



EN

Welding machine

Picomig 180 puls TKG

099-005545-EW501

20.10.2017

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General instructions

WARNING



Read the operating instructions!

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

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



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

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

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

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

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

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Dr. Günter-Henle-Straße 8

56271 Mündersbach

Germany

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The content of this document has been prepared and reviewed with all reasonable care. The information provided is subject to change; errors excepted.

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2 For your safety

2.1 Notes on the use of these operating instructions

DANGER

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

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

WARNING

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

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

CAUTION

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

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

























Special technical points which users must observe.

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

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

2.2 Explanation of icons

Symbol	Description	Symbol	Description
	Indicates technical aspects which the user must observe.		Activate and release/tap/tip
	Switch off machine		Release
	Switch on machine		Press and keep pressed
			Switch
	Wrong		Turn
	Correct		Numerical value – adjustable
	Menu entry		Signal light lights up in green
	Navigating the menu		Signal light flashes green
	Exit menu		Signal light lights up in red
	Time representation (e.g.: wait 4 s/activate)		Signal light flashes red
	Interruption in the menu display (other setting options possible)		
	Tool not required/do not use		
	Tool required/use		

2.3 Part of the complete documentation



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

The illustration shows a general example of a welding system.

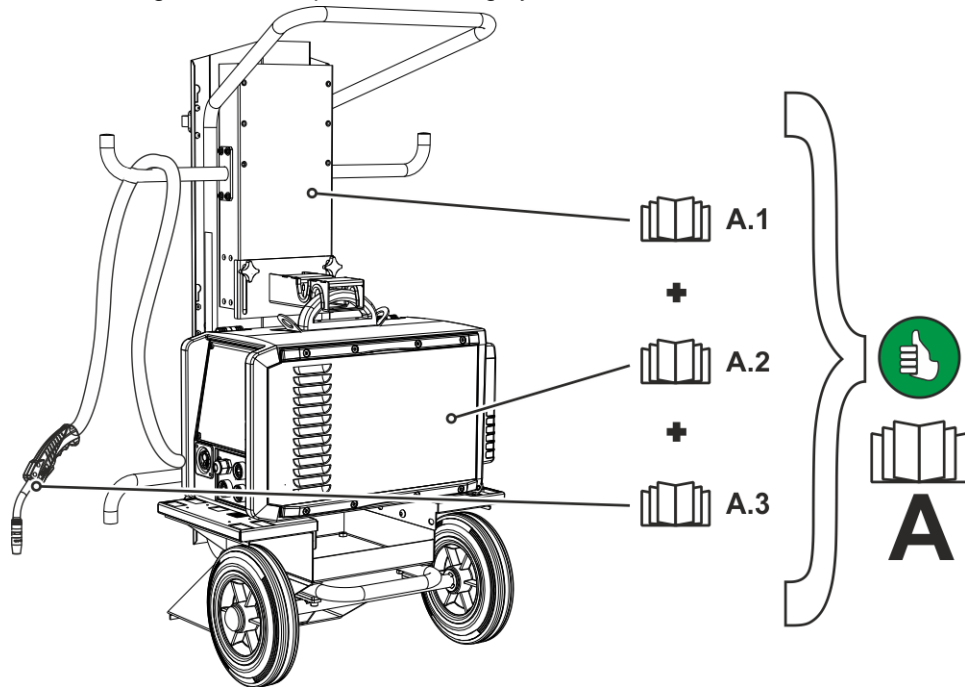


Figure 2-1

Item	Documentation
A.1	Transport cart
A.2	Power source
A.3	Welding torch
A	Complete documentation

2.4 Safety instructions

WARNING



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

Non-compliance with the safety instructions can be fatal!

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

WARNING



Risk of injury from electrical voltage!

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

- Never touch live components such as welding current sockets or stick, tungsten or wire electrodes!
- Always place torches and electrode holders on an insulated surface!
- Wear the full personal protective equipment (depending on the application)!
- The machine may only be opened by qualified personnel!



Hazard when interconnecting multiple power sources!

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

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

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



Risk of injury due to improper clothing!

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

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



Risk of injury due to radiation or heat!

Arc radiation can lead to skin and eye injuries.

Contact with hot workpieces and sparks can lead to burns.

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



Explosion risk!

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

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

⚠ WARNING**Fire hazard!**

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

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

⚠ CAUTION**Smoke and gases!**

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

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

**Noise exposure!**

Noise exceeding 70 dBA can cause permanent hearing damage!

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



According to IEC 60974-10, welding machines are divided into two classes of electromagnetic compatibility (the EMC class can be found in the Technical data) > see 8 chapter:



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



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

Setting up and operating

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

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

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

Recommendations for reducing interference emission

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

CAUTION



Electromagnetic fields!

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



- Observe the maintenance instructions > see 6.3 chapter!
- Unwind welding leads completely!
- Shield devices or equipment sensitive to radiation accordingly!
- The correct functioning of pacemakers may be affected (obtain advice from a doctor if necessary).



Obligations of the operator!

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

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



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

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



Requirements for connection to the public mains network

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

2.5 Transport and installation

WARNING



Risk of injury due to improper handling of shielding gas cylinders!
Improper handling and insufficient securing of shielding gas cylinders can cause serious injuries!

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

CAUTION



Risk of accidents due to supply lines!

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

- Disconnect all supply lines before transport!



Risk of tipping!

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

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



Risk of accidents due to incorrectly installed leads!

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

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



The units are designed for operation in an upright position!

Operation in non-permissible positions can cause equipment damage.

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



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

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



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

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

3 Intended use

WARNING



Hazards due to improper usage!

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

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

3.1 Applications

Arc welding machine for standard and pulsed gas-shielded metal-arc welding with TIG welding and lift arc (touch starting) or MMA welding as secondary process. It may be possible to expand the functionality by using accessories (see the documentation in the relevant chapter).

3.2 Documents which also apply

3.2.1 Warranty



For more information refer to the "Warranty registration" brochure supplied and our information regarding warranty, maintenance and testing at www.ewm-group.com!

3.2.2 Declaration of Conformity



The labelled machine complies with the following EC directives in terms of its design and construction:

- Low Voltage Directive (LVD)
- Electromagnetic Compatibility Directive (EMC)
- Restriction of Hazardous Substance (RoHS)

In case of unauthorised changes, improper repairs, non-compliance with specified deadlines for "Arc Welding Equipment – Inspection and Testing during Operation," and/or prohibited modifications which have not been explicitly authorised by the manufacturer, this declaration shall be voided. An original document of the specific declaration of conformity is included with every product.

3.2.3 Welding in environments with increased electrical hazards



In compliance with IEC / DIN EN 60974, VDE 0544 the machines can be used in environments with an increased electrical hazard.

3.2.4 Service documents (spare parts and circuit diagrams)

WARNING



Do not carry out any unauthorised repairs or modifications!

To avoid injury and equipment damage, the unit must only be repaired or modified by specialist, skilled persons!

The warranty becomes null and void in the event of unauthorised interference.

- Appoint only skilled persons for repair work (trained service personnel)!

Original copies of the circuit diagrams are enclosed with the unit.

Spare parts can be obtained from the relevant authorised dealer.

3.2.5 Calibration/Validation

We hereby confirm that this machine has been tested using calibrated measuring equipment, as stipulated in IEC/EN 60974, ISO/EN 17662, EN 50504, and complies with the admissible tolerances. Recommended calibration interval: 12 months

4 Machine description – quick overview

4.1 Front view

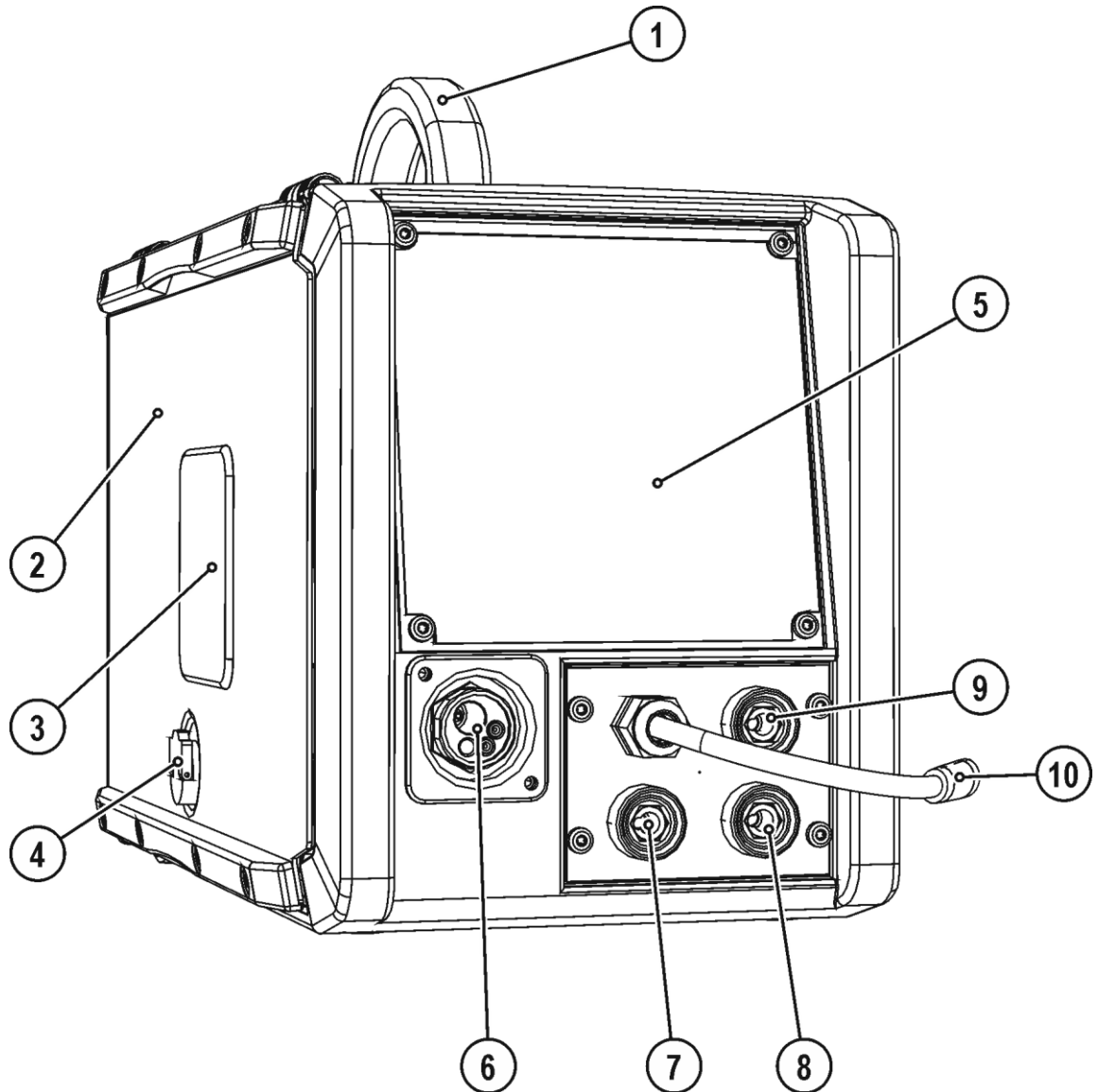




Figure 4-1

Item	Symbol	Description
1		Carrying handle
2		Protective cap Cover for the wire feed mechanism and other operating elements. Depending on the machine series, additional stickers with information on the replacement parts and JOB lists will be located on the inside.
3		Wire spool inspection window Check wire supply
4		Slide latch, lock for the protective cap
5		Machine control > see 4.4 chapter
6		Welding torch connection (Euro torch connector) Welding current, shielding gas and torch trigger integrated
7	+	Connection socket, "+" welding current <ul style="list-style-type: none"> •----- MIG/MAG cored wire welding: Workpiece connection •----- TIG welding: Workpiece connection •----- MMA welding: Workpiece connection

Item	Symbol	Description						
8		"-" welding current connection socket <ul style="list-style-type: none">•----- MIG/MAG welding: Workpiece connection•----- TIG welding: Welding current connection for welding torch•----- MMA welding: electrode holder connection						
9		Park socket, polarity selection plug Retainer for the polarity selection plug in MMA mode or for transport.						
10		Polarity selector plug, welding current cable Internal welding current cable for central connection/welding torch. Connections with: <table><tr><td>MIG/MAG</td><td>Connection socket for "+" or "-" welding current</td></tr><tr><td>TIG</td><td>Connection socket for "-" welding current</td></tr><tr><td>MMA</td><td>Park socket</td></tr></table>	MIG/MAG	Connection socket for "+" or "-" welding current	TIG	Connection socket for "-" welding current	MMA	Park socket
MIG/MAG	Connection socket for "+" or "-" welding current							
TIG	Connection socket for "-" welding current							
MMA	Park socket							

4.2 Rear view

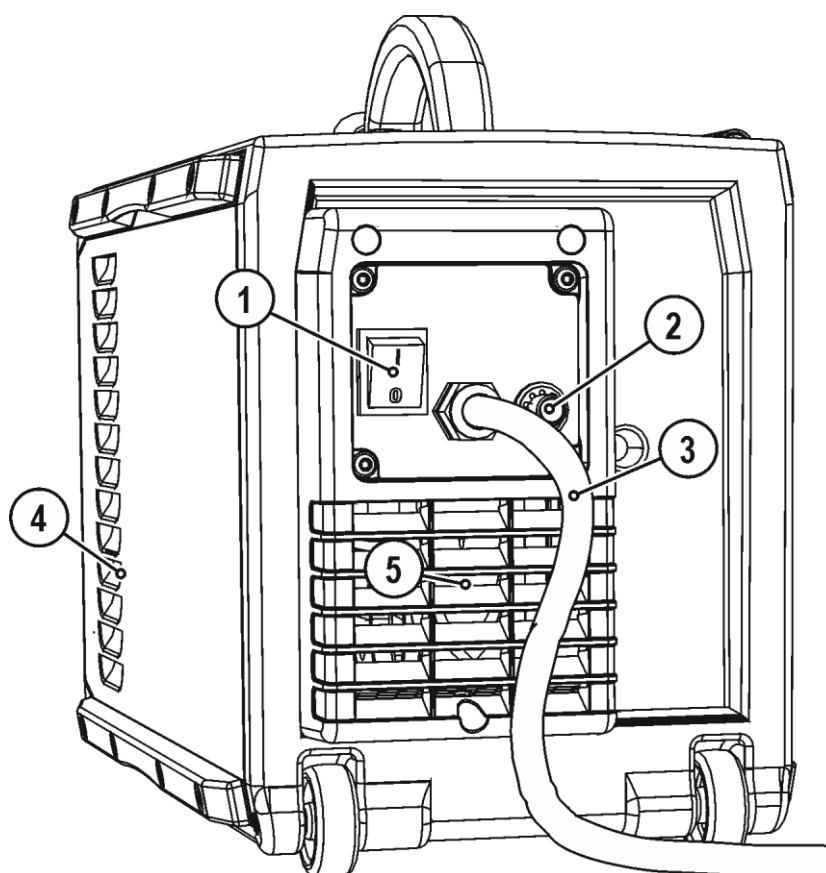




Figure 4-2

Item	Symbol	Description
1		Main switch, machine on/off
2		Connecting nipple G$\frac{1}{4}$, shielding gas connection
3		Mains connection cable with connector plug
4		Cooling air outlet
5		Cooling air inlet

4.3 Inside view

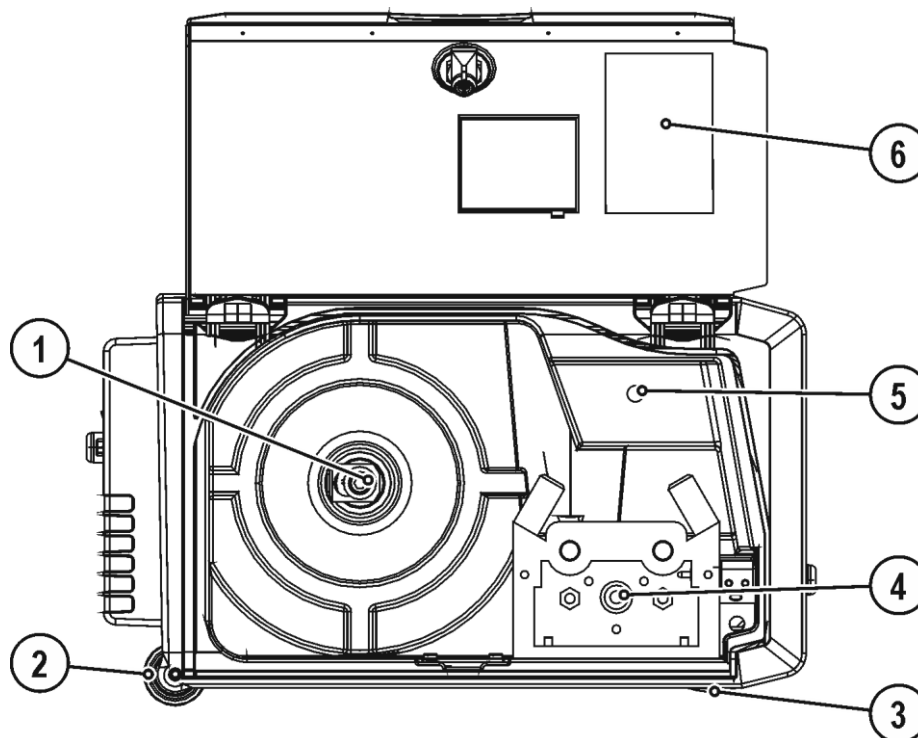



Figure 4-3

Item	Symbol	Description
1		Wire spool holder
2		Wheels
3		Machine feet
4		Wire feed unit
5		Push-button, wire inching Potential- and gas-free inching of the wire electrode through the hose package to the welding torch > see 5.3.2.4 chapter.
6		Sticker, JOB List > see 11.1 chapter

4.4 Machine control – Operating elements

The setting ranges for the parameter values are summarised in the Parameter overview section > see 12.1 chapter.

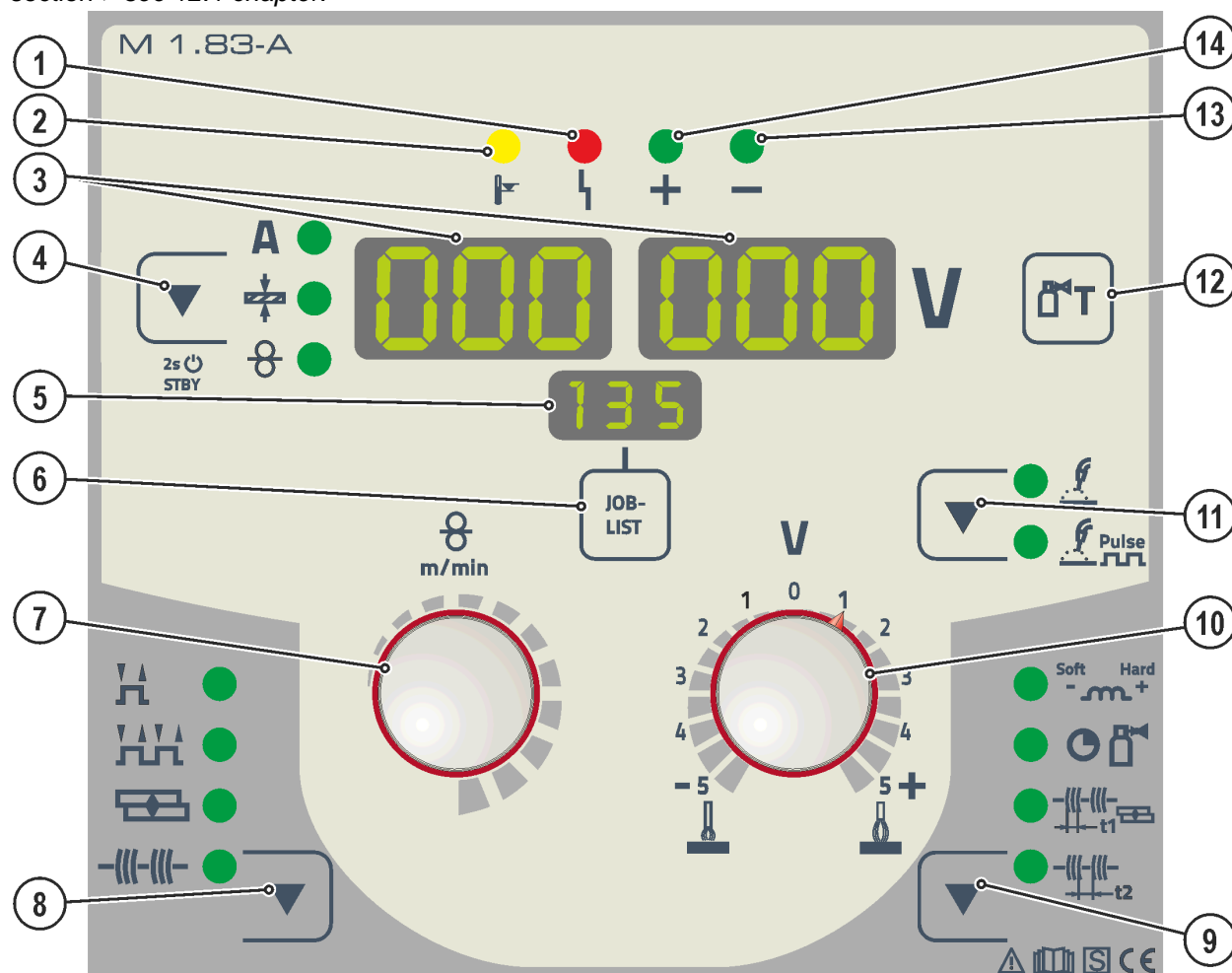
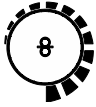



















Figure 4-4

Item	Symbol	Description
1		"Collective interference" signal light
2		"Excess temperature" signal light
3		Welding data display (3-digit) Displays the welding parameters and the corresponding values > see 5.2 chapter
4		Welding parameter display mode/power-saving mode push-button A ----- Welding current ----- Material thickness --- Wire feed speed Press for 2 s to put the machine into power-saving mode. Activate one of the operating elements to reactivate > see 5.7 chapter.
5		Display, JOB Shows the currently selected welding task (JOB number).

Item	Symbol	Description
6	JOB-LIST	Welding task push-button (JOB) Select the welding task from the welding task list (JOB-LIST). The list can be found inside the protective cap on the wire feeder and in the appendix to these operating instructions.
7		Welding parameter setting dial For setting the welding performance, for selecting the JOB (welding task) and for setting other welding parameters.
8		Operating mode button  ----- Non-latched  ---- Latched  --- Spots  ----- Interval
9		Runtime parameters button For selecting the parameters to be set. Also for entering and exiting the menus for advanced settings.  --- Choke effect/dynamics  --- Gas post-flow time  --- Spot time  --- Pause time
10		Arc length correction rotary dial
11		Welding type push-button  ----- Standard arc welding  ---- Pulsed arc welding
12		Gas test push-button > see 5.1.6.3 chapter
13		Signal light polarity setting
14		Signal light polarity setting

5 Design and function

WARNING



Risk of injury from electrical voltage!

Contact with live parts, e.g. power connections, can be fatal!

- Observe the safety information on the first pages of the operating instructions!
- Commissioning must be carried out by persons who are specifically trained in handling power sources!
- Connect connection or power cables while the machine is switched off!



Read and observe the documentation to all system and accessory components!

5.1 Transport and installation

WARNING



Risk of accident due to improper transport of machines that must not be lifted!

Do not lift or suspend the machine! The machine can drop and cause injuries! The handles, straps or brackets are suitable for transport by hand only!

- The machine must not be suspended or lifted using a crane.

5.1.1 Ambient conditions



The machine must not be operated in the open air and must only be set up and operated on a suitable, stable and level base!

- The operator must ensure that the ground is non-slip and level, and provide sufficient lighting for the place of work.
- Safe operation of the machine must be guaranteed at all times.



Unusually high quantities of dust, acid, corrosive gases or substances may damage the equipment.

- Avoid high volumes of smoke, vapour, oil vapour and grinding dust!
- Avoid ambient air containing salt (sea air)!

5.1.1.1 In operation

Temperature range of the ambient air:

- -25 °C to +40 °C

Relative air humidity:

- Up to 50% at 40 °C
- Up to 90% at 20 °C

5.1.1.2 Transport and storage

Storage in an enclosed space, temperature range of the ambient air:

- -30 °C to +70 °C

Relative air humidity

- Up to 90% at 20 °C

5.1.2 Machine cooling



Insufficient ventilation results in a reduction in performance and equipment damage.

- Observe the ambient conditions!
- Keep the cooling air inlet and outlet clear!
- Observe the minimum distance of 0.5 m from obstacles!

5.1.3 Workpiece lead, general

⚠ CAUTION



Risk of burning due to incorrect welding current connection!

If the welding current plugs (machine connections) are not locked or if the workpiece connection is contaminated (paint, corrosion), these connections and leads can heat up and cause burns when touched!

- Check welding current connections on a daily basis and lock by turning to the right when necessary.
- Clean workpiece connection thoroughly and secure properly. Do not use structural parts of the workpiece as welding current return lead!

5.1.4 Notes on the installation of welding current leads



Incorrectly installed welding current leads can cause faults in the arc (flickering).

Lay the workpiece lead and hose package of power sources without HF igniter (MIG/MAG) for as long and as close as possible in parallel.

Lay the workpiece lead and hose package of power sources with HF igniter (TIG) for as long as possible in parallel with a distance of 20 cm to avoid HF sparkover.

Always keep a distance of at least 20 cm to leads of other power sources to avoid interferences

Always keep leads as short as possible! For optimum welding results max. 30 m (welding lead + intermediate hose package + torch lead).

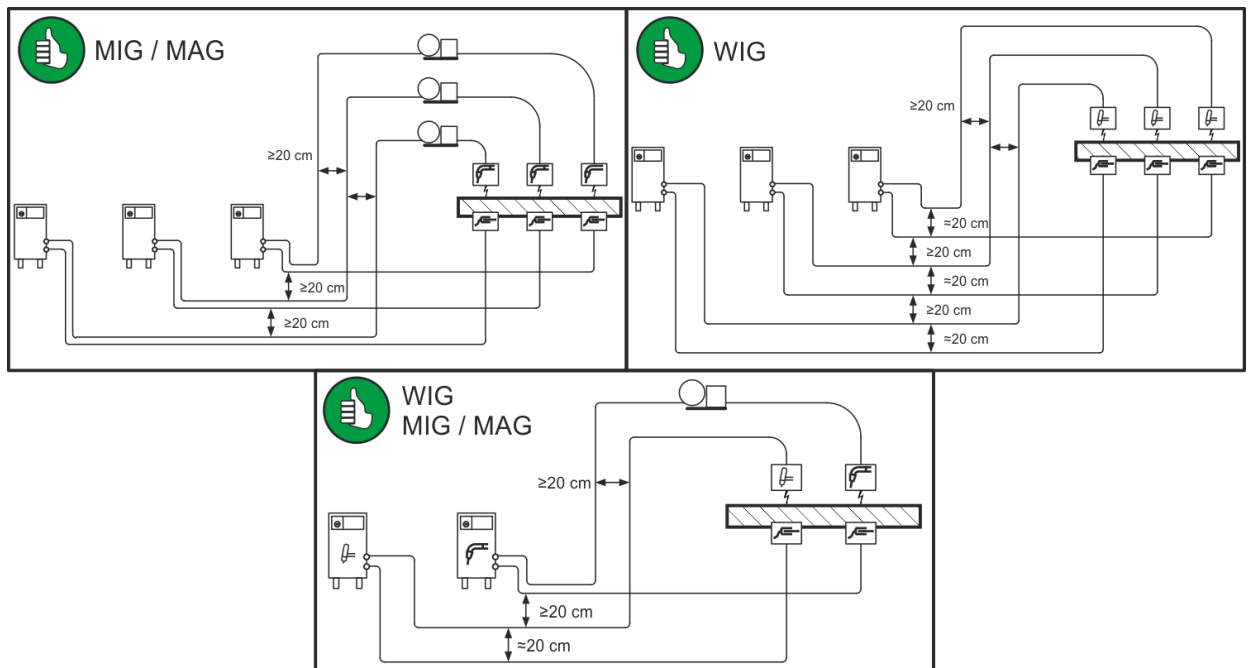


Figure 5-1



Use an individual welding lead to the workpiece for each welding machine!

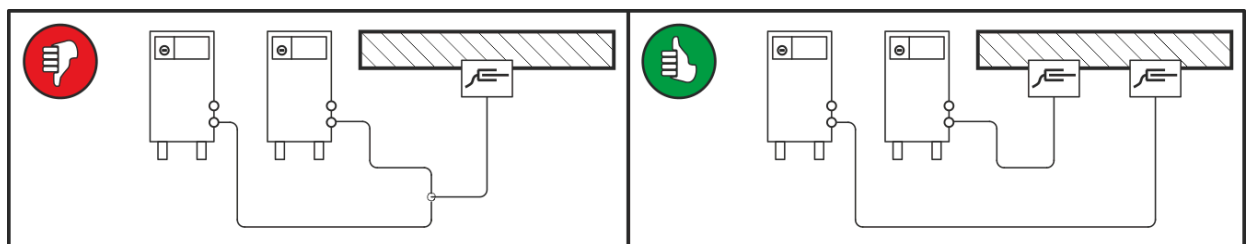


Figure 5-2

Fully unroll welding current leads, torch hose packages and intermediate hose packages. Avoid loops!

Always keep leads as short as possible!

Lay any excess cable lengths in meanders.

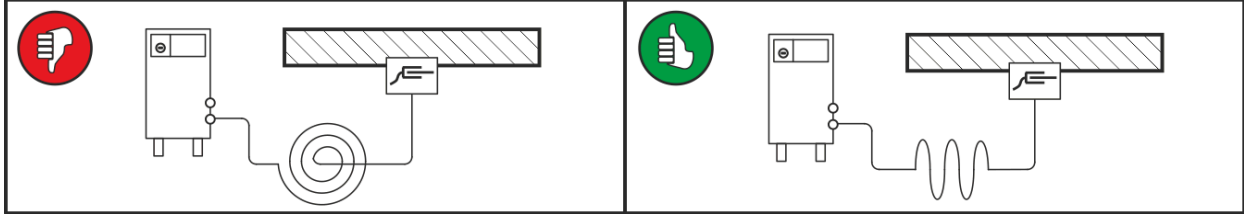


Figure 5-3

5.1.4.1 Stray welding currents

WARNING



Risk of injury due to stray welding currents!

Stray welding currents can destroy protective earth conductors, damage machines and electronic devices and cause overheating of components, leading to fire.

- Check that all welding current connections are firmly secured and electrical connections are in perfect condition.
- Set up, attach or suspend all conductive power source components such as casing, transport vehicles and crane frames so they are insulated.
- Do not place any other electronic devices such as drills or angle grinders on the power source, transport vehicle or crane frames unless they are insulated.
- Always put welding torches and electrode holders on an insulated surface when they are not in use.

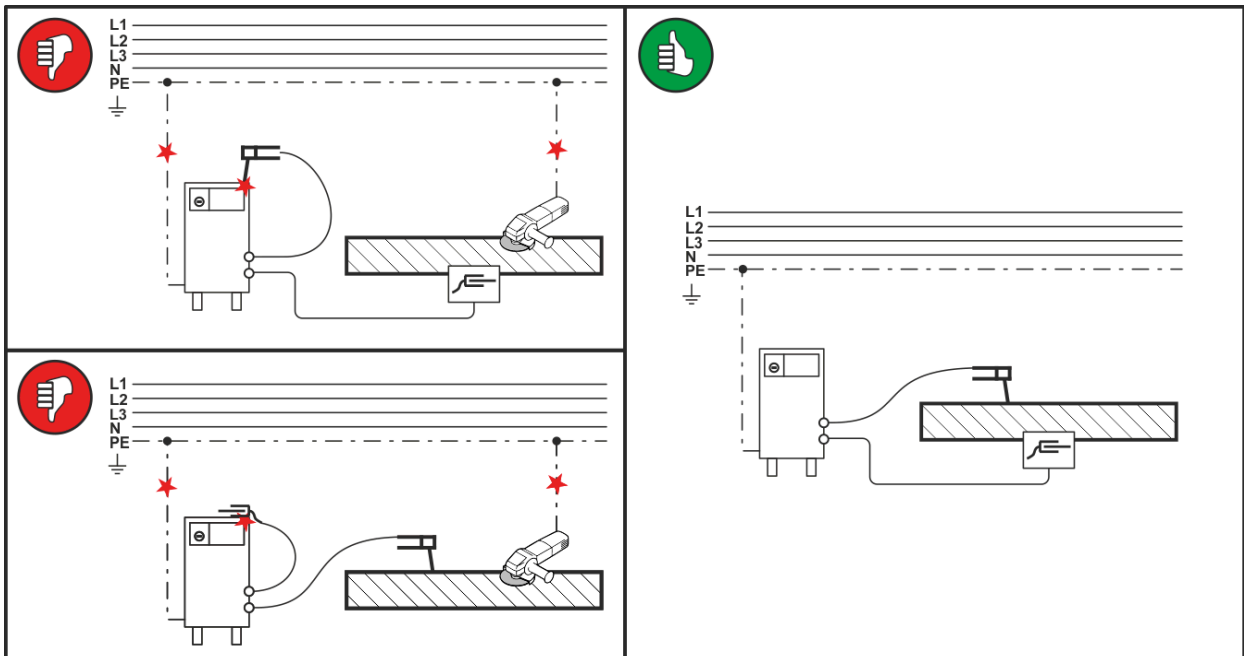


Figure 5-4

5.1.5 Mains connection

DANGER



Hazards caused by improper mains connection!

An improper mains connection can cause injuries or damage property!

- Only operate machine using a socket that has correctly fitted protective earth.
- The mains voltage indicated on the rating plate must match the supply voltage.
- If a new mains plug must be fitted, only an electrician may do so as per the relevant national legislation or regulations.
- Mains plug, socket and lead must be checked by an electrician on a regular basis.
- When operating the generator, always ensure it is earthed as stipulated in the operating instructions. The network created must be suitable for operating machines according to protection class I.

5.1.5.1 Mains configuration



The machine may only be connected to a one-phase system with two conductors and an earthed neutral conductor.

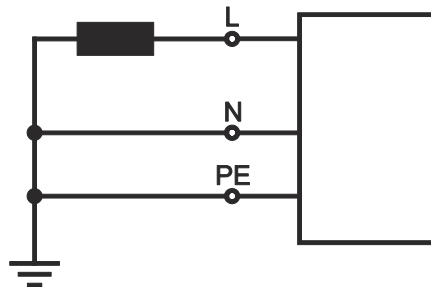


Figure 5-5

Legend

Item	Designation	Colour code
L	Outer conductor	brown
N	Neutral conductor	blue
PE	Protective conductor	green-yellow

- Insert mains plug of the switched-off machine into the appropriate socket.

5.1.6 Shielding gas supply (shielding gas cylinder for welding machine)

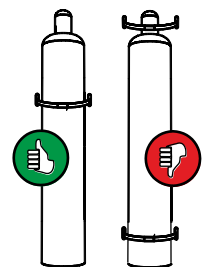
WARNING



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

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

- Place shielding gas cylinder into the designated holder and secure with fastening elements (chain/belt)!
- Attach the fastening elements within the upper half of the shielding gas cylinder!
- The fastening elements must tightly enclose the shielding gas cylinder!



An unhindered shielding gas supply from the shielding gas cylinder to the welding torch is a fundamental requirement for optimum welding results. In addition, a blocked shielding gas supply may result in the welding torch being destroyed.

- Always re-fit the yellow protective cap when not using the shielding gas connection.
- All shielding gas connections must be gas tight.

5.1.6.1 Pressure regulator connection

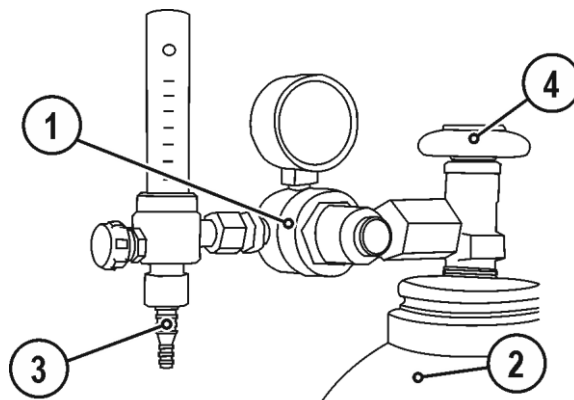


Figure 5-6

Item	Symbol	Description
1		Pressure regulator
2		Shielding gas cylinder
3		Output side of the pressure regulator
4		Cylinder valve

- Before connecting the pressure regulator to the gas cylinder, open the cylinder valve briefly to blow out any dirt.
- Tighten the pressure regulator screw connection on the gas bottle valve to be gas-tight.
- Screw gas hose connection crown nut onto the output side of the pressure regulator.

5.1.6.2 Shielding gas hose connection

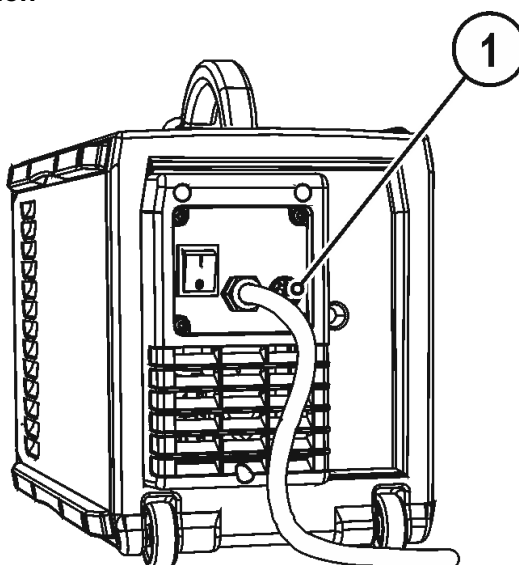



Figure 5-7

Item	Symbol	Description
1		Connecting nipple G $\frac{1}{4}$ ", shielding gas connection

- Connect crown nut of the shielding gas line to the G $\frac{1}{4}$ " connecting nipple.

5.1.6.3 Gas test – setting the shielding gas volume

If the shielding gas setting is too low or too high, this can introduce air to the weld pool and may cause pores to form. Adjust the shielding gas quantity to suit the welding task!

- Slowly open the gas cylinder valve.
- Open the pressure regulator.
- Switch on the power source at the main switch.
- Set the relevant gas quantity for the application on the pressure regulator.
- You can activate the gas test by briefly pressing the “Gas test ” push-button on the machine control (welding voltage and wire feed motor remain switched off – no unintentional ignition of the arc).

Shielding gas flows for around 25 seconds or until the button is pressed again.

Repeat rinsing process several times.

Setting instructions

Welding process	Recommended shielding gas quantity
MAG welding	Wire diameter x 11.5 = l/min
MIG brazing	Wire diameter x 11.5 = l/min
MIG welding (aluminium)	Wire diameter x 13.5 = l/min (100 % argon)
TIG	Gas nozzle diameter in mm corresponds to l/min gas throughput

Helium-rich gas mixtures require a higher gas volume!

The table below can be used to correct the gas volume calculated where necessary:

Shielding gas	Factor
75% Ar/25% He	1.14
50% Ar/50% He	1.35
25% Ar/75% He	1.75
100% He	3.16

5.2 Welding data display

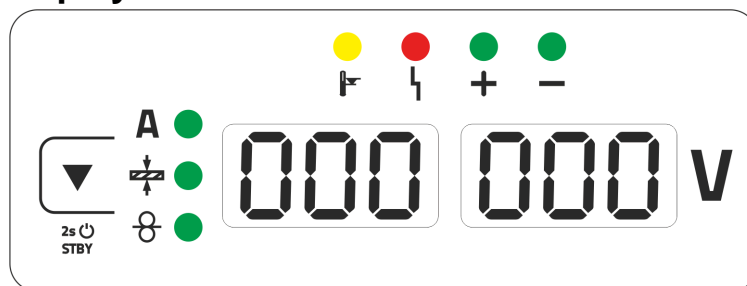


Figure 5-8

The push-button for the welding parameter display mode is next to the display.

Each time the push-button is pressed the display changes to the next parameter. After the last parameter is reached the display continues with the first parameter.

The display shows:

- Nominal values (before welding)
- Actual values (during welding)
- Hold values (after welding)

MIG/MAG

Parameter	Nominal values	Actual values	Hold values
Welding current	<input checked="" type="checkbox"/> /□ ^[1]	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Material thickness	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Wire feed speed	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Welding voltage	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

[1] traditional MIG/MAG

TIG/MMA

Parameter	Nominal values	Actual values	Hold values
Welding current	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Welding voltage	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

After the welding, the display switches from hold values to nominal values by

- pressing the push-buttons or turning the rotary knobs of the control
- waiting for about 5 seconds

5.2.1 Polarity setting

The polarity setting displays the polarity required for the selected JOB on the machine control > see 4.4 chapter. The required polarity can then be set with the polarity selection plug.

5.3 MIG/MAG welding

5.3.1 Welding torch and workpiece line connection



On delivery, the Euro torch connector is fitted with a capillary tube for welding torches with a steel liner. Conversion is necessary if a welding torch with a liner is used!

- Operate welding torches with a liner > with a guide tube.
- Operate welding torches with a steel liner > with a capillary tube.



For connection, observe the operating instructions for the welding torch.

Depending on the wire electrode diameter or type, either a steel liner or liner with the correct inner diameter must be inserted in the torch!

Recommendation:

- Use a steel liner when welding hard, unalloyed wire electrodes (steel).
- Use a chrome nickel liner when welding hard, high-alloy wire electrodes (CrNi).
- Use a plastic or teflon liner when welding or brazing soft wire electrodes, high-alloy wire electrodes or aluminium materials.

Preparation for connecting welding torches with a spiral guide:

- Check that the capillary tube is correctly positioned in relation to the central connector!

Preparation for connecting welding torches with a liner:

- Push forward the capillary tube on the wire feed side in the direction of the Euro torch connector and remove it there.
- Insert the liner guide tube from the Euro torch connector side.
- Carefully insert the welding torch connector with as yet too long a liner into the Euro torch connector and secure with a crown nut.
- Cut off the liner with a liner cutter > see 9 chapter just before the wire feed roller.
- Loosen the welding torch connector and remove.
- Carefully chamfer the cut off end of the liner with a liner sharpener > see 9 chapter and sharpen.



Some wire electrodes (e.g. self-shielding cored wire) are welded using negative polarity. In this case, the welding current lead should be connected to the "-" welding current socket, and the workpiece lead should be connected to the "+" welding current socket. Observe the information from the electrode manufacturer!



Choose welding current connection socket according to the signal light for the polarity setting!

- Select **JOB** > see 5.3.4 chapter
- Polarity selection “+” or polarity selection “-” signal lights show the polarity setting.

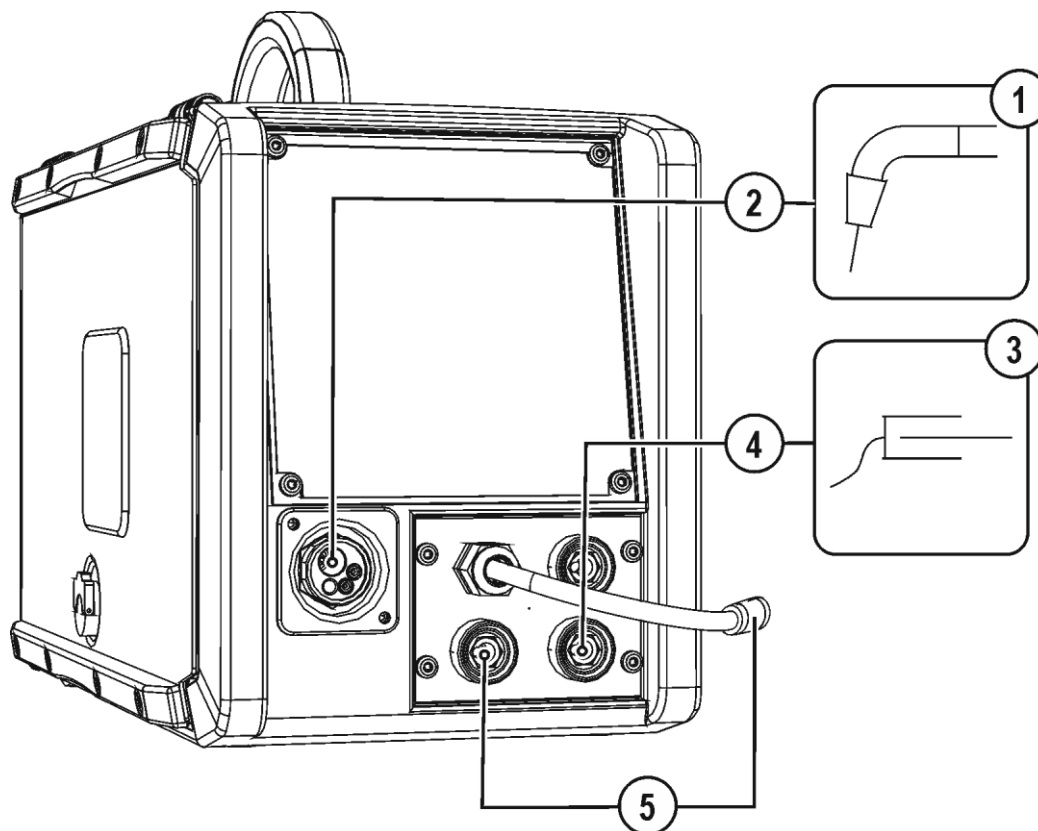







Figure 5-9

Item	Symbol	Description
1		Welding torch
2		Welding torch connection (Euro torch connector) Welding current, shielding gas and torch trigger integrated
3		Workpiece
4		"-" welding current connection socket • ----- MIG/MAG welding: Workpiece connection
5		Polarity selector plug, welding current cable Internal welding current cable for central connection/welding torch. • ----- Connection socket for "+" welding current

- Insert the central plug for the welding torch into the central connector and screw together with crown nut.
- Insert the plug of the workpiece lead in the respective welding current connection socket and lock in place by turning to the right.
- Insert the polarity selection plug in the respective welding current connection socket and lock in place by turning to the right.

5.3.2 Wire feed

⚠ CAUTION**Risk of injury due to moving parts!**

The wire feeders are equipped with moving parts, which can trap hands, hair, clothing or tools and thus injure persons!

- Do not reach into rotating or moving parts or drive components!
- Keep casing covers or protective caps closed during operation!

**Risk of injury due to welding wire escaping in an unpredictable manner!**

Welding wire can be conveyed at very high speeds and, if conveyed incorrectly, may escape in an uncontrolled manner and injure persons!

- Before mains connection, set up the complete wire guide system from the wire spool to the welding torch!
- Check wire guide at regular intervals!
- Keep all casing covers or protective caps closed during operation!

5.3.2.1 Open the protective flap of the wire feeder



To perform the following steps, the protective flap of the wire feeder needs to be opened. Make sure to close the protective flap again before starting to work.

- Unlock and open protective flap.

5.3.2.2 Inserting the wire spool

⚠ CAUTION**Risk of injury due to incorrectly secured wire spool.**

If the wire spool is not secured properly, it may come loose from the wire spool support and fall to the ground, causing damage to the machine and injuries.

- Make sure to correctly fasten the wire spool to the wire spool support.
- Before you start working, always check the wire spool is securely fastened.

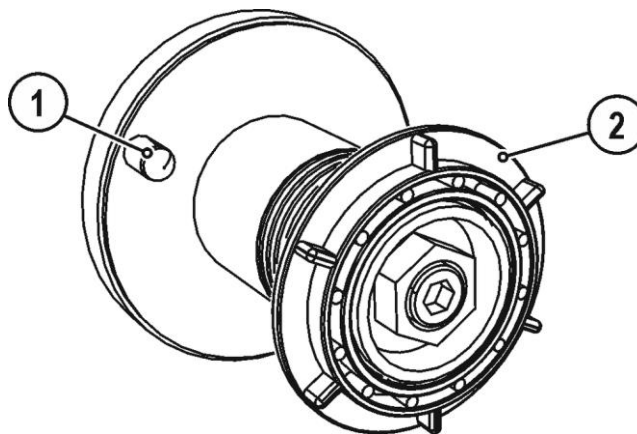


Figure 5-10

Item	Symbol	Description
1		Carrier pin For fixing the wire spool
2		Knurled nut For fixing the wire spool

- Loosen knurled nut from spool holder.
- Fix welding wire reel onto the spool holder so that the carrier pin locks into the spool bore.
- Fasten wire spool using knurled nut.

5.3.2.3 Changing the wire feed rollers



Unsatisfactory welding results due to faulty wire feeding! Wire feed rollers must be suitable for the diameter of the wire and the material.

- **Check the roller label to verify that the rollers are suitable for the wire diameter. Turn or change if necessary!**
- **use V-groove rollers with for steel wires and other hard wires,**
- **use U-groove rollers for aluminium wires and other soft, alloyed wires.**
- Slide new drive rollers into place so that the diameter of the wire used is visible on the drive roller.
- Screw the drive rollers in place with knurled screws.

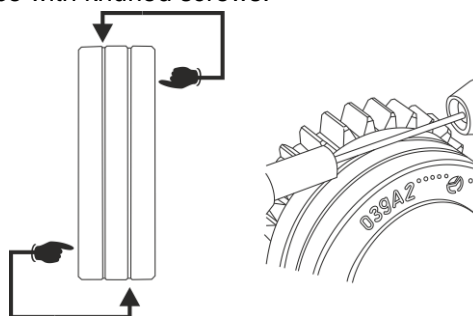


Figure 5-11

5.3.2.4 Inching the wire electrode

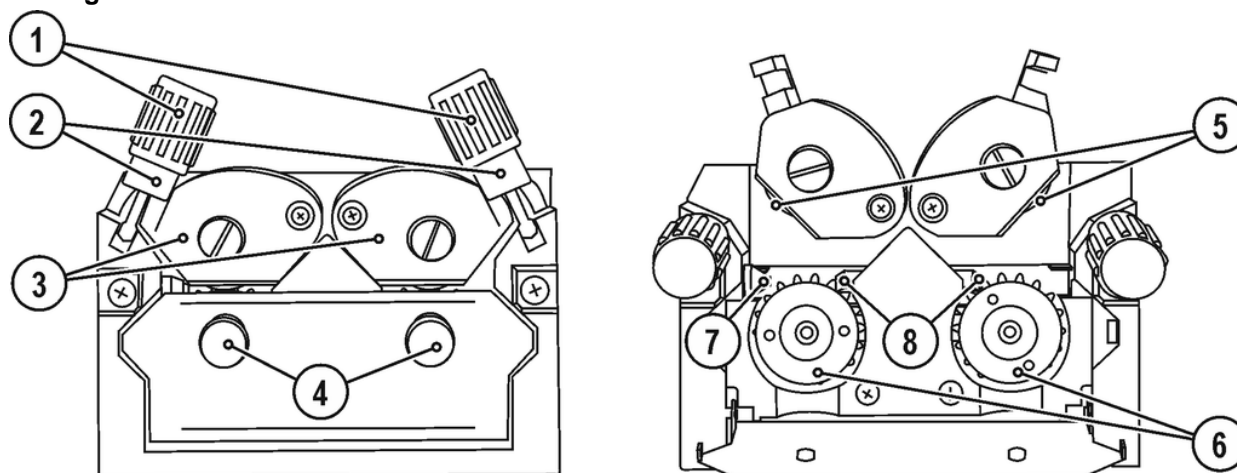


Figure 5-12

Item	Symbol	Description
1		Adjusting nut
2		Feed roll tensioner Fixing the clamping unit and setting the pressure.
3		Clamping unit
4		Knurled screw
5		Pressure roller
6		Drive roller
7		Wire feed nipple
8		Guide tube

- Extend and lay out the torch hose package.
- Unfasten pressure units and fold out (clamping units and pressure rollers will automatically flip upwards).
- Unwind welding wire carefully from the wire spool and insert through the wire inlet nipple over the drive roller grooves and the guide pipe into the capillary tube and Teflon core using guide pipe.
- Press the clamping element with the pressure roller back downwards and fold the wire units back up again (wire electrode should be in the groove on the drive roller).
- Set the contact pressure with the adjusting nuts of the pressure unit.
- Press the wire inching button until the wire electrode projects out of the welding torch.

5.3.2.5 Spool brake setting

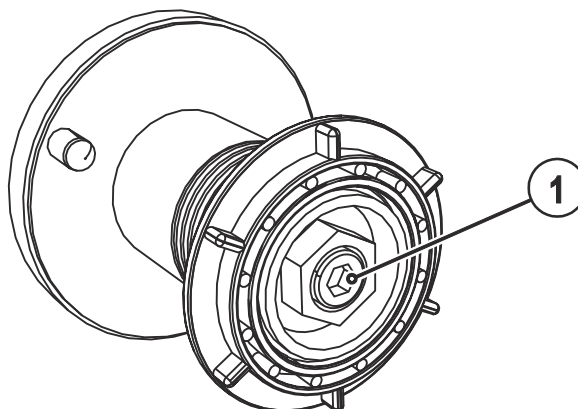


Figure 5-13

Item	Symbol	Description
1		Allen screw Securing the wire spool retainer and adjustment of the spool brake

- Tighten the Allen screw (8 mm) in the clockwise direction to increase the braking effect.



Tighten the spool brake until the wire spool no longer turns when the wire feed motor stops but without it jamming during operation!

5.3.3 Definition of MIG/MAG welding tasks

This machine range features simple operation with a very wide range of functions.

- JOBs (welding tasks consisting of welding process, type of material, wire diameter and type of shielding gas) are pre-defined for all common welding tasks.
- Simple JOB selection from a list of pre-defined JOBs (sticker on the machine).
- The required process parameters are calculated by the system depending on the operating point specified (single-dial operation via wire speed rotary dial).
- Conventional welding task definition using wire speed and welding voltage is also possible.



The welding task definition described below applies when defining MIG/MAG and cored wire welding tasks.



Pay attention to the signal light for the polarity setting!

It may be necessary to change the welding current polarity depending on the JOB selected or the welding process.

- ***Reconnect the polarity selection plug if necessary.***

5.3.4 Welding task selection

The settings for the respective welding parameters are defined by the different JOBs. The right JOB can be determined quickly with the JOB list > see 11.1 chapter.

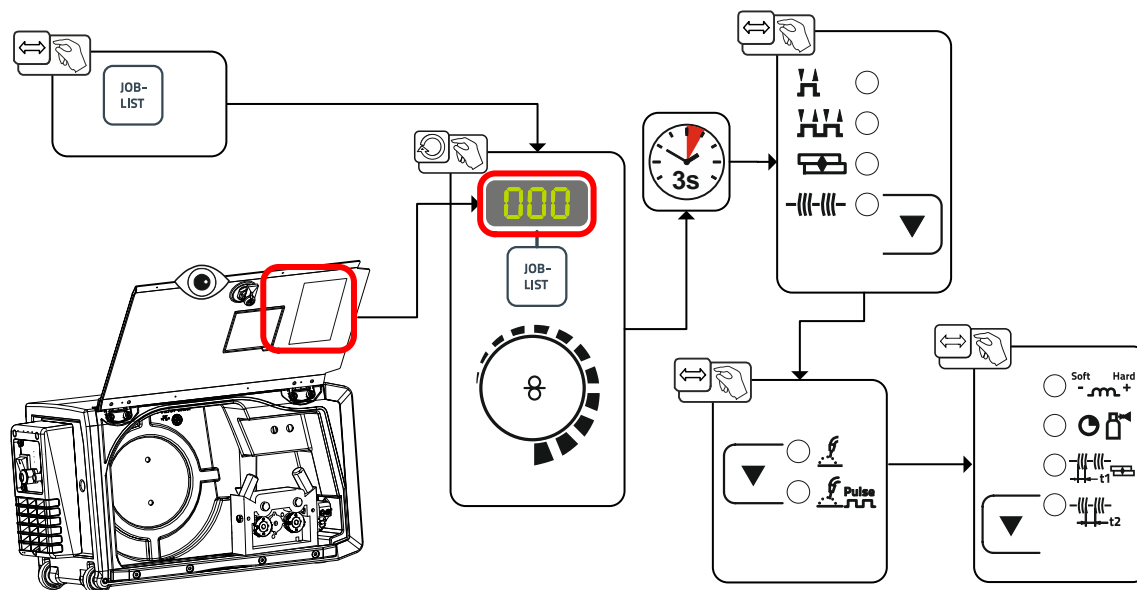


Figure 5-14



Validity of the settings.

Spot time, pause time and wire feed speed settings apply to all JOBs. Throttling effect/dynamics, gas post-flow time, gas pre-flow time and wire burn-back correction are stored for each JOB individually.

Changes are stored permanently in the JOB that is currently selected.

If required, these parameter values can be reset to the factory settings > see 7.3 chapter.

5.3.5 MIG/MAG operating point

5.3.5.1 Selecting the welding parameter display mode

The operating point (welding power) can be displayed or set as the welding current, material thickness or wire speed.

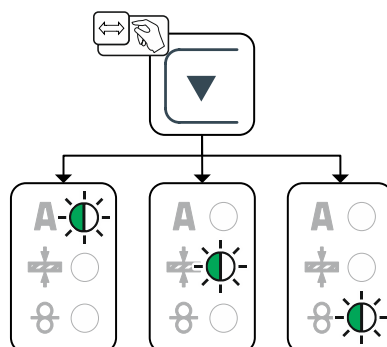


Figure 5-15

5.3.5.2 Operating point setting using material thickness



Automatic display mode switching:

If the wire speed or the voltage is changed, the display will switch briefly to show the respective parameter. This means that you don't have to change the display mode before setting the parameter.

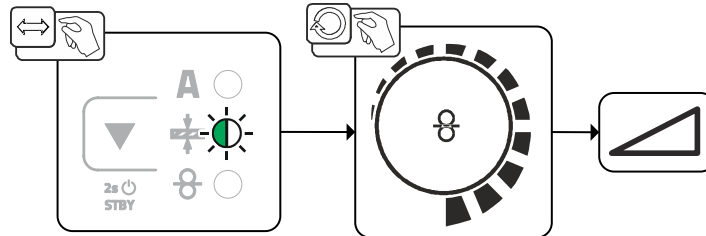


Figure 5-16

5.3.5.3 Arc length correction setting

Setting range: -5 V to +5 V

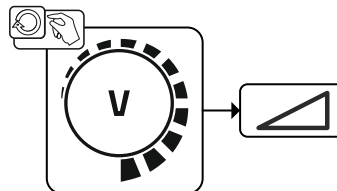


Figure 5-17



The basic settings are now completed. Other welding parameters have already been set optimally in the factory; they can, however, be modified to suit individual requirements.

5.3.6 Further welding parameters

- Preselection: Select a MIG/MAG JOB > see 5.3.4 chapter.

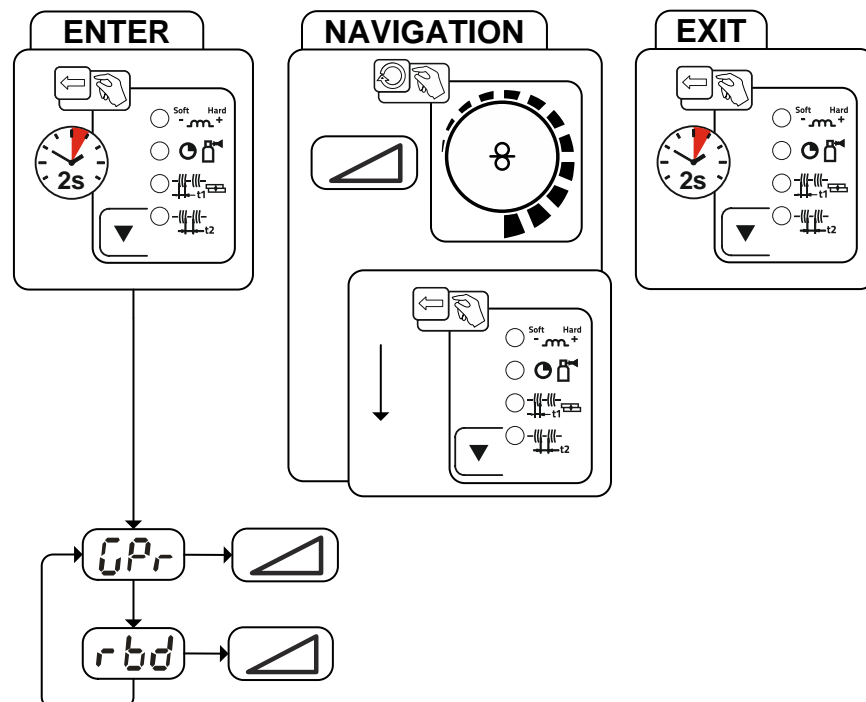
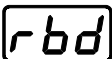













Figure 5-18

Display	Setting/selection
	Gas pre-flow time

Display	Setting/selection
	Burn-back correction

5.3.7 Operating modes (functional sequences)

5.3.7.1 Explanation of signs and functions

Symbol	Meaning
	Press torch trigger
	Release torch trigger
	Shielding gas flowing
	Welding output
	Wire electrode is being conveyed
	Wire creep
	Wire burn-back
	Gas pre-flows
	Gas post-flows
	Non-latched
	Latched
t	Time
t₁	Spot time
t₂	Pause time

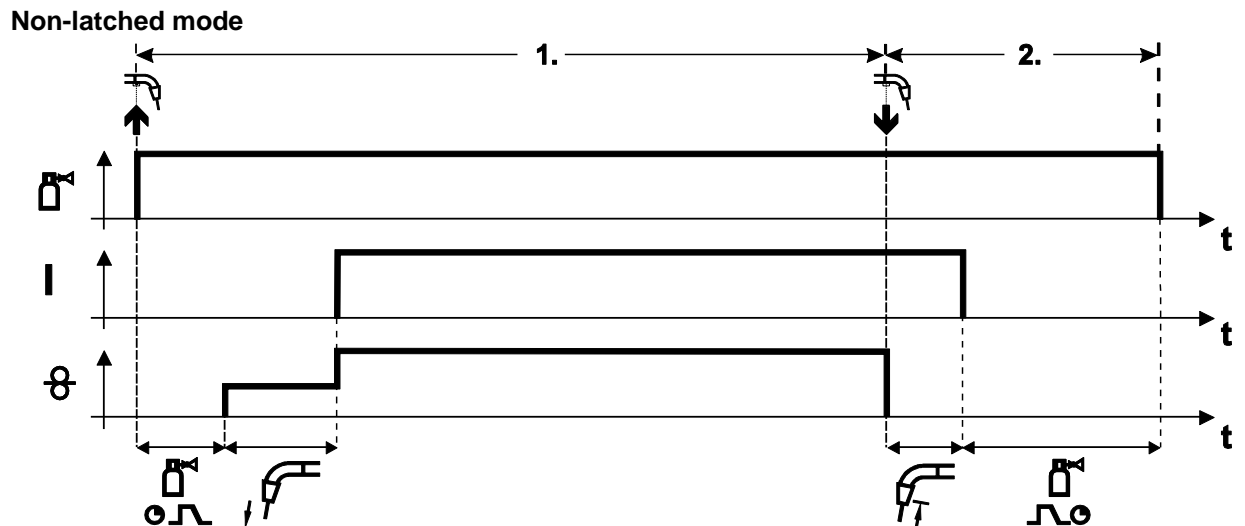


Figure 5-19

Step 1

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

Step 2

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

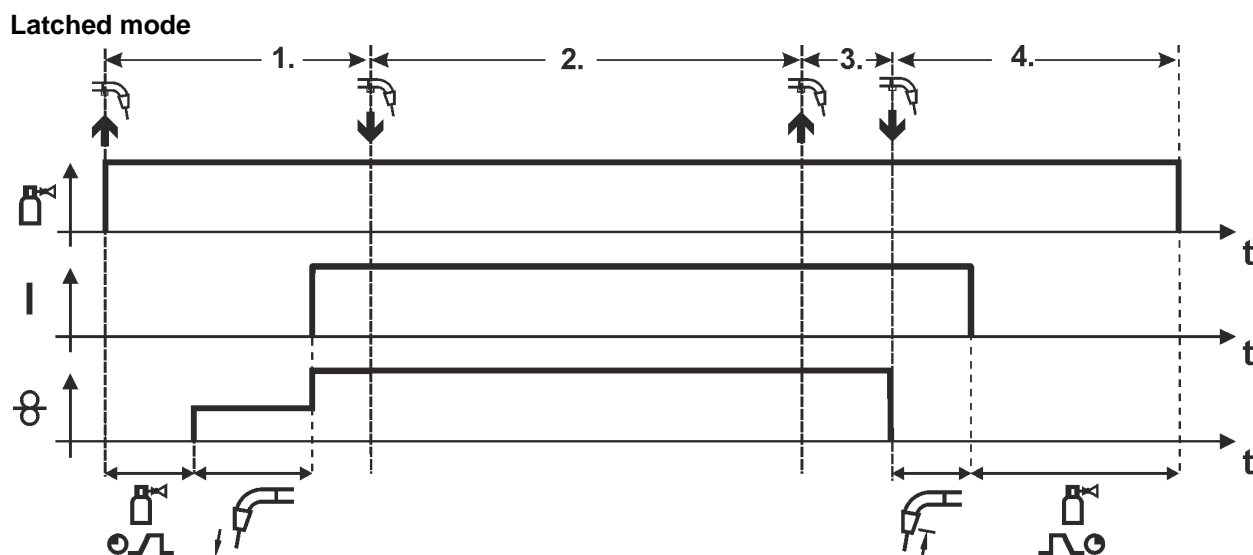


Figure 5-20

1. cycle

- Press and hold torch trigger
- Shielding gas is expelled (gas pre-flows)
- Wire feed motor runs at "creep speed"
- Arc ignites when the wire electrode makes contact with the workpiece
Welding current flows
- Wire feed speed increases to the set nominal value

2. cycle

- Release torch trigger (no effect)

3. cycle

- Press torch trigger (no effect)

4. cycle

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

Spot welding

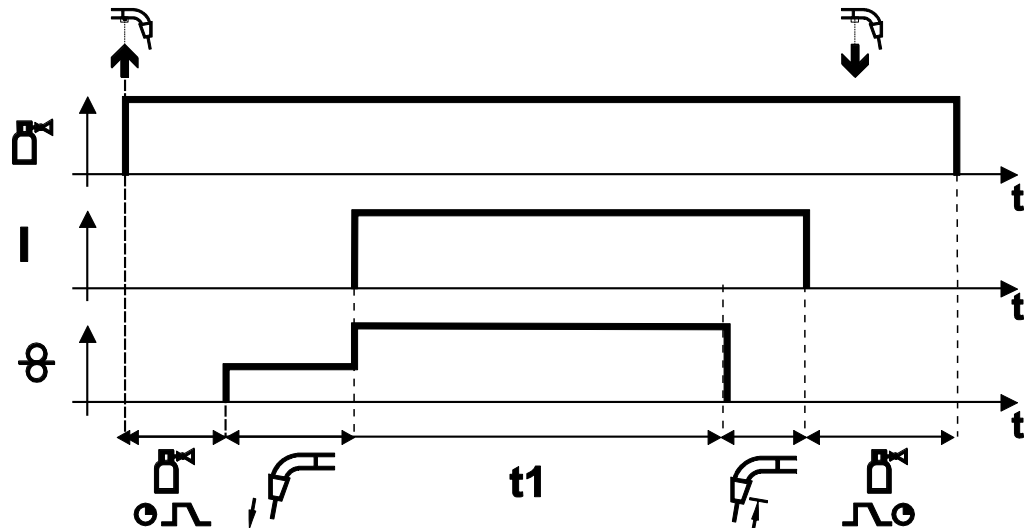


Figure 5-21

Start

- Press and hold torch trigger.
- Shielding gas is expelled (gas pre-flows).
- Arc ignites after the wire electrode makes contact with the workpiece at creep speed.
- Welding current flows.
- Wire feed speed increases to the set nominal value.
- The wire feed stop welding after the spot time elapses.
- Arc is extinguished after the wire burn-back time elapses.
- Gas post-flow time elapses.

Premature termination

- Release torch trigger.

Interval

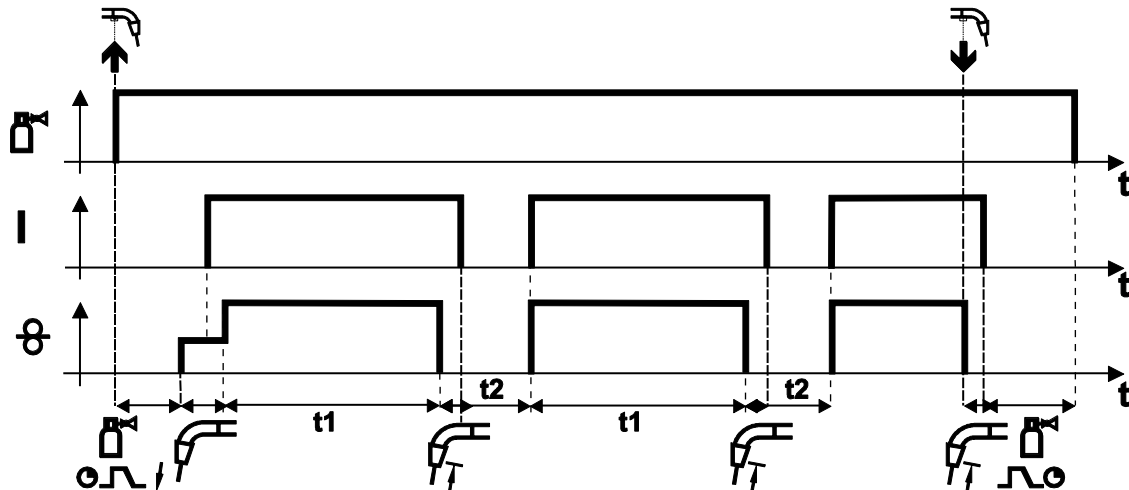


Figure 5-22

Start

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

Sequence

- Arc ignites after the wire electrode makes contact with the workpiece at creep speed.
- Welding current flows.
- Wire feed speed increases to the set nominal value.
- The wire feed stops after the spot time elapses.
- Arc is extinguished after the wire burn-back time elapses.
- The process is repeated when the pause time is over.

End

- Release torch trigger, wire feed stops, arc is extinguished, gas post-flow time elapses.

If the pause time is less than 3 s, wire creep only takes place in the first spot phase.

When the torch trigger is released, the welding process is also ended even before the spot time elapses.

5.3.8 Conventional MIG/MAG Welding (GMAW non synergic)



You can only change the JOB number when no welding current is flowing.

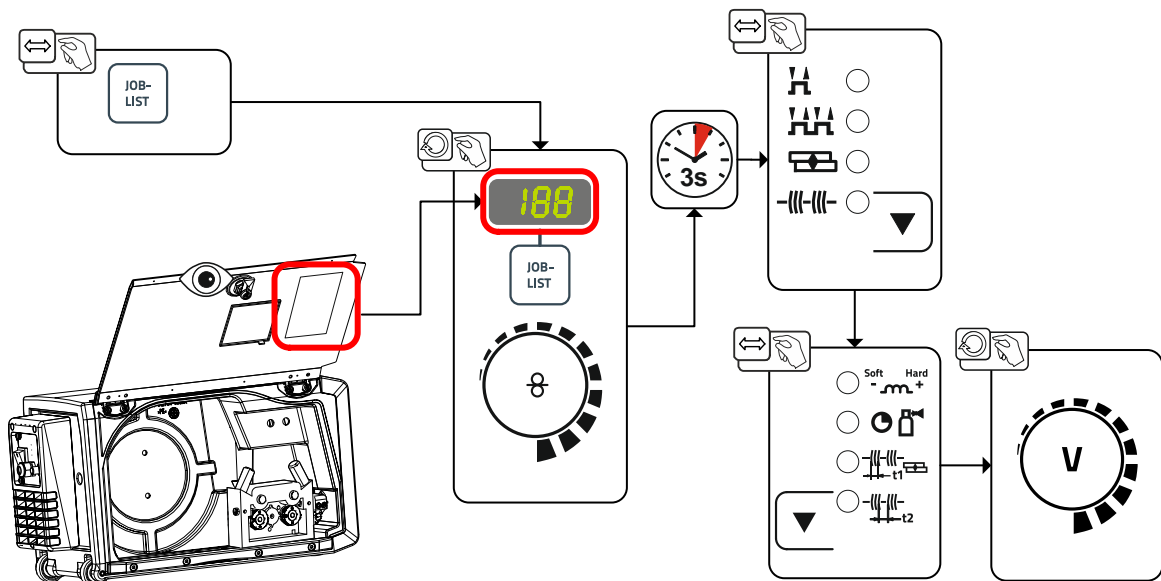


Figure 5-23

5.3.9 MIG/MAG automatic cut-out



The welding machine ends the ignition process or the welding process with an

- *Ignition fault (no welding current flows within 5 s after the start signal).*
- *Arc interruption (arc is interrupted for longer than 3 s).*

5.4 MMA welding

⚠ CAUTION



Risk of crushing and burns!

When changing stick electrodes there is a risk of crushing and burns!

- Wear appropriate and dry protective gloves.
- Use an insulated pair of tongs to remove the used stick electrode or to move welded workpieces.

5.4.1 Connecting the electrode holder and workpiece lead

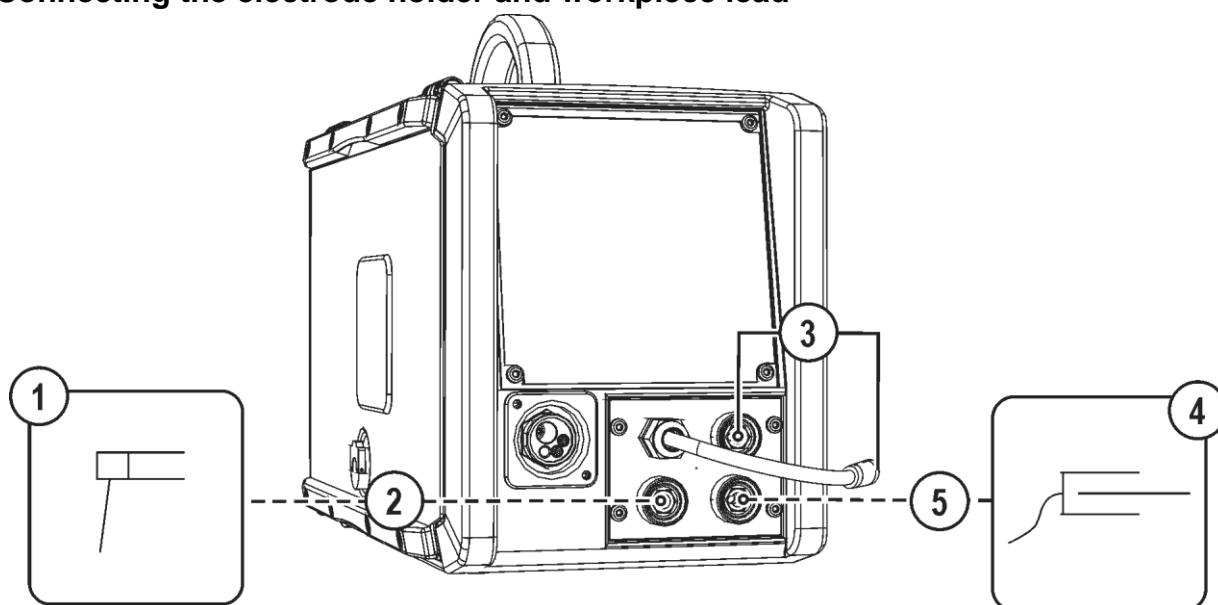


Figure 5-24

Item	Symbol	Description
1		Electrode holder
2		Connection socket for "+" welding current Electrode holder or workpiece lead connection
3		Polarity selector plug, welding current cable • Connect to the park socket.
4		Workpiece
5		Connection socket, "-" welding current Electrode holder or workpiece lead connection

- Insert the polarity selection plug in the park socket and lock in place by turning to the right.
- Insert cable plug of the electrode holder into either the "+" or "-" welding current connection socket and lock by turning to the right.
- Insert cable plug of the workpiece lead into either the "+" or "-" welding current connection socket and lock by turning to the right.



Polarity depends on the instructions from the electrode manufacturer given on the electrode packaging.

5.4.2 Welding task selection

- Select MMA JOB 128 > see 11.1 chapter.

You can only change the JOB number when no welding current is flowing.

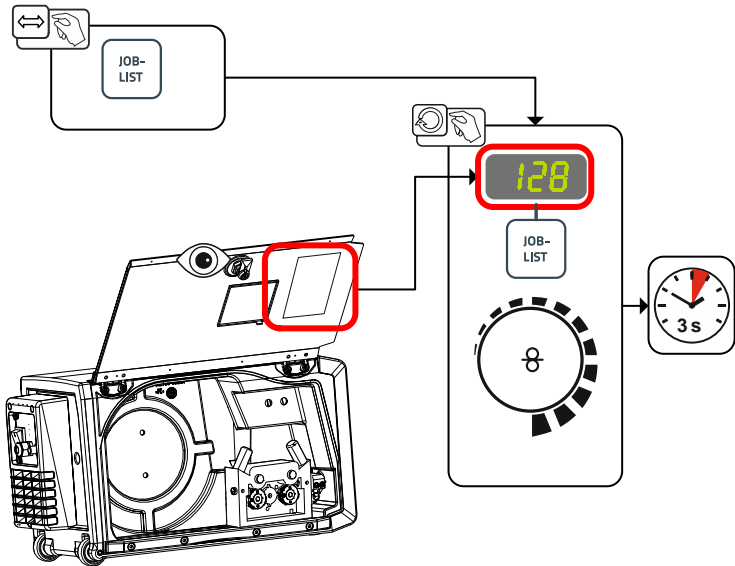


Figure 5-25

5.4.3 Arcforce

During the welding process, arcforce prevents the electrode sticking in the weld pool with increases in current. This makes it easier to weld large-drop melting electrode types at low current strengths with a short arc in particular.

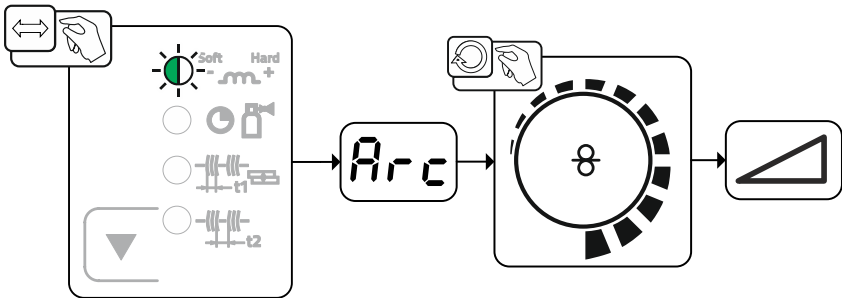


Figure 5-26

Display	Setting/selection
Arc	Arcforce correction <ul style="list-style-type: none">• Increase value > harder arc• Decrease value > softer arc

5.4.4 Hotstart

The hot start function improves the arc striking.

After striking the stick electrode, the arc ignites at the increased hot start current and decreases to the set main current once the hot start time has elapsed.

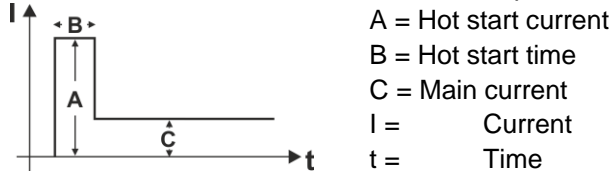


Figure 5-27

5.4.4.1 Hotstart settings

The setting ranges for the parameter values are summarised in the Parameter overview section > see 12.1 chapter.

- Select MMA JOB 128 > see 5.4.2 chapter.

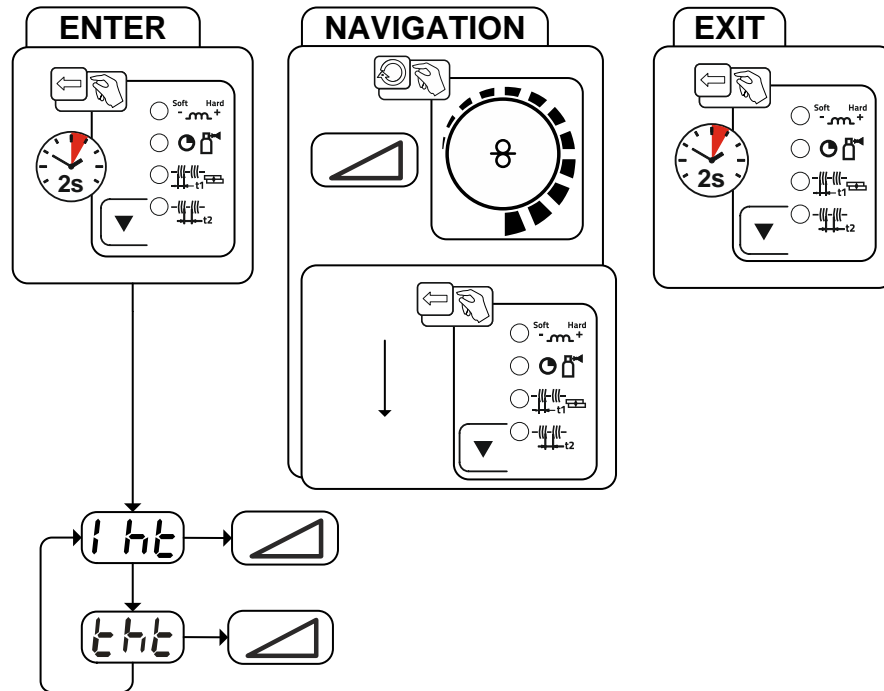
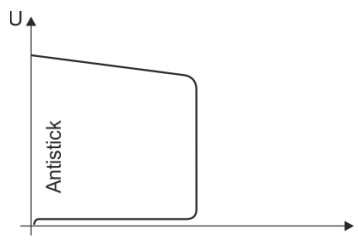


Figure 5-28

Display	Setting/selection
	Hotstart current
	Hotstart time

5.4.5 Antistick



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

Figure 5-29

5.5 TIG welding

5.5.1 Preparing the TIG welding torch

The TIG welding torch is to be equipped to suit the relevant welding task!

- Fit suitable tungsten electrodes and
- an appropriate shielding gas nozzle.
- Observe the operating instructions for the TIG welding torch!

5.5.2 Welding torch and workpiece line connection

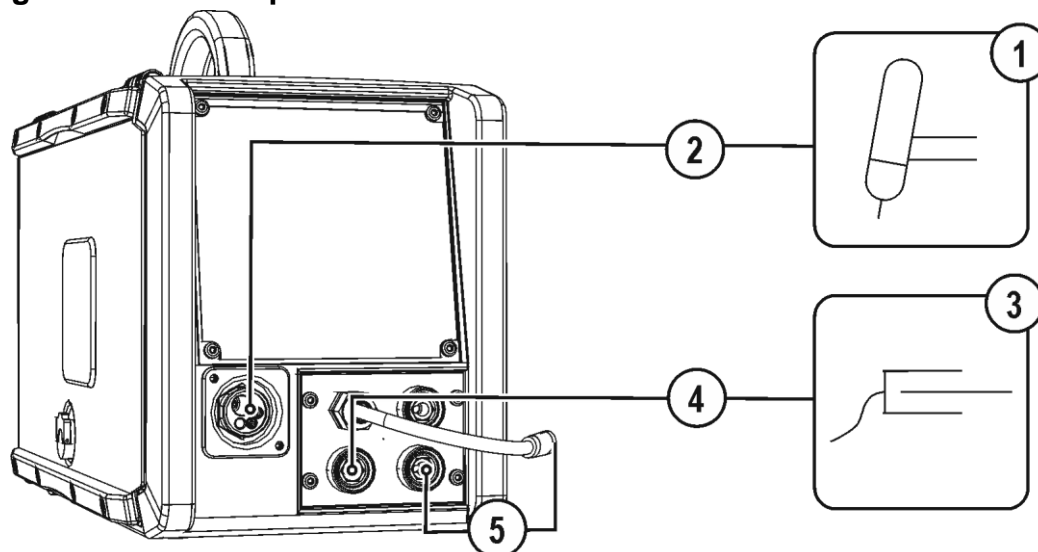





Figure 5-30

Item	Symbol	Description
1		Welding torch
2		Welding torch connection (Euro torch connector) Welding current, shielding gas and torch trigger integrated
3		Workpiece
4		Connection socket, "+" welding current • TIG welding: Workpiece connection
5		Polarity selector plug, welding current cable Internal welding current cable for central connection/welding torch. • Connection socket for "-" welding current

- Insert the central plug for the welding torch into the central connector and screw together with crown nut.
- Insert the polarity selection plug into the "-" welding current connection socket and lock in place by turning to the right.
- Insert the plug of the workpiece lead into the "+" welding current connection socket and lock in place by turning to the right.

5.5.3 Welding task selection

- Select TIG JOB 127 > see 11.1 chapter.

You can only change the JOB number when no welding current is flowing.

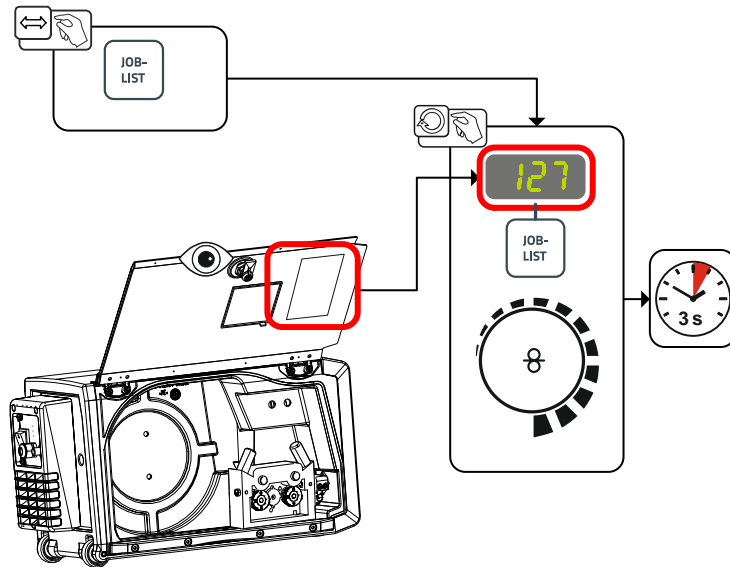


Figure 5-31

5.5.4 Adjusting the gas post-flow time

- Preselection: Select TIG JOB 127 > see 5.5.3 chapter.

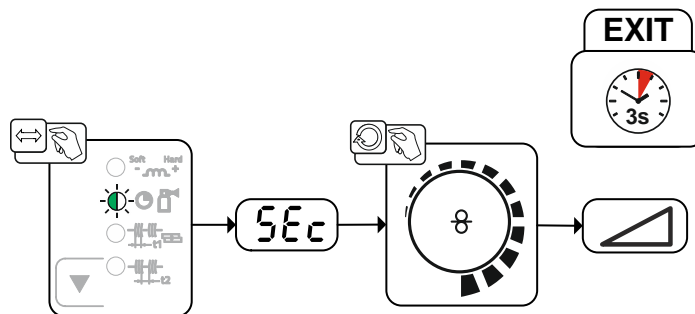


Figure 5-32

Display	Setting/selection
	Gas post-flow time

5.5.5 Further welding parameters

The setting ranges for the parameter values are summarised in the Parameter overview section > see 12.1 chapter.

- Preselection: Select TIG JOB 127 > see 5.5.3 chapter.

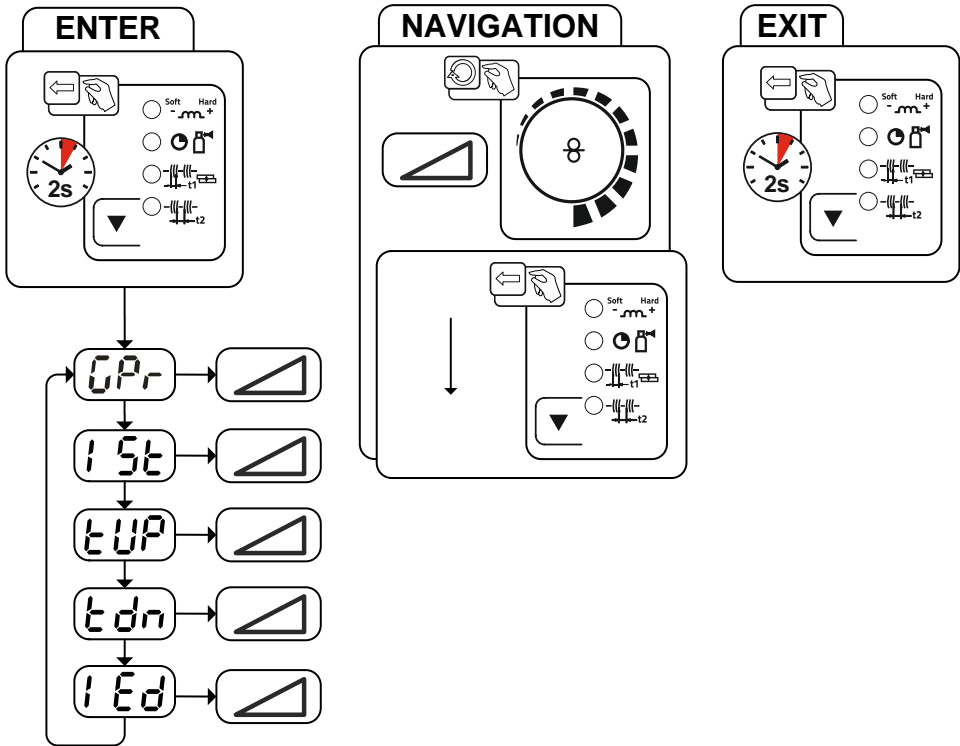


Figure 5-33

Display	Setting/selection
	Gas pre-flow time
	Ignition current
	Up-slope time
	Down-slope time
	End current

5.5.6 TIG arc ignition

5.5.6.1 Liftarc

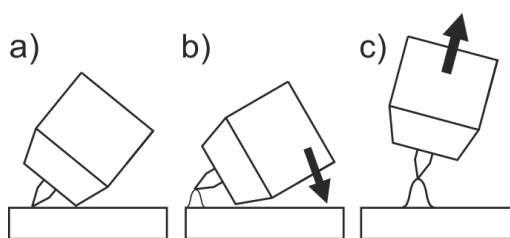


Figure 5-34







The arc is ignited on contact with the workpiece:

- Carefully place the torch gas nozzle and tungsten electrode tip onto the workpiece and press the torch trigger (liftarc current flowing, regardless of the main current set).
- Incline the torch over the torch gas nozzle to produce a gap of approx. 2-3 mm between the electrode tip and the workpiece. The arc ignites and the welding current is increased, depending on the operating mode set, to the ignition or main current set.
- Lift off the torch and swivel to the normal position.

Ending the welding process: Release or press the torch trigger depending on the operating mode selected.

5.5.7 Operating modes (functional sequences)

5.5.7.1 Legend

Symbol	Meaning
	Press torch trigger
	Release torch trigger
I	Welding current
	Gas pre-flows
	Gas post-flows
	Non-latched
	Latched
t	Time
t_{Up}	Upslope time
t_{Down}	Downslope time
I_{start}	Ignition current
I_{end}	End-crater current

Non-latched mode

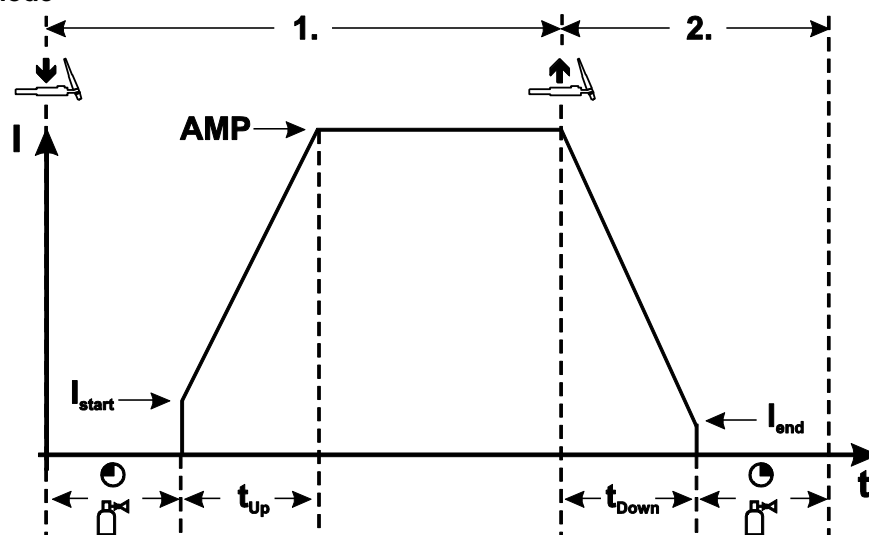


Figure 5-35

1st cycle

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

The arc is ignited using liftarc.

- The welding current flows with the value set for the starting current I_{start} .
- Welding current increases to the main current in the set upslope time.

2nd cycle

- Release torch trigger.
- The main current falls in the set downslope time to the end-crater current I_{end} .

If the torch trigger is pressed again during the downslope time, the welding current returns to the set main current!

- The main current reaches the end-crater current I_{end} , the arc extinguishes.
- Gas post-flow time elapses.

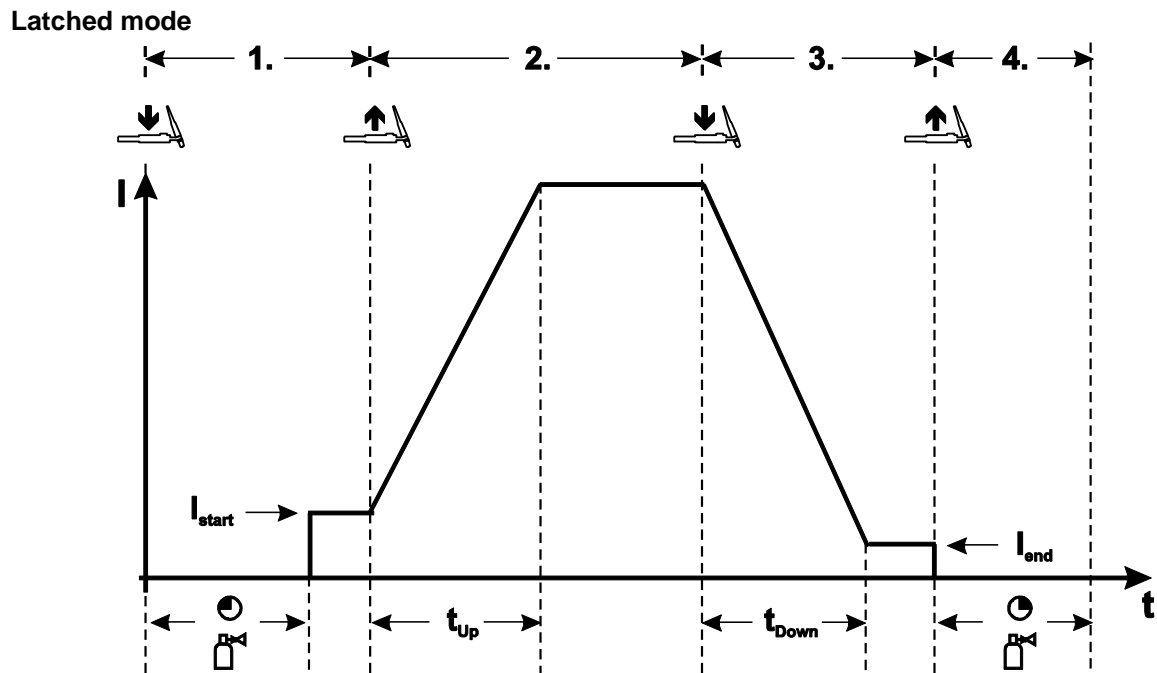


Figure 5-36

1st cycle

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

The arc is ignited using liftarc.

- The welding current flows with the value set for the starting current I_{start} .

2nd cycle

- Release torch trigger.
- Welding current increases to the main current in the set upslope time.

3rd cycle

- Press and hold torch trigger.
- The main current falls in the set downslope time to the end-crater current I_{end} .

4th cycle

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

The welding process is terminated immediately if the torch trigger is released during the downslope time.

The welding current drops to zero and the gas post-flow time begins.

5.5.8 TIG automatic cut-out



The welding machine ends the ignition process or the welding process with an

- **ignition fault** (no welding current flows within 5 s after the start signal)
- **arc interruption** (arc is interrupted for longer than 5 s)

5.6 Machine configuration menu

5.6.1 Selecting, changing and saving parameters

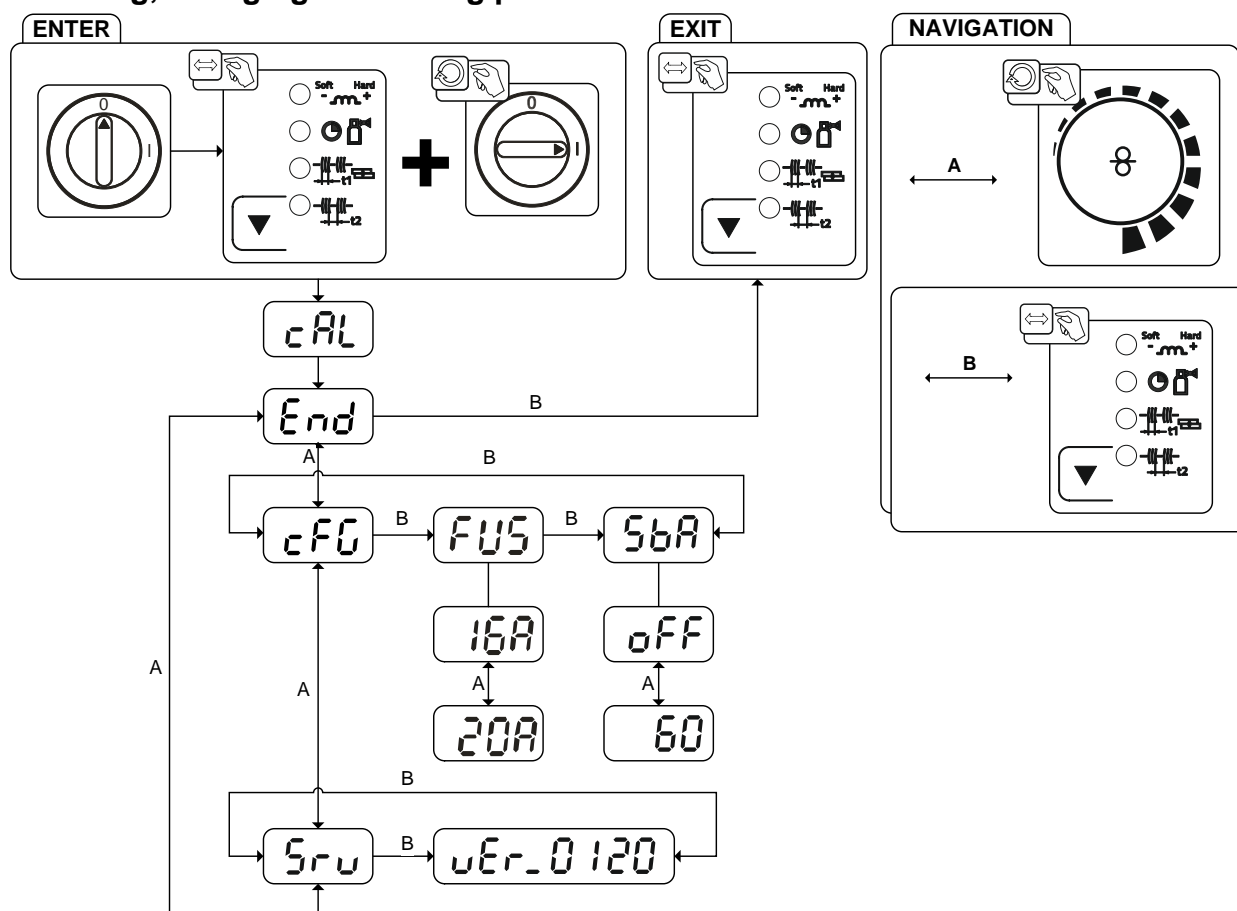
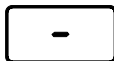


Figure 5-37

Display	Setting/selection
cAL	Calibration The machine will be calibrated for approx 2 seconds each time it is switched on.
End	Exit the menu Exit
cFC	Machine configuration Settings for machine functions and parameter display
FUS	Dynamic power adjustment > see 7.5 chapter
SbA	Time-based power-saving mode > see 5.7 chapter Time to activation of the power-saving mode in case of inactivity. Setting off = disabled or numerical value 5– 60 min. (ex works: 20).
Srv	Service menu Any changes to the service menu should be agreed with the authorised service personnel.
vEr	Software version of the machine control Version display

5.7 Power-saving mode (Standby)

You can activate the power-saving mode by either pressing the push-button > see 4.4 chapter for a prolonged time or by setting a parameter in the machine configuration menu (time-controlled power-saving mode **5bA**).



When power-saving mode is activated, the machine displays show the horizontal digit in the centre of the display only.

Pressing any operating element (e.g. turning a rotary knob) deactivates power-saving mode and the machine is ready for welding again.

6 Maintenance, care and disposal

6.1 General

DANGER



Risk of injury due to electrical voltage after switching off!

Working on an open machine can lead to fatal injuries!

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

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

WARNING



Incorrect maintenance, testing and repair!

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

Observe the maintenance instructions > see 6.3 chapter.

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

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

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

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

6.2 Cleaning

- Clean the outer surfaces with a moist cloth (no aggressive cleaning agents).
- Purge the machine venting channel and cooling fins (if present) with oil- and water-free compressed air. Compressed air may overspeed and destroy the machine fans. Never direct the compressed air directly at the machine fans. Mechanically block the fans, if required.
- Check the coolant for contaminants and replace, if necessary.

6.2.1 Dirt filter

The duty cycle of the welding machine decreases as an effect of the reduced cooling air volume. Depending on the amount of dirt building up (at least every two months), the dirt filter has to be uninstalled and cleaned regularly (e.g. by purging with compressed air).

6.3 Maintenance work, intervals

6.3.1 Daily maintenance tasks

Visual inspection

- Mains supply lead and its strain relief
- Gas cylinder securing elements
- Check hose package and power connections for exterior damage and replace or have repaired by specialist staff as necessary!
- Gas tubes and their switching equipment (solenoid valve)
- Check that all connections and wearing parts are hand-tight and tighten if necessary.
- Check correct mounting of the wire spool.
- Wheels and their securing elements
- Transport elements (strap, lifting lugs, handle)
- Other, general condition

Functional test

- Operating, message, safety and adjustment devices (Functional test)
- Welding current cables (check that they are fitted correctly and secured)
- Gas tubes and their switching equipment (solenoid valve)
- Gas cylinder securing elements
- Check correct mounting of the wire spool.
- Check that all screw and plug connections and replaceable parts are secured correctly, tighten if necessary.
- Remove any spatter.
- Clean the wire feed rollers on a regular basis (depending on the degree of soiling).

6.3.2 Monthly maintenance tasks

Visual inspection

- Casing damage (front, rear and side walls)
- Wheels and their securing elements
- Transport elements (strap, lifting lugs, handle)
- Check coolant tubes and their connections for impurities

Functional test

- Selector switches, command devices, emergency stop devices, voltage reducing devices, message and control lamps
- Check that the wire guide elements (inlet nipple, wire guide tube) are fitted securely.
- Check coolant tubes and their connections for impurities
- Check and clean the welding torch. Deposits in the torch can cause short circuits and have a negative impact on the welding result, ultimately causing damage to the torch.

6.3.3 Annual test (inspection and testing during operation)

A periodic test according to IEC 60974-4 "Periodic inspection and test" has to be carried out. In addition to the regulations on testing given here, the relevant local laws and regulations must also be observed.



For more information refer to the "Warranty registration" brochure supplied and our information regarding warranty, maintenance and testing at www.ewm-group.com!

6.4 Disposing of equipment



Proper disposal!

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

- ***Do not dispose of in household waste!***
- ***Observe the local regulations regarding disposal!***
- According to European provisions (Directive 2012/19/EU on Waste of Electrical and Electronic Equipment), used electric and electronic equipment may no longer be placed in unsorted municipal waste. It must be collected separately. The symbol depicting a waste container on wheels indicates that the equipment must be collected separately.
This machine has to be disposed of, or recycled, in accordance with the waste separation systems in use.
- According to German law (law governing the distribution, taking back and environmentally correct disposal of electric and electronic equipment (ElektroG)), used machines are to be placed in a collection system separate from unsorted municipal waste. The public waste management utilities (communities) have created collection points at which used equipment from private households can be disposed of free of charge.
- Information about returning used equipment or about collections can be obtained from the respective municipal administration office.
- In addition to this, returns are also possible throughout Europe via EWM sales partners.



7 Rectifying faults

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

7.1 Checklist for rectifying faults



The correct machine equipment for the material and process gas in use is a fundamental requirement for perfect operation!

Legend	Symbol	Description
	↗	Fault/Cause
	✕	Remedy

Wire feed problems

- ↗ Contact tip blocked
 - ✕ Clean, spray with anti-spatter spray and replace if necessary
- ↗ Setting the spool brake > see 5.3.2.5 chapter
 - ✕ Check settings and correct if necessary
- ↗ Setting pressure units > see 5.3.2.4 chapter
 - ✕ Check settings and correct if necessary
- ↗ Worn wire rolls
 - ✕ Check and replace if necessary
- ↗ Wire feed motor without supply voltage (automatic cutout triggered by overloading)
 - ✕ Reset triggered fuse (rear of the power source) by pressing the key button
- ↗ Kinked hose packages
 - ✕ Extend and lay out the torch hose package
- ↗ Wire guide core or spiral is dirty or worn
 - ✕ Clean core or spiral; replace kinked or worn cores

Functional errors

- ↗ All machine control signal lights are illuminated after switching on
- ↗ No machine control signal light is illuminated after switching on
- ↗ No welding power
 - ✕ Phase failure > check mains connection (fuses)
- ↗ Several parameters cannot be set (machines with access block)
 - ✕ Entry level is blocked, disable access lock
- ↗ Connection problems
 - ✕ Make control lead connections and check that they are fitted correctly.
- ↗ Loose welding current connections
 - ✕ Tighten power connections on the torch and/or on the workpiece
 - ✕ Tighten contact tip correctly

Mains fuse triggers

- ↗ Unsuitable mains fuse
 - ✕ Set up recommended mains fuse > see 8 chapter.

7.2 Error messages (power source)



A welding machine error is indicated by the collective fault signal lamp (A1) lighting up and an error code (see table) being displayed in the machine control display. In the event of a machine error, the power unit shuts down.

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

Error message	Possible cause	Remedy
E 0	Start signal set in the event of errors	Do not press the torch trigger or the foot-operated remote control
E 4	Temperature error	Allow the machine to cool down
E 5	Mains overvoltage	Switch off the machine and check the mains voltage
E 6	Mains undervoltage	
E 7	Electronics error	Switch the machine on and off again. If the error persists, notify service department
E 9	Secondary overvoltage	
E12	Voltage reduction error (VRD)	
E13	Electronics error	Switch off the machine, place the electrode holder in an insulated position and switch the machine back on. If the error persists, notify service department
E14	Adjustment error in current recording	
E15	Error in on of the electronics supply voltages	Switch the machine off and on again. If the error persists, notify service department
E23	Temperature error	Allow the machine to cool down
E32	Electronics error	Switch the machine on and off again. If the error persists, notify service department
E33	Adjustment error in voltage recording	Switch off the machine, place the electrode holder in an insulated position and switch the machine back on. If the error persists, notify service department
E34	Electronics error	Switch the machine on and off again. If the error persists, notify service department
E37	Temperature error	Allow the machine to cool down
E40	Motor fault	Check wire feed unit, switch the machine off and on again, inform the service department if the fault persists.
E55	Failure of a mains phase	Switch off the machine and check the mains voltage
E58	Short circuit in welding circuit	Switch off machine and check welding current leads for correct installation, e.g., put down electrode holder in an electrically insulated manner, disconnect degausser current lead.

7.3 Resetting welding parameters to the factory settings

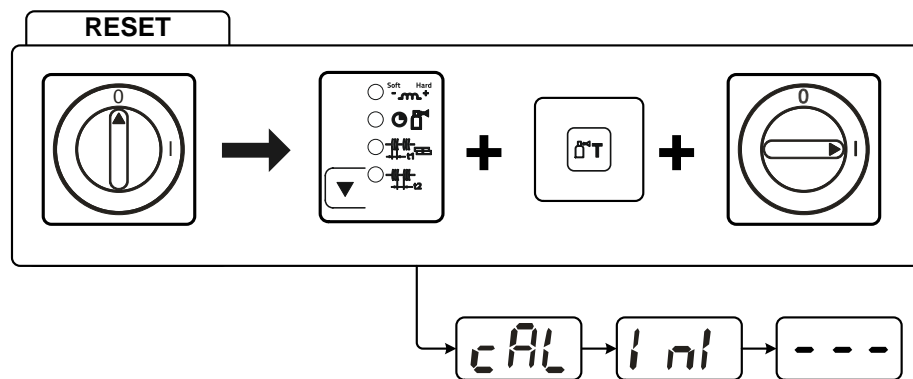




Figure 7-1

Display	Setting/selection
	Calibration The machine will be calibrated for approx 2 seconds each time it is switched on.
	Initialising Keep the push-button pressed until "InI" is shown on the display.

7.4 Display machine control software version

The query of the software versions only serves to inform the authorised service staff. It is available in the machine configuration menu > see 5.6 chapter.

7.5 Dynamic power adjustment



This requires use of the appropriate mains fuse.
Observe mains fuse specification > see 8 chapter!

The dynamic power adjustment automatically adjusts the welding performance to an uncritical level for the fuse.

The dynamic power adjustment can be set in two increments in the machine configuration menu using parameter "FUS": 20 A, 16 A > see 5.6 chapter.




The currently selected value will be shown on the "cal" section of the display for three seconds after the machine has been switched on.

8 Technical data

8.1 Picomig 180 puls TKG



Performance specifications and guarantee only in connection with original spare and replacement parts!

Setting range	MIG/MAG	TIG	MMA
Welding current	5 A to 180 A		5 A to 150 A
Welding voltage	14.3 V to 23 V	10.2 V to 17.2 V	20.2 V to 26 V
Duty cycle (DC) at 40 °C			
25%	180 A	-	-
30%	-	180 A	-
35%	-	-	150 A
60%	120 A	140 A	110 A
100%	100 A	120 A	100 A
Load cycle	10 min. (60% DC Δ 6 min. welding, 4 min. pause)		
Open circuit voltage	80 V		
Mains voltage (tolerances)	1 x 230 V (-40% to +15%)		
Mains connection lead	H07RN-F3G2,5		
Max. connected load	5.9 kVA	4.4 kVA	5.5 kVA
Recommended generator rating	8.0 kVA		
Frequency	50/60 Hz		
Mains fuse (safety fuse, slow-blow)	16 A ¹		
cos ϕ /efficiency	0.99/86%		
Workpiece lead (minimum)	25 mm ²		
Ambient temperature	-25 °C to +40 °C		
Machine cooling/torch cooling	Fan (AF)/gas		
Noise level	< 70 dB(A)		
Insulation class/protection classification	H/IP 23		
EMC class	A		
Wire spool diameter	Standardised wire spools up to 200 mm		
Wire feed speed	1 m/min. to 15 m/min.		
Standard roll equipment	0.8/1.0 mm for steel wire		
Drive type	4 rolls (37 mm)		
Torch connector	Euro torch connector		
Safety identification	 /  / 		
Harmonised standards used	See declaration of conformity (machine documentation)		
Dimensions L x W x H	559 x 276 x 340 mm		
	22.0 x 10.9 x 13.4 inch		
	16 kg		
Weight	35.3 lb		

¹ DIAZED xxA gG safety fuses are recommended. When using automatic cutouts, the "C" trigger characteristic must be used.

9 Accessories



Performance-dependent accessories like torches, workpiece leads, electrode holders or intermediate hose packages are available from your authorised dealer.

9.1 Options

Type	Designation	Item no.
ON Filter Picomig 180	Retrofit option, dirt filter for air inlet	092-002553-00000
ON Trolley Picomig	Trolley Picomig 180 with holder for 300 mm wire spool	092-000312-00000
ON CS K	Crane suspension for Picomig 180 / 185 D3 / 305 D3, Phoenix and Taurus 355 compact, drive 4	092-002549-00000

9.2 Transport systems

Type	Designation	Item no.
Trolley 35-1	Transport vehicle	090-008629-00000

9.3 General accessories

Type	Designation	Item no.
ADAP CEE16/SCHUKO	Earth contact coupling/CEE16A plug	092-000812-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
G1 G1/4 R 3M	Gas hose	094-000010-00003
ADAPTER EZA --> DINSE-ZA	Adapter for welding torches with Dinse connector to Euro central connector, on the machine	094-016765-00000

10 Replaceable parts



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

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

10.1 Wire feed rollers

10.1.1 Wire feed rollers for steel wire

Type	Designation	Item no.
FE 2DR4R 0,6+0,8	Drive rollers, 37 mm, steel	092-000839-00000
FE 2DR4R 0,8+1,0	Drive rollers, 37 mm, steel	092-000840-00000
FE 2DR4R 0,9+1,2	Drive rollers, 37 mm, steel	092-000841-00000
FE 2DR4R 1,0+1,2	Drive rollers, 37 mm, steel	092-000842-00000
FE 2DR4R 1,2+1,6	Drive rollers, 37 mm, steel	092-000843-00000
FE/AL 2GR4R SF	Pressure rollers, smooth, 37 mm	092-000414-00000

10.1.2 Wire feed rollers for aluminium wire

Type	Designation	Item no.
AL 4ZR4R 0,8+1,0	Twin rollers, 37 mm, for aluminium	092-000869-00000
AL 4ZR4R 1,0+1,2	Twin rollers, 37 mm, for aluminium	092-000848-00000
AL 4ZR4R 1,2+1,6	Twin rollers, 37 mm, for aluminium	092-000849-00000
AL 4ZR4R 2,4+3,2	Twin rollers, 37 mm, for aluminium	092-000870-00000

10.1.3 Wire feed rollers for cored wire

Type	Designation	Item no.
ROE 2DR4R 0,8/0,9+0,8/0,9	Drive rollers, 37 mm, cored wire	092-000834-00000
ROE 2DR4R 1,0/1,2+1,4/1,6	Drive rollers, 37 mm, cored wire	092-000835-00000
ROE 2DR4R 1,4/1,6+2,0/2,4	Drive rollers, 37 mm, cored wire	092-000836-00000
ROE 2DR4R 2,8+3,2	Drive rollers, 37 mm, cored wire	092-000837-00000
ROE 2GR4R	Pressure rollers, knurled, 37mm	092-000838-00000

10.1.4 Conversion kit

Type	Designation	Item no.
URUE VERZ>UNVERZ FE/AL 4R SF	Conversion kit, 37mm, 4-roller drive on non-toothed rollers (steel/aluminium)	092-000415-00000
URUE ROE 2DR4R 0,8/0,9+0,8/0,9 SF	Conversion kit, 37 mm, 4-roller drive for cored wire	092-000410-00000
URUE ROE 2DR4R 1,0/1,2+1,4/1,6 SF	Conversion kit, 37 mm, 4-roller drive for cored wire	092-000411-00000
URUE ROE 2DR4R 1,4/1,6+2,0/2,4 SF	Conversion kit, 37 mm, 4-roller drive for cored wire	092-000412-00000
URUE ROE 2DR4R 2,8+3,2 SF	Conversion kit, 37 mm, 4-roller drive for cored wire	092-000413-00000
URUE AL 4ZR4R 0,8+1,0 SF	Conversion kit, 37 mm, 4-roller drive for aluminium	092-002268-00000
URUE AL 4ZR4R 1,0+1,2 SF	Conversion kit, 37 mm, 4-roller drive for aluminium	092-002266-00000
URUE AL 4ZR4R 1,2+1,6 SF	Conversion kit, 37 mm, 4-roller drive for aluminium	092-002269-00000
URUE AL 4ZR4R 2,4+3,2 SF	Conversion kit, 37 mm, 4-roller drive for aluminium	092-002270-00000

<div> <div>D</div> Verschleißteile 4 Rollen-Antrieb Ø = 37mm </div> <div> St= Stahl Al= Aluminium CrNi= Edelstahl Cu= Kupfer </div>		<div> <div>GB</div> Wear parts 4-Roller drive system Ø = 37mm </div> <div> St= Steel Al= Aluminium CrNi= Stainless steel Cu= Copper </div>	
V-Nut: St-, CrNi-, Cu-Draht „Standard V-Nut“, oben unverzahnt und glatt, Rollenbezeichnung: „1,0“		V-groove: St-, CrNi-, Cu wire "Standard V-groove", on the top ungeared and plane, rolls description: "1,0"	
Antriebsrollen- Ø (b): Drive rolls- Ø (b): 0,6 + 0,8 0,8 + 1,0 0,9 + 1,2 1,0 + 1,2 1,2 + 1,6		Ersatzset: Spare set: 092-000839-00000 092-000840-00000 092-000841-00000 092-000842-00000 092-000843-00000	
Gegendruckrollenset (a) <i>Set of counter pressure rolls (a)</i>		092-000414-00000	
Umrüstung verzahnt → unverzahnt: <i>conversion geared → ungeared:</i>		092-000415-00000	
U-Nut: Al-, Cu-Draht „Option U-Nut“, oben verzahnt, Rollenbezeichnung: „1,0 A2“		U-groove: Al-, Cu wire "Option U-groove", on the top geared-twin rolls, rolls description: "1,0 A2"	
Antriebsrollen- Ø (a+b): Drive rolls- Ø (a+b): 0,8 + 1,0 1,0 + 1,2 1,2 + 1,6 2,4 + 3,2		Ersatzset: Spare set: 092-000869-00000 092-000848-00000 092-000849-00000 092-000870-00000	
Umrüstset: Conversion set: 092-002268-00000 092-002266-00000 092-002269-00000 092-002270-00000			
U-Nut gerändelt: Füll-/Röhrchendraht „Option U-Nut gerändelt“, oben verzahnt, ohne Nut gerändelt, Rollenbezeichnung: „1,0-1,2 R“		knurled U-groove: Cored wire "Option knurled U-groove", on the top geared, without knurled groove, rolls description: "1,0-1,2 R"	
Antriebsrollen- Ø (b): Drive rolls- Ø (b): 0,8 / 0,9 + 0,8 / 0,9 1,0 / 1,2 + 1,4 / 1,6 1,4 / 1,6 + 2,0 / 2,4 2,8 + 3,2		Ersatzset: Spare set: 092-000834-00000 092-000835-00000 092-000836-00000 092-000837-00000	
Umrüstset: Conversion set: 092-000410-00000 092-000411-00000 092-000412-00000 092-000413-00000			
Gegendruckrollenset (a) <i>Set of counterpressure rolls (a):</i>		092-000838-00000	

094-014500-00502









Figure 10-1

11 Appendix A

11.1 JOB-List



We recommend using the characteristics for 1.0-mm solid wire electrodes also for the 0.9-mm solid wire electrodes.

 Pulse/ Standard		 Standard	JOB-LIST			
Pulse only in Picomig puls Version						
 Massivdraht / Solid Wire	 Material	 % Gas	Ø Wire			
			0,6	0,8	1,0	1,2
			Job-Nr.			
	SG2/3 G3/4 Si1	CO ₂ 100 / C1	176	1	3	4
		Ar80 - 90 / M21	175	6	8	9
	CrNi	Ar91 - 99 / M12 - M13		34	35	
		Ar/He / I3		42	43	
	CuSi Löten / Brazing	Ar100 / I1		114	115	116
		Ar91 - 99 / M12 - M13		110	111	112
	AlMg	Ar100 / I1		74	75	76
AlSi	Ar100 / I1		82	83	84	
Al99	Ar100 / I1		90	91	92	
 Fülldraht / Flux-Cored Wire	 Material	 % Gas	Ø Wire			
			0,9	1,0	1,1	1,2
			Job-Nr.			
	E71T-11	Self-Shielded	172		171	170
	E71T-1M Rutile	Ar80-90 / M21		242		
	E70TC Metal	Ar80-90 / M21		237		
GMAW non synergic			188			
WIG / TIG			127			
E-Hand / MMA			128			

094-015117-00504

Figure 11-1



MIG/MAG pulse arc welding can be selected with JOBs 6, 34, 42, 74, 75, 76, 82, 83, 84, 90, 91, 110, 111, 114 and 115. If an attempt is made to set another JOB to pulse, "noP" = "no Pulse" appears briefly on the display and the machine is reset to default.

12 Appendix B

12.1 Parameter overview – setting ranges

Welding data display (3-digit)	Parameters/function	Setting range			
		Standard (ex works)	Min.	Max.	Unit
MIG/MAG					
GP_r	Gas pre-flow time	0,2	0,0	- 20,0	s
dY_n	Dynamic correction	0	-40	- 40	
SE_c	Gas post-flow time	0,5	0,0	- 20,0	s
SE_c	Spot time	1,0	0,1	- 20,0	s
SE_c	Pause time (interval)	1,0	0,1	- 20,0	s
rbd	Wire burn-back	0	-50	- 50	%
TIG					
GP_r	Gas pre-flow time	0,5	0,0	- 5,0	s
IS_t	Ignition current	20	1	- 200	%
tUP	Up-slope time	1,0	0,0	- 20,0	s
tD_n	Down-slope time	1,0	0,0	- 20,0	s
IE_d	End current	20	1	- 200	%
SE_c	Gas post-flow time	4,0	0,0	- 20,0	s
MMA					
AR_c	Arcforce correction	0	-10	- 10	
Ih_t	Hot start current	120	50	- 200	%
th_t	Hot start time	0,5	0,1	- 20,0	s
Basic parameters (independent of procedure)					
cRL	Calibration				
End	Exit menu				
cFG	Machine configuration				
FUS	Dynamic power adjustment	16	16	- 20	A
SbR	Time-based power-saving mode	off	5	- 60	min.
SrU	Service menu				
-	Power-saving mode active				

13 Appendix C

13.1 Overview of EWM branches

Headquarters

EWM AG

Dr. Günter-Henle-Straße 8
56271 Mündersbach · Germany
Tel: +49 2680 181-0 · Fax: -244
www.ewm-group.com · info@ewm-group.com

Technology centre

EWM AG

Forststraße 7-13
56271 Mündersbach · Germany
Tel: +49 2680 181-0 · Fax: -144
www.ewm-group.com · info@ewm-group.com

Production, Sales and Service

EWM AG

Dr. Günter-Henle-Straße 8
56271 Mündersbach · Germany
Tel: +49 2680 181-0 · Fax: -244
www.ewm-group.com · info@ewm-group.com

EWM HIGH TECHNOLOGY (Kunshan) Ltd.

10 Yuanshan Road, Kunshan · New & Hi-tech Industry Development Zone
Kunshan City · Jiangsu · Post code 215300 · People's Republic of China
Tel: +86 512 57867-188 · Fax: -182
www.ewm.cn · info@ewm.cn · info@ewm-group.cn

EWM HIGHTEC WELDING s.r.o.

9. května 718 / 31
407 53 Jířkov · Czech Republic
Tel: +420 412 358-551 · Fax: -504
www.ewm-jirikov.cz · info@ewm-jirikov.cz

Sales and Service Germany

EWM AG - Rathenow branch

Sales and Technology Centre
Grünauer Fenn 4
14712 Rathenow · Tel: +49 3385 49402-0 · Fax: -20
www.ewm-rathenow.de · info@ewm-rathenow.de

EWM AG - Göttingen branch

Rudolf-Winkel-Straße 7-9
37079 Göttingen · Tel: +49 551-3070713-0 · Fax: -20
www.ewm-goettingen.de · info@ewm-goettingen.de

EWM AG - Pulheim branch

Dieselstraße 9b
50259 Pulheim · Tel: +49 2238-46466-0 · Fax: -14
www.ewm-pulheim.de · info@ewm-pulheim.de

EWM AG - Koblenz branch

August-Horch-Straße 13a
56070 Koblenz · Tel: +49 261 963754-0 · Fax: -10
www.ewm-koblenz.de · info@ewm-koblenz.de

EWM AG - Siegen branch

Eiserfelder Straße 300
57080 Siegen · Tel: +49 271 3878103-0 · Fax: -9
www.ewm-siegen.de · info@ewm-siegen.de

EWM AG - München Region branch

Gadastraße 18a
85232 Bergkirchen · Tel: +49 8142 284584-0 · Fax: -9
www.ewm-muenchen.de · info@ewm-muenchen.de

EWM AG - Tett nang branch

Karlsdorfer Straße 43
88069 Tett nang · Tel: +49 7542 97998-0 · Fax: -29
www.ewm-tett nang.de · info@ewm-tett nang.de

EWM AG - Neu-Ulm branch

Heinkelstraße 8
89231 Neu-Ulm · Tel: +49 731 7047939-0 · Fax: -15
www.ewm-neu-ulm.de · info@ewm-neu-ulm.de

EWM Schweißfachhandels GmbH

Dr. Günter-Henle-Straße 8 · 56271 Mündersbach
St. Augustin branch
Am Apfelbäumchen 6-8
53757 St. Augustin · Tel: +49 2241 1491-530 · Fax: -549
www.ewm-sankt-augustin.de · info@ewm-sankt-augustin.de

Sales and Service International

EWM HIGH TECHNOLOGY (Kunshan) Ltd.

10 Yuanshan Road, Kunshan · New & Hi-tech Industry Development Zone
Kunshan City · Jiangsu · Post code 215300 · People's Republic of China
Tel: +86 512 57867-188 · Fax: -182
www.ewm.cn · info@ewm.cn · info@ewm-group.cn

EWM HIGHTEC WELDING GmbH

Wiesenstraße 27b
4812 Pinsdorf · Austria · Tel: +43 7612 778 02-0 · Fax: -20
www.ewm-austria.at · info@ewm-austria.at

EWM KAYNAK SİSTEMLERİ TİC. LTD. ŞTİ.

Orhangazi Mah. Mimsan San. Sit. 1714. Sok. 22/B blok No:12-14
34538 Esenyurt · İstanbul · Turkey
Tel: +90 212 494 32 19
www.ewm.com.tr · turkey@ewm-group.com

EWM HIGHTEC WELDING UK Ltd.

Unit 2B Coopies Way · Coopies Lane Industrial Estate
Morpeth · Northumberland · NE61 6JN · Great Britain
Tel: +44 1670 505875 · Fax: -514305
www.ewm-morpeth.co.uk · info@ewm-morpeth.co.uk

EWM HIGHTEC WELDING s.r.o.

Benešov branch
Prodejní a poradenské centrum Tyršova 2106
256 01 Benešov u Prahy · Czech Republic
Tel: +420 317 729-517 · Fax: -712
www.ewm-benesov.cz · info@ewm-benesov.cz

