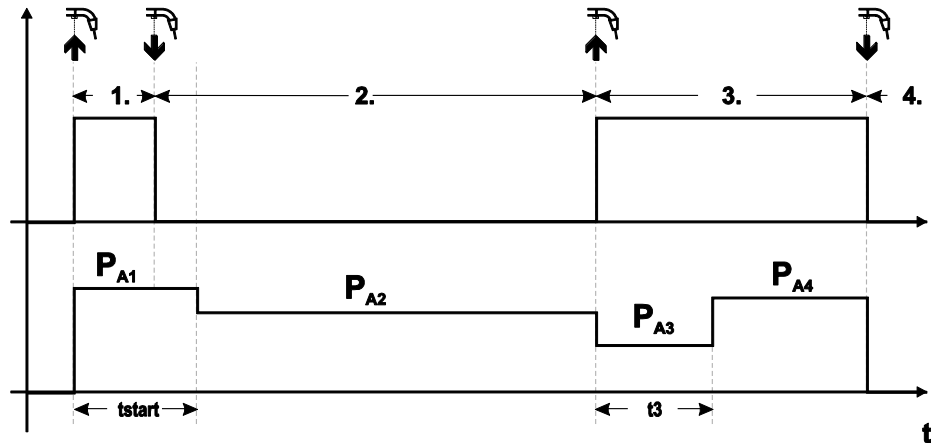


Figure 5-5

Specific latched special (n cycle)

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

In the second cycle, the machine switches to absolute program 2, once the start time "tstart" has elapsed. Tapping switches to other programs (P_{A1} to max. P_{A9}).

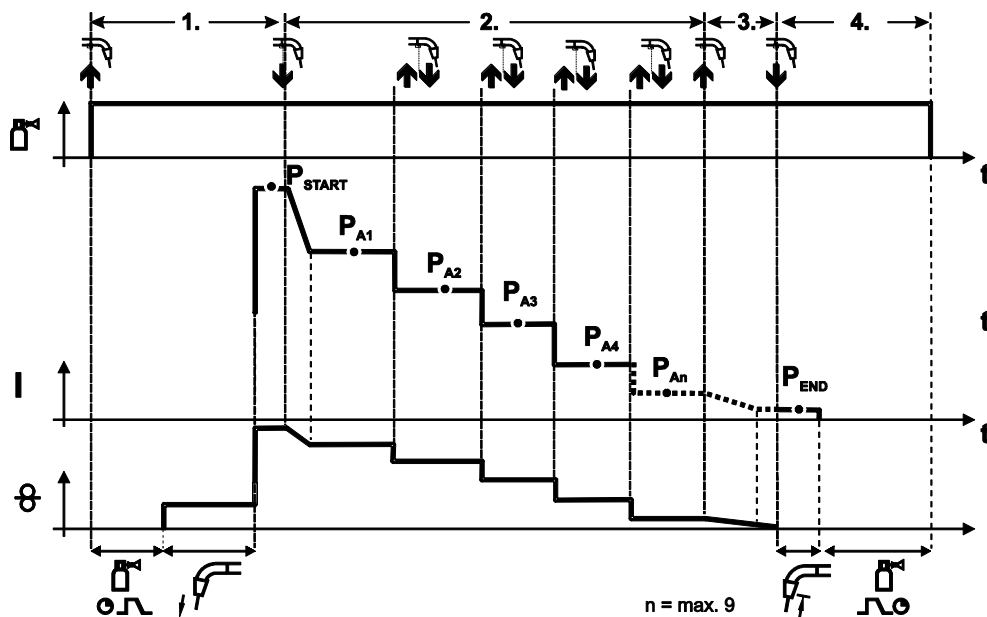


Figure 5-6

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

1st cycle

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

2nd cycle

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

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

3rd cycle

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

4th cycle

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

Special latched tapping start (P9)

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

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

Set special latched tapping time (P11)

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

0 = no tapping

1 = 320ms (factory setting)

2 = 640ms

JOB list switching (P12)

Value	Name	Explanation
1	Real JOB list	JOB numbers correspond to the actual memory cells. Every job can be selected, there will be no memory cells if the selection will be skipped.
2	Real JOB list, JOB switching active	Like real JOB list. In addition JOB switching with appropriate accessory components such as a function torch is possible.

Creating user-defined JOB lists

An associated memory area, in which switching with accessory components such as a function torch between JOBS is possible, is created.

- Set special parameters P12 to "2".
- Set switch "Program or Up/Down Function" to "Up/Down" position.
- Select existing JOB, which comes as close as possible to the desired result.
- Copy JOB to one or more destination JOB numbers.

If JOB parameters still need to be adjusted, select destination JOBS one after the other and adjust parameters individually.

- Special parameters P13 to the lower limit and
- Adjust special parameters P14 to the upper limit of the destination JOBS.
- Set switch "Program or Up/down function" to position "Program".

With the accessory component JOBS can be switched in the specified range.

Copying JOBS, "Copy to" function

The possible target range is between 129 - 169.

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

Copy JOB by number, see corresponding operating instructions ("Control").

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

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

Lower and upper limit of JOB remote switching (P13, P14)

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

Avoids an accidental changeover into undesirable or undefined JOBS.

Block JOB mode (P16)

The following accessory components support block JOB mode:

- Up/Down welding torch with one-digit 7-segment display (two keys)
- Program 0 is always active in JOB 0 and program 1 in all other JOBS

In this operating mode, up to 30 JOBS (welding tasks) divided into three blocks can be called up with accessory components.

The following configurations must be carried out to use the block JOB operation:

- Set the "Program or Up/Down function" changeover switch to "Program"
- Set the JOB list to actual JOB list (special parameter P12 = "1")
- Enable block JOB mode (special parameter P16 = "1")
- Switch to block JOB mode by selecting one of the special JOBS 129, 130 or 131.

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

Allocation of JOB numbers to the display on the accessory components

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

JOB 0:

This JOB allows the manual setting of the welding parameters.

The selection of JOB 0 can be prevented by using the key switch or with the parameter "Block program 0" (P2).

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

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

JOBS 1-9:

In each special JOB, nine JOBS (see Table) can be called up.

Nominal values for wire feed speed, arc correction, dynamics, etc. must be stored in advance in these JOBS. This is done conveniently using the software PC300.Net.

If the software is not available, the "Copy to" function can be used to create user-defined JOB lists in the special JOB areas (see explanations in the Chapter "JOB list switching (P12)").

Selecting programs with the standard torch trigger (P17)

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

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

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

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

Program settings for relative programs (P23)

The start, down-slope and end program relative programs can be set individually or combined for the P0-P15 operating points. When choosing the combined setting, in contrast to the individual setting, the parameter values are saved in the JOB. With the individual setting, the parameter values are identical for all JOBS (except for special JOBS and SP1, SP2 und SP3).

Nominal value wire heater (P26)

The Wire Heating System (WHS) prevents moisture deposits on the welding wire and thus reduces the risk of pinholes. The setting is infinitely variable in the temperature range from 25°C to 50°C; the factory setting of 45°C is mainly used for moisture-attracting welding consumables such as aluminium or flux-cored wire.

Operating mode switching at welding start (P27)

With the selected 4-cycle-Special mode, the user can determine by the time of the torch trigger operation in which operating mode (4-cycle or 4-cycle-Special) the program sequence shall be carried out.

Hold torch trigger (longer than 300 ms): Program sequence with operating mode 4-cycle-Special (standard).

Tap torch trigger: Device changes to operating mode 4-cycle.

Error threshold of electronic gas flow control (P28)

The set percentage value is the error threshold; if it is undershot or exceeded, an error message > see 8.3 chapter is displayed.

5.4.5 Control

Menu item / parameter	Value	Comment
Operation without wire feeder is possible (This parameter controls the system behaviour depending on the connected wire feeder)	No (factory setting)	The wire feeder (WF) can be changed during operation. Operation without a connected wire feeder is not possible.
	Yes	The welding system can be operated without a wire feeder connected.

5.4.6 Operating panel settings

Menu item / parameter	Value	Comment
Type of main screen	1-3	-
Automatic selection of welding power	Off-30 s	-
Display brightness:	0-100 %	-
Display contrast:	0-100 %	-
Display negative:	No	-
	Yes	-
Non-latched selectable	No	-
	Yes	-
Latched selectable	No	-
	Yes	-
Special non-latched selectable	No	-
	Yes	-
Spot welding selectable	No	-
	Yes	-
Special latched selectable	No	-
	Yes	-
P0 of Expert XQ 2.0 can be changed:	No	-
	Yes	-
Mean value display for superPuls:	Yes	When superPuls is enabled the welding power is displayed as average value.
	No	The welding power is displayed by program A even when superPuls is enabled.
Hold function:	On	-
	Off	-
Language	German	-
Measuring units	Metric	-
	Imperial	-
Numbering files consecutively	Yes	The file names are numbered consecutively when saving.
	No	One file is always overwritten.
Expert XQ 2.0 reset to factory settings	Yes	Only those parameters relevant for Expert XQ 2.0 (e.g. display settings and languages) will be reset. This does not affect system parameters such as Xbutton - activation or JOBs.
	No	-

5.4.7 Aligning the cable resistance

The resistance value of cables can either be set directly or it can be aligned using the power source. The factory setting of the power sources is 8 mΩ. This value corresponds to a 5 m earth cable, a 1.5 m intermediate hose package and a 3 m water-cooled welding torch. With other hose package lengths, it is necessary to carry out a +/- voltage correction to optimise welding properties. The voltage correction value can be set close to zero by means of realigning the cable resistance. It is recommended to align the electric cable resistance after replacing accessories such as torches or intermediate hose packages.

In case a second wire feeder is used the (rL2) parameter has to be aligned. For all other configurations it is sufficient to align the (rL1) parameter.

1 Preparation

- Switch off the welding machine.
- Unscrew the gas nozzle from the welding torch.
- Trim the welding wire so that it is flush with the contact tip.
- Pull the welding wire back a little (about 50 mm) on the wire feeder (by pressing button B - wire return). There should be no more welding wire in the contact tip at this point.

2 Configuration

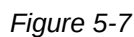
- Switch on the welding machine
- Press the "System" push-button.
- Select the "Cable resistance alignment" parameter using the main control button. Parameter RL1 must be aligned for all machine combinations. In case of welding systems with a second power circuit – if two wire feeders are to be operated from a single power source, for example – a second alignment with parameter RL2 must be made. To activate the required wire feeder for measurement, briefly activate (tap) the torch trigger of this machine.

3 Alignment / Measurement

- Press the "D" push-button.
- Place the welding torch with the contact tip on a clean spot of the workpiece with a little pressure and press the torch trigger for approx. 2 seconds. A short-circuit current will flow briefly, which is used to determine and display the cable resistance. The value can be between 0 mΩ and 40 mΩ. The new value is immediately saved without requiring further confirmation. If no value is shown on the display, then the measurement failed. The measurement must be repeated.
- Press the "A" push-button after successful measurement.

4 Restoring welding standby mode

- Switch off the welding machine.
- Screw the gas nozzle onto the welding torch.
- Switch on the welding machine.
- Insert the welding wire again.



5.4.8 Xnet machine

The Xnet machine defines the system component required for operating the Xnet system as part of the Expert 2.0 Net/Gateway to connect to power sources or to record welding data.

5.4.8.1 Coupling mobile machines

QR code for coupling mobile end devices. Upon a successful connection, welding data are displayed on the end device.

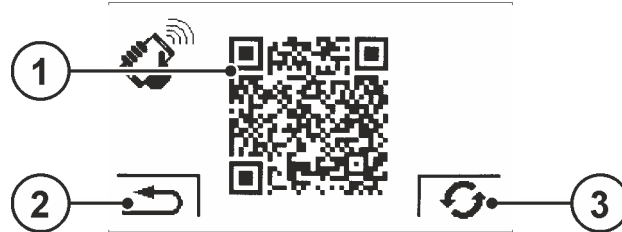


Figure 5-8

Item	Symbol	Description
1		QR code
2		Menu navigation Skip back to previous menu
3		Reset message The message can be reset and a new QR code may be requested from the network.

5.4.9 Component identification

Bar codes predefined in ewm Xnet are recorded with a manual scanner. Component data are retrieved and displayed in the control.

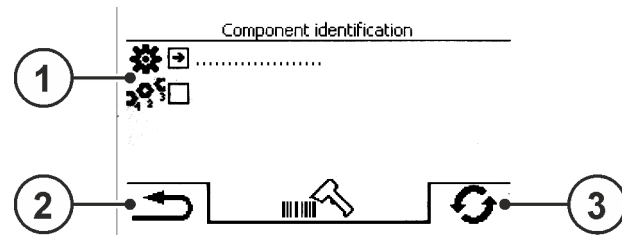


Figure 5-9

Item	Symbol	Description
1		Component data
2		Menu navigation Skip back to previous menu
3		Reset message The message can be reset

5.4.9.1 Component details

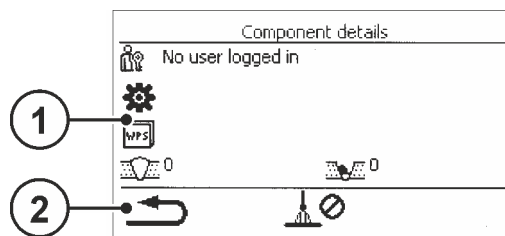


Figure 5-10

Item	Symbol	Description
1		Component data
2		Menu navigation Skip back to previous menu

5.4.9.2 Errors and warnings

A list of all ewm Xnet-specific errors and warnings are displayed with their ID number and description.

5.4.10 Status information

Status information	
Remainig capacity of system memory	100 %
	

Figure 5-11

5.4.10.1 Network

Network	Network	WiFi
>Device-Name<	Status of network use	Status
IP address 004.003.002.001	DHCP-Configuration DHCP-PLUS	connected
Subnet mask 208.192.176.160	DHCP-Status DHCP-PLUS OK	SSID Network-Name
Gateway 139.122.111.094		BSSID BSSID-Name
MAC address C3:D2:E1:F0:B4:A5		Channel number 23
		WiFi firmware ModulVersion
		

Figure 5-12

5.4.11 Clear system memory

Resets the internal system memory used for saving welding and log data and deletes all data.

All welding data recorded so far, which have not been transferred to the Xnet server via flash drive or network connection, will be permanently deleted.

5.4.12 Reset to factory settings

All machine configuration data relating to Xnet will be reset to the factory setting. The system memory data will not be affected, i.e. any welding or log data recorded will be saved.

5.5 Offline data transfer (USB)



You may only use this USB interface to exchange data with a USB flash memory. You must not connect any other USB devices such as keyboards, hard disks, mobile telephones, cameras or other devices so as to avoid any damage tp the machine. The interface does not provide any load functions either.

Using the USB interface, data can be transferred between the machine control and a USB storage medium.

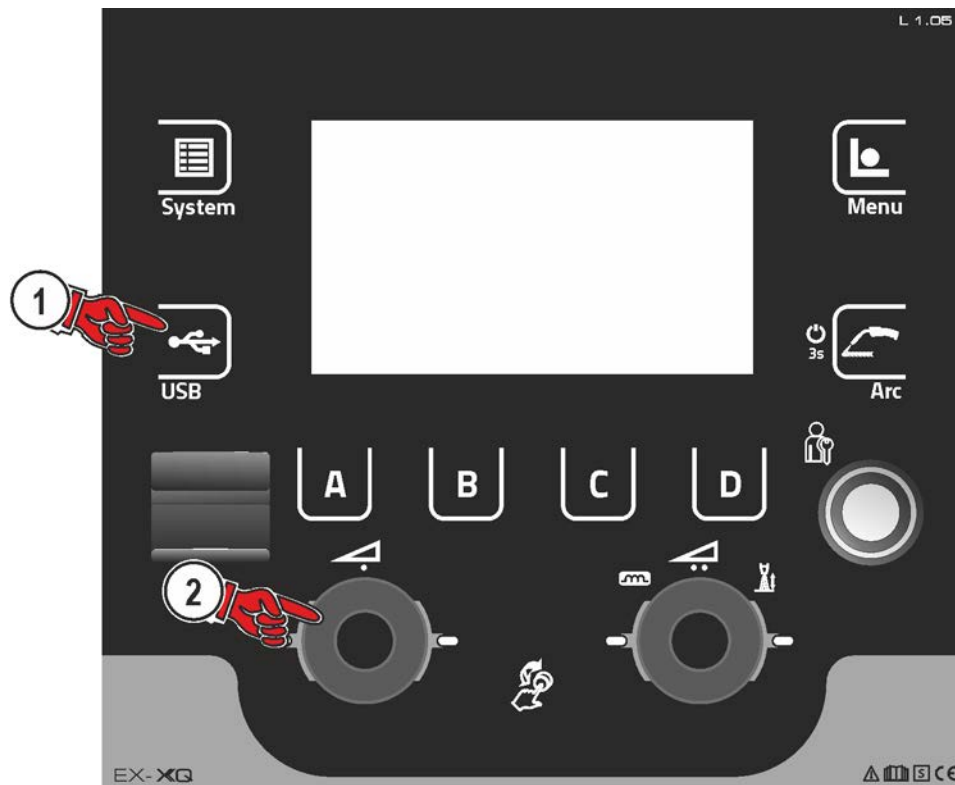


Figure 5-13

5.5.1 Save JOB(s)

Saving a single (JOB) or a range of welding tasks (JOB)s (from-to) from the welding machine to the storage media (USB).

5.5.2 Load JOB(s)

Loading a single JOB or a range of welding tasks (JOBs) (from-to) from the storage media (USB) to the welding machine.

5.5.3 Save configuration

5.5.3.1 System

Configuration data of the power source's system components.

5.6 Xnet machine

Master configuration

Core data for network communication (independent of machine).

Individual configuration

Machine-related configuration data, matching the current power source only.

5.6.1 Load configuration

5.6.1.1 System

Configuration data of the power source's system components.

5.6.1.2 Xnet machine

Master configuration

Core data for network communication (independent of machine).

Individual configuration

Machine-related configuration data, matching the current power source only.

5.6.2 Load languages and texts

Load a language and text package from the storage medium (USB) to the welding machine.

5.6.3 Record on USB drive

You can record welding data on a storage medium and read or analyse them using the Xnet quality management software when required. For machine variants with network capability (LG/WLG) only!

5.6.3.1 Register USB drive

To identify and allocate the welding data between power source and storage medium the storage medium has to be registered once. This is done by selecting the menu option "Register USB drive" or by starting a data recording process. Successful registration is indicated by a checkmark next to the relevant menu option.

If the storage medium is registered and connected when the power source is being switched on, recording of the welding data starts automatically.

5.6.3.2 Start recording

After confirming the start of data recording the storage medium will be registered (if not registered yet). Data recording starts and is indicated at the main screen by a slow flashing of the  icon.

5.6.3.3 Stop recording

To avoid data loss, finish the recording with this menu option before removing the USB drive or switching off the machine.

Welding data must be imported into the Xnet quality management software using the XWDImport software. This software is an integral part of the Xnet installation.

5.7 Welding task administration (Menu)

In this menu the user can carry out all welding task (JOB) organisation operations.

This machine series offers user-friendly operation and a multitude of features.

- Various welding tasks (JOBS) consisting of welding procedure, material type, wire diameter and shielding gas type have been predefined > see 9.2 chapter.
- The system calculates the required process parameters depending on the operating point specified (one-knob operation via wire feed speed rotary transducer).
- You can adjust additional parameters at the machine control or using the PC300.NET welding parameter software, if required.

Enter the menu:



Figure 5-14

5.7.1 JOB selection (material/wire/gas)

The welding task (JOB) can be set in two ways:

- Enter the relevant JOB number. Each welding task has a unique JOB number (for predefined JOBS > see 9.2 chapter, see the JOB list in the annex or the sticker on the machine).
- Enter the basic welding parameters: welding procedure, material type, wire diameter and shielding gas type.

5.7.2 JOB favourites

Favourites are additional locations for storing and loading frequently used welding tasks, programs and their settings. The status of the Favourites (loaded, changed, not loaded) is indicated by signal lights.

- Five Favourites are available to save any settings.
- As required, the access control can be adjusted with the key switch or Xbutton function.

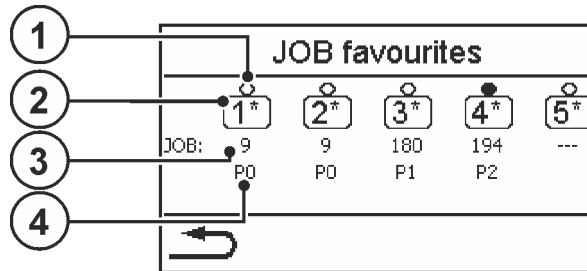


Figure 5-15

Item	Symbol	Description
1		Status of Favourites ●----- Favourite loaded, settings of the Favourite and the current device settings are identical ○----- Favourite loaded, but settings of the Favourite and the current device settings are not identical (e.g. operating point has been changed) ○----- Favourite not loaded (e.g. JOB number has been changed)
2		Location number of the Favourite
3		Display of the welding task (JOB) Displays the JOB number assigned to the Favourites location (setting "---" means: no JOB assigned)
4		Display of the program (P0-P15) Display of the program number assigned to the Favourite location

5.7.2.1 Saving current settings to Favourites

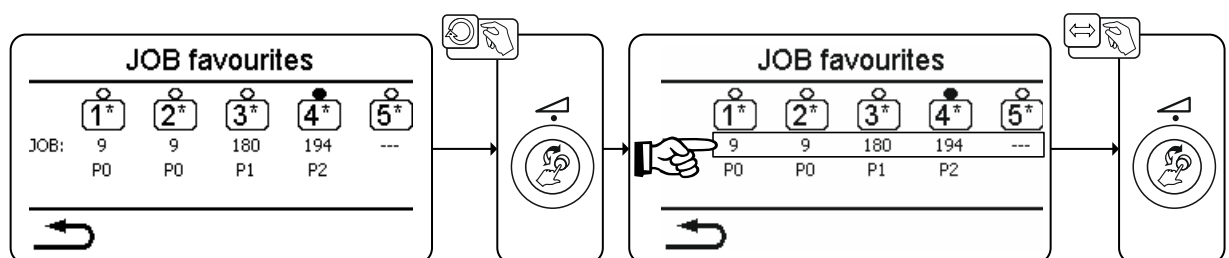


Figure 5-16

- Use the click wheel welding power to switch to the desired Favourite (JOB line).
- Press the click wheel to confirm the current settings in this location.

5.7.2.2 Loading saved Favourites

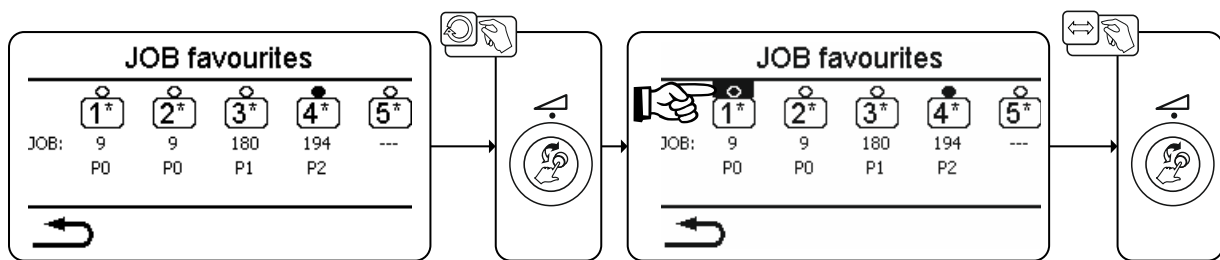


Figure 5-17

- Use the click wheel welding power to switch to the desired Favourite ("Status Favourite" line).
- Press the click wheel to load the appropriate Favourite.

5.7.2.3 Deleting saved Favourites

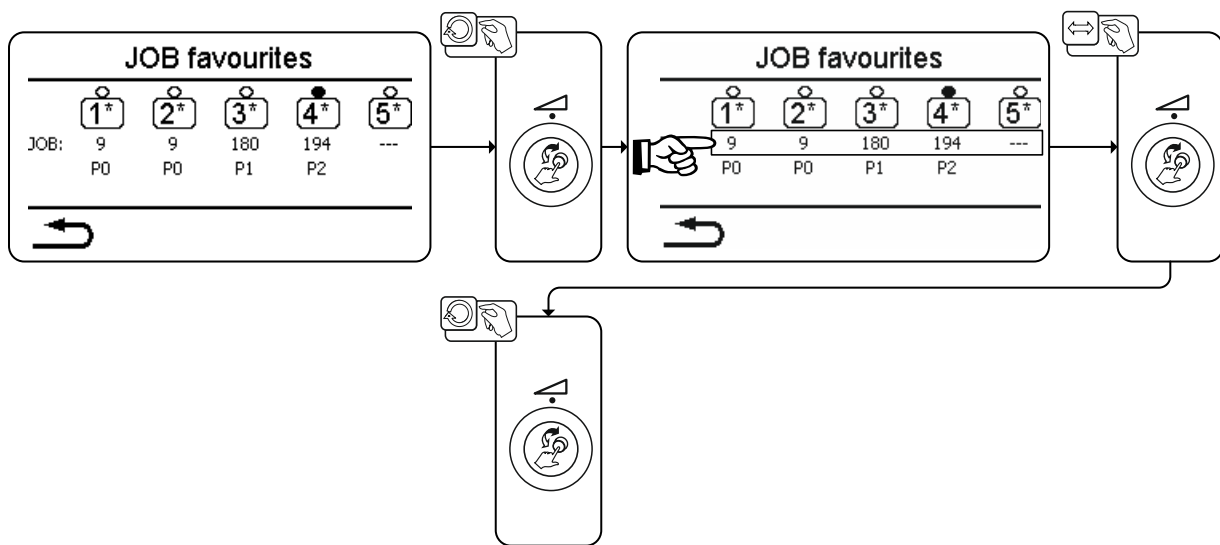


Figure 5-18

- Turn the click wheel welding power to switch to the desired Favourite (JOB line).
- Press the click wheel to confirm the selection of the appropriate Favourite.
- Turn the click wheel to the left to delete the Favourite (indicated by three hyphens "---")
- Press the click wheel to confirm the deletion.

5.7.3 JOB manager

5.7.3.1 Copy JOB to number

Copy JOB to a number of the definable range (129–169).

5.7.3.2 Reset current JOB

Reset all parameters of the selected JOB to the factory setting

5.7.3.3 Reset all JOBS

Reset all JOBS to the factory setting, except JOBS in the definable range (129–169) > see 8.4 chapter.

5.7.4 Program sequence

In the program sequence, you can select welding parameters and set their values. The number of parameters shown depends on the selected operating mode.

In addition, the user can access advanced settings and the setup mode.

The setting range for the parameter values are summarised in the parameter overview section > see 9.1 chapter.

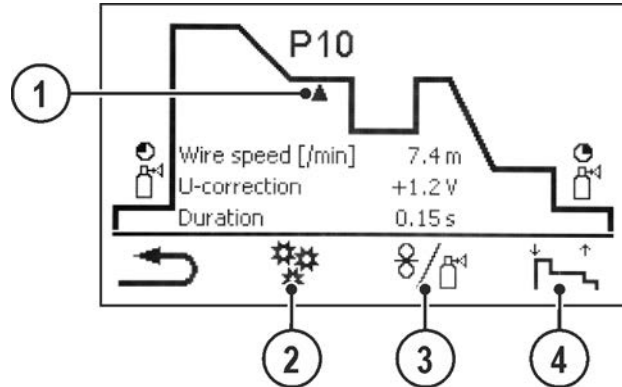


Figure 5-19

Item	Symbol	Description
1	▲	Parameter position Displays the currently selected welding parameters in the functional sequence
2	⚙️	Advanced settings Display and setting of advanced process parameters
3	🔧/🔩	Setup mode > see 5.7.5 chapter
4	□	Operating mode setting

5.7.4.1 Programs (P_A 1-15)

In the manual program P0, the user can adjust the operating point in a conventional way using the parameter settings on the machine control. The active program is shown in the main menu of the machine display in the display area for process parameters with the letter “P” and the corresponding program number.

Different welding tasks or positions on a workpiece require different welding power values (operating points) or parameter settings. These settings can be stored in up to 15 programs (P1 to P15) and recalled, as needed, at the machine control or a suitable accessory component (e.g. welding torch).

Welding parameters for program 0 (P0) are changed for decompact machine systems at the machine control of the wire feeder (factory setting). To change the parameters using the Expert 2.0 machine control, the parameter “P0 changeable by Expert 2.0” must be set to “Yes” > see 5.4.6 chapter.

Welding parameters for programs 1 - 15 can be changed on any control connected in the system.

The following parameters and their values are stored in each program:

- Wire feed speed and voltage correction (welding power)
- Operating mode, welding type, dynamics and setting superPuls

Changes to the parameter settings are stored in the selected program without further prompt.

Selection

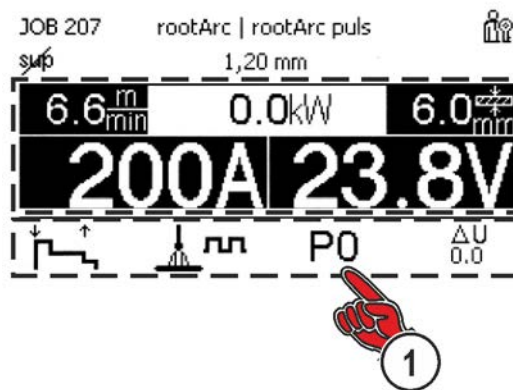


Figure 5-20

5.7.4.2 Overview of the welding parameter switching options

The user can change the welding parameters of the main programs with the following components.

	Program switching	JOB switching	Process switching	Welding type	Program	Operating mode	Wire feed speed	Voltage correction	Dynamics
M3.7 – I/J Wire feeder control					P0				
					P1-15				
PC 300.NET Software					P0				
					P1-15				
MT Up/Down Welding torch					P0				
					P1-9				
MT 2 Up/Down Welding torch					P0				
					P1-15				
MT PC 1 Welding torch					P0				
					P1-15				
MT PC 2 Welding torch					P0				
					P1-15				
PM 2 Up/Down Welding torch					P0				
					P1-15				
PM RD 2 Welding torch					P0				
					P1-15				
PM RD 3 Welding torch					P0				
					P1-15				

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

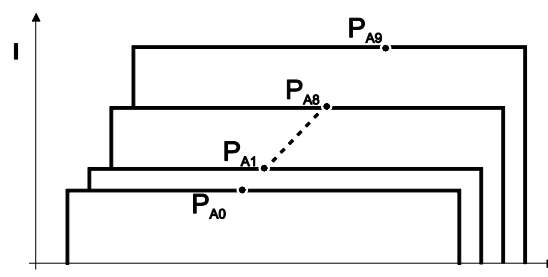


Figure 5-21

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

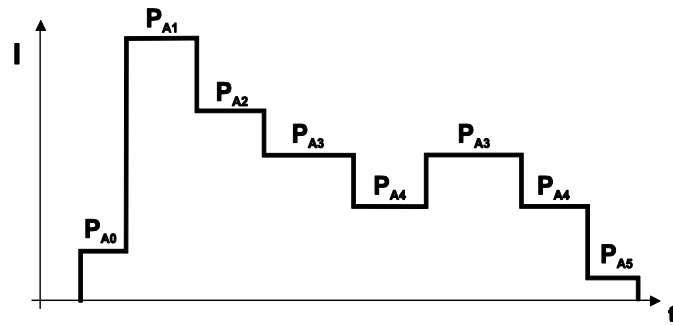


Figure 5-22

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

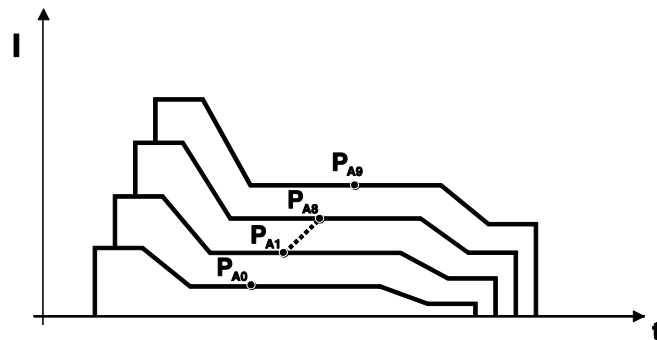


Figure 5-23

5.7.4.3 MIG/MAG welding

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

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

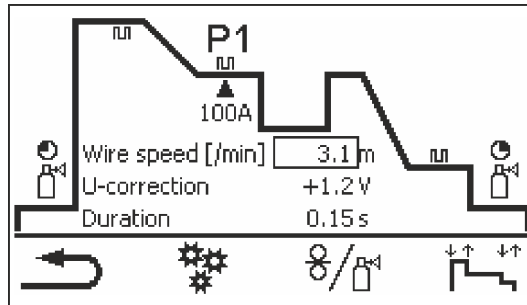


Figure 5-24

P_{START}, P_B and P_{END} are set as relative programs ex factory. They relate to percentages of the wire feed value of the main program P_A. These programs can also be configured using absolute values, if desired (see Absolute value set point). > see 5.7.8 chapter.

Menu item/parameter	Program	Comment
Gas pre-flow time		
Gas nominal value		GFE option/variant (electronic gas volume control) required
WF relative	P _{START}	Wire feed speed, relative
Duration		Duration (start program)
U correction		Arc length correction
Slope time		Slope duration from P _{START} to P _A
WF (/min.)	P _A	Wire feed speed, absolute
U correction		Arc length correction
Duration		Duration (spot time and superPuls time)
Slope time		Slope duration from P _A to P _B
WF relative	P _B	Wire feed speed, relative
Duration		Duration (reduced main program)
U correction		Arc length correction, relative
Slope time		Slope duration from P _B to P _A
Slope time		Slope duration from P _B to P _{END}
WF relative	P _{END}	Wire feed speed, relative
Duration		Duration (end program)
U correction		Arc length correction, relative
Wire burn-back		
Gas post-flow time		

5.7.4.4 Advanced settings

Menu item/parameter	Value	Comment
Process switching	Off	
	On	
Start program pulsing	Off	
	On	
End program pulsing	Off	
	On	
Wire retraction ignition	Off	
	Lift arc (PP)	
	Lift arc	
End pulse duration	0.0–20 ms	
U correction limit	0.0–9.9 V	Applies with correction operation enabled
Wire correction limit	0–30%	
N cycle program limit	Off	
	1-15	
Slope between programs (/100 ms)	Off	
	0.1–2.0 m/min	
waveArc	Off	
	On	

5.7.4.5 TIG welding

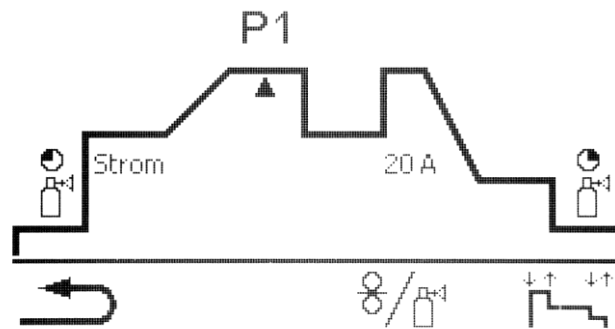


Figure 5-25

Menu item/parameter	Program	Comment
Gas pre-flow time		
Gas nominal value		GFE option/variant (electronic gas volume control) required
Current	P _{START}	Start current
Duration		Duration (start program)
Slope time		Slope duration from P _{START} to P _A
Current	P _A	Welding current, absolute
Duration		Pulse time (superPuls)
Slope time		Slope duration from P _A to P _B
Current	P _B	Welding current
Duration		Pulse pause time (superPuls)
Slope time		Slope duration from P _B to P _A
Slope time		Slope duration from P _A to P _{END}
Current	P _{END}	Welding current
Duration		
Gas post-flow time		

5.7.4.6 MMA welding

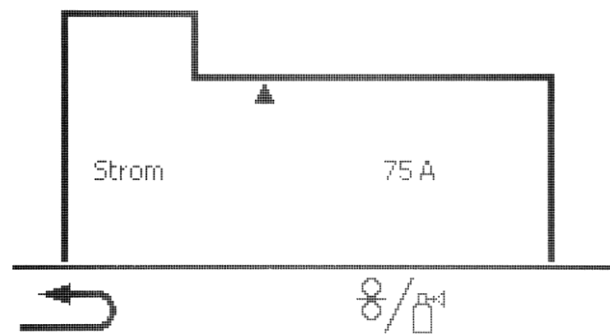


Figure 5-26

Menu item/parameter	Comment
Current	Hot start current
Duration	Hot start time
Current	Main current

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

5.7.5 Setup mode

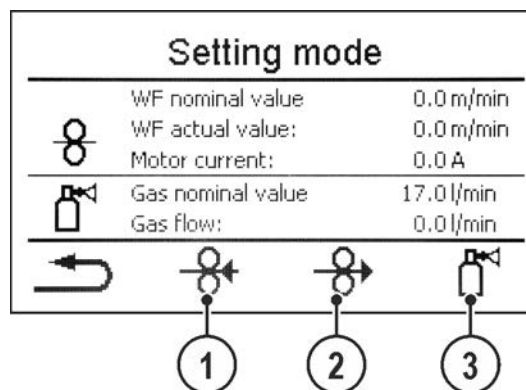


Figure 5-27

Item	Symbol	Description
1		Wire return Results in reverse inching of the wire. Pressing the push-button longer will increase the wire reversing speed.
2		Wire inching The wire is inched into the hose package. Pressing the push-button longer will increase the wire inching speed.
3		Push-button, gas test/purge hose package ----- Gas test: Shielding gas (symbol flashes slowly) will flow for approximately 20 seconds after pressing the push-button once. Press the button again to cancel the process early. ----- Purge hose package: Press push-button for about 5 sec: Shielding gas flows permanently (mac 300 s) until the Gas test push-button is pressed again (shielding gas flashes fast).

All functions run without current (set-up phase). This provides a high degree of safety for the welder, since the arc cannot be inadvertently ignited. The following parameters can be monitored during the wire configuration:

Menu item/parameter	Value	Comment
WF nominal value	0.0 m/min	only if the control is integrated in the wire feeder
WF actual value	0.0 m/min	
Motor current	0.0 A	
Gas nominal value	0.0 l/min	GFE option/variant (electronic gas volume control) required
Gas flow	0.0 l/min	

5.7.6 WPQR welding data assistant

The cooling-down time from 800°C to 500°C essential for the welding result (known also as t8/5 time) can be calculated using the input data in the WPQR welding data assistant. Prerequisite is the prior determination of the heat input. Upon input of the values, the valid t8/5 time is displayed with a black background.

Menu item/parameter	Value	Comment
Weld length:	1.0-999.9 cm	
Welding speed:	1.0-999.9 cm/min.	
Thermal efficiency:	10-100%	
Heat input:	kJ/mm	
Preheating temperature:	0-499 °C	
Material thickness:	1.0-999.9 mm	
Weld seam factor:	0.01-1.5	
Transition thickness:	mm	
t8/5-time:	s	

5.7.7 Welding monitoring

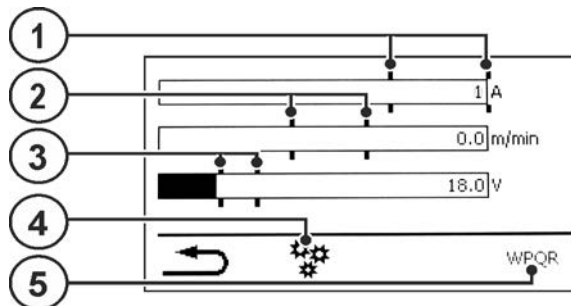


Figure 5-28

Item	Symbol	Description
1		Current tolerance
2		WF tolerance
3		Voltage tolerance
4		Advanced settings Display and setting of advanced system parameters
5	WPQR	WPQR welding data assistant

Menu item / parameter	Value	Comment
Automatic	No	
	Yes	The welding monitoring window opens automatically from the main screen after a welding start. A rotary knob actuation automatically switches back to the main window.
Errors and warnings	Off	
	Warnings	Exceeding a tolerance limit for the duration of the tolerance response time triggers warning 12.
	Error	Exceeding a tolerance limit for the duration of the tolerance response time triggers error 61. Please note: Error leads to immediate stop of the ongoing welding!
Voltage tolerance	0-100 %	
Current tolerance	0-100 %	
Tolerance response time	0.00-20.0 s	For voltage and current tolerance
Wire feeder tolerance	0-100 %	
Maximum permissible motor current	0.0-5.0 A	
Tolerance response time	0.00-20.0 s	For WF tolerance and motor current

5.7.8 JOB display setting

Menu item/parameter	Value	Comment
Text for material:	Standard	
	Alternative	
Text for gas:	Standard	
	Alternative	
Absolute value set point:	Yes	Start current, secondary current and end current are set and displayed as absolute values.
	No	Start current, secondary current and end current are defined and displayed as a percentage of program A (ex works)

5.8 Change welding procedure (Arc)

In this menu the user can change the welding procedure based on the preselected material, wire and gas (change of process based on welding task).

For changing the welding task (JOB) > see 5.7 chapter

Enter the menu:



Figure 5-29

5.9 Online data transfer (network)

For machine variants with network capability (LG/WLG) only!

The network is used to transfer welding data from manual, automated and welding machines. It can include as many welding machines and computers as require and the collected data can be retrieved from one or several server PCs.

The Xnet software allows the user to monitor all welding parameters in real time and/or to subsequently analyse the saved welding data. The results can be used for process optimisation, welding calculations or checking welding wire batches.

Depending on the welding machine the data are transferred to the server via LAN/WiFi and can then be accessed in a browser window. The user interface and web-based design of the software offer the possibility to analyse and monitor the welding data via a tablet PC.

5.9.1 Wired local network (LAN)

Status description	Status display
No physical connection to a network	Deactivated LAN symbol
Connection to the network, the machine has been configured, no data transfer	Activated LAN symbol
Connection to the network, the machine has been configured and transfers data	LAN symbol flashing
Connection to the network, the machine has been configured and tries to connect to the data server	LAN symbol flashing in the specified rhythm

5.9.2 Wireless local network (WiFi)

Status description	Status display
No physical connection to a network	Deactivated WiFi symbol
Connection to a network, no data transfer	Activated WiFi symbol
Connection to a network, transferring data	WiFi symbol flashing
Connection to the network, the machine has been configured and tries to connect to the data server	LAN symbol flashing in the specified rhythm

6 Welding procedure

The welding task is selected in the JOB selection menu (material/wire/gas) > see 5.7.1 chapter.

The basic settings of the relevant welding procedure, such as operating mode or arc length correction, can be selected on the main screen on the process parameter panel > see 4.3.2 chapter.

The program sequence settings are set in the program sequence menu > see 5.7.4 chapter.

6.1 MIG/MAG welding

6.1.1 Welding type

Different forms of MIG/MAG processes are referred to as welding type.

Standard (Welding with standard arc)

Depending on the set combination of wire feed speed and arc voltage, the arc types short arc, transitional arc or spray arc can be used for welding.

Pulse (Welding with pulsed arc)

A targeted change in the welding current generates current pulses in the arc, which lead to a 1 drop per pulse of material transfer. The result is an almost spatter-free process, suitable for welding of all materials, in particular high-alloy CrNi steels or aluminium.

Positionweld (Positional welding)

A combination of the pulse/standard or pulse/pulse welding types, which is particularly suitable for positional welding due to factory-optimized parameters.

6.1.2 Welding power (operating point)

The welding power is adjusted according to the principle of one-knob operation. The user can set their operating point optionally as wire feed speed, welding current or material thickness. The optimum welding voltage for the operating point is calculated and set by the welding machine. If necessary, the user can correct this welding voltage > see 6.1.2.2 chapter.

Application example (setting via material thickness)

The required wire feed speed is not known and is to be determined.

- Select welding task JOB 76(> see 5.7 chapter): material = AlMg, gas = Ar 100%, wire diameter = 1.2 mm.
- Switch the display to material thickness.
- Measure the material thickness (workpiece).
- Set the measured value, e.g. 5 mm, at the machine control.

This set value corresponds to a specific wire feed speed. Switching the display to this parameter will show the associated value.

In this example, a material thickness of 5 mm corresponds to a wire feed speed of 8.4 m/min.

The material thickness details in the welding programs generally refer to fillet welds in the PB welding position. They should be regarded as guideline values and may differ in other welding positions.

6.1.2.1 Accessory components for operating point setting

The operating point can be set at various accessory components as well, such as remote control, special welding torches or robot and industrial bus interfaces (optional interface for automated welding required, not available for all machines of this series).

See the operating instructions for the machine in question for a more detailed description of the individual machines and their functions.

6.1.2.2 Arc length

When required, the arc length (welding voltage) can be adjusted for the welding task in hand by ± 9.9 V.

6.1.2.3 Arc dynamics (choke effect)

This function can be used to adjust the arc between a narrow, hard arc with deep penetration (positive values) and a wide and soft arc (negative values). In addition, the selected settings are displayed with signal lights below the rotary knobs.

6.1.2.4 superPuls

In superPuls mode, the program toggles between the main program (PA) and the reduced main program (PB). This function is e.g. used for thin sheet welding to reduce the heat input in a controlled manner or for positional welding without the need for weaving.

The combination of superPuls and other EWM welding processes offers a multitude of possibilities. For example, to enable the welding of vertical-up welds without the "Christmas tree" technique, when selecting program 1 > see 5.7.4.1 chapter the relevant superPuls variant (depending on the material) is activated as well. The required superPuls parameters are defined ex works.

The welding power can be represented as average value (ex works) or solely as program A value. If the average value display is activated the signal lights of the main (PA) and reduced main program (PB) are illuminated simultaneously. The display variants can be toggled using special parameter P19, > see 5.4.4.4 chapter.

6.1.3 Operating modes

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

6.1.3.1 Explanation of signs and functions

Symbol	Meaning
	Press torch trigger
	Release torch trigger
	Tap torch trigger (press briefly and release)
	Shielding gas flowing
I	Welding output
	Wire electrode is being conveyed
	Wire creep
	Wire burn-back
	Gas pre-flows
	Gas post-flows
	Non-latched
	Special, non-latched
	Latched
	Special, latched
t	Time
P _{START}	Ignition program
P _A	Main program
P _B	Reduced main program
P _{END}	End program
t ₂	Spot time

Non-latched mode

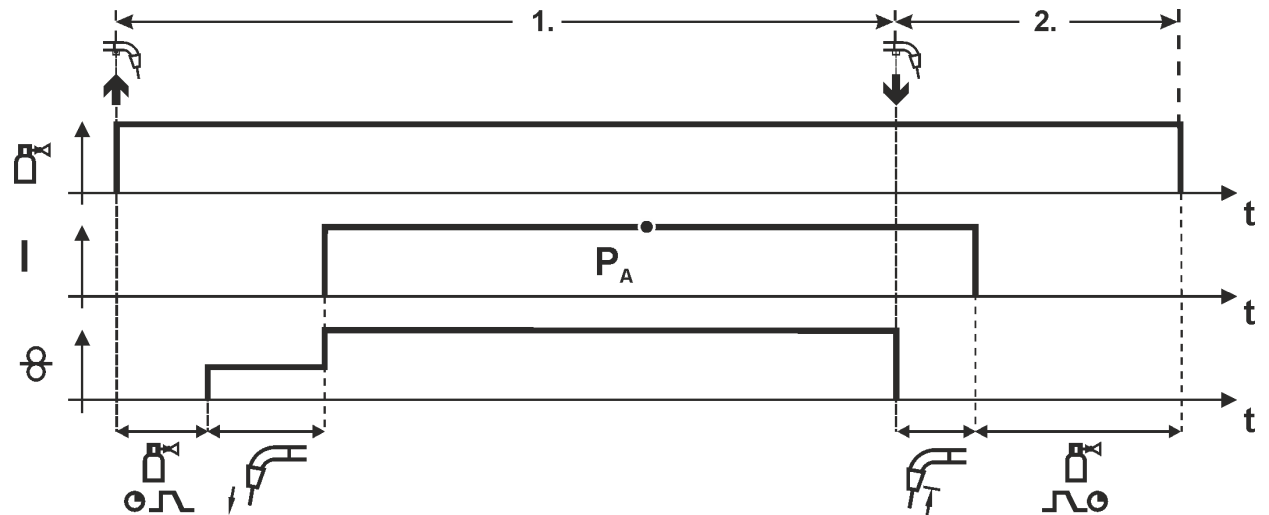


Figure 6-1

Step 1

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

Step 2

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

Non-latched operation with superpulse

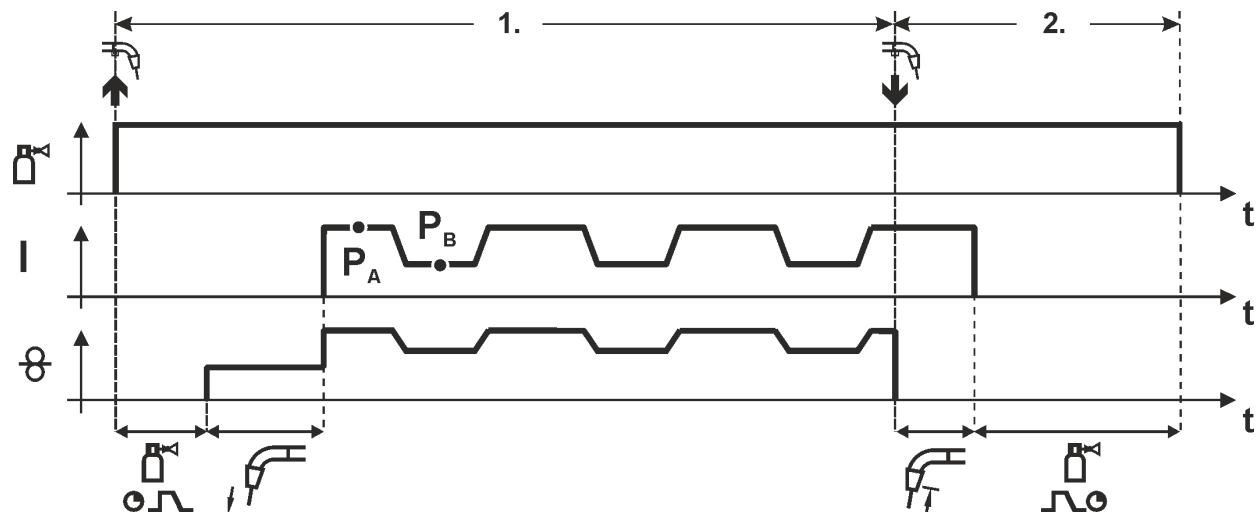


Figure 6-2

Step 1

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

Step 2

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

Special, non-latched

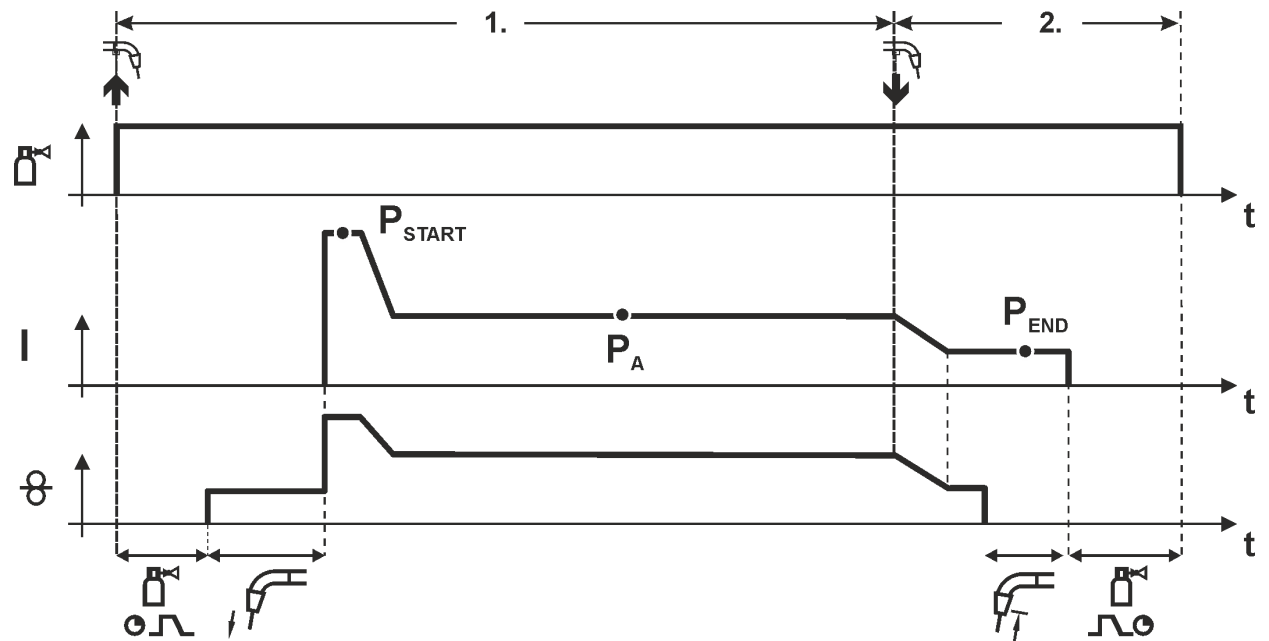


Figure 6-3

Step 1

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

Step 2

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

Spot welding

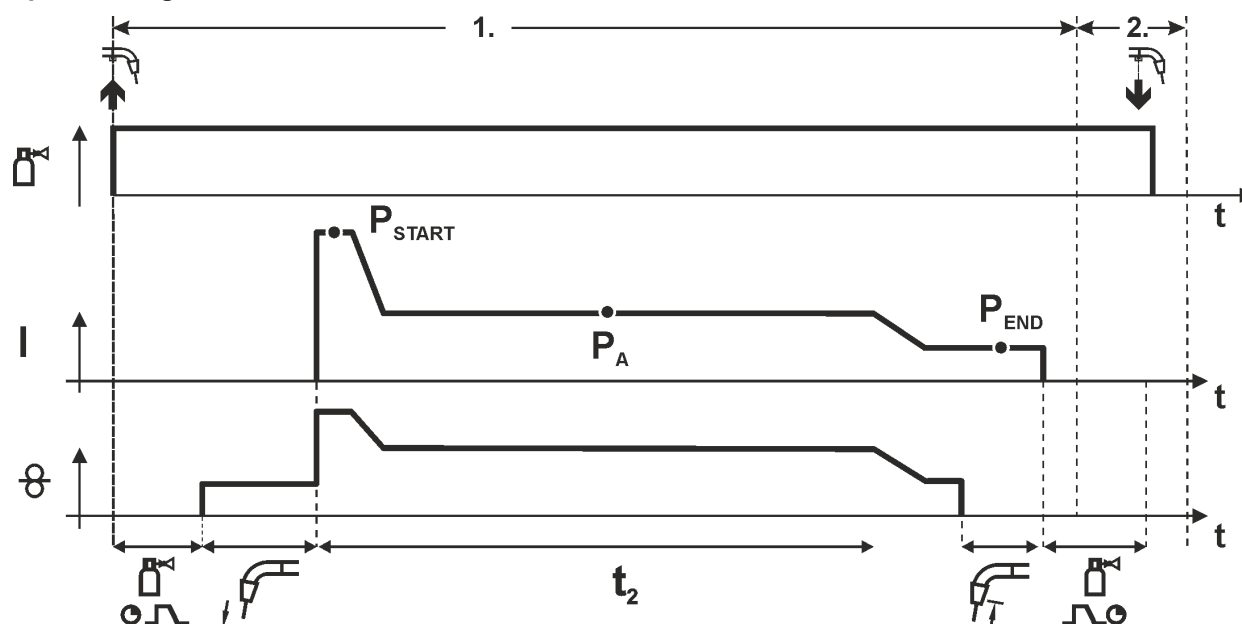


Figure 6-4

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

1st cycle

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

2nd cycle

- Release torch trigger

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

Special, non-latched with superpulse

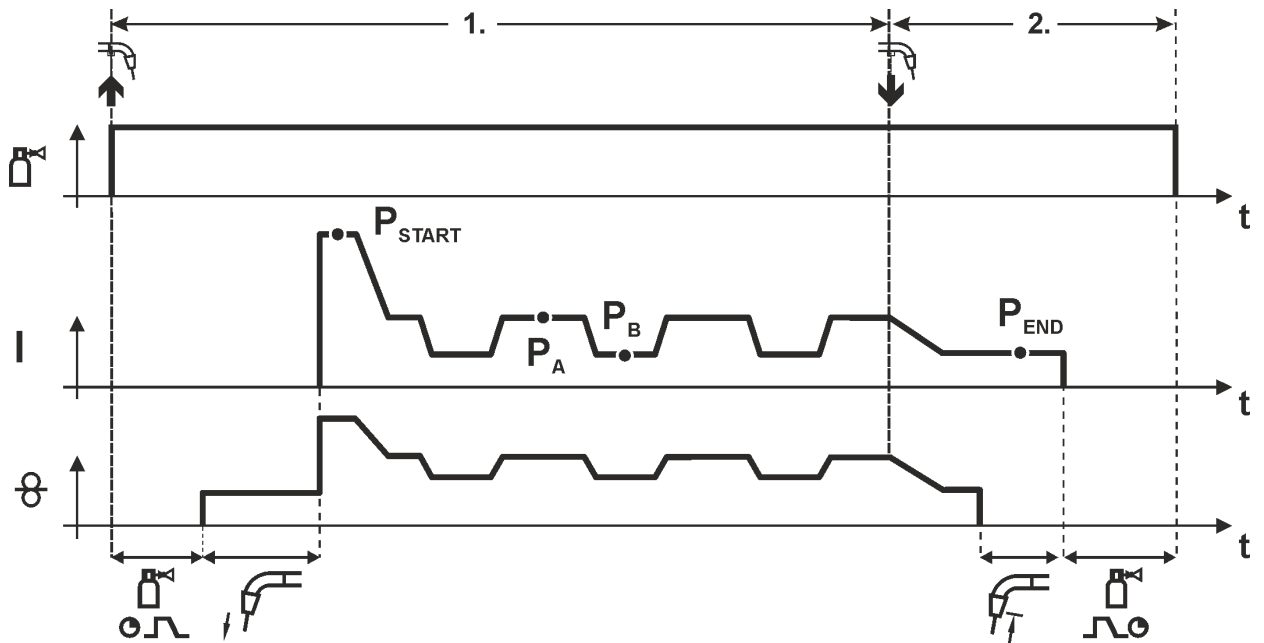


Figure 6-5

Step 1

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

Step 2

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

Latched mode

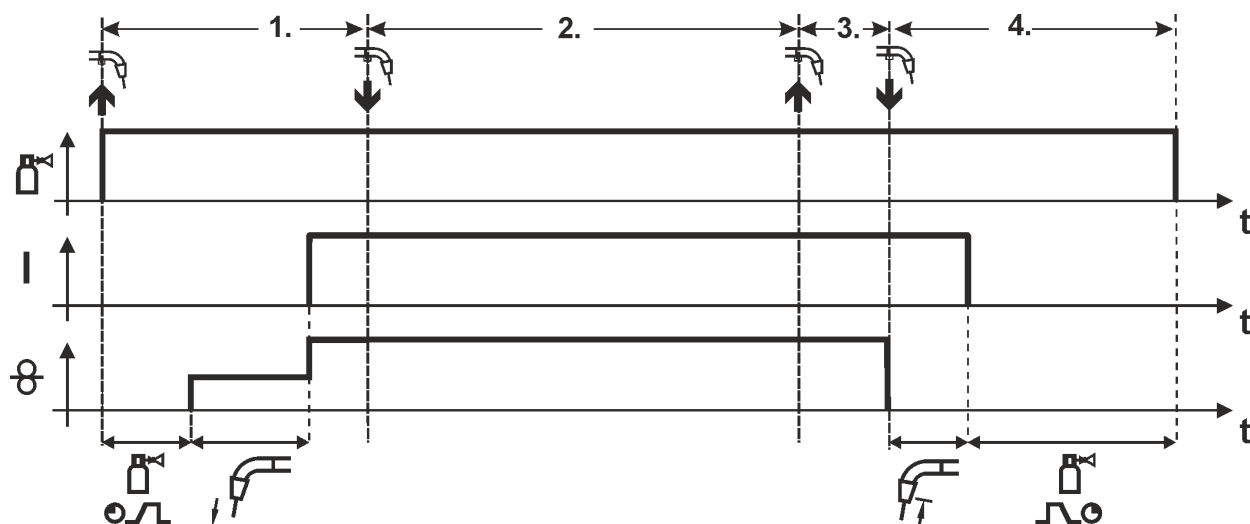


Figure 6-6

Step 1

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

Step 2

- Release torch trigger (no effect)

Step 3

- Press torch trigger (no effect)

Step 4

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

Latched mode with superpulse

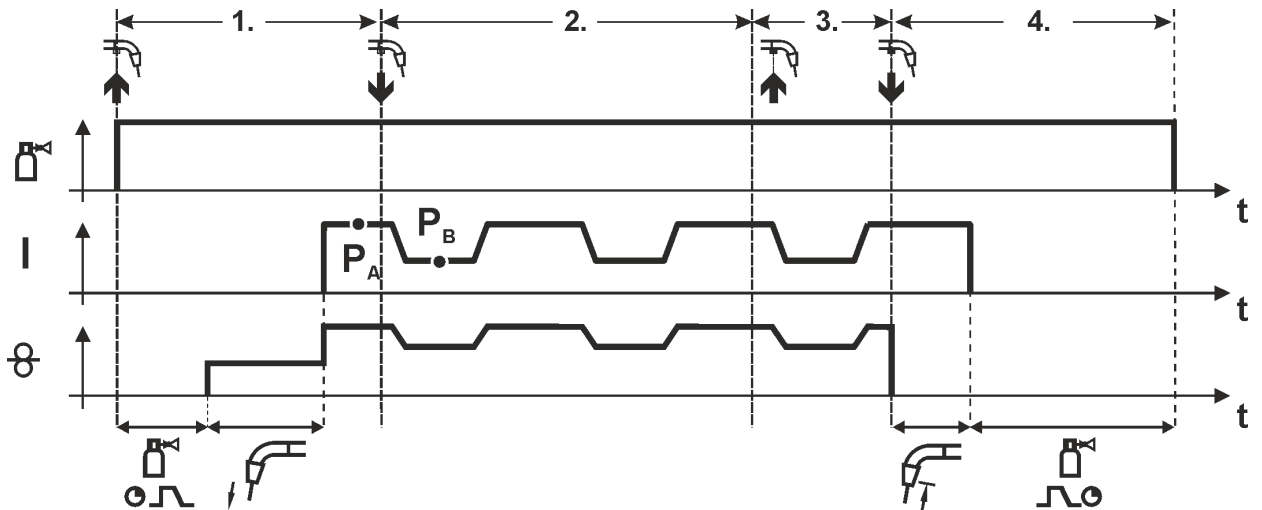


Figure 6-7

Step 1:

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

Step 2:

- Release torch trigger (no effect)

Step 3:

- Press torch trigger (no effect)

Step 4:

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

Latched with changing welding method (process switching)

Exclusively for devices with pulsed arc welding type > see 3.3 chapter.

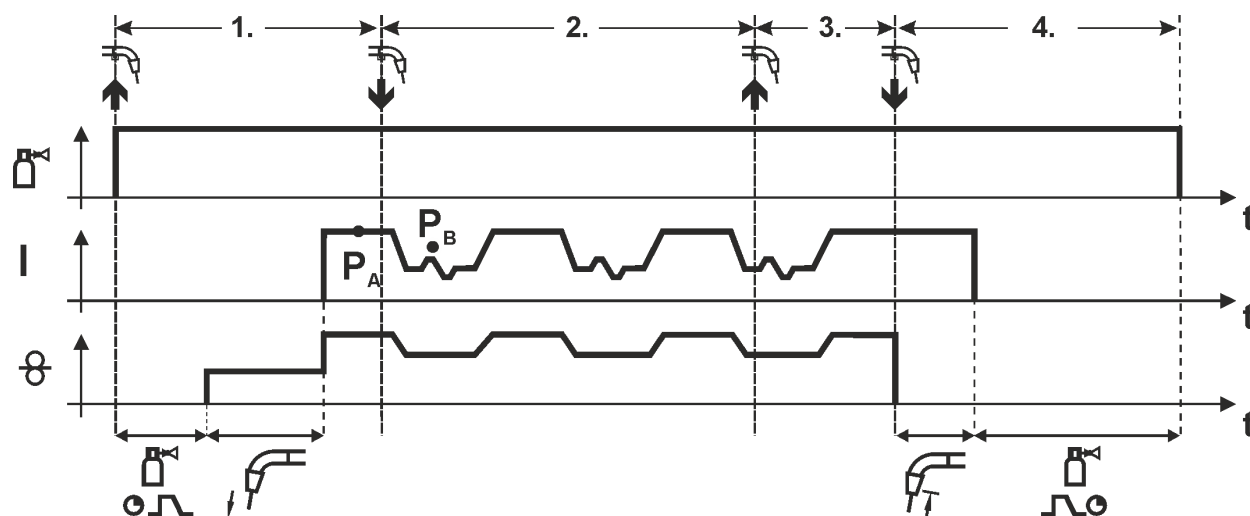


Figure 6-8

1st cycle:

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

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

2nd cycle:

- Release torch trigger (no effect)

3rd cycle:

- Press torch trigger (no effect)

4th cycle:

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

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

Refer to the software operating instructions.

Latched special

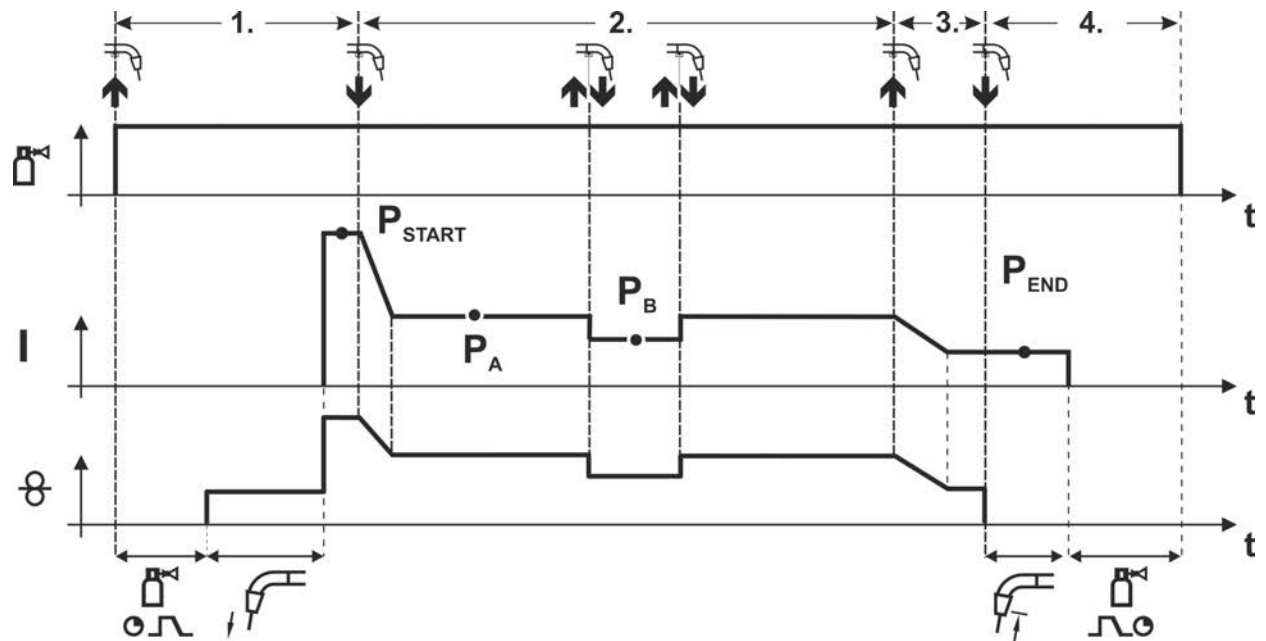


Figure 6-9

Step 1

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

Step 2

- Release torch trigger
- Slope to main program P_A .

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

Tapping¹⁾ can be used to change over to the reduced main program P_B .

Repeated tapping will switch back to the main program P_A .

Step 3

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

Step 4

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

¹⁾ Prevent tapping (brief press and release within 0.3 seconds)

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

Special latched with changing welding method by tapping (process switching)

Exclusively for devices with pulsed arc welding type > see 3.3 chapter.

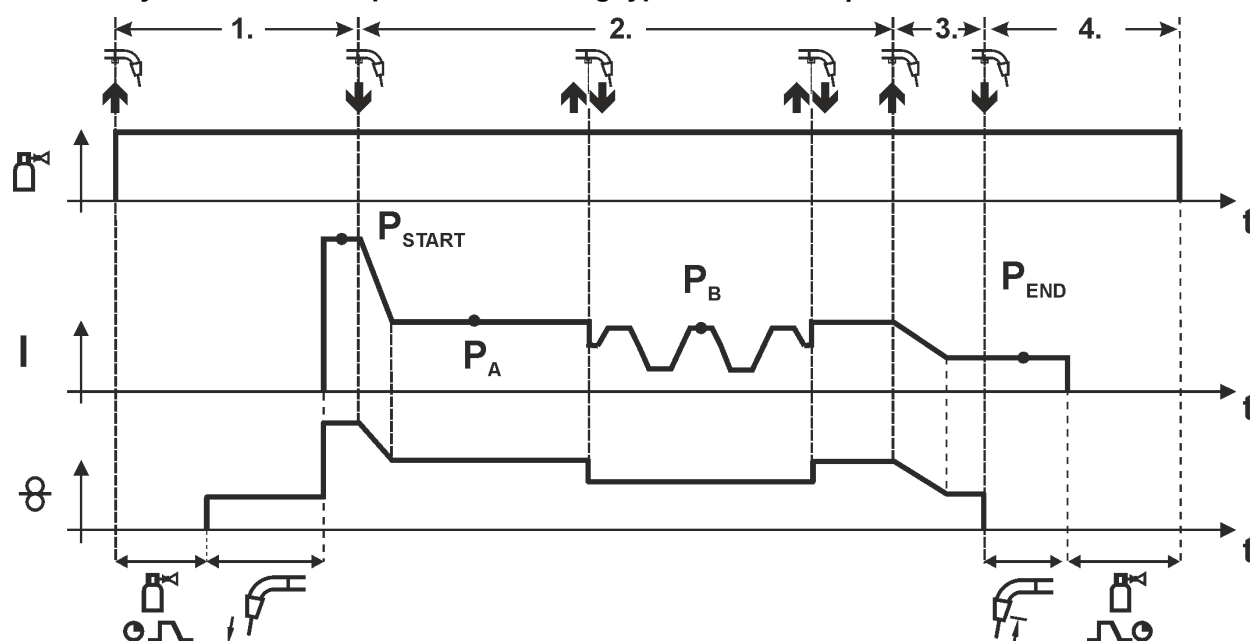


Figure 6-10

1st cycle

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

2nd cycle

- Release torch trigger
- Slope on main program P_A

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

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

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

3rd cycle

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

4th cycle

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

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

Refer to the software operating instructions.

Special latched with changing welding method (process switching)
Exclusively for devices with pulsed arc welding type > see 3.3 chapter.

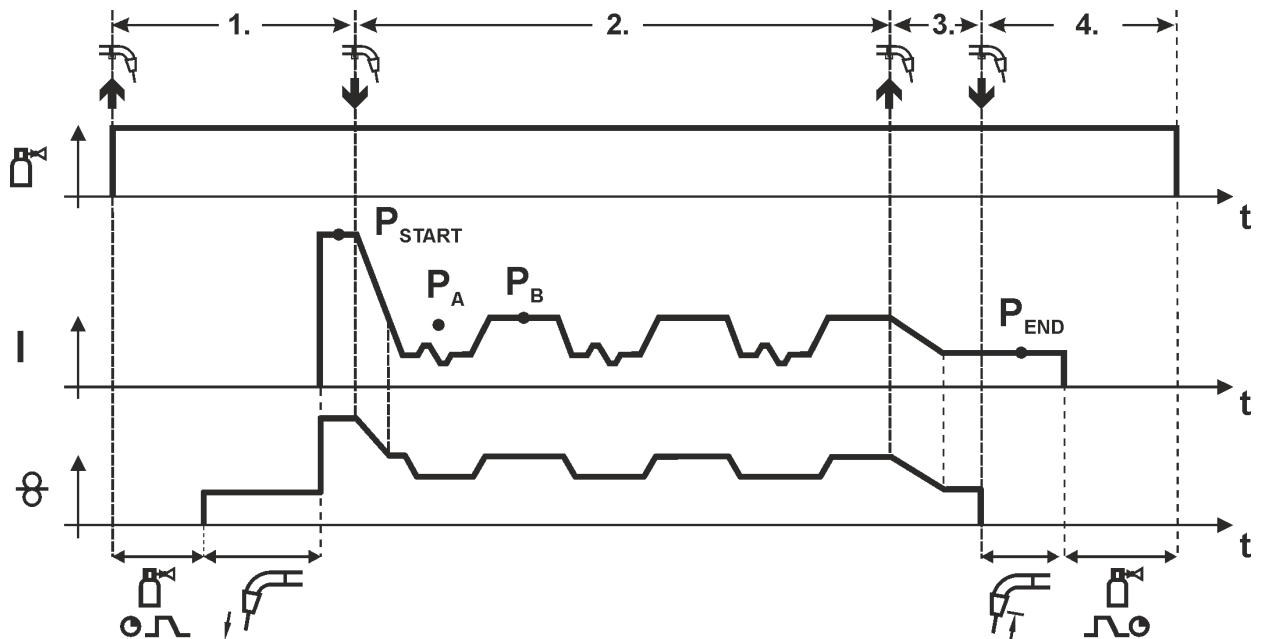


Figure 6-11

1st cycle

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

2nd cycle

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

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

3rd cycle

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

4th cycle

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

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

Refer to the software operating instructions.

Special, latched with superpulse

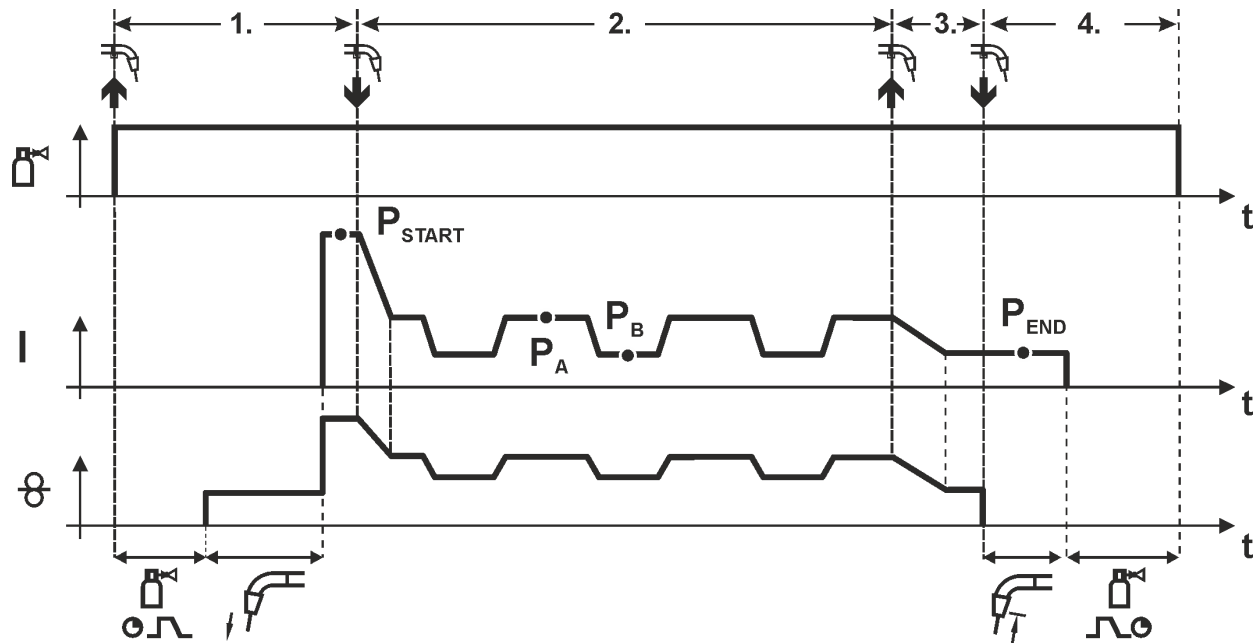


Figure 6-12

Step 1

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

Step 2

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

Step 3

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

Step 4

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

6.1.3.2 Automatic cut-out

Once the fault periods have elapsed, the automatic cut-out stops the welding process when it has been triggered by one of two states:

- During ignition
5 s after the start of the welding process, no welding current flows (ignition error).
- During welding
The arc is interrupted for more than 5 s (arc interruption).

6.1.4 coldArc XQ / coldArc puls XQ

Heat-reduced, low-spatter short arc for high dimensional stability welding and brazing of thin metal sheets with excellent gap-bridging.



Figure 6-13

After selecting the coldArc process > see 5.7 chapter you benefit from:

- Less distortion and reduced discolouration thanks to minimised heat input
- Considerably reduced spatter thanks to virtually power-free material transfer
- Easy welding of the root passes in all plate thicknesses and in all positions
- Perfect gap bridging even with inconsistent gap widths
- Manual and automated applications

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

With coldArc welding, it is important to ensure good quality wire feeding because of the welding filler materials being used!

- Equip the welding torch and torch hose package to suit the task! (and the operating instructions for the welding torch.)

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

(See operating instructions for the software)

6.1.5 forceArc XQ / forceArc puls XQ

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

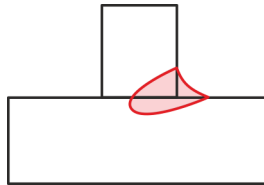


Figure 6-14

- Smaller included angle due to deep penetration and directionally stable arc
- Excellent root and sidewall fusion
- Secure welding also with very long stick-outs
- Reduced undercuts
- Manual and automated applications

You can make use of these properties after selecting the forceArc process > see 5.7 chapter.

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

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

Unstable arc!

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

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

6.1.6 rootArc XQ / rootArc pulse XQ

Short arc with perfect weld modelling capabilities for effortless gap bridging, especially for root welding



Figure 6-15

- Reduced spatter compared to standard short arc
- Good root formation and secure sidewall fusion
- Manual and automated applications

Unstable arc!

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

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

6.1.7 acArc puls XQ

The alternating current welding process acArc puls XQ makes MIG aluminium welding even easier in manual and automated modes. Clean weld seams with no traces of powder on the thinnest metal sheets, even with AlMg alloys, are possible with acArc puls XQ.

Advantages

- Perfect aluminium welding, especially in thin sheet metal due to directed heat reduction
- Excellent gap bridging, also facilitates automated applications
- Minimised heat input - reduces the risk of burn-through
- Less welding fume emissions
- Clean weld seams due to greatly reduced magnesium burn-off
- Easy and safe handling of the arc for manual and automated welding

A constant change of polarity (see following figure) takes place during the process.

The heat input from the material shifts to the welding consumable and the drop size increases significantly (compared to the direct current welding process). This ensures excellent bridging of air gaps and reduced welding fume emissions.

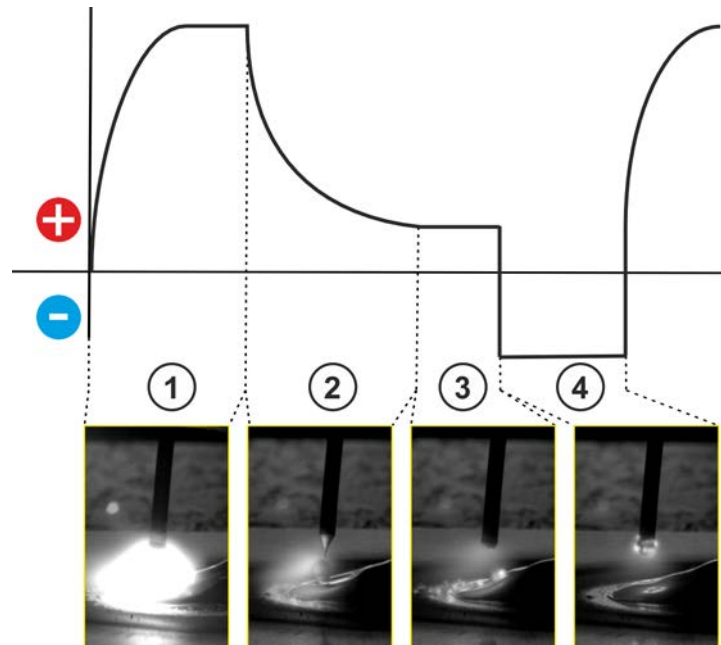


Figure 6-16

Item	Symbol	Description
1		Droplet formation in the pulse phase
2		Droplet detachment after the pulse phase
3		Fundamental current phase

Item	Symbol	Description
4		Cleaning and preheating the wire in the negative phase

With the rotary knob “arc dynamics”, the negative phase in the process can be influenced.

	Setting of the dynamics	Welding properties
	Left turn (more minus), negative phase gets longer	• -----More power on the wire • -----Droplet volume increases • -----Process becomes cooler
	Right turn (more plus), negative phase gets shorter	• -----More power on the workpiece • -----Droplet volume decreases • -----Process becomes hotter

The basic requirement for optimum welding results is the application-specific equipment of the wire feed system. For the acArc puls XQ welding process, the entire wire feed system of the Titan XQ AC series is factory-equipped with components for aluminium welding consumables! Recommended system components:

- Power source of type Titan XQ 400 AC puls D
- Wire feeder of type Drive XQ AC
- Welding torch series of type PM 551 W Alu

Note the following equipment and setting features of the wire feed system:

- Wire feed rolls (set contact pressure depending on welding consumables and hose package lengths)
- Central torch connection (use guide tube instead of capillary tube)
- Combined liner (PA liner with matching inner diameter for welding consumables)
- Use contact tips with forced contact

6.1.8 wiredArc

Welding process with active wire control for stable and uniform penetration characteristics and perfect arc length stability, even in difficult applications and positional welding.

With a GMAW arc, the welding current (AMP) changes with the change of the stick-out. If, for instance, the stick-out is extended, the welding current decreases at constant wire feed speed (DG). Thus, the heat input into the workpiece (molten metal) decreases and the penetration reduces.

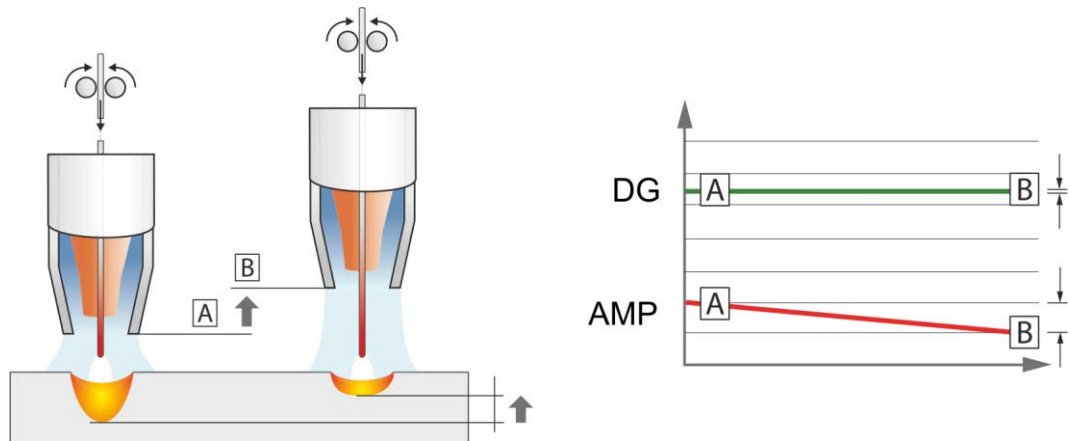


Figure 6-17

With the EWM wiredArc arc with wire control, the welding current (AMP) changes with the change of the stick-out only slightly. The compensation of the welding current takes place with an active control of wire feed speed (DG). If, for instance, the stick-out is extended, the wire feed speed will be increased. Due to this, the welding current remains almost constant and thus the heat input into the workpiece remains almost constant. As a result, the penetration changes with the change of the stick-out only slightly.

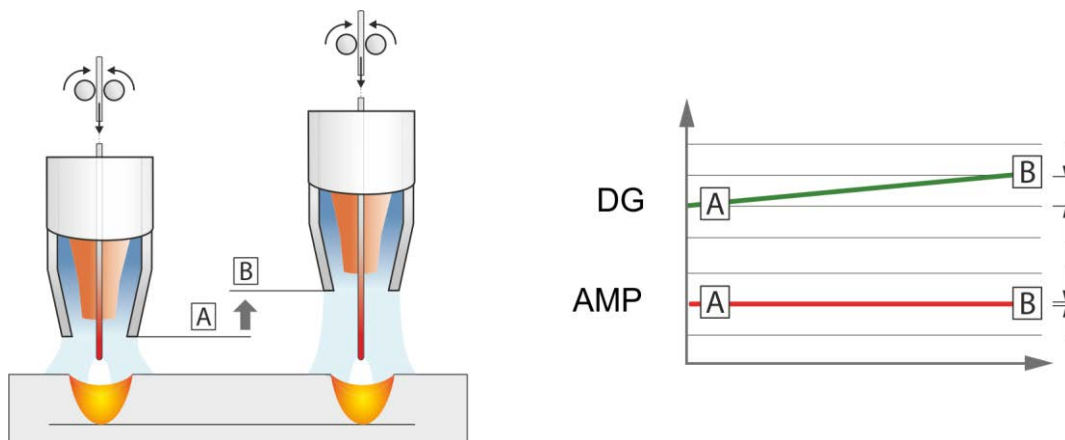


Figure 6-18

6.1.9 Standard MIG/MAG torch

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

Operating elements	Functions
 Torch trigger	Start/stop welding

Additional functions such as program switching (before or after welding) are possible by tapping the torch trigger (depending on machine type and control configuration).

The following parameters must be configured accordingly in the menu Special Parameters > see 5.4.4.4 chapter .

6.2 TIG welding

6.2.1 Operating modes (functional sequences)

6.2.1.1 Explanation of signs and functions

Symbol	Meaning
	Press torch trigger
	Release torch trigger
	Tap torch trigger (press briefly and release)
	Shielding gas flowing
I	Welding output
	Gas pre-flows
	Gas post-flows
	Non-latched
	Special, non-latched
	Latched
	Special, latched
t	Time
P _{START}	Ignition program
P _A	Main program
P _B	Reduced main program
P _{END}	End program
tS1	Slope duration from P _{START} to P _A

6.2.1.2 Automatic cut-out

Once the fault periods have elapsed, the automatic cut-out stops the welding process when it has been triggered by one of two states:

- During ignition
5 s after the start of the welding process, no welding current flows (ignition error).
- During welding
The arc is interrupted for more than 5 s (arc interruption).

Non-latched mode

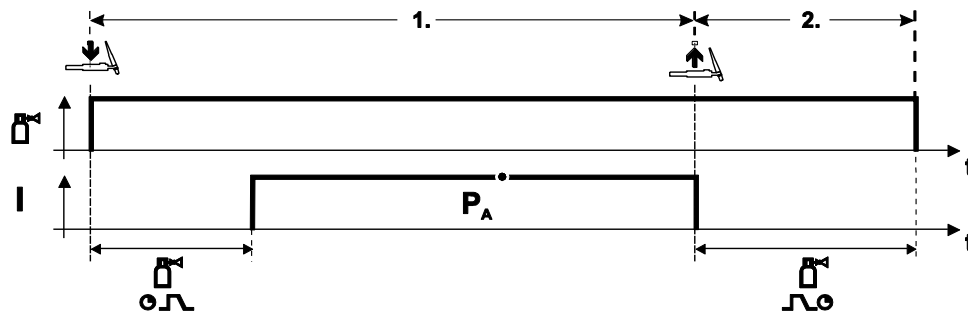


Figure 6-19

Selection

- Select non-latched operating mode .

Step 1

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

The arc is ignited using liftarc.

- Welding current flows with pre-selected setting.

Step 2

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

Special, non-latched

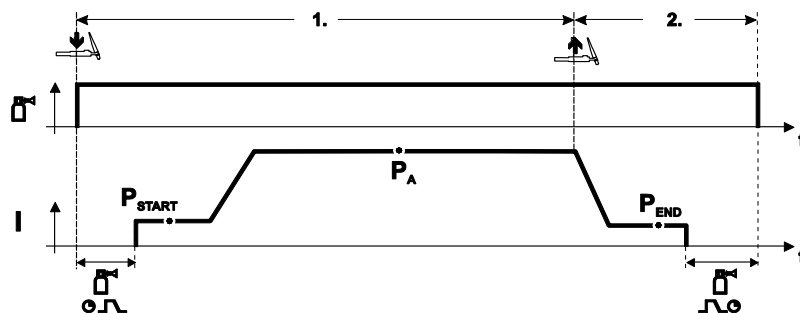


Figure 6-20

Selection

- Select non-latched special mode .

Step 1

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

The arc is ignited using liftarc.

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

Step 2

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

Latched mode

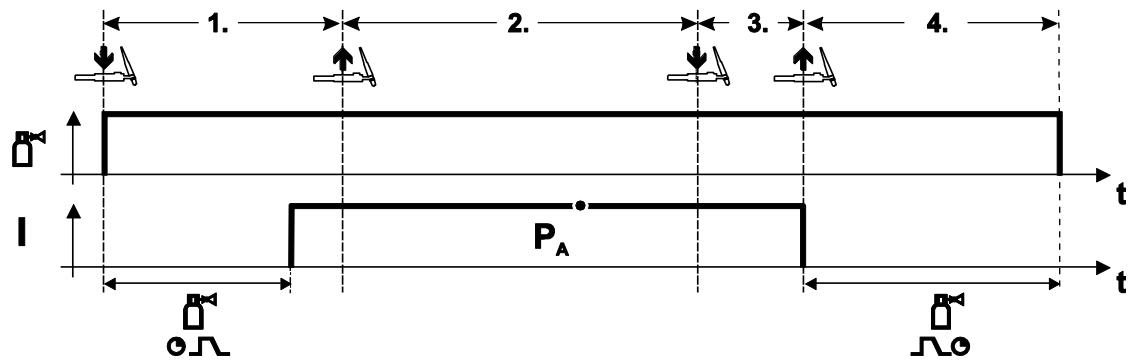


Figure 6-21

Selection

- Select latched operating mode .

Step 1

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

The arc is ignited using liftarc.

- Welding current flows with pre-selected setting.

Step 2

- Release torch trigger (no effect)

Step 3

- Press torch trigger (no effect)

Step 4

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

Latched special

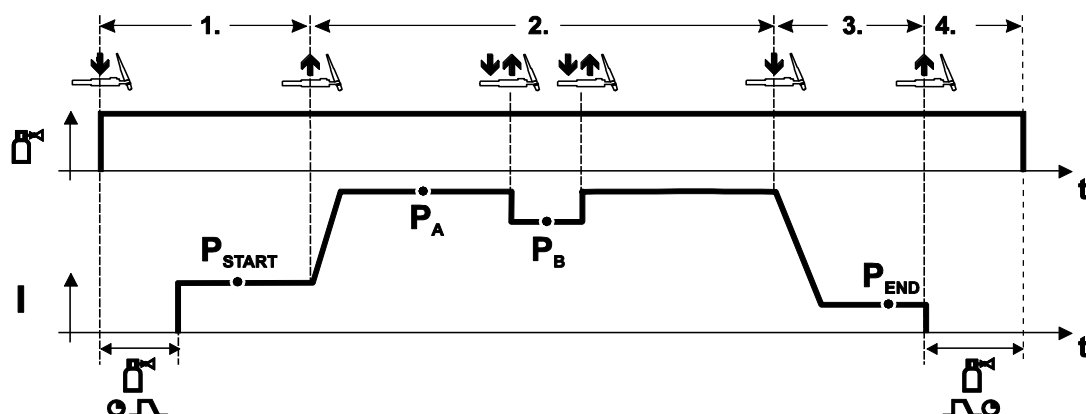


Figure 6-22

Selection

- Select latched special mode

Step 1

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

The arc is ignited using liftarc.

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

Step 2

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

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

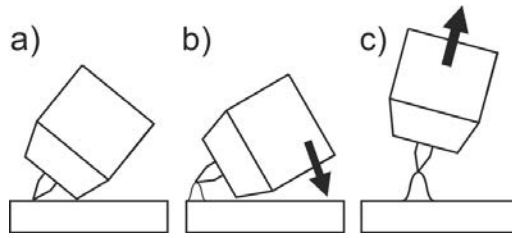
Tapping can be used to switch to the reduced main program "P_B". Repeated tapping will switch back to the main program "P_A".

Step 3

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

Step 4

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

6.2.2 Arc ignition**6.2.2.1 Liftarc***Figure 6-23*

The arc ignites through contact with the workpiece:

- a) Carefully place the torch gas nozzle and tungsten electrode tip against the workpiece (lift arc current flows independent of the set main current)
- b) Angle the torch above the torch gas nozzle until the distance between electrode tip and workpiece is approx. 2–3 mm (arc ignites, current increases to the set main current).
- c) Lift the torch off and bring into normal position.

Complete the welding task: Remove the torch from the workpiece so that the arc extinguishes.

6.3 MMA welding

6.3.1 Hotstart

The function hot start ensures a secure igniting of the arc and a sufficient heating to the still cold parent metal at the beginning of the welding process. The ignition takes place here with increased current (hot start current) over a certain time (hot start time).

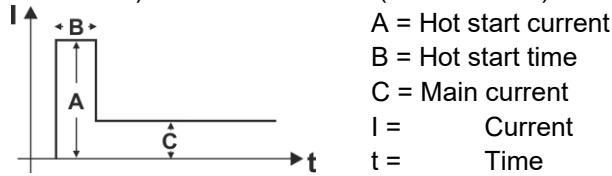
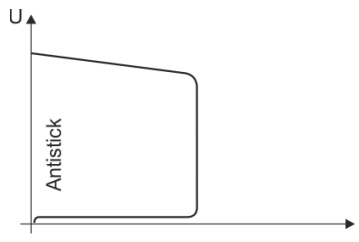


Figure 6-24

6.3.2 Antistick



The Antistick feature prevents the electrode from annealing.

Should the electrode stick despite the Arcforce feature, the machine automatically switches to the minimum current within approx. one second. This prevents the electrode from annealing. Check the welding current setting and correct for the welding task in hand.

Figure 6-25

6.4 Air arc gouging

During gouging, an arc burns between a carbon electrode and the workpiece, heating the workpiece until it is molten. At the same time, the molten metal is blown out with compressed air. Special electrode holders with a compressed-air connection and carbon electrodes are required for gouging.

7 Maintenance, care and disposal

7.1 General

DANGER



Risk of injury due to electrical voltage after switching off!

Working on an open machine can lead to fatal injuries!

Capacitors are loaded with electrical voltage during operation. Voltage remains present for up to four minutes after the mains plug is removed.

1. Switch off machine.
2. Remove the mains plug.
3. Wait for at last 4 minutes until the capacitors have discharged!

WARNING



Incorrect maintenance, testing and repair!

Maintenance, testing and repair of the machine may only be carried out by skilled and qualified personnel. A qualified person is one who, because of his or her training, knowledge and experience, is able to recognise the dangers that can occur while testing welding power sources as well as possible subsequent damage, and who is able to implement the required safety procedures.

Observe the maintenance instructions.

- In the event that the provisions of one of the below-stated tests are not met, the machine must not be operated again until it has been repaired and a new test has been carried out!

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

Under the specified ambient conditions and normal working conditions this machine is essentially maintenance-free and requires just a minimum of care.

Contamination of the machine may impair service life and duty cycle. The cleaning intervals depend on the ambient conditions and the resulting contamination of the machine. The minimum interval is every six months.

7.2 Disposing of equipment



Proper disposal!

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

- Do not dispose of in household waste!
- Observe the local regulations regarding disposal!
- According to European provisions (Directive 2012/19/EU on Waste of Electrical and Electronic Equipment), used electric and electronic equipment may no longer be placed in unsorted municipal waste. It must be collected separately. The symbol depicting a waste container on wheels indicates that the equipment must be collected separately.
This machine has to be disposed of, or recycled, in accordance with the waste separation systems in use.

According to German law (law governing the distribution, taking back and environmentally correct disposal of electrical and electronic equipment (ElektroG)), used machines are to be placed in a collection system separate from unsorted municipal waste. The public waste management utilities (communities) have created collection points at which used equipment from private households can be disposed of free of charge.

The deletion of personal data is the responsibility of the end user.

Lamps, batteries or accumulators must be removed and disposed of separately before disposing of the device. The type of battery or accumulator and its composition is marked on the top (type CR2032 or SR44). The following EWM products may contain batteries or accumulators:

- Welding helmets
Batteries or accumulators are easy to remove from the LED cassette.
- Device controls
Batteries or accumulators are located on the back of these in corresponding sockets on the circuit board and are easy to remove. The controls can be removed using standard tools.

Information on returning used equipment or collections can be obtained from the respective municipal administration office. Devices can also be returned to EWM sales partners across Europe.

Further information on the topic of the disposal of electrical and electronic equipment can be found on our website at: <https://www.ewm-group.com/de/nachhaltigkeit.html>.

8 Rectifying faults

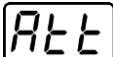
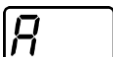
All products are subject to rigorous production checks and final checks. If, despite this, something fails to work at any time, please check the product using the following flowchart. If none of the fault rectification procedures described leads to the correct functioning of the product, please inform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

8.1 Display machine control software version

Identifying the machine software is key to quick troubleshooting by the authorised service technician. The version number is shown on the initial screen of the machine control for about 5 seconds (switch the machine off and on again) > see 4.3.4 chapter.

8.2 Warnings

Depending on the display options of the machine display, a warning message is displayed as follows:

Display type - machine control	Display
Graphic display	
two 7-segment displays	
one 7-segment display	

The cause of the warning is indicated by a corresponding warning number (see table).

- In case of multiple warnings, these are displayed in sequence.
- Document machine warning and inform service personnel, if required.

Warning	Possible cause / remedy
1 Excess temperature	A shutdown is imminent due to excess temperature.
2 Half-wave failures	Check process parameters.
3 Torch cooling warning	Check coolant level and top up if necessary.
4 Shielding gas	Check shielding gas supply.
5 Coolant flow	Check min. flow rate. ^[2]
6 Wire reserve	Only a small amount of wire is left on the spool.
7 CAN bus failure	Wire feeder not connected; automatic circuit-breaker of wire feed motor (reset the tripped automatic circuit-breaker by actuating).
8 Welding circuit	The inductance of the welding circuit is too high for the selected welding task.
9 WF configuration	Check WF configuration.
10 Partial inverter	One of several partial inverters is not supplying welding current.
11 Excess temperature of the coolant ^[1]	Check temperature and switching thresholds. ^[2]
12 Welding monitoring	The actual value of a welding parameter is outside the specified tolerance field.
13 Contact error	The resistance in the welding circuit is too high. Check earth connection.
14 Alignment error	Switch the machine off and on. If the error persists, notify Service.
15 Mains fuse	The power limit of the mains fuse is reached and the welding power is reduced. Check the fuse setting.
16 Shielding gas warning	Check the gas supply.

Warning	Possible cause / remedy
17 Plasma gas warning	Check the gas supply.
18 Forming gas warning	Check the gas supply.
19 Gas warning 4	reserved
20 Coolant temperature warning	Check coolant level and top up if necessary.
21 Excess temperature 2	reserved
22 Excess temperature 3	reserved
23 Excess temperature 4	reserved
24 Coolant flow warning	Check coolant supply. Check coolant level and top up if necessary. Check flow and switching thresholds. ^[2]
25 Flow 2	reserved
26 Flow 3	reserved
27 Flow 4	reserved
28 Wire stock warning	Check wire feeding.
29 Low wire 2	reserved
30 Low wire 3	reserved
31 Low wire 4	reserved
32 Tacho error	Fault of wire feeder - permanent overload of the wire drive.
33 Excess current on the wire feed motor	Excess current detected on wire feed motor.
34 JOB unknown	JOB Selection was not carried out because the JOB number is unknown.
35 Excess current on the wire feed motor slave	Excess current detected on wire feed motor slave (push/push system or intermediate drive).
36 Slave tacho error	Fault of wire feeder - permanent overload of the wire drive (push/push system or intermediate drive).
37 FAST bus failure	Wire feeder not connected (reset by actuating the automatic circuit-breaker of the wire feed motor).
38 Incomplete component information	Check XNET component management.
39 Mains half-wave failure	Check supply voltage.
40 Weak power grid	Check supply voltage.
41 Cooling unit not recognised	Check the cooling unit connection.
47 Battery (Bluetooth remote control)	Battery level is low (replace battery)

^[1] only for the XQ machine series

^[2] See technical data for values and other switching thresholds.

8.3 Error messages

The possible error numbers displayed depend on the machine series and version!

Depending on the options of the machine display, a fault is shown as follows:

Display type - machine control	Display
Graphic display	
two 7-segment displays	
one 7-segment display	

The possible cause of the fault is signalled by a corresponding fault number (see table). In the case of an error, the power unit shuts down.

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

Legend for categories (reset error)

- The error message will disappear once the error has been rectified.
- The error message can be reset by pressing a context-dependent push-button with the  icon.
- The error message can only be reset by switching the machine off and on again.

Error (category)	Possible cause	Remedy
3 ^{A, B} Tacho error	Wire feed unit interference	Check connections (connections, pipes).
	Permanent overload of the wire drive.	Do not place the liner in tight radii. Check liner for smooth movement.
4 ^A Excess temperature	Power source overheated	Allow the switched on machine to cool down.
	Fan blocked, dirty or defective.	Check fan and clean or replace.
	Air inlet or outlet blocked.	Check air inlet and outlet.
5 Mains overvoltage	Mains voltage too high	Check the mains voltages and compare with the power source connection voltages.
6 Mains undervoltage	Mains voltage too low	

Error (category)	Possible cause	Remedy
7 ^B Low coolant level	low flow rate	Fill coolant.
		Check coolant flow - remove kinks in hose package.
		Adjust flow threshold. ^[1] ^[3]
		Clean water block.
	Pump does not turn	Turn the pump shaft.
	Air in the coolant circuit	Vent coolant circuit.
	Hose package not completely filled with coolant.	Switch the machine off and on again > pump running > filling process.
	Operation with gas-cooled welding torch.	Deactivate torch cooling. Connecting coolant feed and return to hose bridges.
8 ^{A, B} Shielding gas error	Failure of automatic circuit-breaker ^[2]	Reset automatic circuit-breaker.
	No shielding gas	Check shielding gas supply.
9 Overvoltage on secondary	Pre-pressure too low.	Remove kinks in the hose package (nominal value: 4-6 bar pre-pressure).
	Overvoltage at output: Inverter error	Request service.
10 Earth fault (PE error)	Connection between welding wire and machine casing	Remove electrical connection.
11 ^{A, B} Fast shut-down	Removing the logical signal "robot ready" during the process.	Eliminate errors on the higher-level control.
16 ^A General pilot arc	Emergency stop circuit error	Check emergency stop circuit.
	Temperature error	See description of error 4.
	Short circuit on welding torch	Check welding torch.
	Request service	
17 ^B Cold wire error	See description of error 3.	See description of error 3.
18 ^B Plasma gas error	Low gas level	See description of error 8.
19 ^B Shielding gas error	Low gas level	See description of error 8.
20 ^B Low coolant level	see description of error 7.	See description of error 7.
22 ^A Excess coolant temperature ^[1]	Coolant overheated ^[3]	Allow the switched on machine to cool down.
	Fan blocked, dirty or defective.	Check fan and clean or replace.
	Air inlet or outlet blocked.	Check air inlet and outlet.
23 ^A Excess temperature of the HF choke	External XF ignition unit overheated	Allow the switched on machine to cool down.
24 ^B Pilot arc ignition error	Pilot arc cannot ignite.	Check welding torch equipment.
25 ^B Forming gas error	Low gas level	See description of error 8.
26 ^A Excess pilot arc module temperature	Pilot arc module overheated	See description of error 4.
32 Error I>0 ^[1]	Current recording faulty	Request service.

Error (category)	Possible cause	Remedy
33 Error UIST ^[1]	Voltage recording faulty	Eliminate short circuit in welding circuit.
		remove external sensor voltage.
		Request service.
34 Electronics error	A/D-channel error	Switch the machine off and on again.
		Request service.
35 Electronics error	Slope error	Switch the machine off and on again.
		Request service.
36  -Error	 -Conditions violated.	Switch the machine off and on again.
		Request service.
37 Electronics error	Temperature error	Allow the switched on machine to cool down.
38 Error IIST ^[1]	Short circuit in welding circuit before welding.	Eliminate short circuit in welding circuit.
		Request service.
39 Electronics error	Secondary overvoltage	Switch the machine off and on again.
		Request service.
40 Electronics error	I>0 error	Request service.
47 ^B Bluetooth error	-	Observe accompanying documentation for Bluetooth function.
48 ^B Ignition error	no ignition at process start (automated machines).	Check wire feeding
		Check load cable connections in welding current circuit.
		clean corroded surfaces on work-piece before welding if necessary.
49 ^B Arc interruption	An arc interruption occurred during welding with an automated system.	Check wire feeding.
		Adjust welding speed.
50 ^B Program number	Internal error	Request service.
51 ^A Emergency stop	The emergency stop circuit of the power source has been activated.	Disable the activation of the emergency stop circuit (release protective circuit).
52 No wire feeder	After switching on the automated system, no wire feeder (DV) was detected.	Check or connect the control lines of the wire feeders;
		Check the identification number of the automated wire feeder (for 1DV: number 1, for 2DV: each a wire feeder with number 1 and a wire feeder with number 2).
53 ^B No wire feeder 2	Wire feeder 2 not detected.	Check control cable connections.
54 VRD error	Open circuit voltage reduction error.	if necessary, disconnect external machine from the welding circuit.
		Request service.
55 ^B Excess wire feeder current	Excess current detected on wire feed mechanism.	Do not place the liner in tight radii.
		Check liner for smooth movement.

Error (category)	Possible cause	Remedy
56 Mains phase failure	One phase of the mains voltage has failed.	Check mains connection, mains plug and mains fuses.
57 ^B Slave tacho error	Wire feeder fault (slave drive).	Check connectors, cables, connections.
	Permanent overload of the wire drive (slave drive).	Do not place the liner in tight radii. Check liner for smooth movement.
58 ^B Short circuit	Check welding circuit for short circuit.	Check welding current circuit.
		Place welding torch on an insulated surface.
59 Incompatible machine	A machine connected to the system is not compatible.	Disconnect incompatible machine from system.
60 Incompatible software	A machine's software is not compatible.	Request service.
61 Welding monitor	The actual value of a welding parameter is outside the specified tolerance field.	Observe tolerance fields.
		Adjust welding parameters.
62 System component ^[1]	System component not found.	Request service.
63 Mains voltage error	Operating and mains voltage are incompatible	Check or adjust operating and mains voltage

^[1] only for XQ. machine series

^[2] not for XQ. machine series

^[3] See technical data for values and other switching thresholds.

8.4 Resetting JOBs (welding tasks) to the factory settings

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

Instructions on how to reset welding tasks (JOBs) to the factory setting can be found in the JOB manager > see 5.7.3 chapter chapter.

9 Appendix

9.1 Parameter overview – setting ranges

Parameter	Setting range				Comment
	Unit	min.		max.	
MIG/MAG					
Gas pre-flow time	s	0	-	20	
Gas nominal value	l/min				GFE option
Start program P _{START}					
WF relative	%	1	-	200	
Duration	s	0,00	-	20,0	
U correction	V	-9,9	-	9,9	
Slope time	s	0,00		20,0	
Main program P _A					
WF [l/min.]	m/min	0,00	-	20,0	
U correction	V	-9,9	-	9,9	
Duration	s	0,00	-	20,0	
Slope time	s	0,00	-	20,0	
Down-slope program P _B					
WF relative	%	0	-	200	
Duration	s	0,0	-	20,0	
U correction	V	-9,9	-	9,9	
Slope time	s	0,00	-	20,0	
Slope time	s	0,00	-	20,0	
End program P _{END}					
WF relative	%	0	-	200	
Duration	s	0,0	-	20,0	
U correction	V	-9,9	-	9,9	
Wire burn-back		0		499	
Gas post-flow time	s	0,0		20,0	
TIG (TIG)					
Gas pre-flow time	s	0	-	20	
Start current AMP%	%	0	-	200	% of main current AMP
Start time	s	0,00	-	20,0	
Up-slope time	s	0,0	-	20,0	
Pulse current	%	1		200	
Pulse time	s	0,01	-	20,0	
Slope time	s	0,00	-	20,0	Time from main current AMP to secondary current AMP%
Secondary current AMP%	%	1		200	% of main current AMP
Pulse pause time	s	0,01	-	20,0	
Slope time	s	0,00	-	20,0	Time from main current AMP to secondary current AMP%
Down-slope time	s	0,0	-	20,0	
End current AMP%	%	0	-	200	% of main current AMP

Parameter	Setting range				Comment
	Unit	min.		max.	
End current time	s	0,00	-	20,0	
Gas post-flow time	s	0,0	-	20,0	
MMA (MMA)					
Hot start current	%	1	-	200	
Hot start time	s	0,0	-	-10,0	
Arcforce		-40	-	40	

9.2 JOB-List

JOB no.	Processes	Material	Gas	Diameter [mm]
1	GMAW standard	G3Si1 / G4Si1	100% CO2	0,8
2	GMAW standard	G3Si1 / G4Si1	100% CO2	0,9
3	GMAW standard	G3Si1 / G4Si1	100% CO2	1,0
4	GMAW standard	G3Si1 / G4Si1	100% CO2	1,2
5	GMAW standard	G3Si1 / G4Si1	100% CO2	1,6
6	Standard GMAW / pulse	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	0,8
7	Standard GMAW / pulse	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	0,9
8	Standard GMAW / pulse	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,0
9	Standard GMAW / pulse	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,2
10	Standard GMAW / pulse	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,6
11	Standard GMAW / pulse	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	0,8
12	Standard GMAW / pulse	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	0,9
13	Standard GMAW / pulse	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	1,0
14	Standard GMAW / pulse	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	1,2
15	Standard GMAW / pulse	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	1,6
26	Standard GMAW / pulse	CrNi 19 12 3 Nb / 1.4576	Ar-97.5 / CO2-2.5 (M12)	0,8
27	Standard GMAW / pulse	CrNi 19 12 3 Nb / 1.4576	Ar-97.5 / CO2-2.5 (M12)	1,0
28	Standard GMAW / pulse	CrNi 19 12 3 Nb / 1.4576	Ar-97.5 / CO2-2.5 (M12)	1,2
29	Standard GMAW / pulse	CrNi 19 12 3 Nb / 1.4576	Ar-97.5 / CO2-2.5 (M12)	1,6
30	Standard GMAW / pulse	CrNi 18 8 / 1.4370	Ar-97.5 / CO2-2.5 (M12)	0,8
31	Standard GMAW / pulse	CrNi 18 8 / 1.4370	Ar-97.5 / CO2-2.5 (M12)	1,0
32	Standard GMAW / pulse	CrNi 18 8 / 1.4370	Ar-97.5 / CO2-2.5 (M12)	1,2
33	Standard GMAW / pulse	CrNi 18 8 / 1.4370	Ar-97.5 / CO2-2.5 (M12)	1,6
34	Standard GMAW / pulse	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	0,8
35	Standard GMAW / pulse	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	1,0
36	Standard GMAW / pulse	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	1,2
37	Standard GMAW / pulse	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	1,6
38	Standard GMAW / pulse	CrNi 19 12 3 / 1.4430	Ar-97.5 / CO2-2.5 (M12)	0,8
39	Standard GMAW / pulse	CrNi 19 12 3 / 1.4430	Ar-97.5 / CO2-2.5 (M12)	1,0
40	Standard GMAW / pulse	CrNi 19 12 3 / 1.4430	Ar-97.5 / CO2-2.5 (M12)	1,2

JOB no.	Processes	Material	Gas	Diameter [mm]
41	Standard GMAW / pulse	CrNi 19 12 3 / 1.4430	Ar-97.5 / CO2-2.5 (M12)	1,6
42	Standard GMAW / pulse	CrNi 22 9 3 / 1.4462	Ar-97.5 / CO2-2.5 (M12)	0,8
43	Standard GMAW / pulse	CrNi 22 9 3 / 1.4462	Ar-97.5 / CO2-2.5 (M12)	1,0
44	Standard GMAW / pulse	CrNi 22 9 3 / 1.4462	Ar-97.5 / CO2-2.5 (M12)	1,2
45	Standard GMAW / pulse	CrNi 22 9 3 / 1.4462	Ar-97.5 / CO2-2.5 (M12)	1,6
46	Standard GMAW / pulse	CrNi 22 9 3 / 1.4462	Ar-78 / He-20 / CO2-2 (M12)	0,8
47	Standard GMAW / pulse	CrNi 22 9 3 / 1.4462	Ar-78 / He-20 / CO2-2 (M12)	1,0
48	Standard GMAW / pulse	CrNi 22 9 3 / 1.4462	Ar-78 / He-20 / CO2-2 (M12)	1,2
49	Standard GMAW / pulse	CrNi 22 9 3 / 1.4462	Ar-78 / He-20 / CO2-2 (M12)	1,6
50	coldArc / coldArc puls	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	0,8
51	coldArc / coldArc puls	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	1,0
52	coldArc / coldArc puls	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	1,2
55	coldArc / coldArc puls	AlMg4.5Mn	Ar-100 (I1)	1,0
56	coldArc / coldArc puls	AlMg4.5Mn	Ar-100 (I1)	1,2
59	coldArc / coldArc puls	AlSi	Ar-100 (I1)	1,0
60	coldArc / coldArc puls	AlSi	Ar-100 (I1)	1,2
63	coldArc / coldArc puls	Al99	Ar-100 (I1)	1,0
64	coldArc / coldArc puls	Al99	Ar-100 (I1)	1,2
66	coldArc Brazing	CuSi	Ar-100 (I1)	0,8
67	coldArc Brazing	CuSi	Ar-100 (I1)	1,0
68	coldArc Brazing	CuSi	Ar-100 (I1)	1,2
70	coldArc Brazing	CuAl	Ar-100 (I1)	0,8
71	coldArc Brazing	CuAl	Ar-100 (I1)	1,0
72	coldArc Brazing	CuAl	Ar-100 (I1)	1,2
74	Standard GMAW / pulse	AlMg4.5Mn	Ar-100 (I1)	0,8
75	Standard GMAW / pulse	AlMg4.5Mn	Ar-100 (I1)	1,0
76	Standard GMAW / pulse	AlMg4.5Mn	Ar-100 (I1)	1,2
77	Standard GMAW / pulse	AlMg4.5Mn	Ar-100 (I1)	1,6
78	Standard GMAW / pulse	AlMg4.5Mn	Ar-70 / He-30 (I3)	0,8
79	Standard GMAW / pulse	AlMg4.5Mn	Ar-70 / He-30 (I3)	1,0
80	Standard GMAW / pulse	AlMg4.5Mn	Ar-70 / He-30 (I3)	1,2
81	Standard GMAW / pulse	AlMg4.5Mn	Ar-70 / He-30 (I3)	1,6
82	Standard GMAW / pulse	AlSi	Ar-100 (I1)	0,8
83	Standard GMAW / pulse	AlSi	Ar-100 (I1)	1,0
84	Standard GMAW / pulse	AlSi	Ar-100 (I1)	1,2
85	Standard GMAW / pulse	AlSi	Ar-100 (I1)	1,6
86	Standard GMAW / pulse	AlSi	Ar-70 / He-30 (I3)	0,8
87	Standard GMAW / pulse	AlSi	Ar-70 / He-30 (I3)	1,0
88	Standard GMAW / pulse	AlSi	Ar-70 / He-30 (I3)	1,2
89	Standard GMAW / pulse	AlSi	Ar-70 / He-30 (I3)	1,6
90	Standard GMAW / pulse	Al99	Ar-100 (I1)	0,8
91	Standard GMAW / pulse	Al99	Ar-100 (I1)	1,0
92	Standard GMAW / pulse	Al99	Ar-100 (I1)	1,2
93	Standard GMAW / pulse	Al99	Ar-100 (I1)	1,6

JOB no.	Processes	Material	Gas	Diameter [mm]
94	Standard GMAW / pulse	Al99	Ar-70 / He-30 (I3)	0,8
95	Standard GMAW / pulse	Al99	Ar-70 / He-30 (I3)	1,0
96	Standard GMAW / pulse	Al99	Ar-70 / He-30 (I3)	1,2
97	Standard GMAW / pulse	Al99	Ar-70 / He-30 (I3)	1,6
98	Standard GMAW / pulse	CuSi	Ar-100 (I1)	0,8
99	Standard GMAW / pulse	CuSi	Ar-100 (I1)	1,0
100	Standard GMAW / pulse	CuSi	Ar-100 (I1)	1,2
101	Standard GMAW / pulse	CuSi	Ar-100 (I1)	1,6
102	Standard GMAW / pulse	CuSi	Ar-97.5 / CO2-2.5 (M12)	0,8
103	Standard GMAW / pulse	CuSi	Ar-97.5 / CO2-2.5 (M12)	1,0
104	Standard GMAW / pulse	CuSi	Ar-97.5 / CO2-2.5 (M12)	1,2
105	Standard GMAW / pulse	CuSi	Ar-97.5 / CO2-2.5 (M12)	1,6
106	Standard GMAW / pulse	CuAl	Ar-100 (I1)	0,8
107	Standard GMAW / pulse	CuAl	Ar-100 (I1)	1,0
108	Standard GMAW / pulse	CuAl	Ar-100 (I1)	1,2
109	Standard GMAW / pulse	CuAl	Ar-100 (I1)	1,6
110	Brazing	CuSi	Ar-97.5 / CO2-2.5 (M12)	0,8
111	Brazing	CuSi	Ar-97.5 / CO2-2.5 (M12)	1,0
112	Brazing	CuSi	Ar-97.5 / CO2-2.5 (M12)	1,2
113	Brazing	CuSi	Ar-97.5 / CO2-2.5 (M12)	1,6
114	Brazing	CuSi	Ar-100 (I1)	0,8
115	Brazing	CuSi	Ar-100 (I1)	1,0
116	Brazing	CuSi	Ar-100 (I1)	1,2
117	Brazing	CuSi	Ar-100 (I1)	1,6
118	Brazing	CuAl	Ar-97.5 / CO2-2.5 (M12)	0,8
119	Brazing	CuAl	Ar-97.5 / CO2-2.5 (M12)	1,0
120	Brazing	CuAl	Ar-97.5 / CO2-2.5 (M12)	1,2
121	Brazing	CuAl	Ar-97.5 / CO2-2.5 (M12)	1,6
122	Brazing	CuAl	Ar-100 (I1)	0,8
123	Brazing	CuAl	Ar-100 (I1)	1,0
124	Brazing	CuAl	Ar-100 (I1)	1,2
125	Brazing	CuAl	Ar-100 (I1)	1,6
126	Gouging			
127	TIG (lift arc)			
128	MMA			
129	Special JOB 1	Special	Special	Spezial
130	Special JOB 2	Special	Special	Spezial
131	Special JOB 3	Special	Special	Spezial
132		Free JOB		
133		Free JOB		
134		Free JOB		
135		Free JOB		
136		Free JOB		
137		Free JOB		
138		Free JOB		
139		Free JOB		
140		Block 1/ JOB1		

JOB no.	Processes	Material	Gas	Diameter [mm]
141		Block 1/ JOB2		
142		Block 1/ JOB3		
143		Block 1/ JOB4		
144		Block 1/ JOB5		
145		Block 1/ JOB6		
146		Block 1/ JOB7		
147		Block 1/ JOB8		
148		Block 1/ JOB9		
149		Block 1/ JOB10		
150		Block 2/ JOB1		
151		Block 2/ JOB2		
152		Block 2/ JOB3		
153		Block 2/ JOB4		
154		Block 2/ JOB5		
155		Block 2/ JOB6		
156		Block 2/ JOB7		
157		Block 2/ JOB8		
158		Block 2/ JOB9		
159		Block 2/ JOB10		
160		Block 3/ JOB1		
161		Block 3/ JOB2		
162		Block 3/ JOB3		
163		Block 3/ JOB4		
164		Block 3/ JOB5		
165		Block 3/ JOB6		
166		Block 3/ JOB7		
167		Block 3/ JOB8		
168		Block 3/ JOB9		
169		Block 3/ JOB10		
171	coldArc / coldArc puls	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	1,0
172	coldArc / coldArc puls	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	1,2
173	rootArc / rootArc puls	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	1,0
174	rootArc / rootArc puls	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	1,2
179	forceArc / forceArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,0
180	forceArc / forceArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,2
181	forceArc / forceArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,6
182	coldArc	G3Si1 / G4Si1	CO2-100 (C1)	0,8
183	coldArc	G3Si1 / G4Si1	CO2-100 (C1)	0,9
184	coldArc	G3Si1 / G4Si1	CO2-100 (C1)	1,0
185	coldArc	G3Si1 / G4Si1	CO2-100 (C1)	1,2
188	GMAW Non-synergic	Special	Special	Spezial
189	forceArc / forceArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	0,8
190	forceArc / forceArc puls	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	0,8
191	coldArc / coldArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	0,8
192	coldArc / coldArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	0,9
193	coldArc / coldArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,0
194	coldArc / coldArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,2

JOB no.	Processes	Material	Gas	Diameter [mm]
195	coldArc / coldArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,6
197	coldArc Brazing	AlSi	Ar-100 (I1)	1,0
198	coldArc Brazing	AlSi	Ar-100 (I1)	1,2
201	coldArc Brazing	ZnAl	Ar-100 (I1)	1,0
202	coldArc Brazing	ZnAl	Ar-100 (I1)	1,2
204	rootArc	G3Si1 / G4Si1	CO2-100 (C1)	1,0
205	rootArc	G3Si1 / G4Si1	CO2-100 (C1)	1,2
206	rootArc / rootArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,0
207	rootArc / rootArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,2
208	coldArc - Mg/Mg	Mg	Ar-70 / He-30 (I3)	1,2
209	coldArc - Mg/Mg	Mg	Ar-70 / He-30 (I3)	1,6
212	Flux cored wire rutile	FCW CrNi Rutile	CO2-100 (C1)	1,2
213	Flux cored wire rutile	FCW CrNi Rutile	CO2-100 (C1)	1,6
216	Standard GMAW / pulse	AlMg3	Ar-100 (I1)	1,0
217	Standard GMAW / pulse	AlMg3	Ar-100 (I1)	1,2
218	Standard GMAW / pulse	AlMg3	Ar-100 (I1)	1,6
220	coldArc - St/Al	ZnAl	Ar-100 (I1)	1,0
221	coldArc - St/Al	ZnAl	Ar-100 (I1)	1,2
224	coldArc - St/Al	AlSi	Ar-100 (I1)	1,0
225	coldArc - St/Al	AlSi	Ar-100 (I1)	1,2
229	Flux cored wire metal	FCW CrNi Metal	Ar-97.5 / CO2-2.5 (M12)	1,2
230	Flux cored wire metal	FCW CrNi Metal	Ar-97.5 / CO2-2.5 (M12)	1,6
233	Flux cored wire rutile	FCW CrNi Rutile	Ar-82 / CO2-18 (M21)	1,2
234	Flux cored wire rutile	FCW CrNi Rutile	Ar-82 / CO2-18 (M21)	1,6
235	Flux cored wire metal	FCW Steel Metal	Ar-82 / CO2-18 (M21)	0,8
237	Flux cored wire metal	FCW Steel Metal	Ar-82 / CO2-18 (M21)	1,0
238	Flux cored wire metal	FCW Steel Metal	Ar-82 / CO2-18 (M21)	1,2
239	Flux cored wire metal	FCW Steel Metal	Ar-82 / CO2-18 (M21)	1,6
240	Flux cored wire rutile	FCW CrNi Rutile	Ar-82 / CO2-18 (M21)	0,8
242	Flux cored wire rutile	FCW CrNi Rutile	Ar-82 / CO2-18 (M21)	1,0
243	Flux cored wire rutile	FCW CrNi Rutile	Ar-82 / CO2-18 (M21)	1,2
244	Flux cored wire rutile	FCW CrNi Rutile	Ar-82 / CO2-18 (M21)	1,6
245	forceArc / forceArc puls	Al99	Ar-100 (I1)	1,2
246	forceArc / forceArc puls	Al99	Ar-100 (I1)	1,6
247	forceArc / forceArc puls	AlMg4.5Mn	Ar-100 (I1)	1,2
248	forceArc / forceArc puls	AlMg4.5Mn	Ar-100 (I1)	1,6
249	forceArc / forceArc puls	AlSi	Ar-100 (I1)	1,2
250	forceArc / forceArc puls	AlSi	Ar-100 (I1)	1,6
251	forceArc / forceArc puls	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	1,0
252	forceArc / forceArc puls	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	1,2
253	forceArc / forceArc puls	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	1,6
254	forceArc / forceArc puls	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	1,0
255	forceArc / forceArc puls	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	1,2
256	forceArc / forceArc puls	G3Si1 / G4Si1	Ar-90 / CO2-10 (M20)	1,6
258	Standard GMAW / pulse	AlMg4.5Mn	Ar-50/He-50 (I3)	1,2
259	Standard GMAW / pulse	AlMg4.5Mn	Ar-50/He-50 (I3)	1,6
260	Flux cored wire rutile	FCW Steel Rutile	CO2-100 (C1)	1,2

JOB no.	Processes	Material	Gas	Diameter [mm]
261	Flux cored wire rutile	FCW Steel Rutile	CO2-100 (C1)	1,6
263	Flux cored wire metal	High-strength steels / Special	Ar-82 / CO2-18 (M21)	1,2
264	Flux cored wire basic	FCW Steel Basic	Ar-82 / CO2-18 (M21)	1,2
268	Surfacing	NiCr 6617 / 2.4627	Ar-70 / He-30 (I3)	1,2
269	Surfacing	NiCr 6617 / 2.4627	Ar-70 / He-30 (I3)	1,6
271	Surfacing	NiCr 6625 / 2.4831	Ar-70 / He-30 (I3)	1,0
272	Surfacing	NiCr 6625 / 2.4831	Ar-70 / He-30 (I3)	1,2
273	Surfacing	NiCr 6625 / 2.4831	Ar-70 / He-30 (I3)	1,6
275	Surfacing	NiCr 6625 / 2.4831	Ar-78 / He-20 / CO2-2 (M12)	1,0
276	Surfacing	NiCr 6625 / 2.4831	Ar-78 / He-20 / CO2-2 (M12)	1,2
277	Surfacing	NiCr 6625 / 2.4831	Ar-78 / He-20 / CO2-2 (M12)	1,6
279	Standard GMAW / pulse	CrNi 25 20 / 1.4842	Ar-97.5 / CO2-2.5 (M12)	1,0
280	Standard GMAW / pulse	CrNi 25 20 / 1.4842	Ar-97.5 / CO2-2.5 (M12)	1,2
282	Standard GMAW / pulse	CrNi 23 12 / 1.4332	Ar-97.5 / CO2-2.5 (M12)	0,8
283	Standard GMAW / pulse	CrNi 23 12 / 1.4332	Ar-97.5 / CO2-2.5 (M12)	1,0
284	Standard GMAW / pulse	CrNi 23 12 / 1.4332	Ar-97.5 / CO2-2.5 (M12)	1,2
285	Standard GMAW / pulse	CrNi 23 12 / 1.4332	Ar-97.5 / CO2-2.5 (M12)	1,6
290	forceArc / forceArc puls Flux cored wire metal	FCW Steel Metal	Ar-82 / CO2-18 (M21)	0,8
291	forceArc / forceArc puls Flux cored wire metal	FCW Steel Metal	Ar-82 / CO2-18 (M21)	1,0
292	forceArc / forceArc puls Flux cored wire metal	FCW Steel Metal	Ar-82 / CO2-18 (M21)	1,2
293	forceArc / forceArc puls Flux cored wire metal	FCW Steel Metal	Ar-82 / CO2-18 (M21)	1,6
303	forceArc / forceArc puls	CrNi 19 12 3 Nb / 1.4576	Ar-97.5 / CO2-2.5 (M12)	1,0
304	forceArc / forceArc puls	CrNi 19 12 3 Nb / 1.4576	Ar-97.5 / CO2-2.5 (M12)	1,2
305	forceArc / forceArc puls	CrNi 19 12 3 Nb / 1.4576	Ar-97.5 / CO2-2.5 (M12)	1,6
307	forceArc / forceArc puls	CrNi 18 8 / 1.4370	Ar-97.5 / CO2-2.5 (M12)	1,0
308	forceArc / forceArc puls	CrNi 18 8 / 1.4370	Ar-97.5 / CO2-2.5 (M12)	1,2
309	forceArc / forceArc puls	CrNi 18 8 / 1.4370	Ar-97.5 / CO2-2.5 (M12)	1,6
311	forceArc / forceArc puls	CrNi 19 12 3 / 1.4430	Ar-97.5 / CO2-2.5 (M12)	1,0
312	forceArc / forceArc puls	CrNi 19 12 3 / 1.4430	Ar-97.5 / CO2-2.5 (M12)	1,2
313	forceArc / forceArc puls	CrNi 19 12 3 / 1.4430	Ar-97.5 / CO2-2.5 (M12)	1,6
315	forceArc / forceArc puls	CrNi 22 9 3 / 1.4462	Ar-97.5 / CO2-2.5 (M12)	1,0
316	forceArc / forceArc puls	CrNi 22 9 3 / 1.4462	Ar-97.5 / CO2-2.5 (M12)	1,2
317	forceArc / forceArc puls	CrNi 22 9 3 / 1.4462	Ar-97.5 / CO2-2.5 (M12)	1,6
319	forceArc / forceArc puls	CrNi 25 20 / 1.4842	Ar-97.5 / CO2-2.5 (M12)	1,0
320	forceArc / forceArc puls	CrNi 25 20 / 1.4842	Ar-97.5 / CO2-2.5 (M12)	1,2
323	forceArc / forceArc puls	CrNi 23 12 / 1.4332	Ar-97.5 / CO2-2.5 (M12)	1,0
324	forceArc / forceArc puls	CrNi 23 12 / 1.4332	Ar-97.5 / CO2-2.5 (M12)	1,2
325	forceArc / forceArc puls	CrNi 23 12 / 1.4332	Ar-97.5 / CO2-2.5 (M12)	1,6

JOB no.	Processes	Material	Gas	Diameter [mm]
326	coldArc / coldArc puls	CrNi 19 12 3 Nb / 1.4576	Ar-97.5 / CO2-2.5 (M12)	0,8
327	coldArc / coldArc puls	CrNi 19 12 3 Nb / 1.4576	Ar-97.5 / CO2-2.5 (M12)	1,0
328	coldArc / coldArc puls	CrNi 19 12 3 Nb / 1.4576	Ar-97.5 / CO2-2.5 (M12)	1,2
330	coldArc / coldArc puls	CrNi 18 8 / 1.4370	Ar-97.5 / CO2-2.5 (M12)	0,8
331	coldArc / coldArc puls	CrNi 18 8 / 1.4370	Ar-97.5 / CO2-2.5 (M12)	1,0
332	coldArc / coldArc puls	CrNi 18 8 / 1.4370	Ar-97.5 / CO2-2.5 (M12)	1,2
334	coldArc / coldArc puls	CrNi 19 12 3 / 1.4430	Ar-97.5 / CO2-2.5 (M12)	0,8
335	coldArc / coldArc puls	CrNi 19 12 3 / 1.4430	Ar-97.5 / CO2-2.5 (M12)	1,0
336	coldArc / coldArc puls	CrNi 19 12 3 / 1.4430	Ar-97.5 / CO2-2.5 (M12)	1,2
338	coldArc / coldArc puls	CrNi 22 9 3/1.4462/Duplex	Ar-97.5 / CO2-2.5 (M12)	0,8
339	coldArc / coldArc puls	CrNi 22 9 3/1.4462/Duplex	Ar-97.5 / CO2-2.5 (M12)	1,0
340	coldArc / coldArc puls	CrNi 22 9 3/1.4462/Duplex	Ar-97.5 / CO2-2.5 (M12)	1,2
350	Self-shielded flux cored wire	FCW Steel Rutile	No Gas	0,9
351	Self-shielded flux cored wire	FCW Steel Rutile	No Gas	1,0
352	Self-shielded flux cored wire	FCW Steel Rutile	No Gas	1,2
359	wiredArc / wiredArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,0
360	wiredArc / wiredArc puls	G3Si1 / G4Si1	Ar-82 / CO2-18 (M21)	1,2
367	wiredArc / wiredArc puls	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	1,0
368	wiredArc / wiredArc puls	CrNi 19 9 / 1.4316	Ar-97.5 / CO2-2.5 (M12)	1,2
371	wiredArc / wiredArc puls	CrNi 19 12 3 / 1.4430	Ar-97.5 / CO2-2.5 (M12)	1,0
384	wiredArc / wiredArc puls	AlMg4.5Mn	Ar-50/He-50 (I3)	1,2
385	wiredArc / wiredArc puls	AlMg4.5Mn	Ar-50/He-50 (I3)	1,6
386	Surfacing	Co-based	Ar-100 (I1)	1,2
387	Surfacing	Co-based	Ar-100 (I1)	1,6
388	Surfacing	CrNi 23 12 / 1.4332	Ar-97.5 / CO2-2.5 (M12)	1,2
389	Surfacing	CrNi 23 12 / 1.4332	Ar-97.5 / CO2-2.5 (M12)	1,6
391	acArc puls ^[1]	AlMg4.5Mn	Ar-100 (I1)	1,0
392	acArc puls ^[1]	AlMg4.5Mn	Ar-100 (I1)	1,2
393	acArc puls ^[1]	AlMg4.5Mn	Ar-100 (I1)	1,6
394	acArc puls ^[1]	AlSi	Ar-residue/O2-0.03	1,0
395	acArc puls ^[1]	AlSi	Ar-residue/O2-0.03	1,2

^[1] active only in machine series Titan XQ AC.

9.3 Searching for a dealer

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