TIG - Setup

or +

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

*... TransTig only

HOLD

A
%
S
mm

HF

A   V

AC DC DC
~   -   +

I₁   t_down
I_s   I_E
BALANCE

STICK - Setup

+
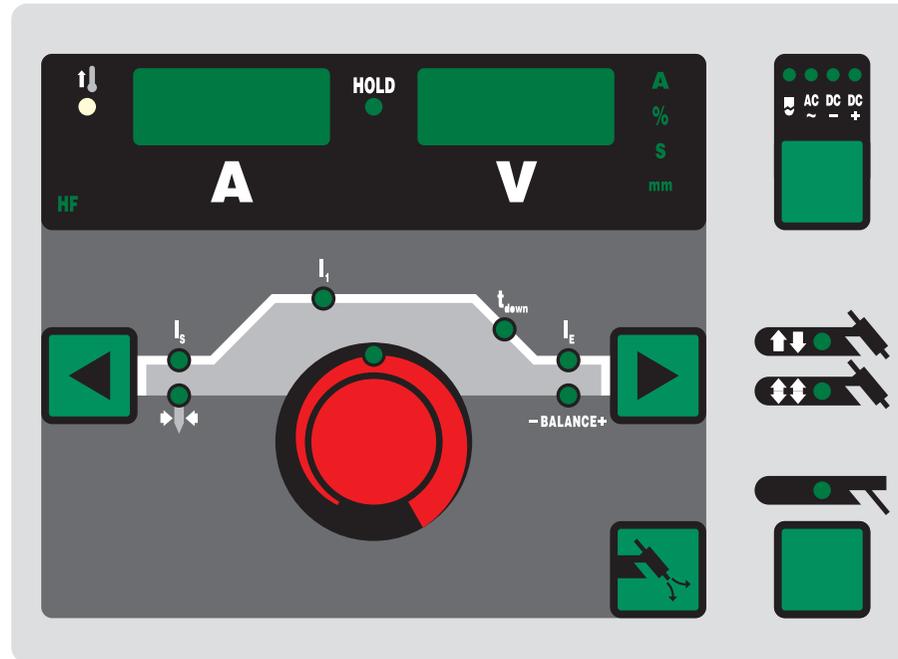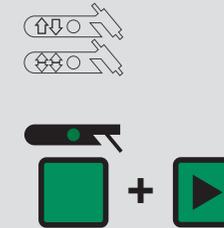
H C U	Hot-start current
H E I	Hot-current time
d Y n	Arc-force dyn. cor.
F A C	Factory

Gas - Setup

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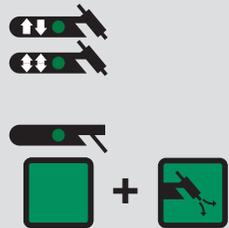
G P r	Gas pre-flow time
G - L	Gas post-flow time at l-min
G - H	Gas post-flow time at l-max
G P U	Gas purging

Exit set-up

+ Display software version

Change parameter(s)
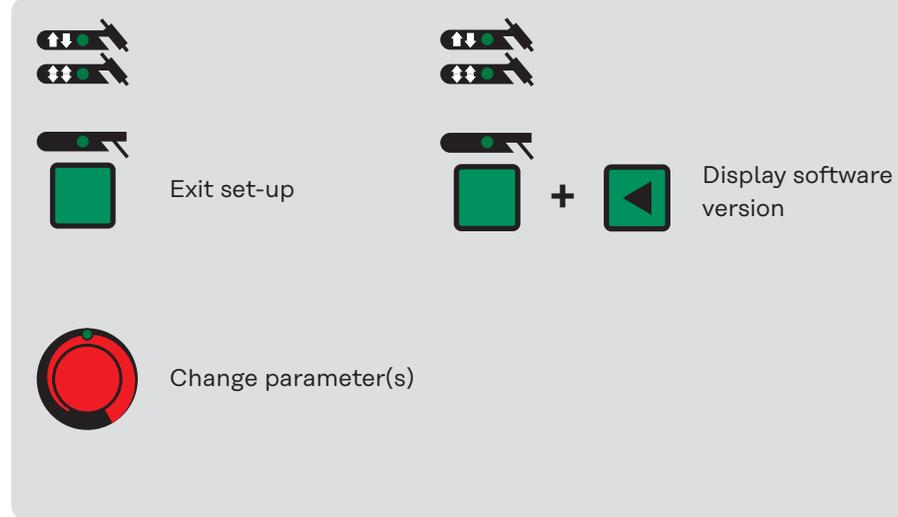
Main parameters

Electrode diameter
I_s	Starting current
I₁	Main current
t_down	Downslope
I_E	Final current
BALANCE	Balance

Fronius International GmbH, www.fronius.com

TIG - Setup
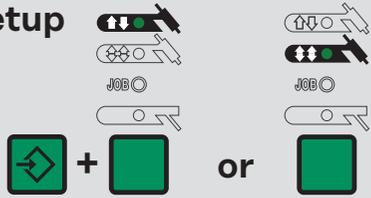
S P t	Spot-welding time	
t A C	Tacking	
F - P	Pulsing frequency	
d c Y	Duty cycle*	
I - G	Background current*	
t - S	Starting current time	
t - E	Final current time	
F d.2	Feeder 2**	
d t 1	Start delay 1**	
d t 2	End delay 2**	
F d i	Feeder inching speed**	
F d b	Wire withdrawal	
F A C	Factory	
2 n d	2nd-Menu	

S F S	Special 4-step mode
C - C	Cooling unit control
C - t	Cooling unit monitoring
H F t	High-frequency ignition
r	Welding circuit resistance
L	Welding circuit inductivity
i t o	Ignition time-out
A r c	Arc-break watchdog
E - P	External parameter
P P U	Push-pull option**
A C S	s/over to main current
C O r	Gas correction***
S E t	Switch between Std./US
S t S	Special 2-step mode
P r I	Pre-ignition
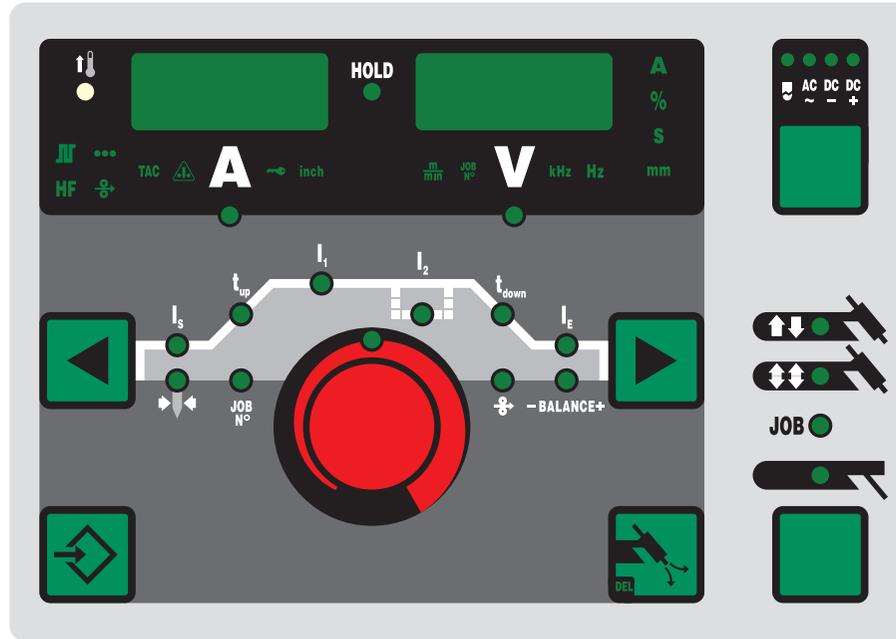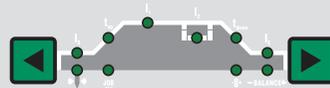
*... with activated pulse frequency
**... with feeder only (KD)
***... with digital gas control only
****... on 3-phase devices only

Main parameters

▼	Electrode diameter	
I_s	Starting current	
t_up	Upslope	
I_1	Main current	
I_2	Reduced current	
t_down	Downslope	
I_E	Final current	
–BALANCE+	Balance	
⚙	vd speed	
JOB N°	Job number	

Job - Setup

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

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

Activate / deactivate keypad lock

Save job / Exit set-up

Change parameter(s)

Display software version

STICK - Setup
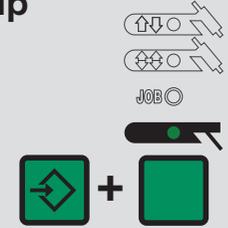
H C U	Hot-start current
H t i	Hot-current time
d Y n	Arc-force dyn. cor.
F A C	Factory
2 n d	2nd-Menu

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

AC / DC - Setup (MagicWave)

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

P o S	AC positive half-wave
n E G	AC negative half-wave
P h A	AC phase synchronous ****
r P i	DC ignition

Gas - Setup

|	
G P r	Gas pre-flow time
G - L	Gas post-flow time at l-min
G - H	Gas post-flow time at l-max
G A S	Gas flow rate***
G P U	Gas purging