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2015-07

Processes



MIG (GMAW) Welding



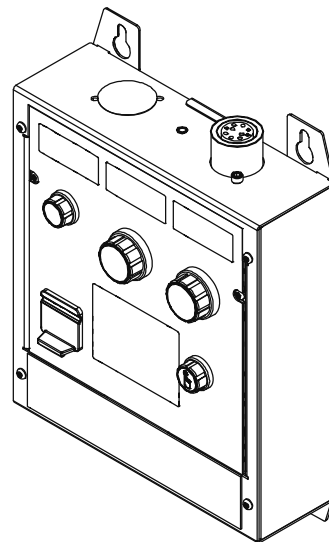
Flux Cored (FCAW) Welding
(Gas- And Self-Shielded)

Description



Wire Feeder

Continuum[®] ROI (Remote Operator Interface)



Visit our website at
www.MillerWelds.com/ams

OWNER'S MANUAL

File: Advanced Manufacturing Systems



From Miller to You

Thank you and congratulations on choosing Miller. Now you can get the job done and get it done right. We know you don't have time to do it any other way.

That's why when Niels Miller first started building arc welders in 1929, he made sure his products offered long-lasting value and superior quality. Like you, his customers couldn't afford anything less. Miller products had to be more than the best they could be. They had to be the best you could buy.

Today, the people that build and sell Miller products continue the tradition. They're just as committed to providing equipment and service that meets the high standards of quality and value established in 1929.

This Owner's Manual is designed to help you get the most out of your Miller products. Please take time to read the Safety precautions. They will help you protect yourself against potential hazards on the worksite.

We've made installation and operation quick and easy. With Miller you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there's a Troubleshooting section that will help you figure out what the problem is. The parts list will then help you to decide the exact part you may need to fix the problem. Warranty and service information for your particular model are also provided.



Miller is the first welding equipment manufacturer in the U.S.A. to be registered to the ISO 9001:2000 Quality System Standard.



Miller Electric manufactures a full line of welders and welding related equipment. For information on other quality Miller products, contact your local Miller distributor to receive the latest full line catalog or individual specification sheets. **To locate your nearest distributor or service agency call 1-800-4-A-Miller, or visit us at www.MillerWelds.com on the web.**



Working as hard as you do – every power source from Miller is backed by the most hassle-free warranty in the business.



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SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING

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 Protect yourself and others from injury — read, follow, and save these important safety precautions and operating instructions.

1-1. Symbol Usage



DANGER! – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.



Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

NOTICE – Indicates statements not related to personal injury.

 Indicates special instructions.



This group of symbols means Warning! Watch Out! ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

1-2. Arc Welding Hazards



The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-5. Read and follow all Safety Standards.



Only qualified persons should install, operate, maintain, and repair this unit.



During operation, keep everybody, especially children, away.



ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.

- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Do not use AC output in damp areas, if movement is confined, or if there is a danger of falling.
- Use AC output ONLY if required for the welding process.
- If AC output is required, use remote output control if present on unit.
- Additional safety precautions are required when any of the following electrically hazardous conditions are present: in damp locations or while wearing wet clothing; on metal structures such as floors, gratings, or scaffolds; when in cramped positions such as sitting, kneeling, or lying; or when there is a high risk of unavoidable or accidental contact with the workpiece or ground. For these conditions, use the following equipment in order presented: 1) a semiautomatic DC constant voltage (wire) welder, 2) a DC manual (stick) welder, or 3) an AC welder with reduced open-circuit voltage. In most situations, use of a DC, constant voltage wire welder is recommended. And, do not work alone!
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Properly install, ground, and operate this equipment according to its Owner's Manual and national, state, and local codes.
- Always verify the supply ground – check and be sure that input power cord ground wire is properly connected to ground terminal in

disconnect box or that cord plug is connected to a properly grounded receptacle outlet.

- When making input connections, attach proper grounding conductor first – double-check connections.
- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cord and ground conductor for damage or bare wiring – replace immediately if damaged – bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or repaired cables.
- Do not drape cables over your body.
- If earth grounding of the workpiece is required, ground it directly with a separate cable.
- Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.
- Do not touch electrode holders connected to two welding machines at the same time since double open-circuit voltage will be present.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Clamp work cable with good metal-to-metal contact to workpiece or worktable as near the weld as practical.
- Insulate work clamp when not connected to workpiece to prevent contact with any metal object.
- Do not connect more than one electrode or work cable to any single weld output terminal. Disconnect cable for process not in use.
- Use GFCI protection when operating auxiliary equipment in damp or wet locations.

SIGNIFICANT DC VOLTAGE exists in inverter welding power sources AFTER removal of input power.

- Turn Off inverter, disconnect input power, and discharge input capacitors according to instructions in Maintenance Section before touching any parts.



HOT PARTS can burn.

- Do not touch hot parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.



FUMES AND GASES can be hazardous.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Keep your head out of the fumes. Do not breathe the fumes.
- If inside, ventilate the area and/or use local forced ventilation at the arc to remove welding fumes and gases. The recommended way to determine adequate ventilation is to sample for the composition and quantity of fumes and gases to which personnel are exposed.
- If ventilation is poor, wear an approved air-supplied respirator.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watch-person nearby. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
- Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.



ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes from arc rays and sparks when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.
- Wear body protection made from durable, flame-resistant material (leather, heavy cotton, wool). Body protection includes oil-free clothing such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.

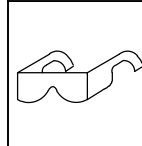


WELDING can cause fire or explosion.

Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.

- Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Do not weld where flying sparks can strike flammable material.
- Protect yourself and others from flying sparks and hot metal.
- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Watch for fire, and keep a fire extinguisher nearby.
- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- Do not weld on containers that have held combustibles, or on closed containers such as tanks, drums, or pipes unless they are properly prepared according to AWS F4.1 and AWS A6.0 (see Safety Standards).
- Do not weld where the atmosphere may contain flammable dust, gas, or liquid vapors (such as gasoline).
- Connect work cable to the work as close to the welding area as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock, sparks, and fire hazards.
- Do not use welder to thaw frozen pipes.

- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
- Wear body protection made from durable, flame-resistant material (leather, heavy cotton, wool). Body protection includes oil-free clothing such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.
- Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding.
- After completion of work, inspect area to ensure it is free of sparks, glowing embers, and flames.
- Use only correct fuses or circuit breakers. Do not oversize or bypass them.
- Follow requirements in OSHA 1910.252 (a) (2) (iv) and NFPA 51B for hot work and have a fire watcher and extinguisher nearby.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.



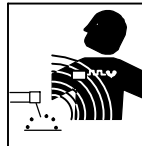
FLYING METAL or DIRT can injure eyes.

- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.



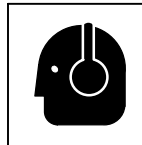
BUILDUP OF GAS can injure or kill.

- Shut off compressed gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



ELECTRIC AND MAGNETIC FIELDS (EMF) can affect Implanted Medical Devices.

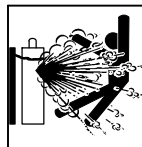
- Wearers of Pacemakers and other Implanted Medical Devices should keep away.
- Implanted Medical Device wearers should consult their doctor and the device manufacturer before going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations.



NOISE can damage hearing.

Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.



CYLINDERS can explode if damaged.

Compressed gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.
- Never weld on a pressurized cylinder – explosion will result.
- Use only correct compressed gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve. Do not stand in front of or behind the regulator when opening the valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Use the right equipment, correct procedures, and sufficient number of persons to lift and move cylinders.
- Read and follow instructions on compressed gas cylinders, associated equipment, and Compressed Gas Association (CGA) publication P-1 listed in Safety Standards.

1-3. Additional Symbols For Installation, Operation, And Maintenance



FIRE OR EXPLOSION hazard.

- Do not install or place unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring – be sure power supply system is properly sized, rated, and protected to handle this unit.



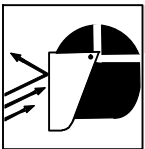
FALLING EQUIPMENT can injure.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.
- Keep equipment (cables and cords) away from moving vehicles when working from an aerial location.
- Follow the guidelines in the Applications Manual for the Revised NIOSH Lifting Equation (Publication No. 94-110) when manually lifting heavy parts or equipment.



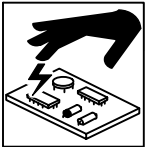
OVERUSE can cause OVERHEATING

- Allow cooling period; follow rated duty cycle.
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit.



FLYING SPARKS can injure.

- Wear a face shield to protect eyes and face.
- Shape tungsten electrode only on grinder with proper guards in a safe location wearing proper face, hand, and body protection.
- Sparks can cause fires — keep flammables away.



STATIC (ESD) can damage PC boards.

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.



MOVING PARTS can injure.

- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.



WELDING WIRE can injure.

- Do not press gun trigger until instructed to do so.
- Do not point gun toward any part of the body, other people, or any metal when threading welding wire.



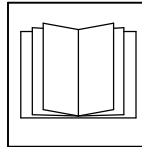
BATTERY EXPLOSION can injure.

- Do not use welder to charge batteries or jump start vehicles unless it has a battery charging feature designed for this purpose.



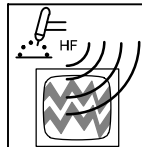
MOVING PARTS can injure.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.
- Have only qualified persons remove doors, panels, covers, or guards for maintenance and troubleshooting as necessary.
- Reinstall doors, panels, covers, or guards when maintenance is finished and before reconnecting input power.



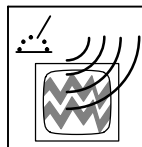
READ INSTRUCTIONS.

- Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.
- Use only genuine replacement parts from the manufacturer.
- Perform maintenance and service according to the Owner's Manuals, industry standards, and national, state, and local codes.



H.F. RADIATION can cause interference.


- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.




ARC WELDING can cause interference.

- Electromagnetic energy can interfere with sensitive electronic equipment such as computers and computer-driven equipment such as robots.
- Be sure all equipment in the welding area is electromagnetically compatible.
- To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor.
- Locate welding operation 100 meters from any sensitive electronic equipment.
- Be sure this welding machine is installed and grounded according to this manual.
- If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area.

1-4. California Proposition 65 Warnings

 **Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)**

 **This product contains chemicals, including lead, known to the state of California to cause cancer, birth defects, or other reproductive harm. Wash hands after use.**

1-5. Principal Safety Standards

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, is available as a free download from the American Welding Society at <http://www.aws.org> or purchased from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Safe Practices for Welding and Cutting Containers that have Held Combustibles, American Welding Society Standard AWS A6.0, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Quincy, MA 02269 (phone: 1-800-344-3555, website: www.nfpa.org and www.sparky.org).

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 14501 George Carter Way, Suite 103, Chantilly, VA 20151 (phone: 703-788-2700, website: www.cganet.com).

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 5060

Spectrum Way, Suite 100, Ontario, Canada L4W 5N5 (phone: 800-463-6727, website: www.csa-international.org).

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 25 West 43rd Street, New York, NY 10036 (phone: 212-642-4900, website: www.ansi.org).

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B, from National Fire Protection Association, Quincy, MA 02269 (phone: 1-800-344-3555, website: www.nfpa.org).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 (phone: 1-866-512-1800) (there are 10 OSHA Regional Offices—phone for Region 5, Chicago, is 312-353-2220, website: www.osha.gov).

Applications Manual for the Revised NIOSH Lifting Equation, The National Institute for Occupational Safety and Health (NIOSH), 1600 Clifton Rd, Atlanta, GA 30333 (phone: 1-800-232-4636, website: www.cdc.gov/NIOSH).

1-6. EMF Information

Electric current flowing through any conductor causes localized electric and magnetic fields (EMF). The current from arc welding (and allied processes including spot welding, gouging, plasma arc cutting, and induction heating operations) creates an EMF field around the welding circuit. EMF fields may interfere with some medical implants, e.g. pacemakers. Protective measures for persons wearing medical implants have to be taken. For example, restrict access for passers-by or conduct individual risk assessment for welders. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:

1. Keep cables close together by twisting or taping them, or using a cable cover.
2. Do not place your body between welding cables. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.

4. Keep head and trunk as far away from the equipment in the welding circuit as possible.
5. Connect work clamp to workpiece as close to the weld as possible.
6. Do not work next to, sit or lean on the welding power source.
7. Do not weld whilst carrying the welding power source or wire feeder.

About Implanted Medical Devices:

Implanted Medical Device wearers should consult their doctor and the device manufacturer before performing or going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations. If cleared by your doctor, then following the above procedures is recommended.

SECTION 2 – CONSIGNES DE SÉCURITÉ – LIRE AVANT UTILISATION

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⚠ Pour écarter les risques de blessure pour vous-même et pour autrui — lire, appliquer et ranger en lieu sûr ces consignes relatives aux précautions de sécurité et au mode opératoire.

2-1. Symboles utilisés



DANGER! – Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.



Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

NOTE – Indique des déclarations pas en relation avec des blessures personnelles.

 Indique des instructions spécifiques.



Ce groupe de symboles veut dire Avertissement! Attention! DANGER DE CHOC ÉLECTRIQUE, PIÈCES EN MOUVEMENT, et PIÈCES CHAUDES. Consulter les symboles et les instructions ci-dessous y afférant pour les actions nécessaires afin d'éviter le danger.

2-2. Dangers relatifs au soudage à l'arc



Les symboles représentés ci-dessous sont utilisés dans ce manuel pour attirer l'attention et identifier les dangers possibles. En présence de l'un de ces symboles, prendre garde et suivre les instructions afférentes pour éviter tout risque. Les instructions en matière de sécurité indiquées ci-dessous ne constituent qu'un sommaire des instructions de sécurité plus complètes fournies dans les normes de sécurité énumérées dans la Section 2-5. Lire et observer toutes les normes de sécurité.



Seul un personnel qualifié est autorisé à installer, faire fonctionner, entretenir et réparer cet appareil.



Pendant le fonctionnement, maintenir à distance toutes les personnes, notamment les enfants de l'appareil.



UNE DÉCHARGE ÉLECTRIQUE peut entraîner la mort.

Le contact d'organes électriques sous tension peut provoquer des accidents mortels ou des brûlures graves. Le circuit de l'électrode et de la pièce est sous tension lorsque le courant est délivré à la sortie. Le circuit d'alimentation et les circuits internes de la machine sont également sous tension lorsque l'alimentation est sur Marche. Dans le mode de soudage avec du fil, le fil, le dérouleur, le bloc de commande du rouleau et toutes les parties métalliques en contact avec le fil sont sous tension électrique. Un équipement installé ou mis à la terre de manière incorrecte ou impropre constitue un danger.

- Ne pas toucher aux pièces électriques sous tension.
- Porter des gants isolants et des vêtements de protection secs et sans trous.
- S'isoler de la pièce à couper et du sol en utilisant des housses ou des tapis assez grands afin d'éviter tout contact physique avec la pièce à couper ou le sol.
- Ne pas se servir de source électrique à courant électrique dans les zones humides, dans les endroits confinés ou là où on risque de tomber.
- Se servir d'une source électrique à courant électrique UNIQUEMENT si le procédé de soudage le demande.
- Si l'utilisation d'une source électrique à courant électrique s'avère nécessaire, se servir de la fonction de télécommande si l'appareil en est équipé.
- D'autres consignes de sécurité sont nécessaires dans les conditions suivantes : risques électriques dans un environnement humide ou si l'on porte des vêtements mouillés ; sur des structures métalliques telles que sols, grilles ou échafaudages ; en position coincée comme assise, à genoux ou couchée ; ou s'il y a un risque élevé de contact inévitable ou accidentel avec la pièce à souder ou

le sol. Dans ces conditions, utiliser les équipements suivants, dans l'ordre indiqué : 1) un poste à souder DC à tension constante (à fil), 2) un poste à souder DC manuel (électrode) ou 3) un poste à souder AC à tension à vide réduite. Dans la plupart des situations, l'utilisation d'un poste à souder DC à fil à tension constante est recommandée. En outre, ne pas travailler seul !

- Couper l'alimentation ou arrêter le moteur avant de procéder à l'installation, à la réparation ou à l'entretien de l'appareil. Déverrouiller l'alimentation selon la norme OSHA 29 CFR 1910.147 (voir normes de sécurité).
- Installez, mettez à la terre et utilisez correctement cet équipement conformément à son Manuel d'Utilisation et aux réglementations nationales, gouvernementales et locales.
- Toujours vérifier la terre du cordon d'alimentation. Vérifier et s'assurer que le fil de terre du cordon d'alimentation est bien raccordé à la borne de terre du sectionneur ou que la fiche du cordon est raccordée à une prise correctement mise à la terre.
- En effectuant les raccordements d'entrée, fixer d'abord le conducteur de mise à la terre approprié et contre-vérifier les connexions.
- Les câbles doivent être exempts d'humidité, d'huile et de graisse; protégez-les contre les étincelles et les pièces métalliques chaudes.
- Vérifier fréquemment le cordon d'alimentation et le conducteur de mise à la terre afin de s'assurer qu'il n'est pas altéré ou dénudé –, le remplacer immédiatement s'il l'est –. Un fil dénudé peut entraîner la mort.
- L'équipement doit être hors tension lorsqu'il n'est pas utilisé.
- Ne pas utiliser des câbles usés, endommagés, de grosseur insuffisante ou mal épissés.
- Ne pas enrouler les câbles autour du corps.
- Si la pièce soudée doit être mise à la terre, le faire directement avec un câble distinct.
- Ne pas toucher l'électrode quand on est en contact avec la pièce, la terre ou une électrode provenant d'une autre machine.
- Ne pas toucher des porte électrodes connectés à deux machines en même temps à cause de la présence d'une tension à vide doublée.
- N'utiliser qu'un matériel en bon état. Réparer ou remplacer sur-le-champ les pièces endommagées. Entretenir l'appareil conformément à ce manuel.
- Porter un harnais de sécurité si l'on doit travailler au-dessus du sol.
- S'assurer que tous les panneaux et couvercles sont correctement en place.
- Fixer le câble de retour de façon à obtenir un bon contact métal-métal avec la pièce à souder ou la table de travail, le plus près possible de la soudure.
- Isoler la pince de masse quand pas mis à la pièce pour éviter le contact avec tout objet métallique.

- Ne pas raccorder plus d'une électrode ou plus d'un câble de masse à une même borne de sortie de soudage. Débrancher le câble pour le procédé non utilisé.
- Utiliser une protection différentielle lors de l'utilisation d'un équipement auxiliaire dans des endroits humides ou mouillés.

Il reste une TENSION DC NON NÉGLIGEABLE dans les sources de soudage onduleur UNE FOIS l'alimentation coupée.

- Arrêter les convertisseurs, débrancher le courant électrique et décharger les condensateurs d'alimentation selon les instructions indiquées dans la partie Entretien avant de toucher les pièces.



LES PIÈCES CHAUDES peuvent provoquer des brûlures.

- Ne pas toucher à mains nues les parties chaudes.
- Prévoir une période de refroidissement avant de travailler à l'équipement.
- Ne pas toucher aux pièces chaudes, utiliser les outils recommandés et porter des gants de soudage et des vêtements épais pour éviter les brûlures.



LES FUMÉES ET LES GAZ peuvent être dangereux.

Le soudage génère des fumées et des gaz. Leur inhalation peut être dangereuse pour votre santé.

- Eloigner votre tête des fumées. Ne pas respirer les fumées.
- À l'intérieur, ventiler la zone et/ou utiliser une ventilation forcée au niveau de l'arc pour l'évacuation des fumées et des gaz de soudage. Pour déterminer la bonne ventilation, il est recommandé de procéder à un prélèvement pour la composition et la quantité de fumées et de gaz auxquels est exposé le personnel.
- Si la ventilation est médiocre, porter un respirateur anti-vapeurs approuvé.
- Lire et comprendre les fiches de données de sécurité et les instructions du fabricant concernant les adhésifs, les revêtements, les nettoyeurs, les consommables, les produits de refroidissement, les dégraisseurs, les flux et les métaux.
- Travailler dans un espace fermé seulement s'il est bien ventilé ou en portant un respirateur à alimentation d'air. Demander toujours à un surveillant dûment formé de se tenir à proximité. Des fumées et des gaz de soudage peuvent déplacer l'air et abaisser le niveau d'oxygène provoquant des blessures ou des accidents mortels. S'assurer que l'air de respiration ne présente aucun danger.
- Ne pas souder dans des endroits situés à proximité d'opérations de dégraissage, de nettoyage ou de pulvérisation. La chaleur et les rayons de l'arc peuvent réagir en présence de vapeurs et former des gaz hautement toxiques et irritants.
- Ne pas souder des métaux munis d'un revêtement, tels que l'acier galvanisé, plaqué en plomb ou au cadmium à moins que le revêtement n'ait été enlevé dans la zone de soudure, que l'endroit soit bien ventilé, et en portant un respirateur à alimentation d'air. Les revêtements et tous les métaux renfermant ces éléments peuvent dégager des fumées toxiques en cas de soudage.

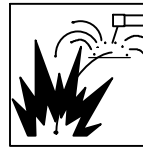


LES RAYONS DE L'ARC peuvent provoquer des brûlures dans les yeux et sur la peau.

Le rayonnement de l'arc du procédé de soudage génère des rayons visibles et invisibles intenses (ultraviolets et infrarouges) susceptibles de provoquer des brûlures dans les yeux et sur la peau. Des étincelles sont projetées pendant le soudage.

- Porter un casque de soudage approuvé muni de verres filtrants appropriés pour protéger visage et yeux pour protéger votre visage et vos yeux pendant le soudage ou pour regarder (voir ANSI Z49.1 et Z87.1 énuméré dans les normes de sécurité).
- Porter des lunettes de sécurité avec écrans latéraux même sous votre casque.

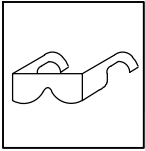
- Avoir recours à des écrans protecteurs ou à des rideaux pour protéger les autres contre les rayonnements les éblouissements et les étincelles ; prévenir toute personne sur les lieux de ne pas regarder l'arc.
- Porter un équipement de protection pour le corps fait d'un matériau résistant et ignifuge (cuir, coton robuste, laine). La protection du corps comporte des vêtements sans huile comme par ex. des gants de cuir, une chemise solide, des pantalons sans revers, des chaussures hautes et une casquette.



LE SOUDAGE peut provoquer un incendie ou une explosion.

Le soudage effectué sur des conteneurs fermés tels que des réservoirs, tambours ou des conduites peut provoquer leur éclatement. Des étincelles peuvent être projetées de l'arc de soudage. La projection d'étincelles, des pièces chaudes et des équipements chauds peut provoquer des incendies et des brûlures. Le contact accidentel de l'électrode avec des objets métalliques peut provoquer des étincelles, une explosion, un surchauffement ou un incendie. Avant de commencer le soudage, vérifier et s'assurer que l'endroit ne présente pas de danger.

- Déplacer toutes les substances inflammables à une distance de 10,7 m de l'arc de soudage. En cas d'impossibilité les recouvrir soigneusement avec des protections homologués.
- Ne pas souder dans un endroit là où des étincelles peuvent tomber sur des substances inflammables.
- Se protéger et d'autres personnes de la projection d'étincelles et de métal chaud.
- Des étincelles et des matériaux chauds du soudage peuvent facilement passer dans d'autres zones en traversant de petites fissures et des ouvertures.
- Surveiller tout déclenchement d'incendie et tenir un extincteur à proximité.
- Le soudage effectué sur un plafond, plancher, paroi ou séparation peut déclencher un incendie de l'autre côté.
- Ne pas effectuer le soudage sur des conteneurs fermés tels que des réservoirs, tambours, ou conduites, à moins qu'ils n'aient été préparés correctement conformément à AWS F4.1 et AWS A6.0 (voir les Normes de Sécurité).
- Ne soudez pas si l'air ambiant est chargé de particules, gaz, ou vapeurs inflammables (vapeur d'essence, par exemple).
- Brancher le câble de masse sur la pièce la plus près possible de la zone de soudage pour éviter le transport du courant sur une longue distance par des chemins inconnus éventuels en provoquant des risques d'électrocution, d'étincelles et d'incendie.
- Ne pas utiliser le poste de soudage pour dégeler des conduites gelées.
- En cas de non utilisation, enlever la baguette d'électrode du porte-électrode ou couper le fil à la pointe de contact.
- Porter un équipement de protection pour le corps fait d'un matériau résistant et ignifuge (cuir, coton robuste, laine). La protection du corps comporte des vêtements sans huile comme par ex. des gants de cuir, une chemise solide, des pantalons sans revers, des chaussures hautes et une casquette.
- Avant de souder, retirer toute substance combustible de vos poches telles qu'un allumeur au butane ou des allumettes.
- Une fois le travail achevé, assurez-vous qu'il ne reste aucune trace d'étincelles incandescentes ni de flammes.
- Utiliser exclusivement des fusibles ou coupe-circuits appropriés. Ne pas augmenter leur puissance; ne pas les ponter.
- Une fois le travail achevé, assurez-vous qu'il ne reste aucune trace d'étincelles incandescentes ni de flammes.
- Utiliser exclusivement des fusibles ou coupe-circuits appropriés. Ne pas augmenter leur puissance; ne pas les ponter.
- Suivre les recommandations dans OSHA 1910.252(a)(2)(iv) et NFPA 51B pour les travaux à chaud et avoir de la surveillance et un extincteur à proximité.
- Lire et comprendre les fiches de données de sécurité et les instructions du fabricant concernant les adhésifs, les revêtements, les nettoyeurs, les consommables, les produits de refroidissement, les dégraisseurs, les flux et les métaux.



DES PIÈCES DE METAL ou DES SALETES peuvent provoquer des blessures dans les yeux.

- Le soudage, l'écaillage, le passage de la pièce à la brosse en fil de fer, et le meulage génèrent des étincelles et des particules métalliques volantes. Pendant la période de refroidissement des soudures, elles risquent de projeter du laitier.
- Porter des lunettes de sécurité avec écrans latéraux ou un écran facial.



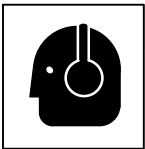
LES ACCUMULATIONS DE GAZ risquent de provoquer des blessures ou même la mort.

- Fermer l'alimentation du gaz comprimé en cas de non utilisation.
- Veiller toujours à bien aérer les espaces confinés ou se servir d'un respirateur d'adduction d'air homologué.



Les CHAMPS ÉLECTROMAGNÉTIQUES (CEM) peuvent affecter les implants médicaux.

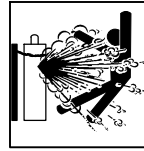
- Les porteurs de stimulateurs cardiaques et autres implants médicaux doivent rester à distance.
- Les porteurs d'implants médicaux doivent consulter leur médecin et le fabricant du dispositif avant de s'approcher de la zone où se déroule du soudage à l'arc, du soudage par points, du gougeage, de la découpe plasma ou une opération de chauffage par induction.



LE BRUIT peut endommager l'ouïe.

Le bruit des processus et des équipements peut affecter l'ouïe.

- Porter des protections approuvées pour les oreilles si le niveau sonore est trop élevé.



LES BOUTEILLES peuvent exploser si elles sont endommagées.

Les bouteilles de gaz comprimé contiennent du gaz sous haute pression. Si une bouteille est endommagée, elle peut exploser. Du fait que les bouteilles de gaz sont normalement parties du procédé de soudage, les manipuler avec précaution.

- Protéger les bouteilles de gaz comprimé d'une chaleur excessive, des chocs mécaniques, des dommages physiques, du laitier, des flammes ouvertes, des étincelles et des arcs.
- Placer les bouteilles debout en les fixant dans un support stationnaire ou dans un porte-bouteilles pour les empêcher de tomber ou de se renverser.
- Tenir les bouteilles éloignées des circuits de soudage ou autres circuits électriques.
- Ne jamais placer une torche de soudage sur une bouteille à gaz.
- Une électrode de soudage ne doit jamais entrer en contact avec une bouteille.
- Ne jamais souder une bouteille pressurisée – risque d'explosion.
- Utiliser seulement des bouteilles de gaz comprimé, régulateurs, tuyaux et raccords convenables pour cette application spécifique; les maintenir ainsi que les éléments associés en bon état.
- Tourner le dos à la sortie de vanne lors de l'ouverture de la vanne de la bouteille. Ne pas se tenir devant ou derrière le régulateur lors de l'ouverture de la vanne.
- Le couvercle du détendeur doit toujours être en place, sauf lorsque la bouteille est utilisée ou qu'elle est reliée pour usage ultérieur.
- Utiliser les équipements corrects, les bonnes procédures et suffisamment de personnes pour soulever et déplacer les bouteilles.
- Lire et suivre les instructions sur les bouteilles de gaz comprimé, l'équipement connexe et le dépliant P-1 de la CGA (Compressed Gas Association) mentionné dans les principales normes de sécurité.

2-3. Dangers supplémentaires en relation avec l'installation, le fonctionnement et la maintenance



Risque D'INCENDIE OU D'EXPLOSION.

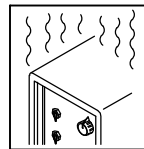
- Ne pas placer l'appareil sur, au-dessus ou à proximité de surfaces inflammables.
- Ne pas installer l'appareil à proximité de produits inflammables.
- Ne pas surcharger l'installation électrique – s'assurer que l'alimentation est correctement dimensionnée et protégée avant de mettre l'appareil en service.



LA CHUTE DE L'ÉQUIPEMENT peut provoquer des blessures.

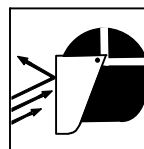
- Utiliser l'anneau de levage uniquement pour soulever l'appareil, NON PAS les chariots, les bouteilles de gaz ou tout autre accessoire.
- Utiliser un équipement de levage de capacité suffisante pour lever l'appareil.
- En utilisant des fourches de levage pour déplacer l'unité, s'assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l'appareil.
- Tenir l'équipement (câbles et cordons) à distance des véhicules mobiles lors de toute opération en hauteur.

- Suivre les consignes du Manuel des applications pour l'équation de levage NIOSH révisée (Publication N°94-110) lors du levage manuel de pièces ou équipements lourds.



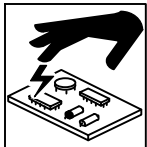
L'EMPLOI EXCESSIF peut SURCHAUFFER L'ÉQUIPEMENT.

- Prévoir une période de refroidissement ; respecter le cycle opératoire nominal.
- Réduire le courant ou le facteur de marche avant de poursuivre le soudage.
- Ne pas obstruer les passages d'air du poste.



LES ÉTINCELLES PROJÉTÉES peuvent provoquer des blessures.

- Porter un écran facial pour protéger le visage et les yeux.
- Affûter l'électrode au tungstène uniquement à la meuleuse dotée de protecteurs. Cette manœuvre est à exécuter dans un endroit sûr lorsque l'on porte l'équipement homologué de protection du visage, des mains et du corps.
- Les étincelles risquent de causer un incendie – éloigner toute substance inflammable.



LES CHARGES ÉLECTROSTATIQUES peuvent endommager les circuits imprimés.

- Établir la connexion avec la barrette de terre avant de manipuler des cartes ou des pièces.
- Utiliser des pochettes et des boîtes antistatiques pour stocker, déplacer ou expédier des cartes de circuits imprimés.



Les PIÈCES MOBILES peuvent causer des blessures.

- Ne pas s'approcher des organes mobiles.
- Ne pas s'approcher des points de coincement tels que des rouleaux de commande.



LES FILS DE SOUDAGE peuvent provoquer des blessures.

- Ne pas appuyer sur la gâchette avant d'en avoir reçu l'instruction.
- Ne pas diriger le pistolet vers soi, d'autres personnes ou toute pièce mécanique en engageant le fil de soudage.



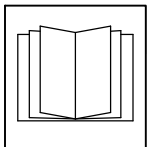
L'EXPLOSION DE LA BATTERIE peut provoquer des blessures.

- Ne pas utiliser l'appareil de soudage pour charger des batteries ou faire démarrer des véhicules à l'aide de câbles de démarrage, sauf si l'appareil dispose d'une fonctionnalité de charge de batterie destinée à cet usage.



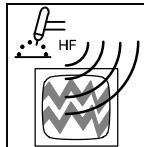
Les PIÈCES MOBILES peuvent causer des blessures.

- S'abstenir de toucher des organes mobiles tels que des ventilateurs.
 - Maintenir fermés et verrouillés les portes, panneaux, recouvrements et dispositifs de protection.
- Lorsque cela est nécessaire pour des travaux d'entretien et de dépannage, faire retirer les portes, panneaux, recouvrements ou dispositifs de protection uniquement par du personnel qualifié.
- Remettre les portes, panneaux, recouvrements ou dispositifs de protection quand l'entretien est terminé et avant de rebrancher l'alimentation électrique.



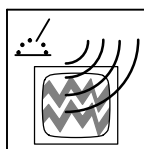
LIRE LES INSTRUCTIONS.

- Lire et appliquer les instructions sur les étiquettes et le Mode d'emploi avant l'installation, l'utilisation ou l'entretien de l'appareil. Lire les informations de sécurité au début du manuel et dans chaque section.
- N'utiliser que les pièces de rechange recommandées par le constructeur.
- Effectuer l'entretien en respectant les manuels d'utilisation, les normes industrielles et les codes nationaux, d'état et locaux.



LE RAYONNEMENT HAUTE FRÉQUENCE (H.F.) risque de provoquer des interférences.

- Le rayonnement haute fréquence (H.F.) peut provoquer des interférences avec les équipements de radio-navigation et de communication, les services de sécurité et les ordinateurs.
- Demander seulement à des personnes qualifiées familiarisées avec des équipements électroniques de faire fonctionner l'installation.
- L'utilisateur est tenu de faire corriger rapidement par un électicien qualifié les interférences résultant de l'installation.
- Si le FCC signale des interférences, arrêter immédiatement l'appareil.
- Effectuer régulièrement le contrôle et l'entretien de l'installation.
- Maintenir soigneusement fermés les portes et les panneaux des sources de haute fréquence, maintenir les éclateurs à une distance correcte et utiliser une terre et un blindage pour réduire les interférences éventuelles.



LE SOUDAGE À L'ARC risque de provoquer des interférences.

- L'énergie électromagnétique risque de provoquer des interférences pour l'équipement électronique sensible tel que les ordinateurs et l'équipement commandé par ordinateur tel que les robots.
- Veiller à ce que tout l'équipement de la zone de soudage soit compatible électromagnétiquement.
- Pour réduire la possibilité d'interférence, maintenir les câbles de soudage aussi courts que possible, les grouper, et les poser aussi bas que possible (ex. par terre).
- Veiller à souder à une distance de 100 mètres de tout équipement électronique sensible.
- Veiller à ce que ce poste de soudage soit posé et mis à la terre conformément à ce mode d'emploi.
- En cas d'interférences après avoir pris les mesures précédentes, il incombe à l'utilisateur de prendre des mesures supplémentaires telles que le déplacement du poste, l'utilisation de câbles blindés, l'utilisation de filtres de ligne ou la pose de protecteurs dans la zone de travail.

2-4. Proposition californienne 65 Avertissements

! Les équipements de soudage et de coupage produisent des fumées et des gaz qui contiennent des produits chimiques dont l'État de Californie reconnaît qu'ils provoquent des malformations congénitales et, dans certains cas, des cancers. (Code de santé et de sécurité de Californie, chapitre 25249.5 et suivants)

! Ce produit contient des produits chimiques, notamment du plomb, dont l'État de Californie reconnaît qu'ils provoquent des cancers, des malformations congénitales ou d'autres problèmes de procréation. *Se laver les mains après utilisation.*

2-5. Principales normes de sécurité

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, is available as a free download from the American Welding Society at <http://www.aws.org> or purchased from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Safe Practices for Welding and Cutting Containers that have Held Combustibles, American Welding Society Standard AWS A6.0, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Quincy, MA 02269 (phone: 1-800-344-3555, website: www.nfpa.org and www.sparky.org).

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 14501 George Carter Way, Suite 103, Chantilly, VA 20151 (phone: 703-788-2700, website: www.cganet.com).

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 5060

Spectrum Way, Suite 100, Ontario, Canada L4W 5NS (phone: 800-463-6727, website: www.csa-international.org).

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 25 West 43rd Street, New York, NY 10036 (phone: 212-642-4900, website: www.ansi.org).

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B, from National Fire Protection Association, Quincy, MA 02269 (phone: 1-800-344-3555, website: www.nfpa.org).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 (phone: 1-866-512-1800) (there are 10 OSHA Regional Offices—phone for Region 5, Chicago, is 312-353-2220, website: www.osha.gov).

Applications Manual for the Revised NIOSH Lifting Equation, The National Institute for Occupational Safety and Health (NIOSH), 1600 Clifton Rd, Atlanta, GA 30333 (phone: 1-800-232-4636, website: www.cdc.gov/NIOSH).

2-6. Informations relatives aux CEM

Le courant électrique qui traverse tout conducteur génère des champs électromagnétiques (CEM) à certains endroits. Le courant issu d'un soudage à l'arc (et de procédés connexes, y compris le soudage par points, le gougeage, le découpage plasma et les opérations de chauffage par induction) crée un champ électromagnétique (CEM) autour du circuit de soudage. Les CEM peuvent créer des interférences avec certains implants médicaux comme des stimulateurs cardiaques. Des mesures de protection pour les porteurs d'implants médicaux doivent être prises: Limiter par exemple tout accès aux passants ou procéder à une évaluation des risques individuels pour les soudeurs. Tous les soudeurs doivent appliquer les procédures suivantes pour minimiser l'exposition aux CEM provenant du circuit de soudage:

1. Rassembler les câbles en les torsadant ou en les attachant avec du ruban adhésif ou avec une housse.
2. Ne pas se tenir au milieu des câbles de soudage. Disposer les câbles d'un côté et à distance de l'opérateur.






3. Ne pas courber et ne pas entourer les câbles autour de votre corps.
4. Maintenir la tête et le torse aussi loin que possible du matériel du circuit de soudage.
5. Connecter la pince sur la pièce aussi près que possible de la soudure.
6. Ne pas travailler à proximité d'une source de soudage, ni s'asseoir ou se pencher dessus.
7. Ne pas souder tout en portant la source de soudage ou le dévidoir.

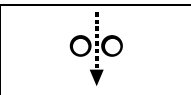
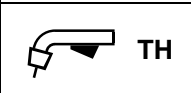
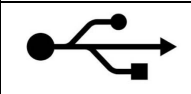
En ce qui concerne les implants médicaux :

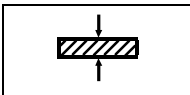
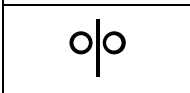
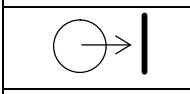


Les porteurs d'implants doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de soudage par points, de gougeage, du coupage plasma ou de chauffage par induction. Si le médecin approuve, il est recommandé de suivre les procédures précédentes.

SECTION 3 – DEFINITIONS

3-1. Miscellaneous Symbols And Definitions

	Purge by Gas
	Memory
	Arc Control
	Push Button
	Rotating Knob And Push Button

	Cold Jog (Inch) Toward Workpiece
	Trigger Hold
	USB
V	Voltage
A	Amperage

	Material Thickness
	Wire Feed
	Output On
	Arc Length
	Synergic Mode Active

Notes

SECTION 4 – INTRODUCTION

4-1. Serial Number And Rating Label Location

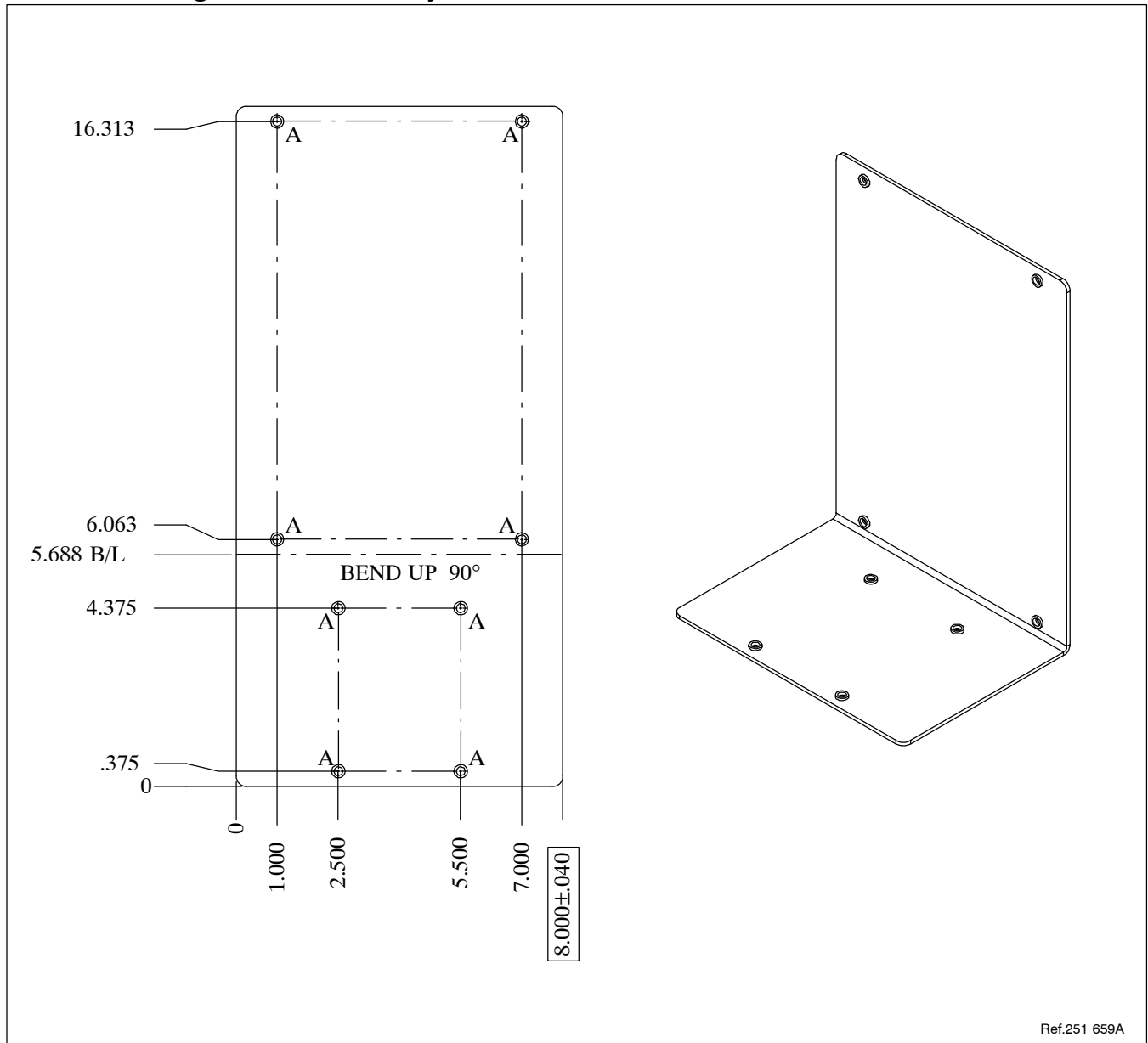
The serial number and rating information for this product is located on the back. Use rating label to determine input power requirements and/or rated output. For future reference, write serial number in space provided on back cover of this manual.

4-2. Specifications

Type of Input Power	Welding Power Source Type	Wire Feed Speed Range	Wire Diameter Range	Welding Circuit Rating	Overall Dimensions	Weight
50 Volts DC	Continuum Series	Standard: 50 To 1000 ipm (1.27 To 25.4 mpm)	.035 To 5/64 in. (0.9 To 2 mm) Max Spool Weight: 60 lb (27 kg)	75 Volts, 500 Amperes, 100% Duty Cycle	Length: 3.3 in. (84 mm) Width: 8 in. (203 mm) Height: 11 in. (280 mm)	4.1 lb (1.86 kg)

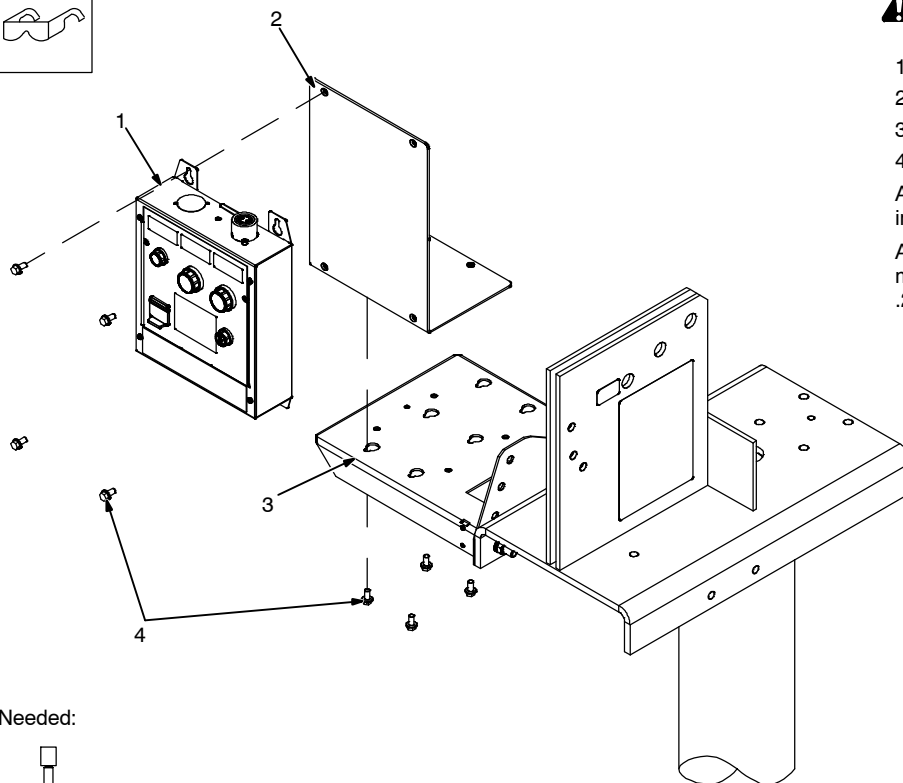
SECTION 5 – INSTALLATION

5-1. Mounting Bracket Hole Layout

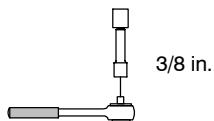


Ref.251 659A

5-2. Mounting Remote Operator Interface To Boom



Tools Needed:



⚠ Turn Off and disconnect input power.

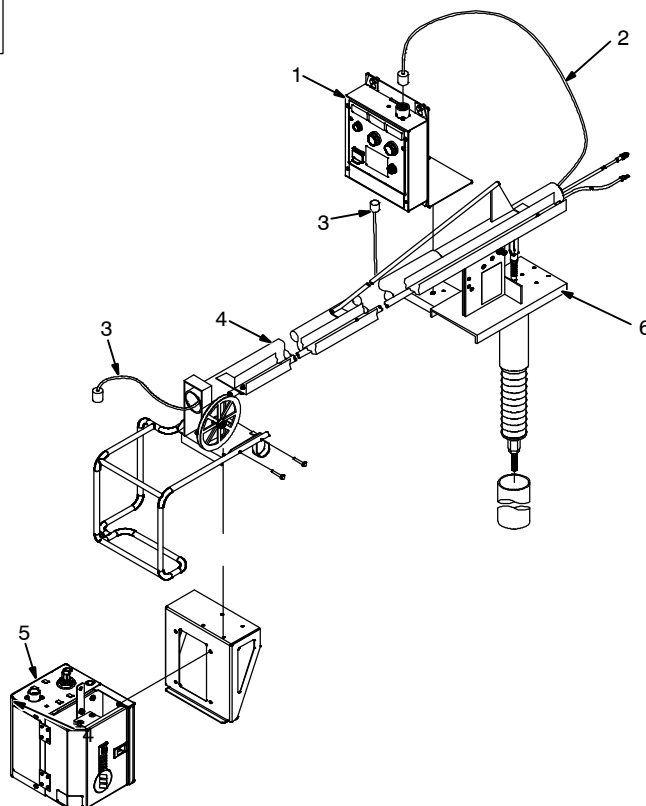
- 1 Remote Operator Interface
- 2 Mounting Bracket
- 3 Mounting Plate
- 4 .250-20 x 1/2 in. Screw (8)

Attach mounting bracket to mounting plate using four screws.

Attach remote operator interface to mounting bracket using four .250-20 x 1/2 in. screws.

804 165-A

5-3. Remote Operator Interface And Wire Drive Installation

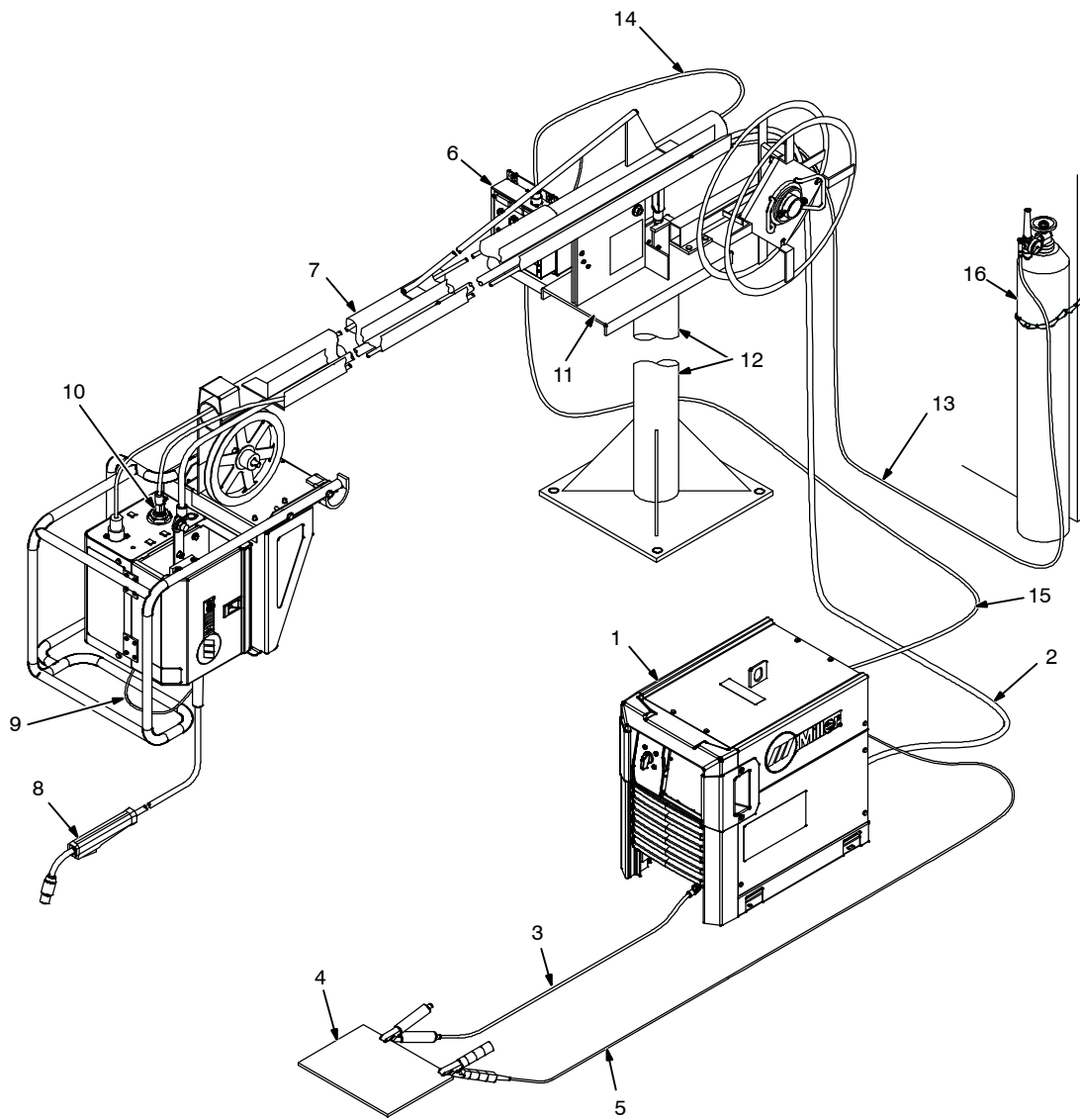


Typical SwingArc installation shown; however, various installations are possible depending on the application.

- 1 Remote Operator Interface
- 2 10-Pin Control Cable to Wire Drive Assembly
- 3 10-Pin Control Cable to welding power source.
- 4 Boom
- 5 Wire Drive Assembly
- 6 SwingArc Swivel Assembly

Ref. 271 204-A

5-4. Equipment Connection Diagram




1 Welding Power Source

2 Positive (+) Weld Cable

3 Negative (-) Weld Cable

4 Workpiece

5 Voltage Sensing Lead (Optional)

 Positive (+) voltage sensing lead is contained in the motor cable.

6 Remote Operator Interface

7 Boom

8 Gun

9 Trigger Connection

10 Shielding Gas Valve

11 Swivel

12 Pipe Post And Base

13 Gas Hose

14 Motor Control/Shielding Gas Valve Cable

15 Network Feeder Cable

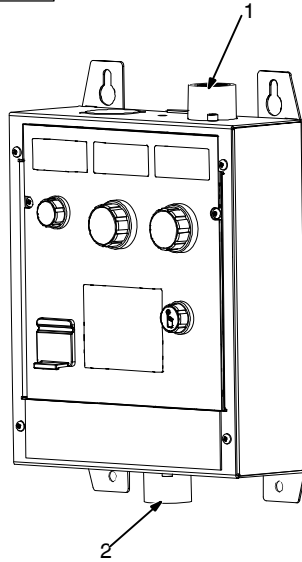
16 Gas Supply And Regulator (Customer Supplied)

271 200-A

5-5. Remote Operator Interface Connections


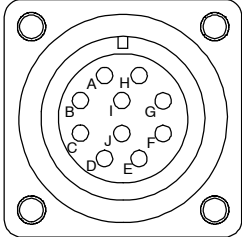


- 1 10-Pin Feeder Receptacle
- 2 10-Pin Welding Power Source Receptacle


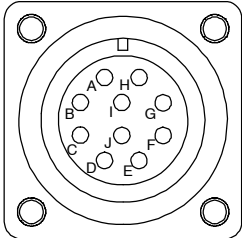


301227-TP3

5-6. 10-Pin Feeder Receptacle Information

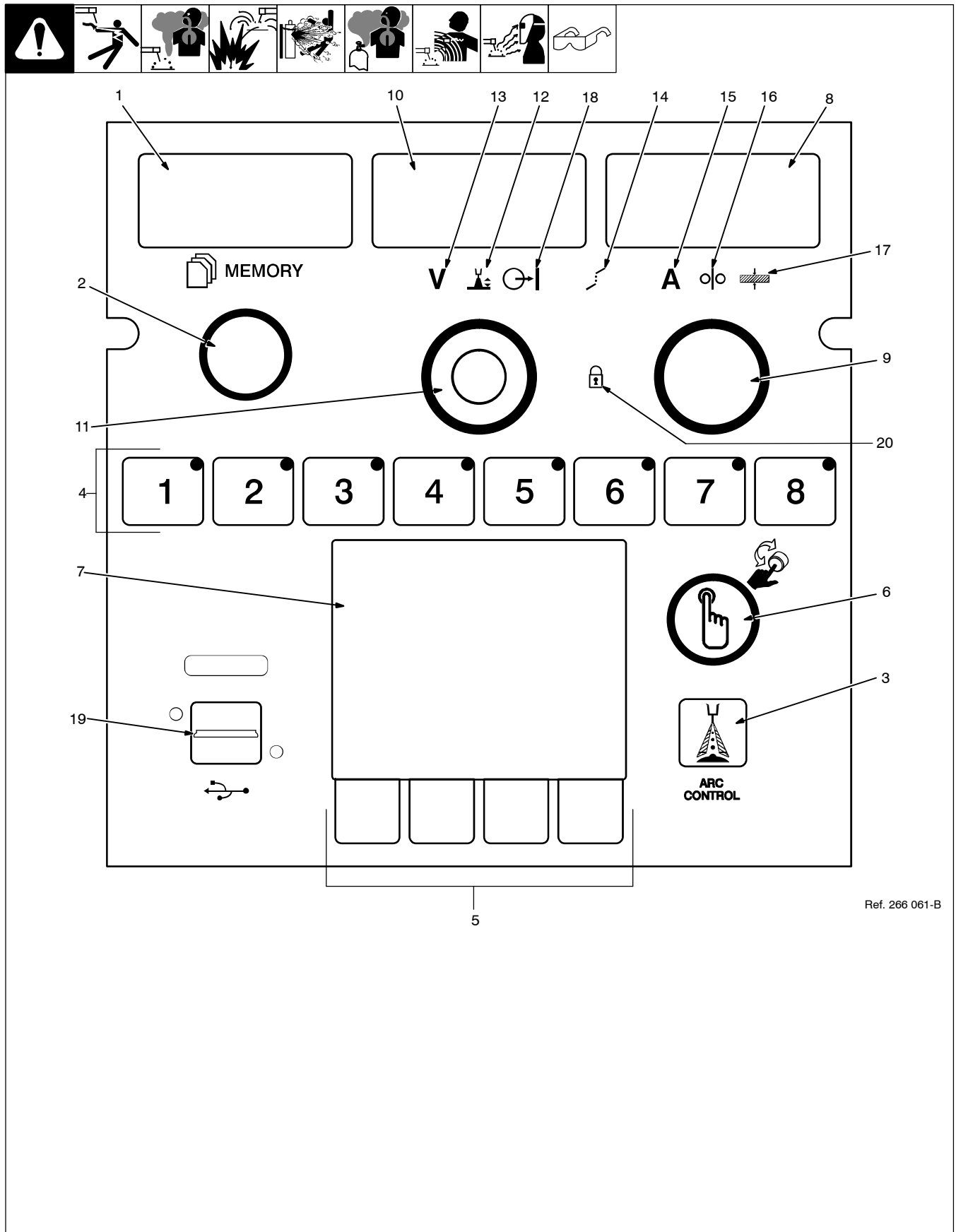
 REMOTE 10	Pin	Pin Information
	A	+50 Volts DC Common
	B	+50 Volts DC Common
	C	Voltage Sense
	D	+50 Volts DC Power
	E	+50 Volts DC Power
	F	ENET Rx -
	G	ENET Tx -
	H	Drain
	I	ENET Tx +
	J	ENET Rx +

5-7. 10-Pin Welding Power Source Receptacle Information

 REMOTE 10	Pin	Pin Information
	A	+50 Volts DC Common
	B	+50 Volts DC Common
	C	Voltage Sense
	D	+50 Volts DC Power
	E	+50 Volts DC Power
	F	ENET Rx -
	G	ENET Tx -
	H	Drain
	I	ENET Tx +
	J	ENET Rx +

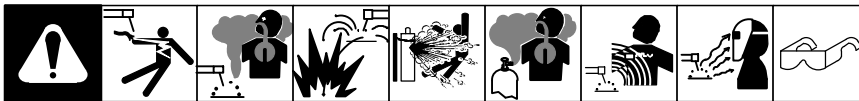
SECTION 6 – OPERATION

6-1. User Interface



Ref. 266 061-B

6-2. Description Of Front Panel Controls (See Section 6-1)



1 Memory Display

The Memory display shows the active weld program. The range is from 0001 to 9999.

2 Memory/Variable Adjustment Knob

Use this knob to select a program number or increase/decrease the variable shown in the Memory display.

3 Arc Control Button

The Arc Control button is process dependent. It allows user to change the variable that appears on the Values/Parameters display, such as inductance, DIG, RMD (ball size) or trim. The range can be +/- depending on the process.

4 Memory 1-8 Buttons And LEDs

Use these buttons to select a stored program from the weld program library data. The LED will indicate which program is selected and active.

The Variables/Parameters display will show weld program library summary data for the selected program.

5 Soft Key Buttons

Use these buttons to navigate the menus appearing in the LCD display (See Section 6-3).

6 Scroll Knob And Select/Save Button

Rotate this knob to scroll available options or increase/decrease the variable shown in the LCD display.

Pressing this knob acts as a Select/Save

button. Press the button to select options available in the LCD display

7 Values/Parameters LCD Display

This display shows all values and parameters that have been selected using the Soft Key buttons and the Scroll knob and Save/Select button.

8 Amperage/Wire Feed Speed Display

This display shows amperage, or wire feed speed depending on the process selected.

9 Amperage/Wire Feed Speed/Material Thickness Adjustment Knob

Use this knob to increase/decrease amperage, wire feed speed, or material thickness depending on the process selection. These values appear on the Amperage/Wire Feed Speed/Material Thickness display.

10 Voltage/Arc Length/Inductance/Arc Adjust/RMD Display

This display shows voltage, arc length, inductance, arc adjust or RMD depending on the process selected.

11 Voltage/Arc Control Adjustment Knob

Use this knob to increase/decrease voltage or arc length depending on the process selection. These values appear on the Voltage/Arc Length/Inductance/Arc Adjust/RMD display.

12 Arc Length Indicator

LED illuminates to show that arc length function is active.

13 Voltage Indicator

LED illuminates to show that the voltage function is active.

14 Synergic Mode Active Indicator

LED illuminates to show that a synergic weld process is active.

15 Amperage Indicator

LED illuminates to show that a SMAW, GMAW or CAG process is selected. Values appear on the Voltage/Arc Length/Inductance/Arc Adjust/RMD display.

16 Wire Feed Speed Indicator

LED illuminates to show that a GMAW or GMAW-P weld process is selected. Values appear on the Amperage/Wire Feed Speed/Material Thickness display.

17 Material Thickness Indicator

This feature will be functional in a later software release.

18 Output ON Indicator

LED illuminates to show that open circuit voltage is present at the weld output terminals.

19 USB Port

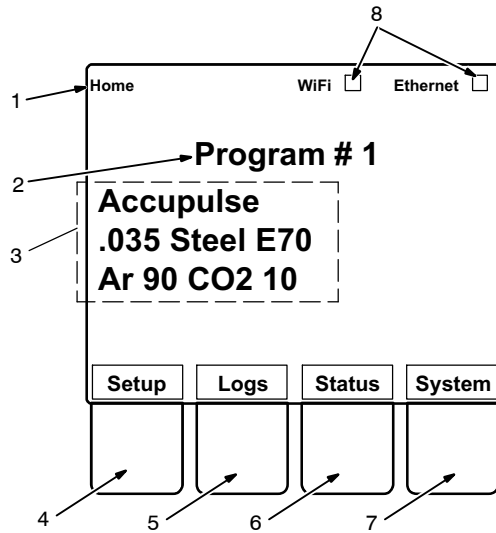
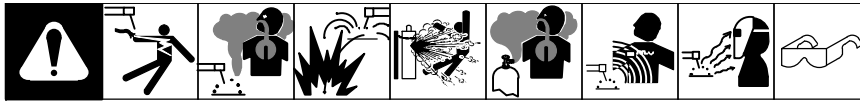
Use this port for all USB related functions (See Section 6-13).

20 Parameter Lock Indicator

LED illuminates to show weld parameters are locked and active.

* Disabled or not available.

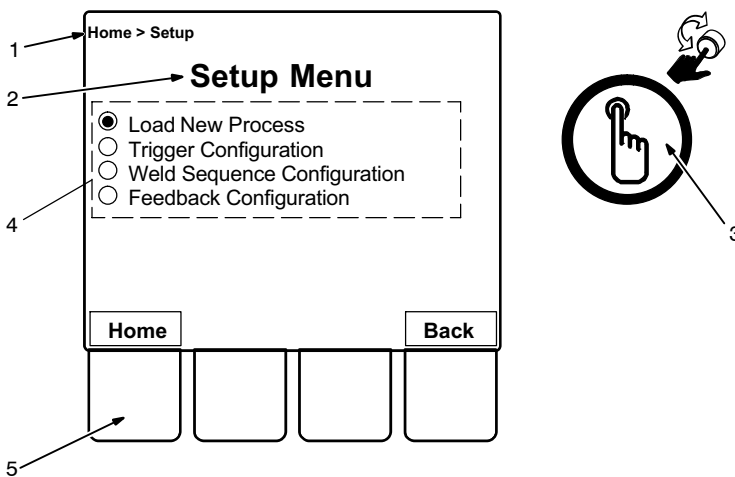
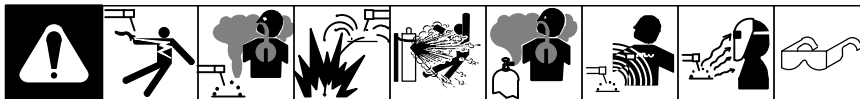
6-3. LCD Home Screen



Ref 266 061-A

- 1 Directory Indicator
Displays the directory path of current screen.
- 2 Program Number
Displays the current weld program number.
- 3 Program Information
Displays the process type, wire diameter, wire type and alloy, and gas mixture assigned to the current weld program.
- 4 Setup Soft Key
Press Setup soft key to enter the Setup menu screen. Setup Menu screen allows weld programs to be created or changed. For more information see Section 6-4.
- 5 Logs Soft Key
Press Logs soft key to enter Logs menu screen. For more information see Section 6-5.
- 6 Status Soft Key
Press Status soft key to enter the Status menu screen. For more information see Section 6-6.
- 7 System Soft Key
Press System Soft Key to enter System menu screen. System menu allows access to System Reset, USB, and board software revision functions. For more information see Section 6-11.
- 8 Network Connection Indicator
Displays the type of network connection being used.

6-4. Setup Menu



- 1 Directory Indicator
Displays the current directory path.
- 2 Menu Name
Displays the current menu name.
- 3 Scroll Knob and Select/Save Button
Rotate knob to change active option. Active option will have black circle next to it while inactive options will be white. Press the knob to select the active option.
- 4 Options
Load New Process- Add or make changes to a weld program. See Section 6-7.
Trigger Configuration- Select and edit dual schedule, trigger dual schedule, 4T, and trigger hold features. See Section 6-8.
Weld Sequence Configuration- Change different aspects of the weld sequence such as preflow, start amperage, crater, and post flow. See Section 6-9.
Feedback Configuration- Set voltage feedback method to stud sense or sense lead. See Section 6-10.
- 5 Home Soft Key
Press Home soft key to return to Home menu screen.

Ref 266 061-A

6-5. Logs Menu

1 Directory Indicator
Displays the current directory path.

2 Menu Name
Displays the current menu name.

3 Scroll Knob and Select/Save Button
Rotate knob to change active option. Active option will have black circle next to it while inactive options will be white. Press the knob to select the active option.

4 Options
Error Log– Displays a list of the last errors the unit has detected. Use the Scroll Knob to scroll through the list. From the Error log screen press the Home soft key to return to the Home screen, or the Logs Soft key to return to the Logs Menu.

5 Home Soft Key
Press Home soft key to return to Home menu screen.

Ref 266 061-A

6-6. Status Menu

1 Directory Indicator
Displays the current directory path.

2 Menu Name
Displays the current menu name.

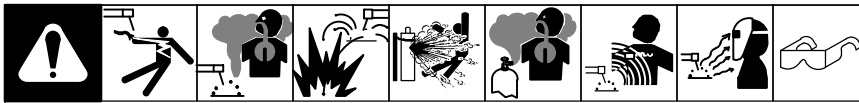
3 Scroll Knob and Select/Save Button
Rotate knob to change active option. Active option will have black circle next to it while inactive options will be white. Press the knob to select the active option.

4 Options
Load Bank Mode- Used to calibrate meters or test equipment when servicing.
Heat Input Mode- Changes amperage displayed while welding to kilojoules per second when On. Display updates once per second while welding.

5 Home Soft Key
Press Home soft key to return to Home menu screen.

Ref 266 061-A

6-7. Creating, Changing And Saving a Weld Program



Home > Setup

Setup Menu

- Load New Process
- Trigger Configuration
- Weld Sequence Configuration
- Feedback Configuration

Home Back



At the Home screen, using either the memory adjustment knob or memory buttons, select the program number to be used.

From the Home screen, press the Setup softkey.

In the Setup menu rotate the scroll knob to make Load New Process the active option. Press the knob to select Load New Process.

Follow screen prompts.

Step 1- Select Wire Type

Step 2- Select Wire Alloy

Step 3- Select Wire Size

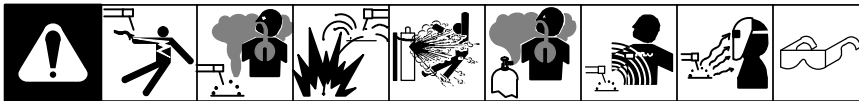
Step 4- Select Gas Mixture

Step 5- Select Process

After selecting process, the display will read Process Loading. At 100% the program is saved and ready to use.

Ref 266 061-A

6-8. Trigger Configuration



Home > Setup > Trigger Config

Program # 1	Program # 2
<input type="checkbox"/> Dual Schedule	<input type="checkbox"/> Dual Schedule
<input type="checkbox"/> Trigger Dual Schedule	<input type="checkbox"/> Trigger Dual Schedule
<input type="checkbox"/> Trigger Program Select	<input type="checkbox"/> Trigger Program Select
<input type="checkbox"/> 4T	<input type="checkbox"/> 4T
<input type="checkbox"/> Trigger Hold	<input type="checkbox"/> Trigger Hold

Home Setup Edit Back



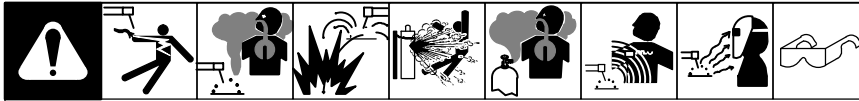
In the Setup menu, rotate the scroll knob to make Trigger Configuration the active option. Press the scroll knob to select Trigger Configuration.

All programs are paired in numerical order for dual schedule functions. Program 1 and 2 are paired, program 3 and 4 are paired, etc.

Select desired trigger function using the scroll knob.

Ref 266 061-A

6-9. Weld Sequence Configuration



Home > Setup > Sequence

Sequence Select - Program 1

<input checked="" type="radio"/> Prewflow -	Disabled
<input type="radio"/> Start -	Disabled
<input type="radio"/> Start Ramp -	Disabled
<input type="radio"/> Weld -	Enabled
<input type="radio"/> Crater Ramp -	Disabled
<input type="radio"/> Crater -	Disabled
<input type="radio"/> Retract -	Disabled
<input type="radio"/> Postflow -	Disabled

Home Setup Edit



At the Home screen, use either the memory adjustment knob or memory buttons to select the program number to be changed.

From the Home screen, press the Setup softkey.

In the Setup menu, rotate the scroll knob to make Weld Sequence Configuration the active option. Press the scroll knob to select Weld Sequence Configuration.

In the weld sequence configuration screen, rotate the scroll knob to desired function. Press the scroll knob to either enable or disable the function.

With the desired function active, press the Edit softkey to change the functions corresponding parameters:

Prewflow- Adjust the length of time gas flows before weld begins.

Start- Adjust voltage, wirefeed speed, time and inductance used for starting weld.

Start Ramp- Adjust the length of time weld takes from start to weld parameters.

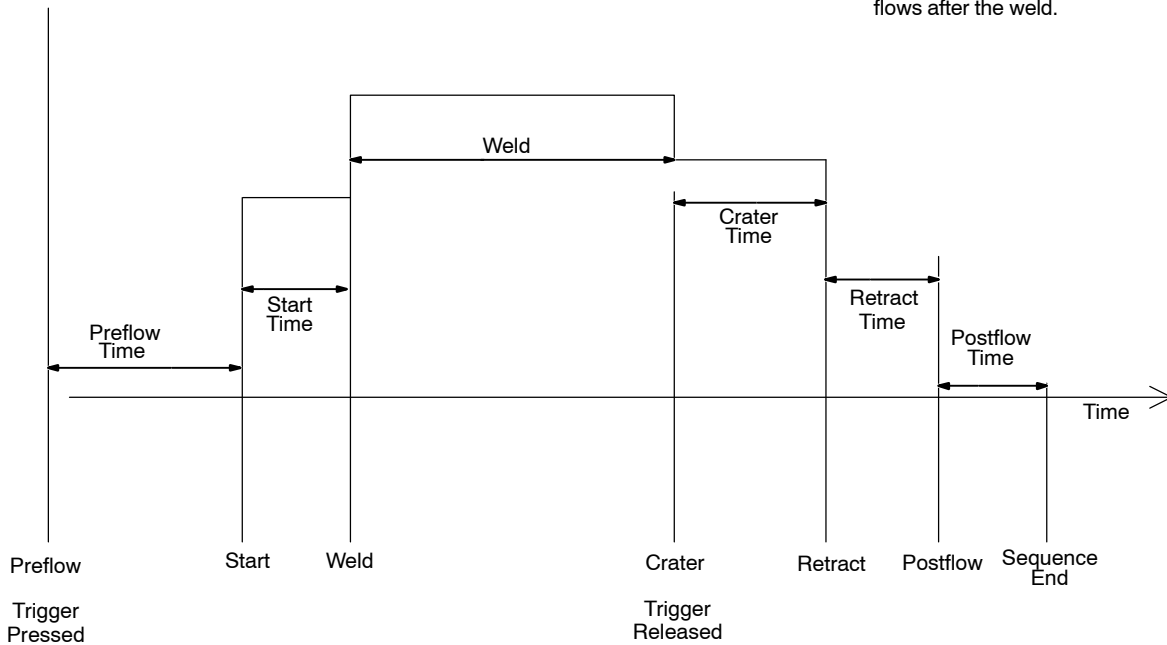
Weld- Adjust the voltage, wirefeed speed, time, and inductance.

Crater Ramp- Adjust the length of time from weld to crater parameters.

Crater- Adjust the voltage, wirefeed speed, time, and inductance for crater settings.

Retract- Set the speed and the amount of time the wire retracts after weld.

Postflow- Adjust the amount of time gas flows after the weld.



6-10. Feedback Configuration

1 Directory Indicator
Displays the current directory path.

2 Menu Name
Displays the current menu name.

3 Active Indicator
Displays the active feedback method.

4 Scroll Knob and Select/Save Button
Rotate knob to change active option. Active option will have black circle next to it while inactive options will be white. Press the knob to select the active option.

5 Options
Stud Sense- Current feedback measurement is taken at the output studs of the welding power source.
Sense Lead- Current feedback measurement is taken with a volt sense lead.

6 Home Soft Key
Press Home soft key to return to Home menu screen.

Ref 266 061-A

6-11. System Menu

1 Directory Indicator
Displays the current directory path.

2 Menu Name
Displays the current menu name.

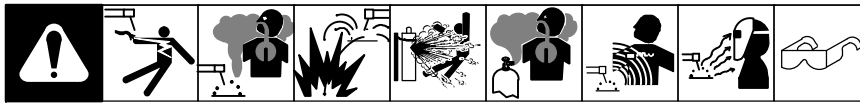
3 Scroll Knob and Select/Save Button
Rotate knob to change active option. Active option will have black circle next to it while inactive options will be white. Press the knob to select the active option.

4 Options
Factory Reset- Allows user to reset all values to factory defaults (See Section 6-12).
USB Functions- Update software and load or save weld programs with a USB (See Section 6-13).
System Software Revision- Displays the current software revision of the welding system.
Network Settings- Displays information about the network connections such as IP Address.
Machine Serial Number- Displays the serial number of the unit.

5 Home Soft Key
Press Home soft key to return to Home menu screen.

Ref 266 061-A

6-12. Factory Reset



Home > System > Factory Reset

Factory Reset

Perform Factory Reset?

No
 Yes

Home Back



From the Home screen, press the System softkey.

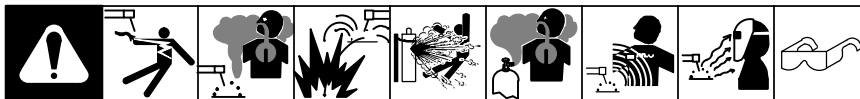
In the System menu rotate the scroll knob to make Factory Reset the active option. Press the knob to select Factory Reset.

At the Factory Reset screen rotate the scroll knob to select Yes. Press the scroll knob to perform a Factory Reset.

Display will return to the Home screen when Factory Reset is complete.

Ref 266 061-A

6-13. USB Functions



Home > System > USB

USB Functions

Write to system
 Write to USB

Home System



From the Home screen, press the System softkey.

In the System menu rotate the scroll knob to make USB Functions the active option. Press the knob to select USB Functions.

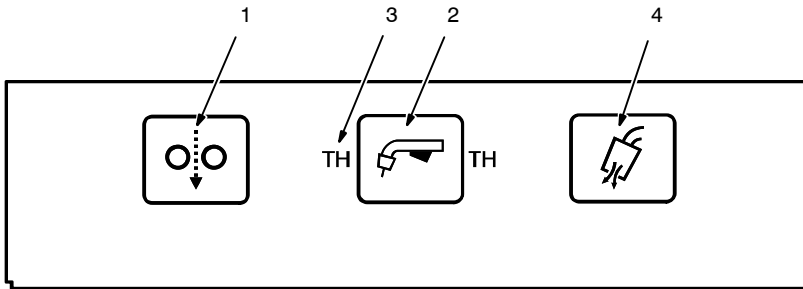
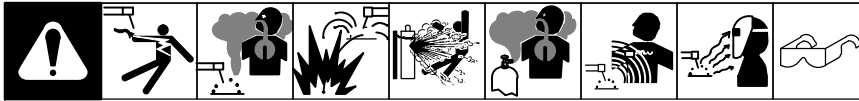
Options

Write to system- Use a USB key to update unit software and weld programs.

Write to USB- Save user created weld programs to a USB key. User settings can then be loaded on other units, or restored on the current unit.

Ref 266 061-A

6-14. Lower Panel Controls



1 Cold Wire Jog Button

Allows the operator to feed wire through gun when changing wire spools. Weld output remains off while using cold wire jog button.

2 Trigger Control Button

Allows operator to cycle through different trigger options. See Section 6-8.

3 TH Indicator

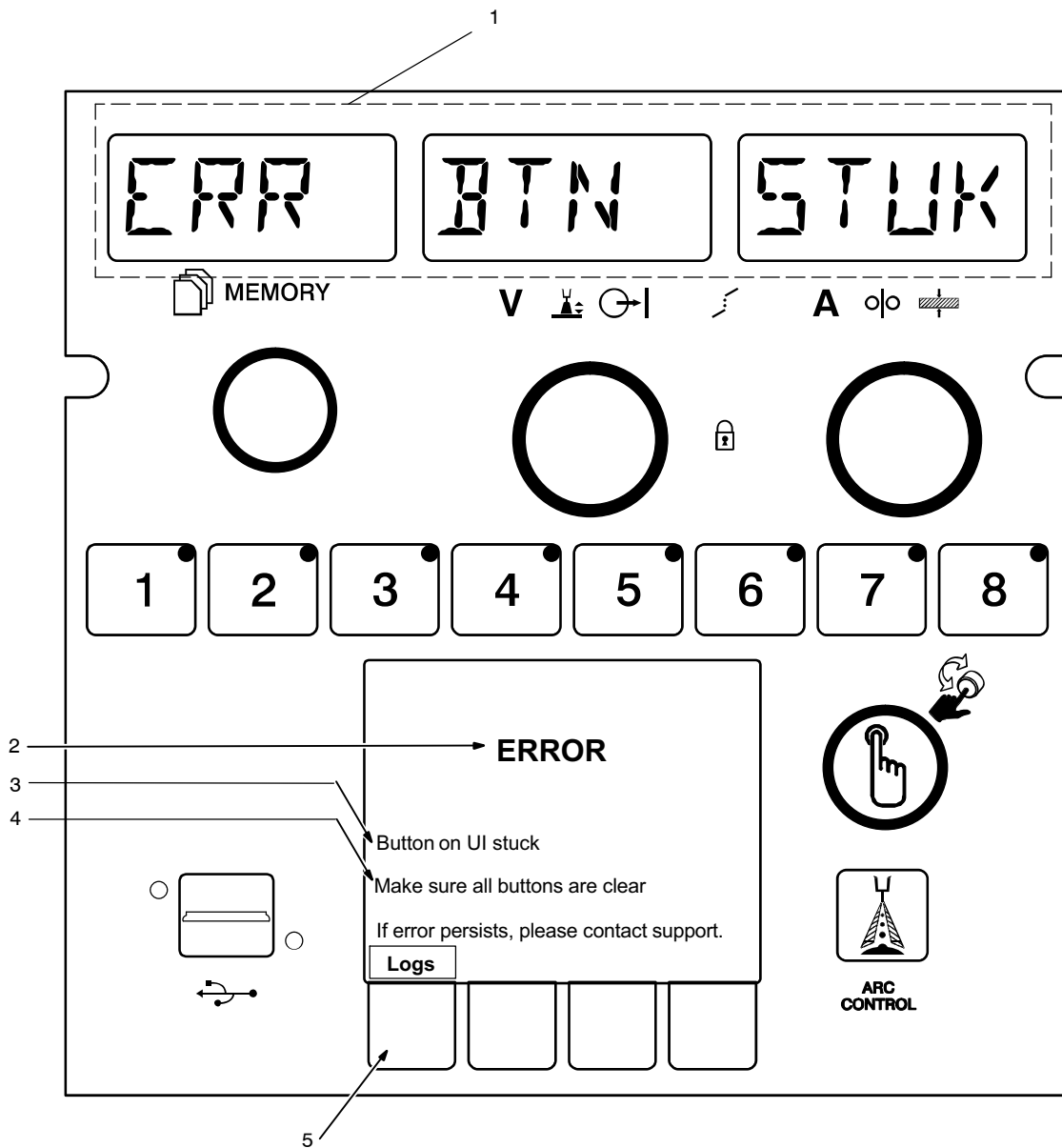
Trigger Hold (TH) allows the operator to start a welding operation by pressing the gun trigger and holding for a preset time period (see Setup Menu features). After the set time elapses the trigger latches and the operator can release the trigger and the welding operation will continue. When the operator presses and releases the trigger, the welding operation will discontinue.

4 Purge Button

Allows operator to purge gas line. To change amount of purge time (See Section 6-9).

Notes

7-2. Error Code Troubleshooting Description And Tables



Ref. 266 061-B

1 LED Display Message

Displays a short message describing the error or where the error is occurring. Some messages may represent multiple different errors. For more specific error information see the LCD Display Message.

2 Message Type

There are three types of messages that will be displayed.

ERROR- The system has experienced a fault that must be addressed before continuing use.

MESSAGE- No fault has occurred, but some action must be taken before resuming use of the welding system. For instance, input power may need to be cycled after loading new software.

WARNING- There is something that should be addressed before continuing. For instance, the volt sense lead connection has been lost.

3 LCD Display Message

Provides more information about the message being displayed.

4 LCD Solution Message

Describes the action needed to clear the message or fault being experienced.

5 Logs Soft Key

Pressing the Logs soft key will take the user to the Logs Menu (See Section 6-5). From the Logs Menu it is possible to access the Error Log. The LCD Error Log Messages are stored in the Error Log.

LED Display Message	Message Type	LCD Display Message	LCD Solution Message	LCD Error Log Message
WELD WAIT	ERROR	Unit was not ready for a weld sequence	Press button to clear error	Weld Wait Error
ERR OVERTEMP	ERROR	Welding power source has overheated	Allow unit too cool then cycle power	Overtemp Error
E STOP	ERROR	Emergency stop activated	Reset the emergency stop button	E Stop
OVER CURRENT	ERROR	Welding power source primary draw too high	Check input primary then cycle power	Primary Overcurrent
CYCLE POWER	MESSAGE	The unit requires a power cycle	Cycle power on the power source	Cycle Power Error
OVER POWER	ERROR			
SLF TST ERR	ERROR	Welder failed self test	Cycle power on the power source	Self Test Error
ERR INPT PWR	ERROR	Input Power Problem	Ensure your primary voltage is correct	Input Power Problem
ERR FDR	ERROR	Feeder Power Problem	Cycle power on the power source	Feeder Power Problem
ERR AUX PWR	ERROR	AUX Power Problem	Cycle power on the power source	AUX Power Problem
ERR THERM	ERROR	Thermal System Problem	Cycle power on the power source	Thermal System Problem
ERR PWR SRC	ERROR	Welder Power Source Problem	Cycle power on the power source	Power Source Problem
ERR WFS	ERROR	Actual WFS does not match command	Press button to clear error	Wire Speed Error
ERR STRT	ERROR	Trigger held too long without arc	Press button to clear error	Arc Start Error
ERR STOP	ERROR	Potential obstruction in wire feed system	Check wire feed and wire drive systems	Arc Stop Error
ERR GAS FLW	ERROR	No gas flow to the gun	Check gas connections	Gas Flow Error
ERR COOL FLW	ERROR	No coolant flow in water system	Check water cooling system	Coolant Flow Error
ERR GND CRNT	ERROR	Weld current detected in earth ground	Check and repair feeder weld connections	Earth Ground Current Error
ERR WIR STUK	ERROR	Wire stick to workpiece at the end of the weld	Break/Cut wire away from workpiece	Wire Stuck Error
ERR ARC	ERROR	Arc Outage occurred	Check wire feeder and power source	Arc Outage Error
ERR TRG STUK	ERROR	Trigger held during power up	Release trigger and cycle power	Trigger Stuck Error
ERR SOFTWARE	ERROR	Incompatible software detected in the system	Update software	Incompatible Software Error
ERR FEEDER	ERROR	Feeder peripheral malfunction	Cycle power on the power source	Feeder EEPROM Error
ERR FEEDER	ERROR	Feeder peripheral malfunction	Cycle power on the power source	Feeder USART1 Error
ERR COMM FDR	ERROR	Feeder Lost Comms to Arc Controller	Check the control cable	Feeder lost comms to AC
ERR FDR PWR	ERROR	Feeder power fault	Cycle power on the power source	Feeder bus overcurrent error
ERR FDR PWR	ERROR	Feeder power fault	Cycle power on the power source	Feeder bus current fault
ERR FDR RLY	ERROR	Feeder power relay stuck open	Cycle power on the power source	Feeder relay stuck open
ERR FDR ETH	ERROR	Feeder Ethernet switch malfunction	Cycle power on the power source	Feeder Ethernet switch error
ERR FEEDER	ERROR	Feeder peripheral malfunction	Cycle power on the power source	Feeder USART3 Error
ERR FEEDER	ERROR	Feeder peripheral malfunction	Cycle power on the power source	Feeder USART2 Error
ERR FEEDER	ERROR	Feeder peripheral malfunction	Cycle power on the power source	Feeder SPI2 Error

LED Display Message	Message Type	LCD Display Message	LCD Solution Message	LCD Error Log Message
ERR FDR TACH	ERROR	Feeder has lost tachometer wire speed feedback		Feeder lost tach signal error
ERR BTN STUK	ERROR	Button on UI stuck	Make sure all buttons are clear	UI Button Stuck
ERR COMM UI	ERROR	UI Lost Comms to the Sequencer	Check the control cable	UI lost comms to Seq
FACTORY RST	ERROR	Factory Reset Complete	Cycle power on the power source	Factory Reset
UNUSED 218	ERROR	Unused Error #218	Cycle power on the power source	Unused Error #218
ERR INPT PWR	ERROR	Must use three phase primary power	Check primary connections	Single Phase Error
ERR INPT PWR	ERROR	Primary input voltage too high	Check primary connections	High Input Voltage Error
ERR INPT PWR	ERROR	Primary input voltage too low	Check primary connections	Low Input Voltage Error
UNUSED 222	ERROR	Unused Error #222	Cycle power on the power source	Unused Error #222
ERR FEEDER	ERROR	Feeder input voltage too high	Cycle power on the power source	Feeder Voltage High Error
ERR FEEDER	ERROR	Feeder input voltage too low	Cycle power on the power source	Feeder Voltage Low Error
UNUSED 225	ERROR	Unused Error #225	Cycle power on the power source	Unused Error #225
ERR AUX PWR	ERROR	Too much current draw from AUX power port	Cycle power on the power source	AUX Power Overcurrent Error
ERR AUX PWR	ERROR	AUX power module overheated	Cycle power on the power source	AUX Power Overtemp Error
ERR AUX PWR	ERROR	AUX power voltage too high	Cycle power on the power source	AUX Voltage High Error
ERR AUX PWR	ERROR	AUX power voltage too low	Cycle power on the power source	AUX Voltage Low Error
UNUSED 230	ERROR	Unused Error #230	Cycle power on the power source	Unused Error #230
ERR THERM 1	ERROR	Thermistor 1 overtemp	Allow welder to cool then cycle power	THERM1 Overtemp Error
ERR THERM 2	ERROR	Thermistor 2 overtemp	Allow welder to cool then cycle power	THERM2 Overtemp Error
ERR THERM 3	ERROR	Thermistor 3 overtemp	Allow welder to cool then cycle power	THERM3 Overtemp Error
ERR THERM 1	ERROR	Thermistor 1 shorted	Cycle power on the power source	THERM1 Shorted Error
ERR THERM 2	ERROR	Thermistor 2 shorted	Cycle power on the power source	THERM2 Shorted Error
ERR THERM 3	ERROR	Thermistor 3 shorted	Cycle power on the power source	THERM3 Shorted Error
ERR THERM 1	ERROR	Thermistor 1 open	Cycle power on the power source	THERM1 Open Error
ERR THERM 2	ERROR	Thermistor 2 open	Cycle power on the power source	THERM2 Open Error
ERR THERM 3	ERROR	Thermistor 3 open	Cycle power on the power source	THERM3 Open Error
UNUSED 240	ERROR	Unused Error #240	Cycle power on the power source	Unused Error #240
ERR PWR SRC	ERROR	Invalid device configuration	Cycle power on the power source	Invalid Power Source Config
ERR PWR SRC	ERROR	Output current sensor malfunction	Cycle power on the power source	Output Current Sensor Error
ERR PWR SRC	ERROR	Inverter -15V power supply out of regulation	Cycle power on the power source	Inverter -15V Power Error
ERR PWR SRC	ERROR	Inverter +15V power supply out of regulation	Cycle power on the power source	Inverter +15V Power Error


LED Display Message	Message Type	LCD Display Message	LCD Solution Message	LCD Error Log Message
ERR PWR SRC	ERROR	Invalid inverter device configuration	Cycle power on the power source	Invalid Inverter Config
ERR PWR SRC	ERROR	Inverter primary CT error	Cycle power on the power source	Inverter Primary CT Error
ERR PWR SRC	ERROR	Boost fault	Cycle power on the power source	Boost Fault Error
ERR PWR SRC	ERROR	Boost contactor error	Cycle power on the power source	Boost Contactor Error
ERR PWR SRC	ERROR	Boost CS1 current error	Cycle power on the power source	Boost CS1 Error
ERR PWR SRC	ERROR	Boost CS2 current error	Cycle power on the power source	Boost CS2 Error
ERR PWR SRC	ERROR	Boost CS3 current error	Cycle power on the power source	Boost CS3 Error
ERR PWR SRC	ERROR	Boost CS4 current error	Cycle power on the power source	Boost CS4 Error
ERR PWR SRC	ERROR	Boost current balance error	Cycle power on the power source	Boost Current Balance Error
ERR PWR SRC	ERROR	Boost overcurrent error	Cycle power on the power source	Boost Overcurrent Error
ERR PWR SRC	ERROR	Boost precharge error	Cycle power on the power source	Boost Precharge Error
ERR PWR SRC	ERROR	Boost bus balance error	Cycle power on the power source	Boost Bus Balance Error
ERR PWR SRC	ERROR	Boost bottom bus cap voltage high	Cycle power on the power source	Boost Bottom Bus Cap V High
ERR PWR SRC	ERROR	Boost top bus cap voltage high	Cycle power on the power source	Boost Top Bus Cap V High
ERR PWR SRC	ERROR	Invalid boost device configuration	Cycle power on the power source	Invalid Boost Config
ERR PWR SRC	ERROR	Boost -15V power supply out of regulation	Cycle power on the power source	Boost -15V Power Error
ERR PWR SRC	ERROR	Boost -24V power supply out of regulation	Cycle power on the power source	Boost -24V Power Error
ERR PWR SRC	ERROR	Boost +15V power supply out of regulation	Cycle power on the power source	Boost +15V Power Error
WRN VSNS LOS	WARNING	Lost volt sense lead feedback	Inspect volt sense lead for break	Vsense Fallback Warning
ERR UNKNOWN	ERROR	An unknown error has occurred	Update software	Unknown Error

7-3. Troubleshooting

						 Disconnect power before troubleshooting
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Trouble	Remedy
Wire feeds, shielding gas flows, but electrode wire is not energized.	Check and secure weld cable connections (see Section 7-4).
Electrode wire feeding stops or feeds erratically during welding.	Check gun trigger connection. See gun Owner's Manual.
	Check gun trigger. See gun Owner's Manual.
	Readjust hub tension and drive roll pressure. See Feeder Owner's Manual.
	Change to correct size drive roll. See Feeder Owner's Manual.
	Clean or replace dirty or worn drive roll.
	Incorrect size or worn wire guides.
	Replace contact tip or liner. See gun Owner's Manual.
	Remove weld spatter or foreign matter from around nozzle opening.
	Have Factory Authorized Service Agency check drive motor or motor control board PC1.
Motor runs slowly.	Check for correct input voltage.
Wire feeder power is on, displays light up, but unit is inoperative.	Check welding gun trigger leads for continuity, and repair leads or replace gun.

SECTION 8 – ELECTRICAL DIAGRAM

	WARNING <ul style="list-style-type: none"> Do not touch live electrical parts. Disconnect input power or stop engine before servicing. Do not operate with covers removed.
	ELECTRIC SHOCK HAZARD <ul style="list-style-type: none"> Have only qualified persons install, use, or service this unit.

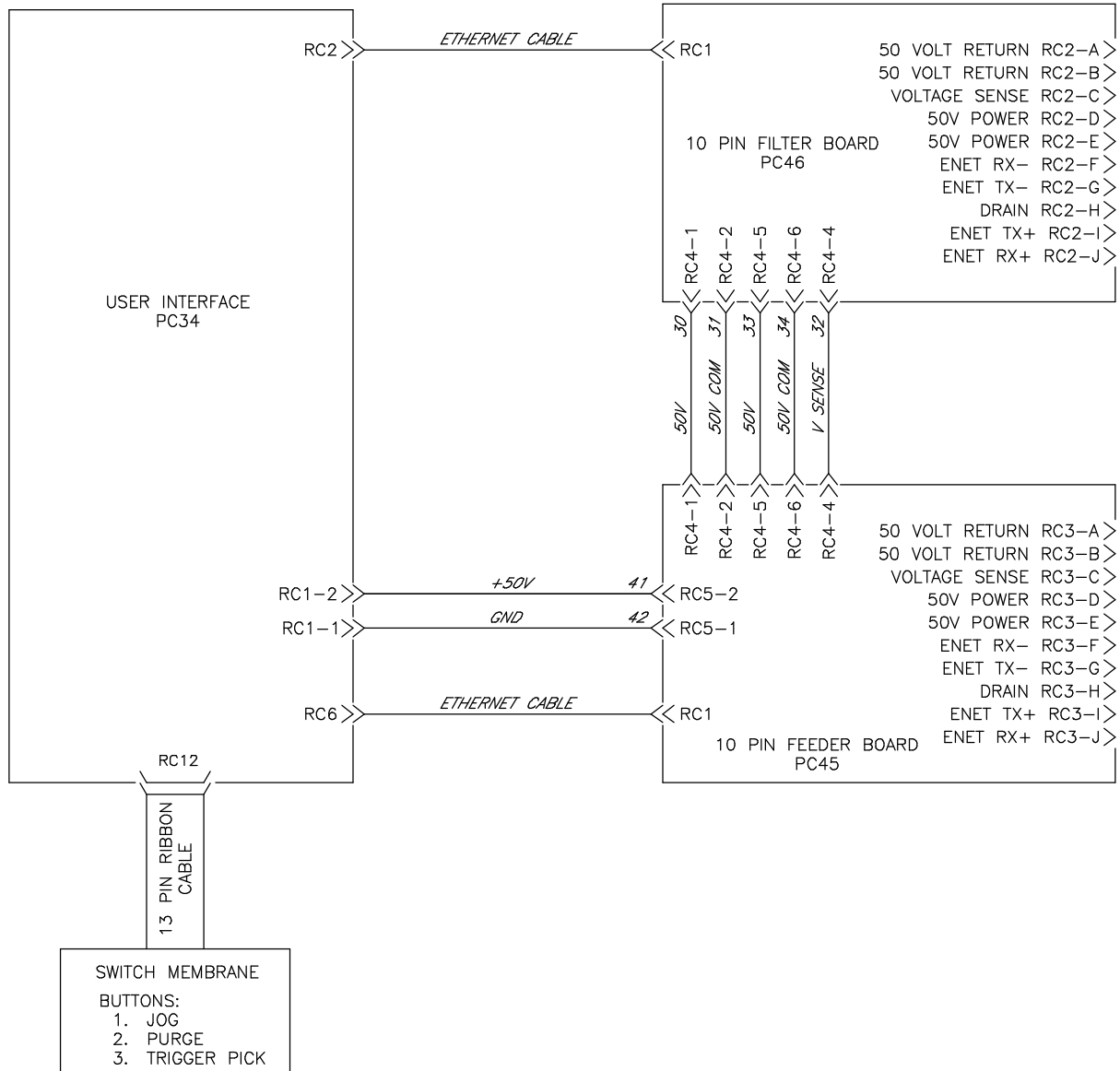

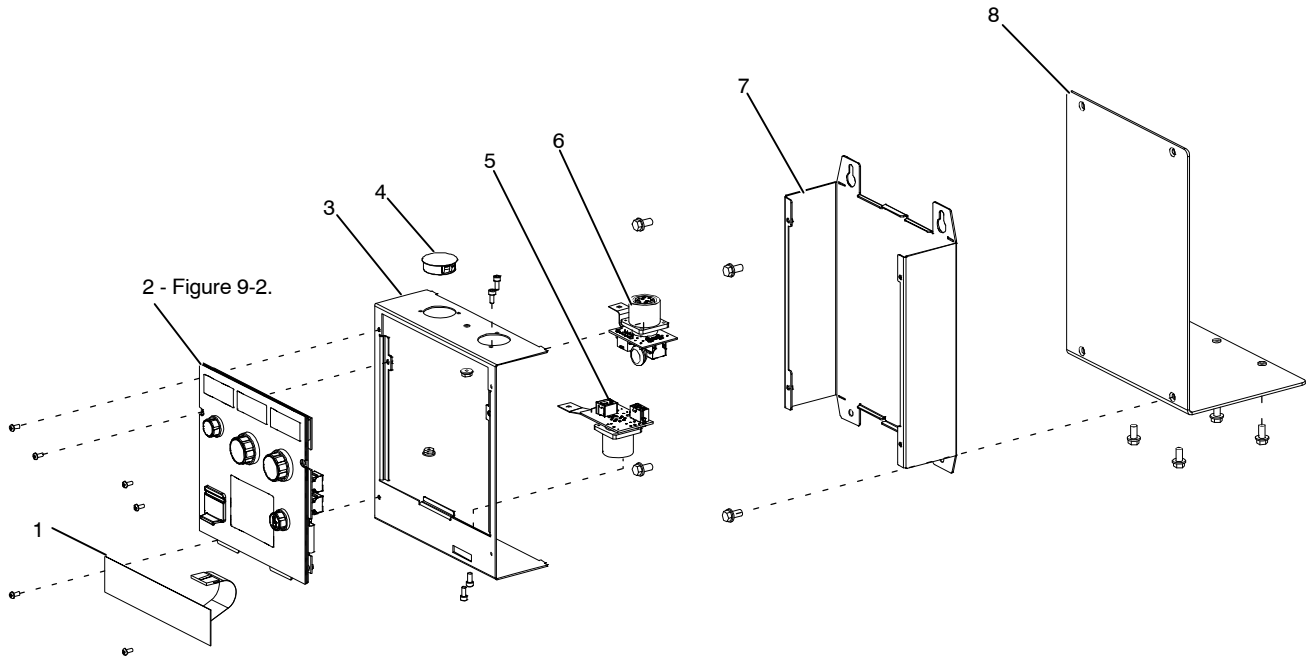


Figure 8-1. Circuit Diagram

SECTION 9 – PARTS LIST

 Hardware is common and not available unless listed.

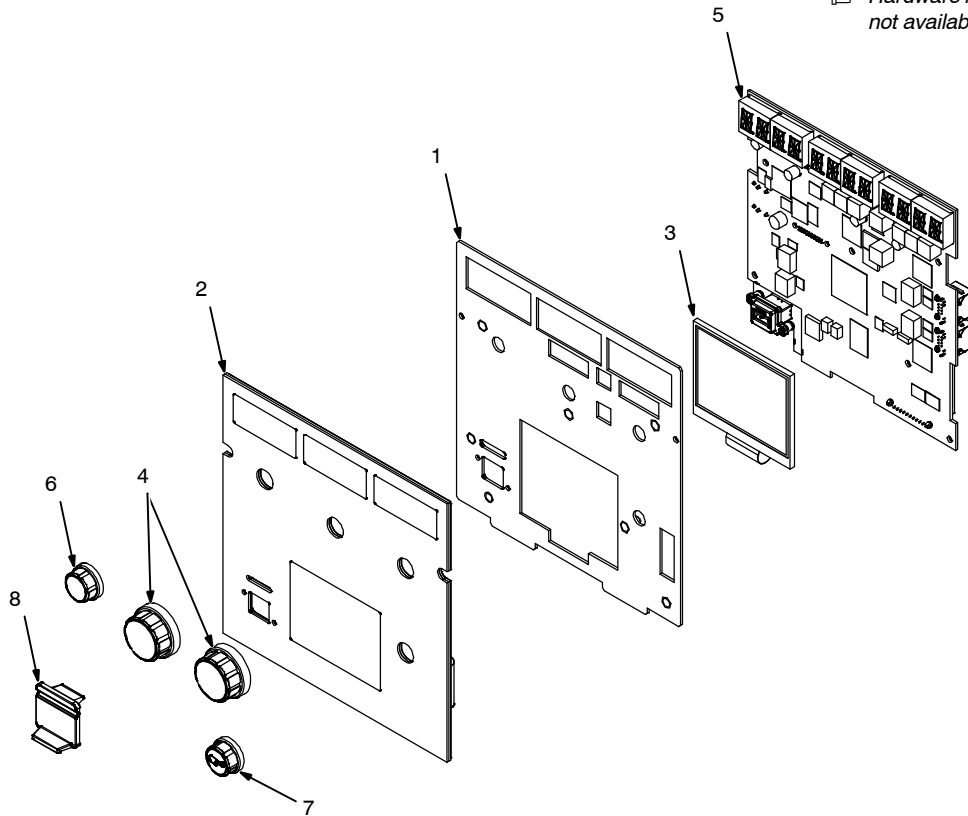


301227-TP2

Figure 9-1. Remote Operator Interface

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 9-1. Remote Operator Interface				
.. 1	..	267033	.. Membrane, Switch Control Continuum Roi	1
.. 2	..	Fig. 9-2.	.. Assy, Ui	1
.. 3	..	269635	.. Enclosure, Front Control Box Continuum	1
.. 4	..	210530	.. Blank, Snap-In Nyl 1.250 Mtg Hole Black	1
.. 5	..	262437	.. Circuit Card Assy, Feeder 10 Pin Filter	1
.. 6	..	261838	.. Circuit Card Assy, Power Source 10 Pin Filter	1
.. 7	..	269636	.. Panel, Rear Control Box Continuum	1
.. 8	..	251659	.. Bracket, Mtg Control Box Continuum	1
..	..	271079	.. Cable, Ethernet Cat6 Ftp Rj45 14.000 In Lg Right An	2
..	.. PLG4, PLG14	115092	.. Housing Plug + Skts, (Service Kit)	2
..	.. PLG21/PLG24
..	.. PLG9/PLG19	202592	.. Housing Plug + Skts, (Service Kit)	2

Hardware is common and not available unless listed.



269 786-A

Figure 9-2. User Interface

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
9-2. User Interface (Figure 9-1, Item 2)				
...	1	266072	.. Plate, Ui	1
...	2	266061	.. Membrane, Switch Control Continuum Ui	1
...	3	266189	.. Display, Lcd Tft 320x240 18bit Rgb Pc Tail	1
...	4	266591	.. Knob, Encoder 1.250 Dia X 6mm Id Push On W/Spring	2
...	5	PC34 . 272938	.. Circuit Card Assy, Ui W/Program	1
...	6	230052	.. Knob, .840 Dia X 6mm Id W/Spring Clip-4.5	1
...	7	269555	.. Knob, .840 Dia X 6mm Id W/Spring Clip-4.5 w/Print	1
...	8	267343	.. Cover, USB	1

+ When ordering a component originally displaying a precautionary label, the label should also be ordered.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

TRUE BLUE[®]

WARRANTY

Effective January 1, 2015

(Equipment with a serial number preface of MF or newer)

This limited warranty supersedes all previous Miller warranties and is exclusive with no other guarantees or warranties expressed or implied.

Warranty Questions?

Call
1-800-4-A-MILLER
for your local
Miller distributor.

Your distributor also gives
you ...

Service

You always get the fast,
reliable response you
need. Most replacement
parts can be in your
hands in 24 hours.

Support

Need fast answers to the
tough welding questions?
Contact your distributor.
The expertise of the
distributor and Miller is
there to help you, every
step of the way.

LIMITED WARRANTY – Subject to the terms and conditions below, Miller Electric Mfg. Co., Appleton, Wisconsin, warrants to its original retail purchaser that new Miller equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Miller. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Miller must be notified in writing within thirty (30) days of such defect or failure, at which time Miller will provide instructions on the warranty claim procedures to be followed. If notification is submitted as an online warranty claim, the claim must include a detailed description of the fault and the troubleshooting steps taken to identify failed components and the cause of their failure.

Miller shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the delivery date of the equipment to the original end-user purchaser, and not to exceed twelve months after the equipment is shipped to a North American distributor or eighteen months after the equipment is shipped to an International distributor.

1. 5 Years Parts — 3 Years Labor
 - * Original Main Power Rectifiers Only to Include SCRs, Diodes, and Discrete Rectifier Modules
2. 3 Years — Parts and Labor
 - * Auto-Darkening Helmet Lenses (Except Classic Series) (No Labor)
 - * Engine Driven Welder/Generators
(NOTE: Engines are Warranted Separately by the Engine Manufacturer.)
 - * Inverter Power Sources (Unless Otherwise Stated)
 - * Plasma Arc Cutting Power Sources
 - * Process Controllers
 - * Semi-Automatic and Automatic Wire Feeders
 - * Transformer/Rectifier Power Sources
3. 2 Years — Parts and Labor
 - * Auto-Darkening Helmet Lenses – Classic Series Only (No Labor)
 - * Fume Extractors – Capture 5, Filtair 400 and Industrial Collector Series
4. 1 Year — Parts and Labor Unless Specified
 - * Automatic Motion Devices
 - * CoolBelt and CoolBand Blower Unit (No Labor)
 - * Desiccant Air Dryer System
 - * External Monitoring Equipment and Sensors
 - * Field Options
(NOTE: Field options are covered for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)
 - * RFCS Foot Controls (Except RFCS-RJ45)
 - * Fume Extractors – Filtair 130, MWX and SWX Series
 - * HF Units
 - * ICE/XT Plasma Cutting Torches (No Labor)
 - * Induction Heating Power Sources, Coolers
(NOTE: Digital Recorders are Warranted Separately by the Manufacturer.)
 - * LiveArc Welding Performance Management System
 - * Load Banks
 - * Motor-Driven Guns (except Spoolmate Spoolguns)
 - * PAPR Blower Unit (No Labor)
 - * Positioners and Controllers
 - * Racks
 - * Running Gear/Trailers
 - * Spot Welders
 - * Subarc Wire Drive Assemblies
 - * Water Coolant Systems
 - * TIG Torches (No Labor)
 - * Wireless Remote Foot/Hand Controls and Receivers
 - * Work Stations/Weld Tables (No Labor)

5. 6 Months — Parts
 - * Batteries
 - * Bernard Guns (No Labor)
 - * Tregaskiss Guns (No Labor)
6. 90 Days — Parts
 - * Accessory (Kits)
 - * Canvas Covers
 - * Induction Heating Coils and Blankets, Cables, and Non-Electronic Controls
 - * M-Guns
 - * MIG Guns and Subarc (SAW) Torches
 - * Remote Controls and RFCS-RJ45
 - * Replacement Parts (No labor)
 - * Roughneck Guns
 - * Spoolmate Spoolguns

Miller's True Blue[®] Limited Warranty shall not apply to:

1. **Consumable components; such as contact tips, cutting nozzles, contactors, brushes, relays, work station table tops and welding curtains, or parts that fail due to normal wear. (Exception: brushes and relays are covered on all engine-driven products.)**
2. Items furnished by Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer's warranty, if any.
3. Equipment that has been modified by any party other than Miller, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

MILLER PRODUCTS ARE INTENDED FOR PURCHASE AND USE BY COMMERCIAL/INDUSTRIAL USERS AND PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

In the event of a warranty claim covered by this warranty, the exclusive remedies shall be, at Miller's option: (1) repair; or (2) replacement; or, where authorized in writing by Miller in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at customer's risk and expense. Miller's option of repair or replacement will be F.O.B., Factory at Appleton, Wisconsin, or F.O.B. at a Miller authorized service facility as determined by Miller. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

TO THE EXTENT PERMITTED BY LAW, THE REMEDIES PROVIDED HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES. IN NO EVENT SHALL MILLER BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT), WHETHER BASED ON CONTRACT, TORT OR ANY OTHER LEGAL THEORY.

ANY EXPRESS WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTY OR REPRESENTATION AS TO PERFORMANCE, AND ANY REMEDY FOR BREACH OF CONTRACT TORT OR ANY OTHER LEGAL THEORY WHICH, BUT FOR THIS PROVISION, MIGHT ARISE BY IMPLICATION, OPERATION OF LAW, CUSTOM OF TRADE OR COURSE OF DEALING, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE, WITH RESPECT TO ANY AND ALL EQUIPMENT FURNISHED BY MILLER IS EXCLUDED AND DISCLAIMED BY MILLER.

Some states in the U.S.A. do not allow limitations of how long an implied warranty lasts, or the exclusion of incidental, indirect, special or consequential damages, so the above limitation or exclusion may not apply to you. This warranty provides specific legal rights, and other rights may be available, but may vary from state to state.

In Canada, legislation in some provinces provides for certain additional warranties or remedies other than as stated herein, and to the extent that they may not be waived, the limitations and exclusions set out above may not apply. This Limited Warranty provides specific legal rights, and other rights may be available, but may vary from province to province.





Owner's Record

Please complete and retain with your personal records.

Model Name

Serial/Style Number

Purchase Date

(Date which equipment was delivered to original customer.)

Distributor

Address

City

State

Zip



For Service

Contact a DISTRIBUTOR or SERVICE AGENCY near you.

Always provide Model Name and Serial/Style Number.

Contact your Distributor for:

Welding Supplies and Consumables

Options and Accessories

Personal Safety Equipment

Service and Repair

Replacement Parts

Training (Schools, Videos, Books)

Technical Manuals (Servicing Information and Parts)

Circuit Diagrams

Welding Process Handbooks

To locate a Distributor or Service Agency visit www.millerwelds.com or call 1-800-4-A-Miller

Contact the Delivering Carrier to:

File a claim for loss or damage during shipment.

For assistance in filing or settling claims, contact your distributor and/or equipment manufacturer's Transportation Department.

Miller Electric Mfg. Co.

An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

International Headquarters—USA

USA Phone: 920-735-4505 Auto-Attended
USA & Canada FAX: 920-735-4134
International FAX: 920-735-4125

For International Locations Visit
www.MillerWelds.com

