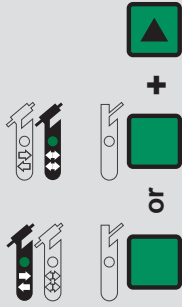


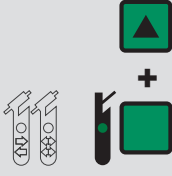
TIG - Setup



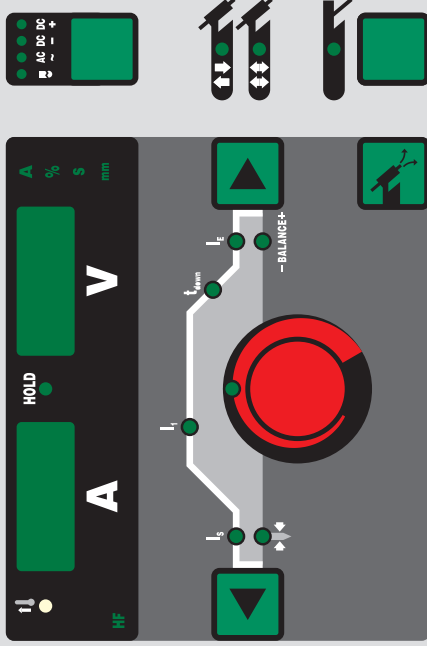
- C C Cooling unit control
- U P 5 Upslope
- 1 - 2 Reduced current
- E I d Electrode diameter*
- H F E High-frequency ignition
- A C F AC frequency/mains sync.
- F R C Factory
- E R C Tacking

* ... TransTig only

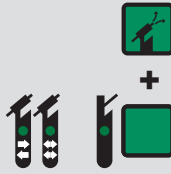
STICK - Setup



- H C U Hot-start current
- H L Hot-current time
- d Y n Arc-force dyn. cor.
- F R C Factory

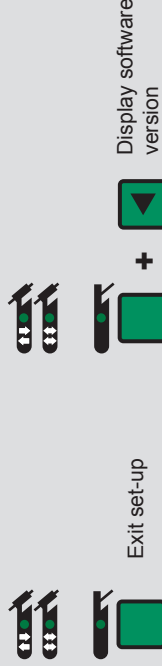


Gas - Setup

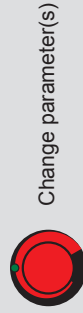


- G P r Gas pre-flow time
- G - L Gas post-flow time at I-min
- G - H Gas post-flow time at I-max
- G P U Gas purging

Main parameters



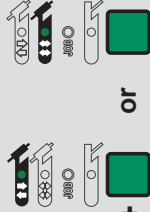
- I_s Electrode diameter
- I₁ Starting current
- I₂ Main current
- t_{down} Downslope
- I_f Final current
- BALANCE+ Balance



Exit set-up + Display software version



TIG - Setup

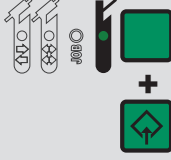


- 5 P t Spot-welding time
- t A C Tacking
- F - P Pulsing frequency
- d c y Duty cycle*
- l - U Background current**
- t - S Starting current time
- t - E Final current time
- F d 2 Feeder 2**
- d t 1 Start delay 1**
- d t 2 End delay 2**
- F d 1 Feeder inching speed**
- F d b Wire withdrawal
- F A C Factory

2nd-Menu

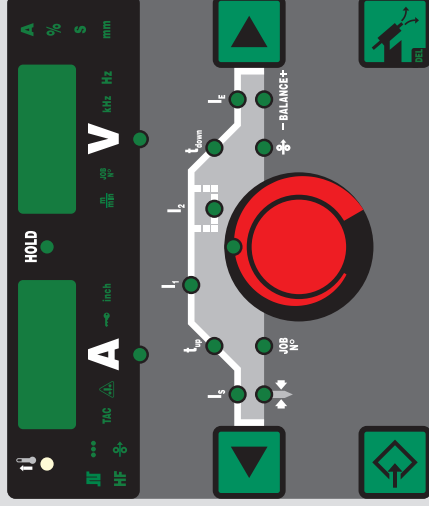
- 5 F 5 Special 4-step mode
- C - C Cooling unit control
- C - E Cooling unit monitoring
- H F E High-frequency ignition
- r Welding circuit resistance
- r Welding circuit inductivity
- l Ignition time-out
- A r c Arc-break watchdog
- E - P External parameter
- P P U Push-pull option**
- A C 5 s/over to main current
- C D r Gas correction***
- 5 E E Switch between Std./US
- 5 E 5 Special 2-step mode
- P r / Pre-ignition

STICK - Setup



- H C U Hot-start current
- H E 1 Hot-current time
- d y n Arc-force dyn. cor.
- F A C Factory
- 2 n d 2nd-Menu

- r Weld. circ. resistance
- L Weld. circ. inductivity
- A S t Anti-stick
- E i n Char. selection
- U c o Break voltage

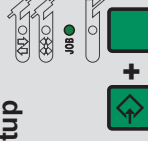


Main parameters



- Electrode diameter
- Starting current
- Upslope
- Main current
- Reduced current
- Downslope
- Final current
- Balance
- vd speed
- Job number

Job - Setup



Up to 100 operating points including associated parameters can be saved, copied, deleted and retrieved.

Details on the Job mode on the parameters see operating instructions.



- Activate / deactivate keypad lock
- Save job / Exit set-up



- Change parameter(s)
- Display software version

AC / DC - Setup (MagicWave)



- A C F AC frequency / synchronous
- 2 n d 2nd-Menu

- P o 5 AC positive half-wave
- r e U AC negative half-wave
- P h A AC phase synchronous ****
- r P 1 DC ignition

Gas - Setup



- C P r Gas pre-flow time
- C - L Gas post-flow time at I-min
- C - H Gas post-flow time at I-max
- C A 5 Gas flow rate***
- C P U Gas purging

* ... with activated pulse frequency
 ** ... with feeder only (KD)
 *** ... with digital gas control only
 **** ... on 3-phase devices only