



MODEL

NOVATIG 204 ACDC LCD G.R.3

INSTRUCTION MANUAL

for installation,
use and maintenance
of welding
machines.

Original instructions in Italian.
Please keep for future use.

1.995.251 EN - Rev. 1.1



Contents

1. PREFACE	4
1.1. PURPOSE OF THE INSTRUCTION MANUAL FOR USE AND MAINTENANCE	4
1.2. RECIPIENTS	4
1.3. STORAGE OF THE INSTRUCTION MANUAL	5
1.4. UPDATING THE INSTRUCTION MANUAL	5
1.5. HOW TO READ THE INSTRUCTION MANUAL	5
1.6. TERMS, SYMBOLS AND PICTOGRAMS	5
2. GENERAL INFORMATION	6
2.1. MANUFACTURER IDENTIFICATION DATA	6
2.2. MACHINE IDENTIFICATION DATA AND PLATES	6
2.3. DECLARATIONS OF CONFORMITY	7
2.4. SAFETY STANDARDS	7
2.5. INFORMATION ON TECHNICAL ASSISTANCE	7
2.6. PREPARATION BY THE CUSTOMER	8
3. SAFETY	8
3.1. GENERAL SAFETY WARNINGS	8
3.2. INTENDED USE	13
3.3. CONTRAINDICATIONS FOR USE	13
3.4. HAZARDOUS AREAS	13
3.5. SAFETY DEVICES	13
3.6. SIGNS	14
3.7. RESIDUAL RISKS	15
4. INSTALLATION	15
4.1. SHIPPING	15
4.2. PACKAGING	15
4.3. MACHINE RECEIPT	15
4.4. HANDLING AND LIFTING	16
4.5. UNPACKING	16
4.6. STORAGE	17
4.7. PREPARATIONS	17
4.8. ASSEMBLY/POSITIONING	18
4.9. CONNECTIONS	18
4.10. PRELIMINARY CHECKS	19
5. MACHINE DESCRIPTION	19
5.1. OPERATING PRINCIPLE	19
5.2. FEATURES AND MAIN COMPONENTS	19
5.3. ENVIRONMENTAL CONDITIONS	20
5.4. LIGHTING	20
5.5. VIBRATIONS	20
5.6. NOISE	20
5.7. TECHNICAL SPECIFICATIONS	21

6. USO MACHINE USE	22
6.1. MACHINE LAYOUT DESCRIPTION	22
6.1.1. Layout for the front and rear panel	22
6.1.2. Water cooler	22
6.2. WELDING OPERATION	22
6.2.1. Operation of DC TIG HF/LIFT welding method:	24
6.2.2. Operation of AC TIG HF/LIFT welding method:	27
6.2.3. Cap mode on iWave AC only	27
6.2.4. AC/DC Output Modes	30
6.2.5. Operation of Smart TIG welding method	31
6.2.6. Operation of the MMA welding method:	32
6.2.7. Job Memory	34
6.3. REMOTE CONTROL CONFIGURATION	36
6.3.1. Wireless remote control Configuration	36
6.3.2. Wire foot pedal Configuration	36
6.3.3. Wireless foot pedal Configuration	37
6.4. START-UP	38
6.5. NORMAL STOP	38
6.6. DECOMMISSIONING	38
7. MAINTENANCE	39
7.1. MACHINE ISOLATION	39
7.2. SPECIAL PRECAUTIONS	39
7.3. CLEANING	39
7.4. ROUTINE MAINTENANCE	39
7.5. WELDING MACHINE REPAIRS	40
7.6. DIAGNOSTICS AND TROUBLESHOOTING	41
8. ACCESSORIES AND SPARE PARTS	43
8.1. CUSTOMER SERVICE	43
8.2. SPARE PARTS	43
9. ADDITIONAL INSTRUCTIONS	43
9.1. WASTE DISPOSAL	43
9.2. DECOMMISSIONING AND DISMANTLING	43
10. ANNEXES	45
10.1. WIRING DIAGRAMS	45
10.2. SPARE PARTS	46

1. PREFACE

1.1. PURPOSE OF THE INSTRUCTION MANUAL FOR USE AND MAINTENANCE

This manual has been designed to provide the user with general knowledge of the machine and to allow it to be used safely.

This instruction manual is an integral part of the machine and has the purpose of providing all the information necessary to ensure:

1. safe handling of the machine, either packaged and unpackaged;
2. correct machine installation;
3. knowledge of the technical specifications of the machine;
4. thorough understanding of machine operations and limitations;
5. indication of the qualifications and specific training required of those operating and carrying out maintenance work on the machine
6. in-depth knowledge of its intended, unforeseen and prohibited uses;
7. its proper and safe use;
8. how to carry out correct and safe maintenance and repair operations;
9. technical assistance and management of spare parts;
10. disposal of waste produced by the machine;
11. the safe dismantling of the machine in accordance with applicable regulations to protect workers' health and the environment.

This document assumes that the applicable occupational health & safety and hygiene regulations are complied with at the site where the machine will be used.

IMPORTANT: Those in charge have the responsibility, in accordance with current legislation, to carefully read the contents of this Instruction Manual and ensure that operators and maintenance personnel read the parts relevant to them.

The customer has the responsibility to make sure that, if this document is modified by the Manufacturer, only the updated versions of the manual are actually present at the workplace.

The instructions, documentation and drawings found in this Manual are of a confidential technical nature and strictly the property of the Manufacturer, therefore, aside from the purpose for which it was produced, any reproduction in whole or in part of the contents and/or format must have the prior consent

of the Manufacturer.

THE OFFICIAL LANGUAGE CHOSEN BY THE MANUFACTURER IS ITALIAN. The manufacturer cannot be held liable for translations in other languages that do not conform to the original meaning (ORIGINAL INSTRUCTIONS).

1.2. RECIPIENTS

This Instruction Manual is intended for the installer, the operator/user, the system manager, the system safety manager and the qualified or qualified and authorised technician authorised to maintain the machine.

INSTALLER: Technician authorised by the manufacturer and expert in handling, installation, connection and adjustment of the machine.

OPERATOR/USER: This is the person in charge of using the machine and cleaning it.

PLANT MANAGER: The individual who makes the adjustments and the programming.

PLANT SAFETY MANAGER: Person responsible for verifying that all applicable safety regulations and the provisions set out in this manual are observed.

QUALIFIED TECHNICIAN: Qualified person who, by virtue of an accurate technical knowledge of the machine and all the safety procedures, performs ordinary maintenance and minor repairs.

QUALIFIED AND AUTHORISED TECHNICIAN: Highly qualified person, trained and authorised by the manufacturer to make significant adjustments and extraordinary maintenance or repairs during the warranty period.

EXPOSED PERSON: Any person who is wholly or partly in a dangerous area (near the machine and exposed to risk due to his or her safety).

The machine is intended for industrial use, so its use is strictly for qualified, skilled technical personnel, in particular those:

- over 18 years of age;
- physically and psychologically capable of performing particularly difficult technical work;
- sufficiently trained to use the machine and carry out maintenance work on it;
- deemed suitable for carrying out the task entrusted to them by their employer;

- capable of comprehending and interpreting the operator manual and the safety instructions;
- familiar with the emergency procedures and how to implement them;
- have understood the operational procedures established by the machine's Manufacturer.

1.3. STORAGE OF THE INSTRUCTION MANUAL

The Instruction Manual must be carefully stored and must accompany the machine each time it changes hands throughout its life cycle.

It should be kept in good condition by handling it with care, with clean hands, and not placing it on dirty surfaces.

Parts of the manual must not be removed, torn or changed.

The Manual should be kept close to the machine to which it refers in an environment free from humidity and heat.

1.4. UPDATING THE INSTRUCTION MANUAL

The Manufacturer is only liable for the Instructions issued and validated by itself (Original Instructions); any translations **MUST** always be accompanied by the Original Instructions to verify the correctness of the translation. In any case, the Manufacturer is not liable for translations that have not been approved by the Manufacturer himself, thus if an inconsistency is detected, attention must be paid to the original language and, if necessary, the manufacturer's sales office should be contacted, which will make the changes deemed appropriate.

The Manufacturer reserves the right to make changes to the project, changes/improvements to the machine and updates to the Instruction Manual without previously informing Customers. However, should changes be made to the machine installed at the Customer's site, in agreement with the Manufacturer and involving the adaptation of one or more chapters of the Instruction Manual, the Manufacturer shall provide the Customer with the parts of the Instruction Manual that concern the change, with the new global revision model. The Customer shall be responsible, following the instructions that accompany the updated documentation, for replacing any parts that are no longer valid with the new ones.

1.5. HOW TO READ THE INSTRUCTION MANUAL

The Manual is split into chapters, each one dedicated to a specific category of information addressed to the personnel for whom the relevant qualifications have been defined.

To facilitate immediate comprehension of the text, terms, abbreviations and pictograms are used, the meanings of which can be found in Paragraph 1.6.

1.6. TERMS, SYMBOLS AND PICTOGRAMS

To highlight parts of text of significant importance the following symbols were adopted:

ATTENTION: Indicates the need to adopt appropriate behaviours so as not to put people's health and safety at risk and not to cause damage to the machine or the environment.

HAZARD: Indicates situations of serious danger that can seriously endanger the health and safety of people.

IMPORTANT: Indicates technical information of particular importance which should not be neglected.

The following pictogram stickers are affixed to the machine, depending on the version:



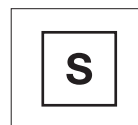
The product complies with the safety requirements provided by the applicable EU directives or regulations.



Carefully read the instructions listed in the manual.



Machine subjected to general danger (see instruction manual).



Machine used in environments with a high risk of electric shock.



WARNING!
Moving mechanical parts.
(For MIG generators only)

2. GENERAL INFORMATION

2.1. MANUFACTURER IDENTIFICATION DATA

MANUFACTURER: **SINCOSALD S.r.l**
HEADQUARTERS - OFFICES
via della Fisica, 26/28
20864 Agrate Brianza (MB) Italy
Tel: +39 039 641171
Fax: +39 039 6057122

CONTACTS:

export@sincosald.it www.sincosald.it

2.2. MACHINE IDENTIFICATION DATA AND PLATES














Each machine is identified by a CE plate on which its reference data is indelibly marked. For any communication with the manufacturer or service centre always quote these references.

IMPORTANT: The plate must not be removed for any reason, under penalty of forfeiture of the guarantee and the unavailability of spare parts due to failure to be identified. The position of the nameplate on the Machine can vary from machine to machine.

NOVATIG 204 ACDC LCD plate explanation

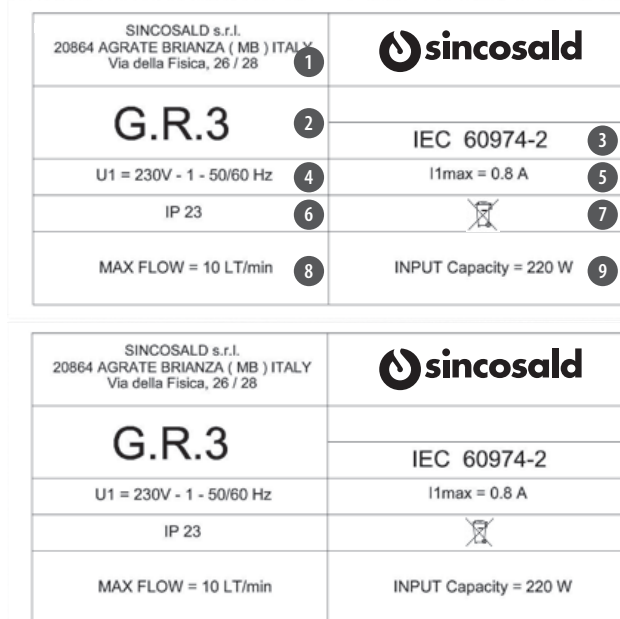
- Pos. 1** Name and address of the manufacturer and trademark
- Pos. 2** Identification of the welding machine model
- Pos. 3** Welding machine serial number
- Pos. 4** Welding machine type symbol: Transformer - Rectifier for arch welding
- Pos. 5** Reference to the legislation followed for welding machine construction: EN 60974-1
- Pos. 6a** Welding with TIG procedure
- Pos. 6b** Welding with MMA procedure
- Pos. 7** Symbol indicating that the welding machine can be used in environments with an increased risk of electric shock
- Pos. 8** Welding current symbol: Direct/Alternating Current
- Pos. 9** Rated no-load voltage U₀ in V
- Pos. 10** Electric adjustment range of the welding machine: minimum and maximum rated welding current, with the relevant charged voltages
- Pos. 11** Welding machine service factor (X): this figure indicates the welding machine service factor as a percentage of a 10-minute work cycle. Example X = 60% - I₂ 350 A, these data indicate that the welding machine on a work cycle can weld with a current I₂ = 350 A for a time of 6 minutes out of 10, that is 60%.
- Pos. 11a** Service factor: 35 %

NOVATIG 204 ACDC LCD

SINCOSALD S.r.l Via della Fisica 26/28 Agrate B.za - MB - Italy 1			
NOVATIG 204 AC/DC LCD 2		SERIAL NUMBER 3	
 4		 5	
6a 	8 	10A/10.4V - 200A/18V 10 	10A/10.4V - 200A/18V
7 	9 U ₀ =69V	X 11 60% 11b 100% 11c	X 60% 100%
		I ₂ 12 200A 12b 155A 12c	I ₂ 200A 155A
		U ₂ 13 18V 13b 16.2V 13c	U ₂ 18V 16.2V
6b 	8 	10A/20.4V - 200A/28V 10 	10A/20.4V - 200A/28V
7 	9 U ₀ =69V	X 11 35% 11a 60% 11b 100% 11c	X 35% 60% 100%
		I ₂ 12 200A 12a 153A 12b 118A 12c	I ₂ 200A 153A 118A
		U ₂ 13 28V 13a 26.1V 13b 24.7V 13c	U ₂ 28V 26.1V 24.7V
	15 U ₁ =230V	I _{max} =27A 16	I _{eff} =16A 17
	U ₁ =230V	I _{max} =30A	I _{eff} =17.7A
14  1~50/60-Hz.	IP21S 18	CE 19	 20

- Pos. 11b** Service factor: 60 %
- Pos. 11c** Service factor: 100 %
- Pos. 12** Rated welding current (I₂)
- Pos. 12a** Value of the rated welding current at 35 %
- Pos. 12b** Value of the rated welding current at 60 %
- Pos. 12c** Value of rated welding current at 100 %
- Pos. 13** Conventional load voltage (U₂)
- Pos. 13a** Voltage at 35 % load
- Pos. 13b** Voltage at 60 % load
- Pos. 13c** Voltage at 100 % load
- Pos. 14** Symbol for the welding machine power supply and number of phases (3) followed by the direct/alternating current symbol
- Pos. 15** Rated power voltage
- Pos. 16** Maximum current
- Pos. 17** Actual current
- Pos. 18** Indicates the degree of welding machine protection: IP 23
- Pos. 19** Product complies with the safety requirements established by the applicable EU directives or regulations
- Pos. 20** See chapter 9. ADDITIONAL INSTRUCTIONS

G.R.3 plate



Explanation of the G.R.3 plate

- Pos. 1** Name and address of the manufacturer and trademark
- Pos. 2** Cooling unit model identification
- Pos. 3** Reference to the regulation followed for cooling unit construction: IEC 60974-2
- Pos. 4** Cooling unit power voltage
- Pos. 5** Maximum current
- Pos. 6** Cooling unit protection grade: IP 23
- Pos. 7** See chapter 9. ADDITIONAL INSTRUCTIONS

- Pos. 8** Maximum flow (LT/min)
- Pos. 9** Absorbed power

2.3. DECLARATIONS OF CONFORMITY

The machine is constructed in compliance with the relevant EU Directives, applicable at the time of its entering onto the market.

2.4. SAFETY STANDARDS

The machine was built in accordance with the following standards and directives:

Harmonised standards
IEC 60974-1 - IEC 60974-5 - IEC 60974-10
Directives
EN 60204-1 - 2014-35-EV - 9231 EEC - 9368 EEC
Standards
EN/IEC 61000-3-12 - EN/IEC 61000-3-11 - EN/IEC 61000-3-3

2.5. INFORMATION ON TECHNICAL ASSISTANCE

The machines are covered by a warranty, as provided for in the general conditions of sale.

If during the warranty period you experience a malfunction or failure of the machine parts, which fall under the cases covered by the warranty, the manufacturer, after the necessary machine checks, will repair or replace defective parts.

The goods travel at the customer's risk; product damage caused by transportation or unloading is not covered by the warranty. All equipment and consumables supplied with the product are also excluded from the warranty.

It is reminded that any modifications carried out by the user, without the express written consent of the manufacturer, will void the warranty and free the manufacturer from any liability for damage caused by a defective product.

This applies in particular to alterations made to safety devices that reduce their effectiveness.

The same considerations apply when using non-original spare parts or those different to the ones explicitly specified by the manufacturer.

For these reasons, we recommend our customers to always contact our Customer Service.

2.6. PREPARATION BY THE CUSTOMER

Unless otherwise agreed in the contract, the following are normally the Customer's responsibility:

- Room preparations, including any building work and/or ducting systems required;
- Electrical supply of the equipment, in compliance with the standards in force in the country of use. Particular care must be given to the protective conductor commonly known as "earthing" and to the efficiency of the circuit breaker installed to protect the power outlet. It is the purchaser's responsibility to keep the above system adequately efficient, in compliance with current accident prevention regulations.
- Consumables or material normally subject to wear;
- Equipment unloading at delivery and the consequent liabilities.

3. SAFETY

3.1. GENERAL SAFETY WARNINGS

WARNING: your safety depends on you!!!

- *Follow all safety rules carefully.*
- *It is your duty to protect yourself and others from the risks of welding operations.*
- *The operator is responsible for his own safety and that of those in the work area. He must therefore know all the safety rules and observe them.*

Nothing can replace common sense!!!

IMPORTANT: Before operating the machine, carefully read the instructions contained in this manual and follow them thoroughly.

The manufacturer has made every effort to design this machine and to make it as **INTRINSICALLY SAFE** as possible.

The manufacturer has also equipped the machine with all the protective and safety devices considered necessary. Finally, it has provided enough information for it to be used safely and correctly.

IMPORTANT: This information must be scrupulously followed.

The user may choose to appropriately add to the information provided by the manufacturer with additional processing instructions, which, obviously, do not contradict that contained in this Instruction Manual, in order to contribute to safe machine use.

For example, you must pay close attention to the clothing that anyone working on the machine is wearing:

- Avoid using clothes with hooks that can remain attached to parts of the machine;
- Avoid using ties or other fluttering clothing parts;
- Avoid wearing bulky rings or bracelets that may get caught in parts of the machine.

Whenever necessary, further recommendations for use will be provided in the Manual for the user related to preventive measures, personal protective equipment, information to prevent human error and any reasonably foreseeable prohibited behaviour.

It is, however, essential to diligently follow the following indications:

- It is absolutely forbidden to operate the machine automatically with the fixed and/or mobile guards removed;
- It is strictly prohibited to disable the safety mech-

anisms installed on the machine;

- Operations at reduced safety levels must be carried out in strict accordance with the instructions given in the relevant descriptions;
- After any operation with reduced safety levels, guards/safety devices should be replaced on the machine as soon as possible;
- Any cleaning must be carried out with the electrical and pneumatic separation devices sectioned.
- Do not alter parts of the machine for any reason; in the event of malfunction, due to non-compliance with the above, the manufacturer cannot be held liable for the consequences. We recommend that you request any changes to be made directly to the manufacturer;
- Clean the casing of the machines, the panels and the controls with soft cloths that are dry or have been lightly soaked in a mild detergent solution; do not use any type of solvent, such as alcohol or petrol, as the surfaces may be damaged;
- Position the machines as determined at the time of order according to the diagrams provided by the manufacturer, otherwise it cannot be held liable for any problems.

ATTENTION:

The Manufacturer cannot be held liable for damage caused by the machine to persons, animals or property in the event of:

- **use of the machine by personnel who are not adequately trained;**
- **improper use of the machine;**
- **electrical, hydraulic or pneumatic power supply faults;**
- **incorrect installation;**
- **failure to perform scheduled maintenance;**
- **unauthorised modifications or operations;**
- **the use of spare parts that are not original or not specific to the model;**
- **total or partial failure to follow the instructions;**
- **use contrary to the specific national regulations;**
- **calamities and exceptional events.**

General requirements

The moving parts must always be used according to the manufacturer's instructions, as indicated in this manual, which must always be available at the workplace.

All safety features placed on moving parts to prevent accidents and safeguard safety can not be modified or removed, but must be adequately safeguarded.

The user must promptly inform the employer or his

direct superior of any defects or anomalies presented on the mobile parts.

A) Electric shock

ELECTRIC SHOCK CAN BE FATAL!!!

- All electric shocks are potentially fatal.
- Do not touch live parts.
- Insulate yourself from the piece to be welded and from the earth, wearing insulating gloves and clothes.
- Keep clothing (gloves, shoes, headgear, clothes) and body dry.
- Do not work in damp or wet environments. Do not lean on the piece to be welded.
- If you have to work near or in an area at risk, use all possible precautions.
- If you also feel a little electric shock, stop welding immediately; do not use the device until the problem is identified and resolved.
- Provide an automatic wall switch, of adequate capacity and possibly in the vicinity of the machine, to immediately cut off the device in the event of an emergency situation.
- Frequently inspect the power cord.
- Disconnect the power cord from the mains before working on the cables or before opening the machine.
- Do not use the machine without the protective bulkheads.
- Always replace any damaged parts of the machine with original materials.
- Never bypass machine safety devices.
- Make sure that the power supply line is equipped with an efficient earth socket.
- Make sure that the work bench and the work piece are connected to an efficient earth socket.
- Never electrically and simultaneously touch "hot" parts of pliers connected to two welders because the voltage between the two can be the total of the no-load voltage of both welding machines.
- Any maintenance must be performed only by expert personnel, aware of the risks due to the voltages necessary for the operation of the equipment.

B) Radiation

Ultraviolet radiation, emitted from the electric arc, can damage the eyes and burn the skin.

Follow the instructions below:

- Wear appropriate clothing and protective masks.
- **DO NOT use CONTACT LENSES!!!** The intense heat emanating from the electric arc could stick them to the cornea.
- Use masks with lenses, with a minimum DIN 10 or

DIN 11 protection grade.

- Protect people near the welding area.
- **REMEMBER:** The arc can blind or damage your eyes. The arc is dangerous up to a distance of 15 metres. Never look at the arc with the naked eye!
- Prepare the welding area so as to reduce reflection and transmission of ultraviolet radiation: paint walls and exposed surfaces black to reduce reflection, installing protective screens or curtains, to reduce ultraviolet transmissions.
- Replace the mask lenses when they are damaged or broken.

C) Welding wire

Attention: the welding wire can cause perforated wounds.

- Do not press the button on the welding torch before carefully reading the instructions for use.
- Do not point the torch towards parts of the body, other people or metals, when mounting the welding wire on the welding machine.

D) Explosions

- Do not weld above or near pressurised containers.
- Do not weld in an atmosphere containing explosive powders, gases or vapours.

This welder uses inert gases such as CO₂, ARGON, or ARGON + CO₂ mixtures to protect the arc, therefore it is necessary to pay the utmost attention to:

1) Cylinders:

- Handle or use pressurised cylinders in accordance with the regulations in force.
- Do not connect the cylinder directly to the machine's gas pipe, without using a pressure regulator.
- Do not use cylinders that leak or are physically damaged.
- Do not use cylinders that are not well secured to the welding machine or to suitable supports.
- Do not transport cylinders without the valve protection fitted.
- Do not use cylinders whose contents have not been clearly identified.
- Do not put the cylinder in electrical contact with the arc.
- Do not expose cylinders to excessive heat, sparks, molten slag or flames.
- Do not tamper with the cylinder valves.
- Do not attempt to unlock blocked valves with hammers, keys, tools or other systems.
- Never delete or alter the name, number or other markings on the cylinders. It is illegal and dangerous.
- Do not lift the cylinders from the ground by holding them by the valve or by the cap, or by using

chains, slings or magnets.

- Do not attempt to mix any gas inside the cylinders.
- Never refill the cylinders, but have them refilled by specialised companies.
- Do not modify or exchange the cylinder fittings.

2) Pressure regulators:

- Keep pressure regulators in good condition. Damaged regulators can cause damage or serious accidents; they must be repaired only by qualified personnel.
- Do not use regulators for gases other than those for which they were manufactured.
- Never use a regulator that leaks or appears physically damaged.
- Never lubricate a regulator with oil or grease.

3) Hoses:

- Replace hoses that appear damaged.
- Keep hoses taut to avoid accidental creases.
- Keep the excess hose collected and keep it out of the work area to prevent damage.

E) Fire

- Avoid igniting fire due to sparks and hot slag or incandescent parts.
- Ensure that appropriate fire protection devices are available near the welding area.
- Remove flammable and combustible materials from the welding area and the surrounding area (minimum 10 metres).
- Do not weld on fuel and lubricant containers, even if empty; these must be carefully cleaned before being welded.
- Allow the welded piece to cool before touching it or putting it in contact with combustible or flammable materials.
- Do not weld on parts with cavities containing flammable materials.
- Do not operate in atmospheres with high concentrations of combustible vapours, flammable gases or dust.
- Always check the work area thirty minutes after the end of welding operations to ensure that there are no fires.
- Do not keep combustible materials such as lighters or matches in your pocket.

F) Burns

Protect the skin against burns caused by ultraviolet radiation emitted by the electric arc, by sparks and slag from molten metal, using fireproof clothing, which covers all exposed surfaces of the body. Wear protective clothing and welder gloves, head-

gear and high shoes with safety tip. Button the shirt collars and pocket flaps and wear trousers without cuff to avoid the entry of sparks and slag.

Wear a mask with protective glass on the outside and adiactinic glass filter inside. This is MANDATORY for welding operations, in order to protect the eyes from radiant energy and volatile metals. Replace the protective glass if it is broken, pitted or spotted. Avoid oily or greasy clothes; a spark could ignite them. Incandescent metal parts, such as work pieces, should always be handled with gloves.

First aid equipment and a qualified person should be available for each shift, unless there are health facilities nearby for immediate treatment of eye and skin burns.

G) Fumes

Welding operations produce harmful fumes and metal dust, which can damage health:

- Do not work in spaces without adequate ventilation. Keep your head out of the fumes.
- In closed environments, use suitable exhaust fans. If ventilation is not adequate, use suitable respirators.
- Clean the material to be welded if there are solvents or halogen degreasers, which give rise to toxic gases. During welding, some chlorinated solvents can decompose in the presence of radiation emitted by the electric arc and produce phosgene gas.
- Do not weld coated metals or those containing lead, graphite, cadmium, zinc, chromium, mercury or beryllium, unless a suitable respirator is available.

The electric arc generates ozone. Prolonged exposure, in environments with high concentrations of ozone, can cause headaches, irritation of the nose, throat and eyes and severe congestion and chest pain.

IMPORTANT: DO NOT USE OXYGEN FOR VENTILATION!!!

Gas leaks must be avoided in small spaces. Large gas leaks can dangerously change the oxygen concentration.

Do not place cylinders in small spaces.

DO NOT WELD or cut where solvent vapours can be drawn into the welding atmosphere or if radiant energy can penetrate into atmospheres containing even tiny amounts of trichloroethylene and perchlorethylene.

H) Moving parts can cause damage

Moving parts, such as the fan, can cut fingers and hands and catch clothes.

Keep all doors, covers and guards closed and securely in place.

Protections and coverings can be removed, for possible maintenance and checks, only by qualified personnel.

Keep hands, hair, loose clothing and tools away from moving parts.

Refit the covers and guards and close the doors when the operation is completed and before restarting the machine.

I) Noise

These welders do not in themselves produce any noise exceeding 70 dB. Arc welding processes can produce noise levels above this limit. Therefore, users must implement the precautions required by law.

Ear plugs should be used when working overhead or in a small space.

A rigid helmet should be used when others work in the area above.

Welders should not use flammable hair products.

WARNINGS ABOUT ELECTROMAGNETIC COMPATIBILITY

Although these welding machines have been built according to the regulations, they can generate electromagnetic disturbances, that is disturbances to the telecommunication systems (telephone, radio, television) or to the control and safety systems. Read the instructions carefully to eliminate or minimise interference.

ATTENTION: the welding machine has been designed to work in an industrial environment, therefore, to operate in domestic environments it may be necessary to observe special precautions in order to avoid possible electromagnetic interference.

You must install and use the welding machine according to the manufacturer's instructions. If electromagnetic interference is detected, countermeasures must be taken to eliminate the problem, possibly using the manufacturer's technical assistance. In any case, do not modify the welding machine without the manufacturer's approval.

Work area control to prevent E.M. interference

Before installing the welding machine it is necessary to check the work area to detect the existence of services that could malfunction in the event of electromagnetic disturbances.

Below is a list of services to consider:

- a) Power cables, control cables, transmission system and telephone cables that pass near the welding machine.
- b) Radio or television transmitters and receivers.
- c) Computer or control equipment.
- d) Safety and industrial process control equipment.
- e) Calibration and measurement instruments.
- f) Check the level of electromagnetic immunity of the equipment operating in the work area.
- g) The health of people in the vicinity, for example people who use pacemakers and earphones for hearing.
- h) The daily duration of welding operations or other activities.

The other devices must be electromagnetically compatible. This operation may require additional protective measures.

The dimensions of the area to be considered depend on the structure of the building and the type of activity in progress.

PACEMAKERS AND HEARING AIDS

Magnetic fields deriving from high currents can affect the correct functioning of pacemakers and hearing aids. Wearers of electronic equipment should consult a physician before approaching arc welding operations.

METHODS FOR REDUCING EMISSIONS

A) Power supply

The welding or cutting device must be connected to the power supply following the manufacturer's recommendations.

When interference problems arise, it may be necessary to take measures to solve the problem, such as the addition of filters on the power supply.

In the case of permanent installation of the equipment, the metal shielding of the power cables can be taken into consideration. The shielding must be connected to the welding machine so that there is good electrical contact between it and the mantle of the welding machine itself.

B) Welding machine maintenance

The welding machine must be periodically subjected to maintenance, according to the manufacturer's instructions.

Remove dust or foreign materials every 6 months, which may have been deposited on the transformer or on the diodes of the rectifier unit; to do this use a jet of dry, clean air.

The mantle and all the possible accesses inside the welding machine must be correctly closed during the welding and cutting operations. The welding ma-

chine must never be modified in any part except for modifications planned and authorised by the manufacturer and carried out by persons authorised by the manufacturer.

In particular, the distance of the arc from the work piece and the stabilisation devices must be adjusted and maintained according to the manufacturer's recommendations.

C) Welding cables

Welding cables must be kept as short as possible and must be placed close to each other and passed on the floor or as low as possible.

D) Work piece earthing

The earth connection of the work piece can reduce electromagnetic emissions in some cases.

The operator must pay attention to avoid that the earthing of the piece is not a source of danger for people and damage to the equipment. Where necessary, earthing must be carried out with a direct connection between the work piece and the ground, while in countries where this is not permitted, the connection must be made using a capacitor in accordance with the regulations of the country.

E) Shielding

Cable and equipment shielding in the work area can reduce interference. Shielding of the entire welding or cutting installation can be considered for special applications.

F) Equipotential connections

The equipotential connections of all metal components in and near welding installations should be considered.

In any case the metal components connected to the piece to be welded will increase the risk for the operator to receive an electric shock from the simultaneous contact with these metal components and the electrode. The operator should be isolated from all these metal components rendered equipotential.

Checks and inspections

Checks must be carried out by a qualified technician or a qualified and authorised technician; they must be visual and functional, with the aim of guaranteeing the safety of the machine.

They include:

- inspection of all supporting structures, which must not show any signs of cracking, breakage, damage, deformation, corrosion, wear or alteration to the original characteristics;
- checking all mechanical parts;

- inspection of all the safety devices installed on the machine;
- ll connections with pins and screws;
- inspection of the machine operations;
- inspection of the machine status;
- verification of the correct operation and efficiency of the electrical system;
- checking the seal and efficiency of the pneumatic and/or hydraulic system.

The results of these checks must be reported on a specific sheet.

ATTENTION: If worn or faulty parts are not promptly replaced, the manufacturer cannot be held in any way liable for the damage caused by accidents that may result.

If faults or anomalies are detected, they must be eliminated before the machine is put into operation, and the expert carrying out the inspection will have to certify that the repair has been made, thus allowing the machine to be used.

If the person performing the inspection detects hazardous faults, they must promptly inform the machine manufacturer.

Place the machine out of service if operating faults are found while performing the appropriate checks/inspections and/or repairs. Check that no objects are left between the moving parts after any maintenance work.

In order to guarantee maximum safety of the machine it is, nonetheless, PROHIBITED to:

- Tamper with any part of the machine;
- Leave moving parts unattended;
- Use the machine when not operating at full efficiency;
- Modify the machine to change the originally established use, without explicit authorisation from the Manufacturer;
- Run moving parts with manual operations in case of power failure.

3.2. INTENDED USE

The welding system should only be used for the purpose for which it was manufactured meaning to generate an electrical arch for MIG/MAG, TIG, MMA welding accordingly.

ATTENTION: It cannot therefore be used as a device for thaw pipes; any improper use automatically voids the warranty and excludes the manufacturer from any liability in case of damage to persons and property.

3.3. CONTRAINDICATIONS FOR USE

The machine must not be used:

- For uses other than those specified by the manufacturer, for different uses or not mentioned in this manual;
- In explosive, corrosive atmospheres or with a high concentration of dust or oily substances suspended in the air;
- In atmospheres with high fire risks;
- Exposed to adverse weather conditions;
- With safety devices bypassed or out of order;
- With electrical bridges and/or other means that exclude power/parts of the machine.

3.4. HAZARDOUS AREAS

The work area pertaining to the operator which is substantially the entire perimeter of the machine is considered hazardous.

It is the responsibility of the operator to keep the work area clear of persons or objects while using the machine and to avoid damage to persons, things or animals.

The use of the machine near other equipment or machines introduces additional risks. The operator is asked to evaluate these risks in order to prevent accidents.

3.5. SAFETY DEVICES

Welding machines are equipped with safety devices designed to prevent damage to the operator or to the welding machine itself. A safety device is any object or system that can reduce the risk of such damage.

Do not tamper with active safety devices or their connections.

Do not operate with the welding machine without the metal covers or with non-insulated connections. If necessary, during installation and connection, they must be integrated with others in order to guarantee compliance with the laws in force.

IMPORTANT: Daily check that the safety devices are functioning properly and efficient.

3.6. SIGNS

The safety signs must always be clearly visible and it is absolutely forbidden to remove or hide them. Generally there are signals or signs on the machine or in the work environment that indicate dangerous situations, prohibitions or instructions during use or operations connected to it, as in the following examples:



Emission of optical radiation:
The risk of optical radiation exists where the sign is affixed. Cat. 2 (EN 12198).



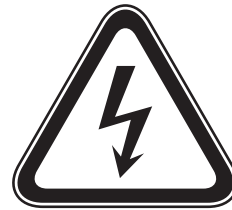
Fire hazard:
Fire hazards exist where the sign is affixed.



General warning:
This symbol indicates a hazard of any nature that may cause personal and property damages.



Explosion hazard:
This symbol indicates the presence of explosive substances or explosion hazard.



Warning:
Contact injuries may occur in this point (i.e. Electrical shock).



Blinding:
Protection goggles or mask must be worn near this symbol.



Fatal hazard:
Pay the utmost attention near this indication!!! Never touch the area indicated by this symbol since it indicates a fatal hazard.



Noise:
Protection goggles or mask
near this symbol.

3.7. RESIDUAL RISKS

Careful use of the machine minimises the probability of accidents; however, during the use of the machine it is necessary to strictly observe the safety rules described in this manual.

4. INSTALLATION

4.1. SHIPPING

The shipment, also depending on the destination, can be carried out by different means.

The packed machine must be properly anchored to the means of transport in order to avoid uncontrolled movements.

The shipment is always carried out under the responsibility of the purchaser who assumes all charges for accidents and thefts that could occur during the transport itself.

4.2. PACKAGING

The machine is shipped packed in a special container and, if necessary, it is suitably stabilised with shock-proof material to ensure its integrity.

The packaging is made, with containment of the overall dimensions, also depending on the type of transport adopted.

To facilitate transport, the shipment can be performed with some components disassembled and properly protected and packaged.

THE PACKAGING CONTAINS (H₂O version):

No. 1 **NOVATIG 204 ACDC LCD** welding machine

No.1 Cooling unit **G.R.3**

No.1 Instruction manual

OPTIONAL ACCESSORIES:

No. 1 Earth cable

No. 1 Clamp cable

No. 1 Welding torch

4.3. MACHINE RECEIPT

Upon receipt of the machine, check that the information in the shipping document actually corresponds to the material received and check that the packaging is perfectly intact.

IMPORTANT: in case of damage or absence of some parts, immediately report the anomaly to the carrier, making any descriptive notes of the damage on the transport document before signing.

Do not use the machine, but contact the seller to agree on the procedure to be adopted.

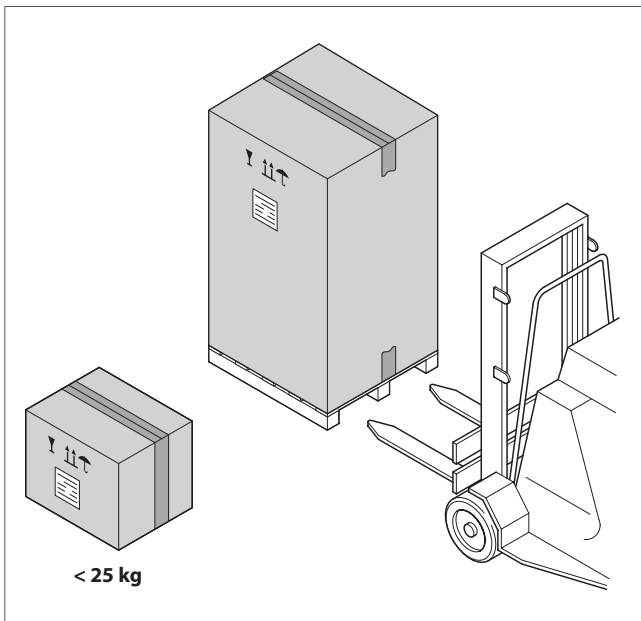
To this end, it is advisable to carry out a check of the packaging during the unloading phase and, in suspicious cases, open the packaging and to verify the safety of the machine and any loose units.

4.4. HANDLING AND LIFTING

ATTENTION: handling and lifting must be carried out by trained and qualified operators, using appropriate means and methods, to avoid risks to personal health and damage to the machine. Before carrying out handling and lifting, check the position of the centre of gravity of the load; always check the correct weight balance of the machine when it is transported, so as to prevent unexpected machine movements or falls. It is recommended to always use vehicles capable of supporting the weight and dimensions of the machine ("TECHNICAL SPECIFICATIONS" paragraph of this manual), so as to avoid damage to the machine or to persons or things around it.

IMPORTANT: the customer is always exclusively liable during the equipment loading and unloading phases.

For transport to the final installation site, it is preferable to use a forklift or pallet truck, taking care that the lifting forks support the entire crate.



For movements within the plant, the machine may be transported with a crane by properly harnessing it using cables with the appropriate resistance characteristics, depending on the weight of the machine itself.

If the supply includes only the welding machine, generally weighing less than 25 kg, the packaging consists of a cardboard box without lifting pallets. It can be easily lifted by two operators and taken to the place of use.

ATTENTION: The machine must remain packed during unloading from the means of transport and until it is transferred to its destination.

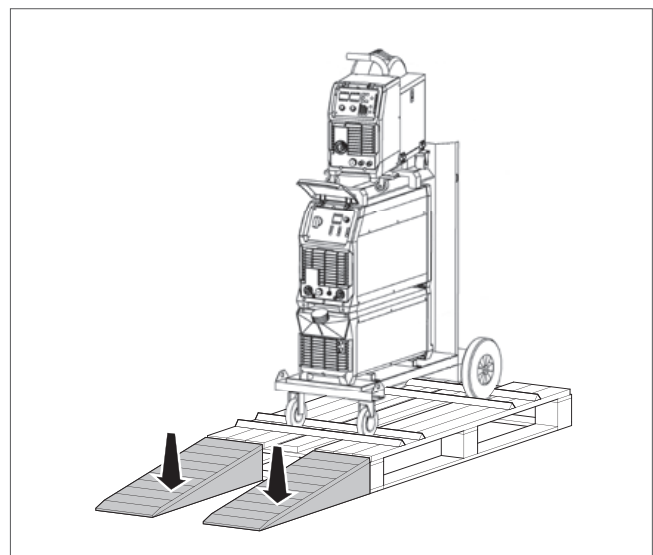
IMPORTANT: The Manufacturer cannot be held liable for damage caused to persons or property due to utilising lifting systems other than those described above.

4.5. UNPACKING

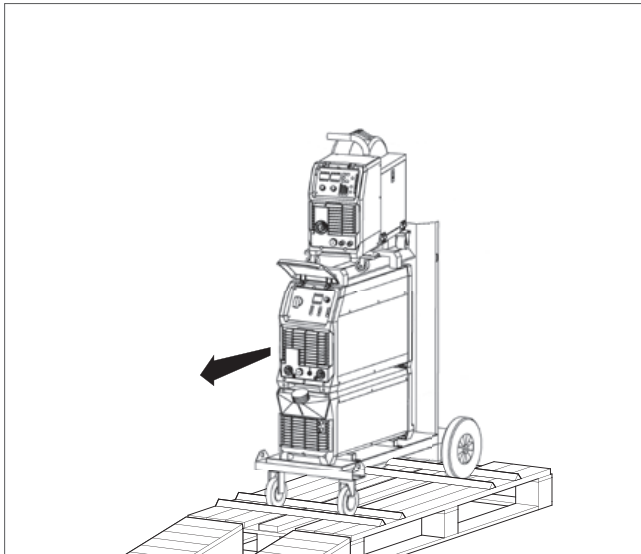
IMPORTANT: Consult the "Handling and lifting" paragraph to correctly handle the machine.

ATTENTION: To remove the machine from the packaging, use appropriate means and methods to avoid risks to human health. The packaging material must be properly disposed of in compliance with the laws in force.

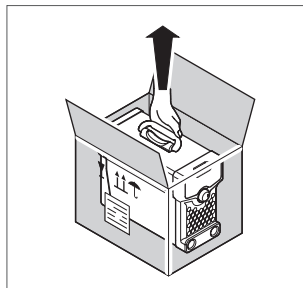
- Remove the protective covers such as straps, boxes, etc. using appropriate tools so as not to ruin the content.
- Remove the protective covers such as straps, boxes, etc. using appropriate tools so as not to ruin the content.
- Position appropriate descent ramps from the pallet verifying that the slides are well hooked to the pallet.



- Complete the unloading operations by carefully lowering the machine from the pallet.



If only the welding machine is present, this must be handled using the convenient handle on the upper part of the welding machine itself.

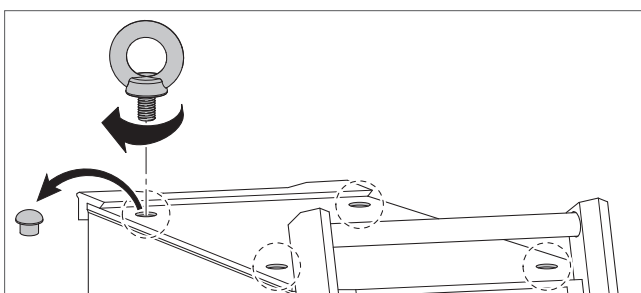


ATTENTION: risk of overturning when unloading the machine from the pallet equipped with descent ramps.

ATTENTION: when carrying out unpacking operations, it may be necessary to have two persons equipped with suitable personal protective equipment.

IMPORTANT: in addition to handling the machine using the special trolley, it can be lifted from the ground after having wrapped it with lifting straps, by slinging it from the bottom in a stable and safe way. If provided, the machine must be lifted only and exclusively by using M10 eye-bolts which are not supplied.

Remove the protective caps from the threaded holes and tighten up the lifting eye-bolts.



Do not lift the machine by the FEEDER or generator handles.

The welder has a sturdy handle integrated in the frame for handling.

N.B. These lifting and handling devices comply with the provisions prescribed by European standards. Do not use other devices such as lifting and handling equipment.

ATTENTION: do not lift and / or move the system with the gas cylinder connected.

4.6. STORAGE

In the case of inactivity, the machine must be stored in compliance with the following precautions:

- Store the machine in an enclosed area accessible only to employees; the storage area must have a stable support surface with an adequate load coefficient and must be free of fire and/or explosion risk; it must have adequate humidity and temperature and sufficient lighting.
- Protect the machine from any impact and stresses;
- Protect the machine from humidity and high temperatures;
- Ensure the machine does not come into contact with corrosive substances;
- In the event of prolonged storage, periodically check that there are no variations in the condition of the packages.

4.7. PREPARATIONS

Installation preparations

For the installation, it is necessary to prepare a manoeuvring area suited to the machine dimensions and selected lifting means. The machine must be positioned so that it is ideally ergonomic and provides maximum safety in the work place: leave an area around it large enough to allow easy operations and handling of the material to be processed and for maintenance and adjustment operations to be carried out.

Before installing the machine, check that the selected area is suitable and has the necessary authorisations to carry out the activity, sufficiently ventilated and illuminated, with a stable and levelled support surface. For installations on a raised floor, check that the slab can withstand the load.

Electrical system preparation

Connection to the electrical system which powers and combines the synchronisation with other machines should be done by specialised and qualified staff fol-

Following the wiring diagram and arrangements set out in Laws and/or Technical Standards currently in force for safety in workplaces and electrical installations. Appropriate safety devices must be provided for its operation in line with those required in the area of safety in the workplace.

IMPORTANT: The manufacturer cannot held liable for any damage to property, persons and/or animals caused by non-compliance with this provision.

To achieve an adequate level of safety, the electrical system to which the machine is connected must provide, at the user's full charge, an earthing system according to the provisions of the user's country, a circuit breaker to protect the power supply socket with value ΔI (current variation) not less than 30mA and anything else for a correct execution in a workmanlike manner, according to Laws and/or Technical standards in matters of safety in the workplace and electrical systems. Prepare connections for earthing the machine casing.

ATTENTION: These preparations are always the sole liability of the user and nothing can be attributed to the manufacturer for damage to property, persons and/or animals due to poor electrical connections.

4.8. ASSEMBLY/POSITIONING

WARNING: the assembly of any detached units and the installation of the machine must be carried out exclusively by technicians authorised by the manufacturer.

To allow for correct operations, the machine must always be positioned in places that comply with the environmental conditions described in this manual.

The machine must always be positioned in a perfectly levelled area; levelling can also be carried out using any adjustment systems present on the machine.

ATTENTION: The machine must be positioned so as not to obstruct the entry and exit of the air from the cooling slots. REDUCED FLOW OF AIR causes overheating and possible damage to internal parts. Keep at least 500 mm of free space around the device.

IMPORTANT: Do not place any filtering device on the air intake passages of this welding machine. The warranty is void if any type of filtering device is used.

4.9. CONNECTIONS

Electrical connections

The machine's internal connections are carried out by qualified personnel sent by the manufacturer. The electrical connection between the machine panel and the customer's power distribution supply line must be carried out by qualified personnel from the Customer.

IMPORTANT: The personnel qualified to carry out the electrical connection must make sure of the perfect efficiency of the earthing of the electrical system and must check that the line voltage and the frequency correspond to the data shown on the identification plate. Incorrect supply voltages can cause serious damage to the system.

If the system is set to operate at single-phase 230 V at 50-60 Hz, wire the end of the power cable to an EEC plug with the same capacity as the socket on the line switch as per the following diagram:

SINGLE-PHASE connections

Wire colour	Connection
Brown	"S" phase
Blue	"T" phase
Yellow/Green	Earth

If the system is set to operate at three-phase 400 V at 50-60 Hz, wire the end of the power cable to an EEC plug with the same capacity as the socket on the line switch as per the following diagram:

THREE-PHASE connections

Wire colour	Connection
Black	"R" phase
Brown	"S" phase
Blue	"T" phase
Yellow/Green	Earth

ATTENTION: Make sure the system line switch is in the "0" position before connecting the power cable.

ATTENTION: It is mandatory to install a circuit breaker with interlocked CEE socket, of adequate capacity and verifying that the earth socket is efficient and separate from the rest of the electrical system of the working environment.

ATTENTION: the yellow-green wire of the welding machine power cable must always be connected to the protection conductor (system earth). The yellow-green wire should NEVER be combined with another phase wire for a voltage withdrawal. Do not touch live parts.

Gas hose connection

ATTENTION: Cylinders can explode if damaged!!!

- Keep the cylinders upright and chained to the appropriate support.
- Keep the cylinders in a place where they cannot be damaged accidentally.
- Do not lift the machine with the cylinder attached.
- Never touch the cylinder with the welding wire.
- Keep the cylinder away from the welding area or from non-insulated electrical circuits.

The inert gas cylinder must be equipped with a pressure reducer and possibly also a flow meter. Only after having correctly positioned the cylinder, connect the gas hose, exiting from the rear of the machine, to the pressure reducer. Next you can open the cylinder and adjust the pressure reducer.

4.10. PRELIMINARY CHECKS

It is necessary to carry out the following operations before each machine start-up:

- Check all the safety systems;
- Check protection and signs.

Before putting the machine into operation, a number of checks and controls must be carried out in order to prevent errors or accidents during the Start-up phase:

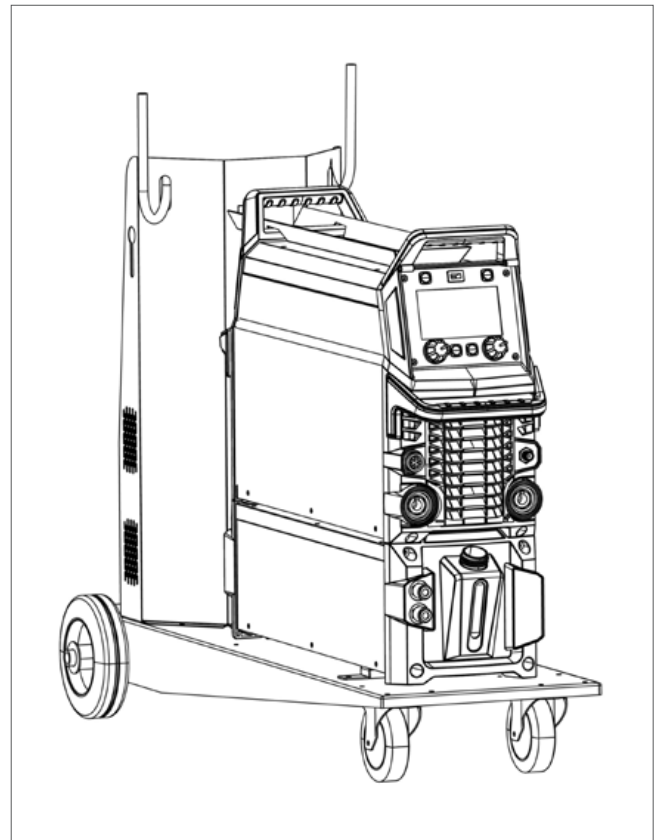
- Check that the machine has not been damaged during assembly;
- Verify, with particular care, the integrity of the electrical panels, control panels, electrical wiring and tubing;
- Check the exact connection of all external power sources;
- Check the free movement and free rotation of all moving parts;
- Check that hydraulic and pneumatic connections are tight so that they do not cause dangerous leakage.

5. MACHINE DESCRIPTION

5.1. OPERATING PRINCIPLE

The **NOVATIG** series welding systems were designed for TIG welding.

The **NOVATIG**.series welding system composition is shown below.



5.2. FEATURES AND MAIN COMPONENTS

- Lift TIG and HF Start Modes for versatility when welding around sensitive electronic equipment.
- Adjustable arc force, hot start & anti stick control for greater control and ease of use when MMA welding.
- Electronic HF TIG arc ignition system for contamination free and easy arc starting with low EMF interference.
- High performance on ultra thin surfaces with no deformation.
- 2T/4T trigger control.
- Digital display meter for accurate setting & feedback of welding output.
- Equipped with temperature, voltage and current sensors for high protection.
- Designed to work with diesel generators and to avoid failures due to its voltage spikes.

- Up/ Down Button Remote Control torch.
- Roller wheel amps control on torch.
- Wireless Remote Control. (optional)
- Wire/Wireless Foot Pedal. (optional)

5.3. ENVIRONMENTAL CONDITIONS

The machine does not require particular environmental conditions. The machine must be installed indoors in a well-lit, ventilated industrial building with solid and level flooring.

The machine is suitable for operating in environments that:

- have an altitude not exceeding 2000 m a.s.l.;
- temperature between + 5 ° and + 35 ° C;
- relative humidity not higher than 80%.

It is forbidden to use the machine in environments that are:

- dusty;
- in corrosive atmosphere;
- at fire risk;
- in an explosive atmosphere.

ATTENTION: The welding machine has an IP 23 protection grade, therefore its use is precluded in certain environmental situations, such as rain, excessive presence of metallic dust, presence of acids and corrosive atmospheres.

5.4. LIGHTING

The lighting of the area of installation must comply with the laws in force in the country where the machine is installed and must, however, ensure good visibility at all points, not create hazardous reflections and allow clear reading of the control panels as well as identification of emergency buttons.

As the machine does not have its own light, it is necessary for the working environment to be equipped with general lighting to guarantee the machine has a value of 200 and 300 lux at all points of the machine.

5.5. VIBRATIONS

Under operating conditions that comply with the indications for proper use, the vibrations are not such as to cause hazardous situations. If this happens, you must request technical assistance and suspend the use of the equipment until the fault is resolved.

5.6. NOISE

The equivalent continuous A-weighted sound pressure level, emitted by the machine at the workplace in full operating conditions, is less than 70 dB (A). These emissions comply with the limits of the regulations in force and are not such as to generate danger for operators.

Arc welding processes can, however, produce noise levels above this limit. Therefore, users must implement the precautions required by law.

5.7. TECHNICAL SPECIFICATIONS

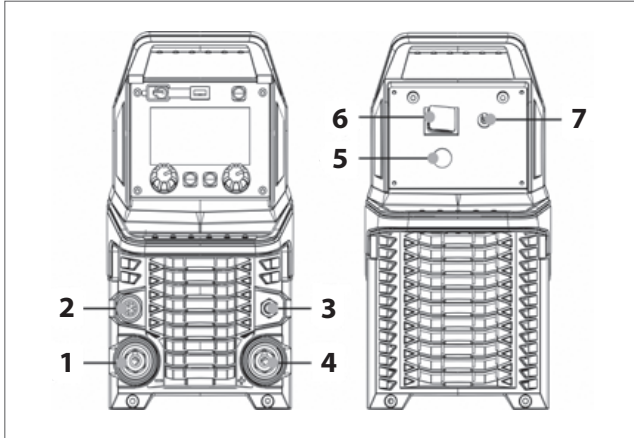
The following table shows the main technical specifications relating to the machine:

Parameters	NOVATIG 204 ACDC LCD	
	AC/DC MMA	AC/DC TIG
Input power	1~220/230/240±10% 50/60HZ	
Rated input current (A)	30	21
Rated input power (KW)	6.8	4.7
Duty cycle (40°C, 10 minutes)	35% 200A	
	60% 153A	60% 200A
	100% 118A	100% 155A
Welding current (A)	10-200	
Power factor	0.99	
No-load voltage(V)	69	
Downslope time (S)	0~10	
Pre-gas time (S)	0.1~2	
Post-gas time (S)	0~10	
Pulse Frequency (HZ)	0.5~999	
AC Frequency (HZ)	50~250	
Balance (%)	-5~+5	
Pulse width range (Duty cycle) (%)	5~95	
Efficiency (%)	≥80%	
Insulation Class	IP 21S	
Protection Class	H	
Cooling	AF	
Dimensions of Machine (L×W×H) (mm)	680×210×395	
Net Weight (Kg)	16.7	

6. USO MACHINE USE

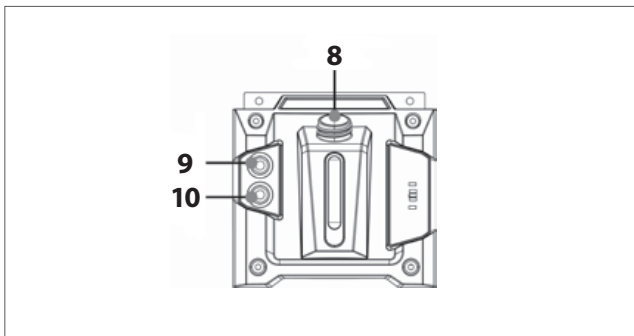
6.1. MACHINE LAYOUT DESCRIPTION

6.1.1. Layout for the front and rear panel



- 1- “-” Output terminal.
- 2- TIG torch remote connection socket. *
- 3. TIG torch gas connector.
- 4. “+” Output terminal.
- 5. Input power cable.
- 6. Power switch
- 7. Inlet gas connector.

6.1.2. Water cooler

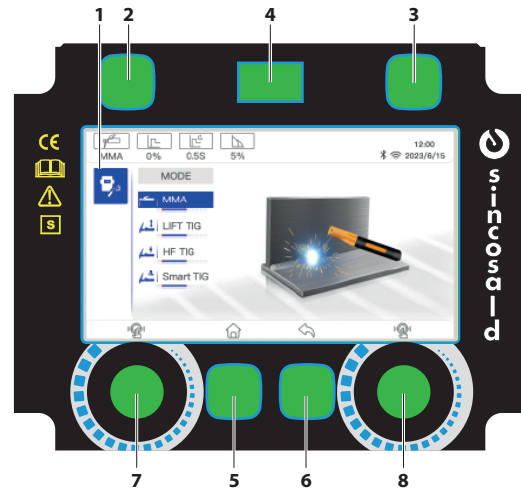


- 8. Water inlet
- 9. Water supply connector (blue)
- 10. Water return connector (red)

* Denotes more detailed explanation of function to follow.

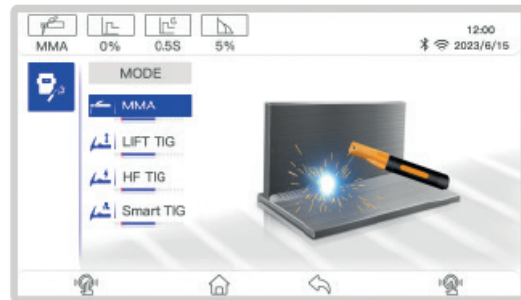
6.2. WELDING OPERATION

Main Start-up Interface:



(1) Function selection interface:

Rotate (7) Knob in the interface to choose from the Four welding methods of MMA, LIT TIG, HF TIG and Smart TIG. Press to confirm.

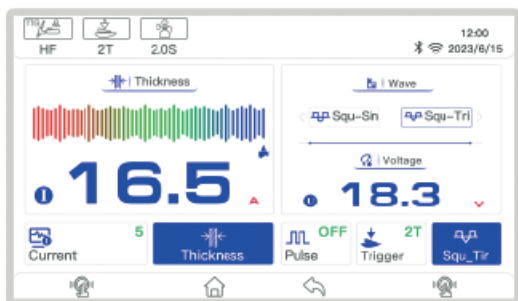




Rotate **(8)** Knob in the interface to choose the wave.



(1) Welding parameter setting interface: a welding parameter and its corresponding value may be selected and set by rotating **(7)** Knob and **(8)** Knob in the interface.

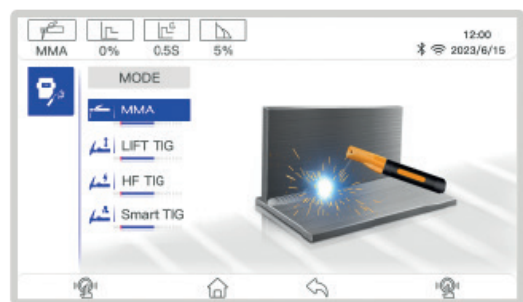


(3) System setting interface: a system parameter and its corresponding value may be selected and set by rotating **(7)** Knob and **(8)** Knob in the interface shown below:

System parameters available by rotating (7) Knob	System parameters available by rotating (8) Knob
Language	English/Simplified Chinese...
Unit	English/Metric
Beeper On/off	
Brightness	1 - 10
Factory Reset	Press
Cooler	ON/OFF (customerise)



(5) Function selection interface button: Press this key to switch **(1)** **(2)** **(3)** **(6)**






- (6) **Enter the welding interface button:** In any case, press this key to enter the final welding interface.
- (7) **Function menu select and determine knob:** Rotate knob to select function/parameters, press knob to indicate selection
- (8) **Parameter adjusting knob:** Rotate knob to select waves/parameters value
- (9) **Welding mode icon display interface:** an interface displaying the icon of the welding mode currently used (2T/4T/Q-Start/D-ARC etc.).


6.2.1. Operation of DC TIG HF/LIFT welding method:

1. Selection of the welding method: (DC MODEL)

- 1) In the main interface, press the  key to enter the function selection interface;
- 2) In the function selection interface, rotate L-Knob to select the TIG HF welding method and press it for confirmation. Rotate R-Knob to select the wave. (DC/AC)



2. Selection and setting of welding method:

- 1) In the main interface, press the  key to enter the welding parameter setting interface;

- 2) In the welding parameter setting interface, rotate L-Knob to select the parameter as required and rotate R-Knob to set a value for the parameter.



Welding parameters available by rotating L Knob	Welding parameters available by rotating R Knob
2T/4T/REPEATED	2T/4T /REPEATED
Pulse	OFF/ON
Spot	OFF/0.1-20S
Q-Start	OFF/0.1-60S
Dynamic ARC	OFF/1-50A
MULTITACK	OFF/0.5-6.0Hz

2T Mode

The trigger is pulled and held on to activate the welding circuit, when the trigger is released, the welding circuit stops.

4T Mode

This is known as 'latching' mode. The trigger is pulled once and released to activate the welding circuit, pulled and released again to stops the welding circuit. This function is useful to longer welds as the trigger is not required to be held on continuously. TIG series of welding machines also has more current control options that can be used in 4T mode.

REPEATED Mode

This is known as the repeat function, which switches the base current and peak current by pressing the torch switch during welding. First set the base current and peak current, press the gun switch to set the base current and then press the gun switch to set the peak current. You can always do this. Long press the gun switch and it will stop working.

Spot Mode

First, set the spot welding time, press the switch welding current, and finish the welding within the set spot welding time.

If the deceleration time is on, finish the welding after the spot welding time + deceleration time.

Q-Start

The Q-Start (quick START) feature helps to interconnect the workpieces during the initial phase of the welding process. When this function is activated, the machine will automatically switch to the cooperative pulse mode, preset the time. The resulting pulse causes the molten metal to move along the edges of the two plates, thus accelerating the formation of the workpiece. This is important for small openings or for irregular joints. The continuous time of the pulse train can be adjusted according to the thickness and shape of the sheet to be welded from 0.1 seconds to 60 seconds)

Dynamic ARC

The DYNAMIC ARC function keeps the voltage X current product constant. The power supply increases the welding current with the decrease of arc voltage and decreases the welding current with the increase of arc voltage. The Dynamic Arc function which ensures an enhance welding penetration, a better stability of The arc, avoiding any gluing between electrode and base metal; it allows to adjust the welding arc, just through slight torch’s movements, at any welding conditions. Dynamic arc values can be adjusted from a minimum of 10 amperes to a maximum of 50 amperes for every 1 volt change (positive or negative).

Welding advantages of dynamic arc function:

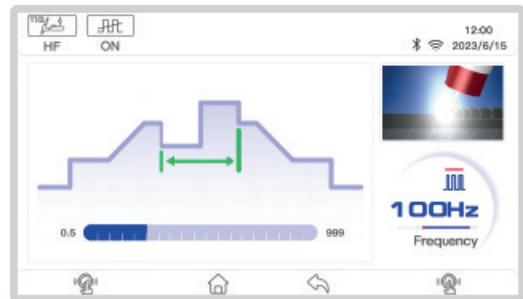
Faster welding - less plastic deformation of welded parts. Increase the apex Angle a heat input focus only on the weld penetration, would have no impact in the surrounding area a reduce oxidation, reduce rework after welding cost a improved control of the first root bead (this is good for the plumber and factory engineers) a lower welding electrode contact hole when the risk of bonding a device can be very close to the welding molten pool, thus can be concentrated arc.

MULTITACK

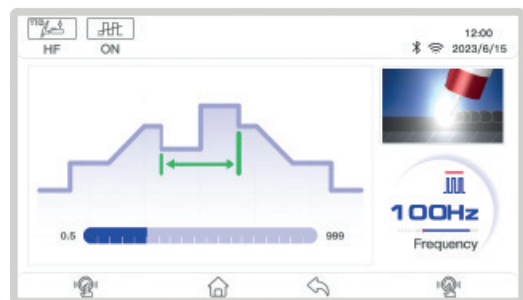
The MULTITACK feature reduces heat output when connecting two lighter workpieces (0.6 mm to 0.8 mm).Although a series of arcs occur at short intervals, the system minimizes deformation by allowing the material to cool during the pause between one arc and the next. The device adjusts the frequency of a series of arc strikes in the unit of time so that the arc strikes can adapt to the welding speed and the geometry of the joint.

3. Welding and parameter setting interface

- 1) In the main interface, press key to enter the welding interface.



WHEN THE PULSE ON

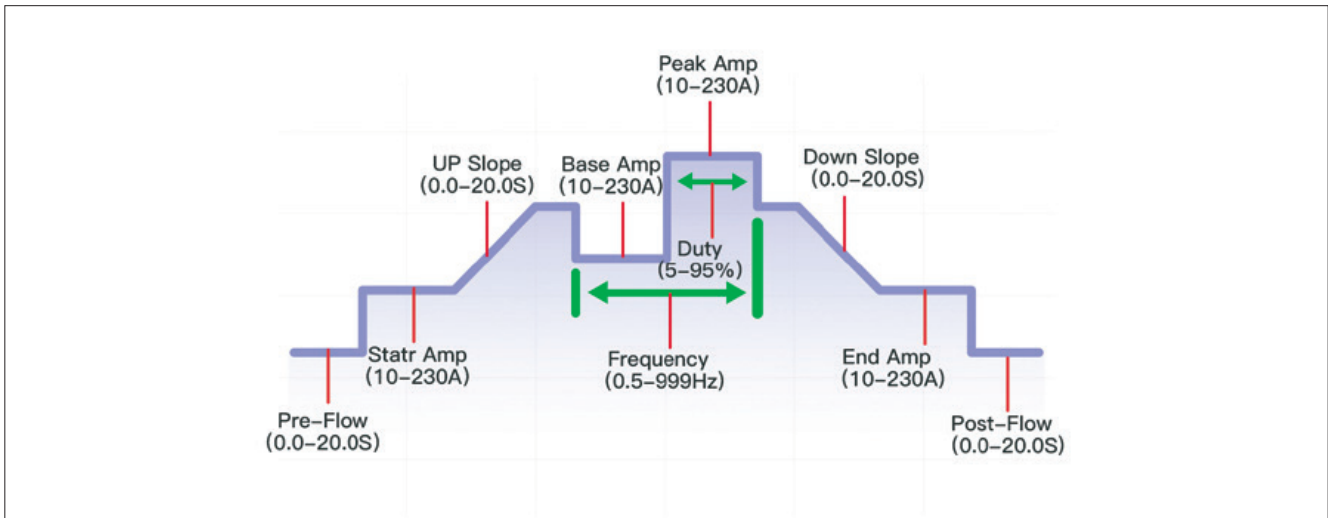


WHEN THE PULSE OFF

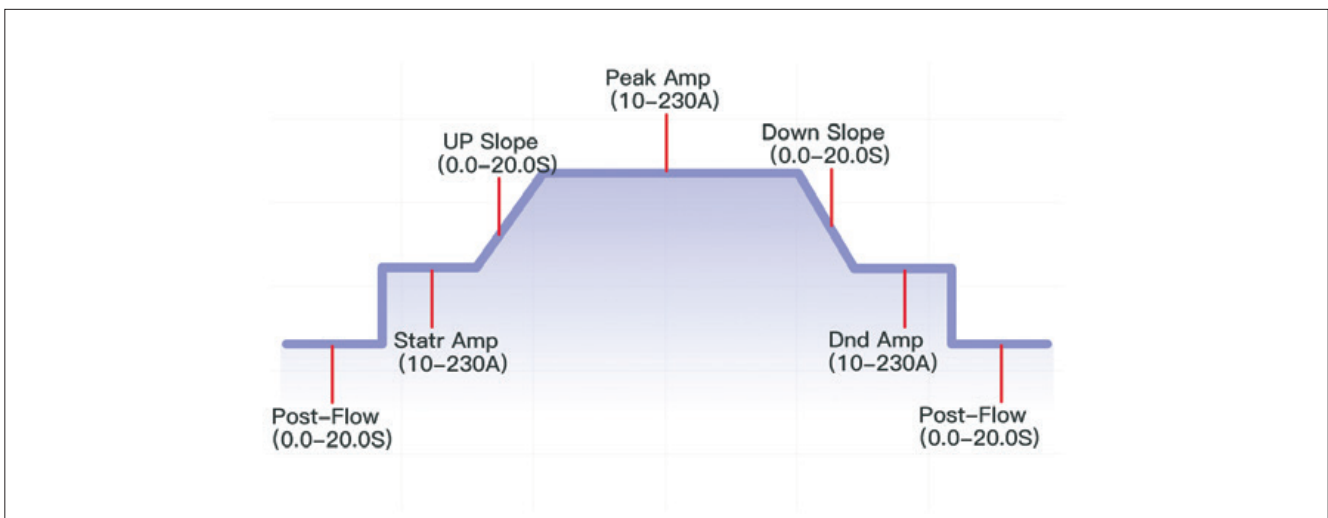
- 2) In the welding parameter setting interface, rotate L-Knob to select the parameter as required and rotate R-Knob to set a value for the parameter..



Parameter description and scope (PULSE ON):




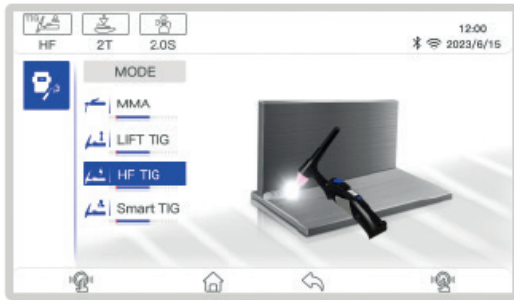
Parameter description and scope (PULSE OFF):




6.2.2. Operation of AC TIG HF/LIFT welding method:

1. Selection of the welding method: (AC MODEL)

- 1) In the main interface, press the  key to enter the function selection interface;
- 2) In the function selection interface, rotate L-Knob to select the TIG HF welding method and press it for confirmation. rotate R-Knob to select the wave.



2. Selection and setting of welding method:

- 1) In the main interface, press the  key to enter the welding parameter setting interface;
- 2) In the welding parameter setting interface, rotate L-Knob to select the parameter as required and rotate R-Knob to set a value for the parameter.



Welding parameters available by rotating L Knob	Welding parameters available by rotating R Knob
2T/4T/REPEATED	2T/4T /REPEATED
Pulse	OFF/ON
Spot	OFF/0.1-20S
MIXED AC/DC	OFF/10%-80%
EXTRA Fusion	OFF/1%-80%
MultiWAVE	OFF/6 Type Waves

6.2.3. Cap mode on iWave AC only



Setting range: OFF/ON
Factory setting: OFF

OFF

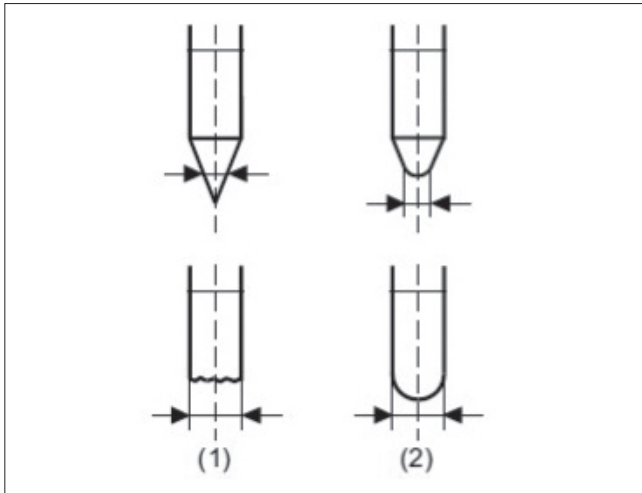
Automatic cap-shaping function is deactivated.

ON

For the entered diameter of the tungsten electrode, the optimum cap is formed during the welding start.

A separate cap-shaping action on a test workpiece is not required.

After this, the automatic cap-shaping function is re-set and deactivated again.



1) Before ignition
2) After ignition

Cap mode must be activated separately for each tungsten electrode.

NOTE: The automatic cap-shaping function is not required if a sufficiently large sphere has already formed on the tip of the tungsten electrode.

MIXED AC/DC

MIX AC/DC AC/DC mixing function can adjust the welding current, alternating TIG AC and DC TIG arc welding with half cycle. This means that the effect of AC TIG can be combined with the high weld permeability of DC TIG to obtain a higher welding speed and quickly form a weld pool on the cold workpiece. Heavy duty instruments can also be welded with a lower current because the current in the DC portion is much higher than the parent portion when welding heavy duty instruments as opposed to using the AC waveform fully. For the operator, the adjustable parameter is the percentage of ac waveform and DC waveform over the entire cycle, and the adjustable range is from 10% to 80%.

Advantages of AC/DC mixing:

- Heavy duty dashboard Supply can be welded at a lower current than specified when using dedicated AC
- The welding speed is very fast due to the high proportion of DC current during this period.
- Rapid generation of welding pool (suitable for surface treatment of tools, molds and large size castings)
- Weld plates of various thickness (1mm to 10mm). It is better not to exceed 50% of the DC waveform, otherwise it will affect the pickling of the parts and the appearance of the weld bead.

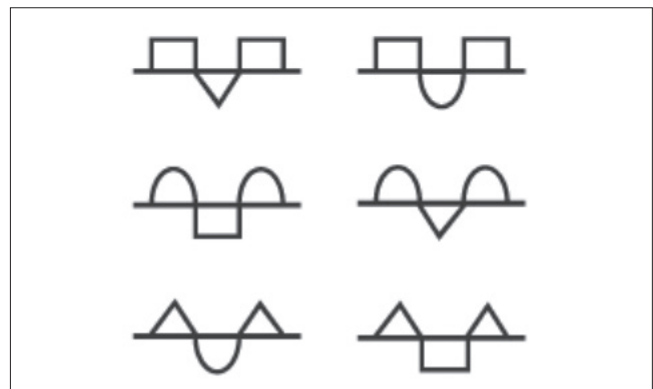
Adjustment range: 1%-80% refers to the proportion of AC

EXTRA Fusion

The EXTRA FUSION feature can move the waveform relative to zero to the negative. This creates a highly permeable and precise pool that allows very light workpieces to be welded using electrode heads comparable to those used for DC TIG welding. The adjustable value of the AC/DC TIG arc power source for the equipment is between 0% and 80% (as compared to the DC half wave percentage). Since the DC + assembly is not sufficient to ensure optimum cleaning (pickling) of the workpiece during welding, the use of additional weld functions is not recommended for welding large instruments.

MultiWAVE

Can each person's habit as well as the different occasion choice different waveform



3. Welding and parameter setting interface

- 1) In the main interface, press key to enter the final welding interface

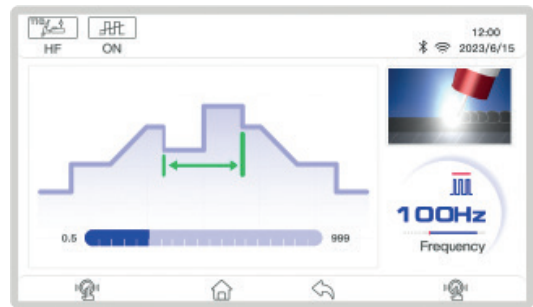


WHEN THE PULSE ON

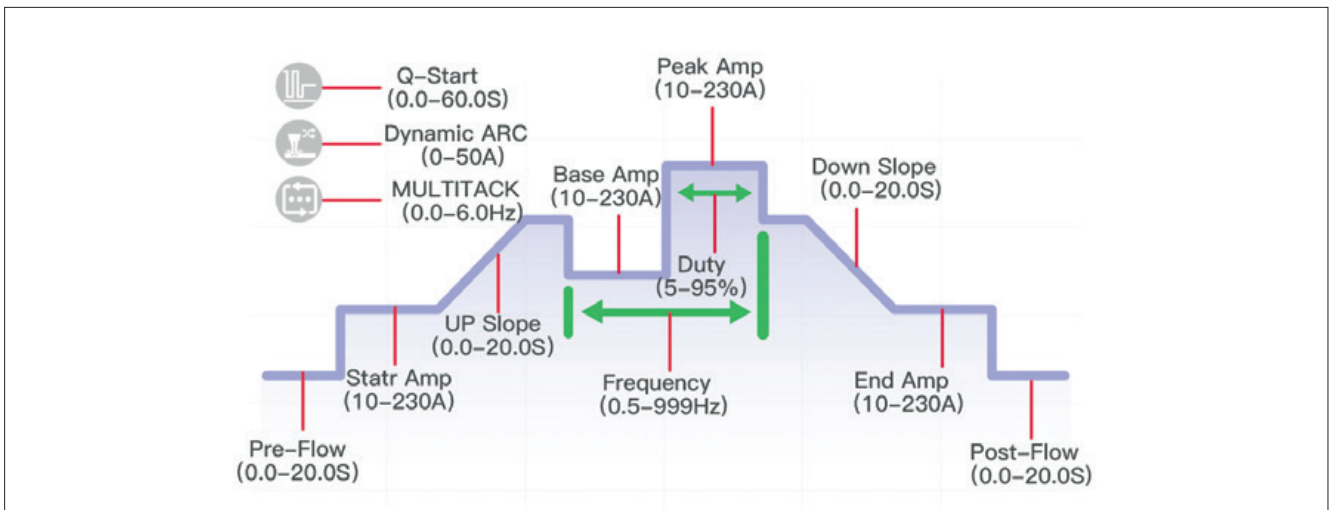


WHEN THE PULSE OFF

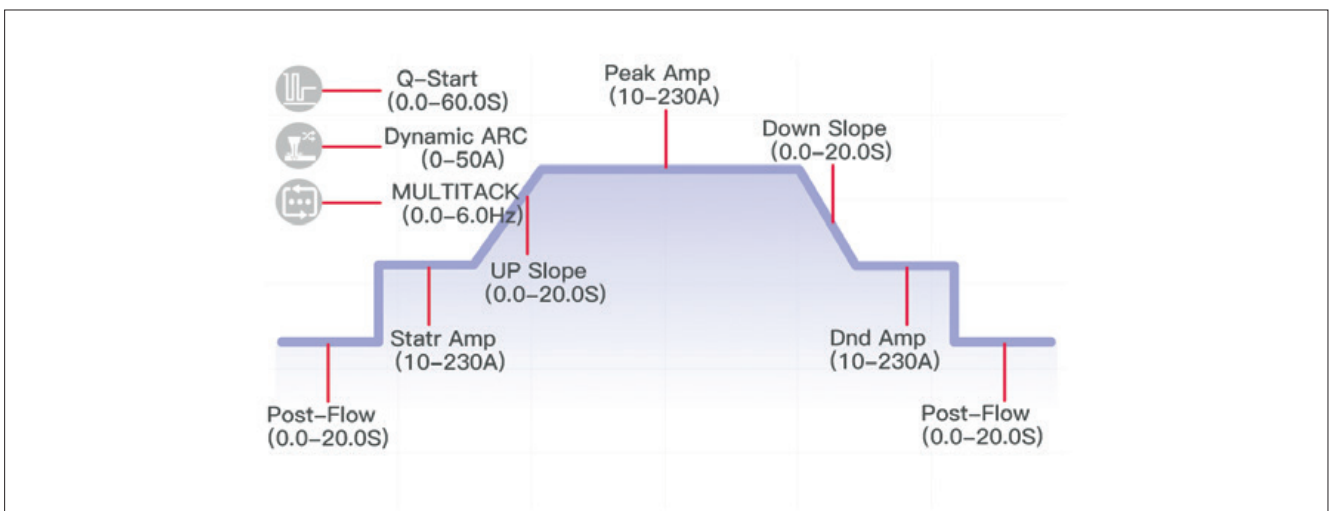
- 3) In the welding parameter setting interface, rotate (6) Knob to select the parameter as required and rotate (7) Knob to set a value for the parameter.



Parameter description and scope (PULSE ON):



Parameter description and scope (PULSE OFF):



Pre Gas

Pre Gas controls the period shielding gas will flow for when the torch is triggered before the arc starts. This purges the work area of atmospheric gas which could contaminate the weld before the weld starts. Unit(S) and setting range (0.1-2S).

Start current

Available in 4T trigger mode, sets a welding current 5-100% of the main welding current activated when the trigger is held on to 'latch' the trigger before the main weld current is started.

Once the trigger is released, the current will go through the up slope (3) period if it is set, to the main welding current.

Up slope

When the trigger is activated, the welding current will increase gradually over the time selected up to the set main welding current. Unit(S) and setting range (0-10.0S).

Peak current

Sets the main welding current. Unit(A) and setting range (5-200A).

Base current

Only available when pulse mode is selected. Sets the current of the low/ base pulse. Unit(A) and setting range (5-200A).

Down slope

When the trigger is released, the welding current will reduce gradually over the time selected down to 0. This allows the operator to complete the weld without leaving a 'crater' at the end of the weld pool. Unit(S) and setting range (0-10.0S).

End current

Available in 4T trigger mode only, sets a welding current 5-100% of the main welding current activated when the trigger is held on to 'unlatch' the trigger before the weld is finished. If downslope is set, the current will go through the downslope period before going to the end current set. When the trigger is released, the arc will stop.

Post Gas

Controls the period of time the shielding gas continues to flow for after the arc is stopped. This protects the weld area and torch tungsten from contamination while it is still hot enough to react with atmospheric gases, after the weld is finished. Unit(S) and setting range (0-10.0S).

Duty Ratio

Only available when pulse mode is selected. Sets the time proportion as a percentage between the peak current and base current when using pulse mode. Neutral setting is 50%, the time period of the peak current and base current pulse is equal. Higher pulse duty setting will give greater heat input, while lower

pulse duty will have the opposite effect. Unit(%) and setting range (5-95%).

Pulse frequency

Only available when pulse mode is selected. Sets the rate that the welding output alternates between the peak and base current settings. Unit(Hz) and setting range (0.5-999Hz).

Clean Width Area/ AC Balance

Only available in AC welding mode. Adjusts the balance as a percentage between the forward and reverse current cycles when welding in AC output mode. The reverse part of the AC cycle gives the 'cleaning' effect on the weld material, while the forward cycle melts the weld material.

Neutral setting is 0. Increased reverse cycle bias will give greater cleaning effect, less weld penetration and more heat in the torch tungsten, which gives the disadvantage of reducing the output current that can be used for a given tungsten size, to prevent the tungsten overheating.

Increased forward cycle bias will give the opposite effect, less cleaning effect, greater weld penetration and less heat in the tungsten. setting range (-5+5).

AC Frequency

Only available in AC welding mode. Increasing AC frequency will focus the shape of the arc, resulting in a tighter, more controlled arc causing increased penetration and less heated affected area for the same current setting. Slower frequency will result in a wider, softer arc shape.

Unit(Hz) and setting range (50-250Hz).

6.2.4. AC/DC Output Modes**DC (Direct Current) / AC Welding Output**

Suitable for TIG welding ferrous (iron based) metals such as mild steel and stainless steel, copper and titanium. TIG welding reactive metals such as Aluminium, Magnesium and Zinc requires AC (alternating current) output. When reactive metals are exposed to air they form an oxide layer that insulates the base metal and prevents welding current flowing, it also contaminates the weld pool. Reverse current flow is required to break through/ clean off this oxide layer so that welding can take place, while the current flow during the positive cycle does the majority of the heating of the weld pool area.

AC Triangle Wave Welding Output

Reduced heat input for same current setting. Especially useful for welding thin metal.

AC Square Wave

Focused arc for maximum penetration, fast travel speed with best directional control.

AC Sine Wave Welding Output

Traditional AC TIG welding wave form. Quieter, 'soft'

arc characteristic.

AC trapezoid Wave Welding Output

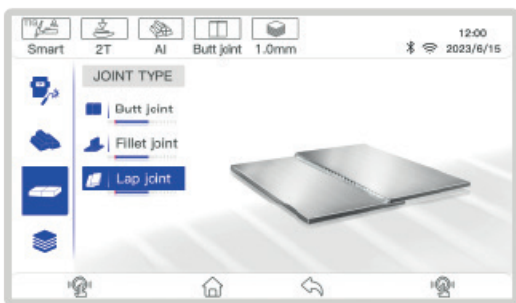
Reduced heat input for same current setting. Quieter, 'soft' arc characteristic than AC Square Wave.

6.2.5. Operation of Smart TIG welding method

Rotate the (7) encoder button then enter into Smart TIG function selection interface, and press the (7) encoder button to enter into Smart TIG unify parameter interface.

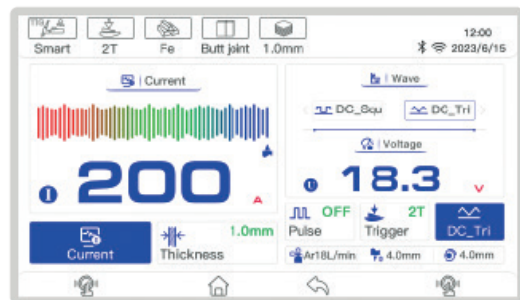


At Smart TIG unify parameter interface, press the (7) encoder button to select Material, Joint Type, Thickness option. Rotate the (7) encoder button to adjust the parameter. The interface just as shown below.



Press the (2) encoder to select unify parameter	Rotate the (2) encoder button to adjust the unify parameter
Material	Fe/Ss/Al
Joint Type	Butt joint/Fillet joint / Lap joint
Thickness	1.0mm / 0.039in 1.5mm / 0.059in
	2.0mm / 0.079in 2.5mm / 0.098in
	3.0mm / 0.118in 3.5mm / 0.138in
	4.0mm / 0.157in 5.0mm / 0.197in
	6.0mm / 0.236in 7.0mm / 0.276in
	8.0mm / 0.315in 9.0mm / 0.354in
10.0mm / 0.394in 11.0mm / 0.433in	
12.0mm / 0.472in 14.0mm / 0.551in	

Press the (5) encoder button and enter into Smart TIG welding interface. The interface just as shown below:



At Smart TIG welding interface, press the **(6)** left button to return to Smart TIG function selection interface. The interface just as shown below:



6.2.6. Operation of the MMA welding method:

1. Selection of the welding method:

- 1) In the main interface, press the **(6)** key to enter the function selection interface;
- 2) In the function selection interface, rotate L-Knob to select the Stick welding method and press it for confirmation. rotate R-Knob to select the wave.



2. Selection and setting of welding parameters:

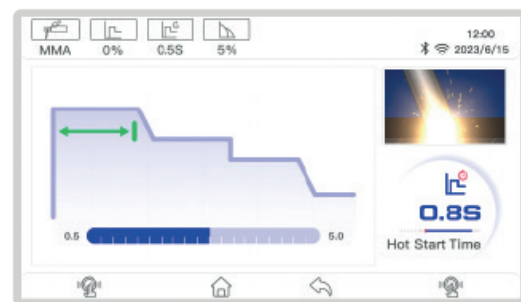
- 1) In the main interface, press **(6)** key to enter the welding parameter setting interface;
- 2) In the welding parameter setting interface, rotate L-Knob to select the parameter as required and rotate R-Knob to set a value for the parameter.



Welding parameters available by rotating L Knob	Welding parameters available by rotating R Knob
Hot Start	0-100%
Hot Start T	0.5-5.0S
Arc Force	0-100%
Peak Amp	10-200A
Pulse	ON/OFF

3. Setting of welding current:

- 1) Press the **(6)** key to enter the welding interface shown below:



WHEN PULSE ON

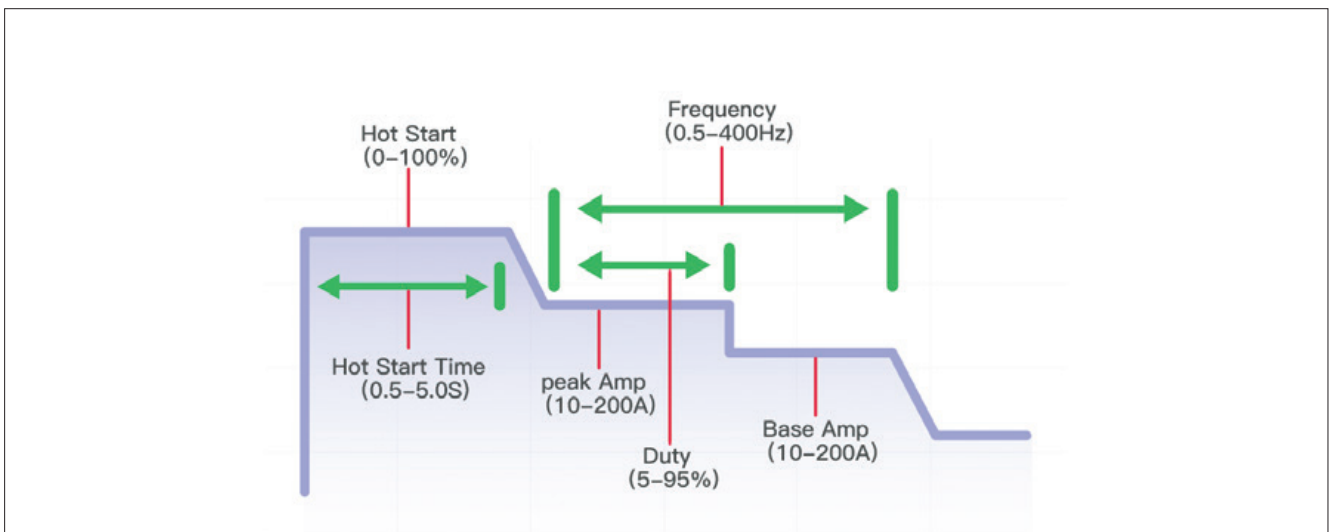


WHEN PULSE OFF

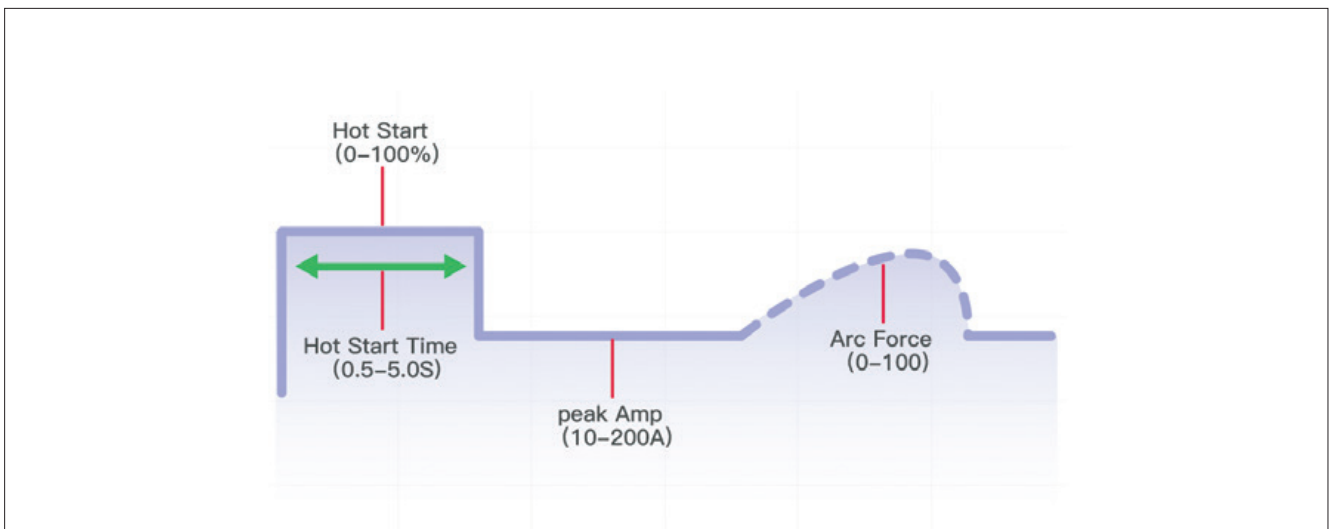
- 2) In the welding parameter setting interface, rotate L-Knob to select the parameter as required and rotate R-Knob to set a value for the parameter.



Parameter description and scope (PULSE ON):



Parameter description and scope (PULSE OFF):



Hot Start

Hot start provides extra power when the weld starts to counteract the high resistance of the electrode and workpiece as the arc is started. Setting range (0-100%).

Arc Force

An MMA welding power source is designed to produce constant output current (CC). This means with different types of electrode and arc length; the welding voltage varies to keep the current constant. This can cause instability in some welding conditions as MMA welding electrodes will have a minimum voltage they can operate with and still have a stable arc. Arc Force control boosts the welding power if it senses the welding voltage is getting too low.

The higher the arc force adjustment, the higher the minimum voltage that the power source will allow. This effect will also cause the welding current to increase. 0% is Arc Force off, 100% is maximum Arc Force. This is practically useful for electrode types that have a higher operating voltage requirement or joint types that require a short arc length such as out of position welds.

MMA Pulse welding

Pulse welding mode switches the welding output between a high and low current output in a cyclical manner. When used correctly this function has substantial benefits in the TIG welding process including greater weld penetration for less work heat input and greater control of the weld pool.

The basic theory for setting the base current using pulse mode is that the base current should be sufficient to maintain the existing molten weld pool, while the peak current is sufficient to melt new metal in order to move/ expand the molten weld pool. Increased pulse frequency will have the effect of making the arc more tightly focused which is useful for fine stainless work and similar.

Pulsing can also be used to help move the weld pool, this technique is useful for welding out of position or with materials that have higher viscosity weld pool. Higher pulse duty setting will give greater heat input, while lower pulse duty will have the opposite effect.

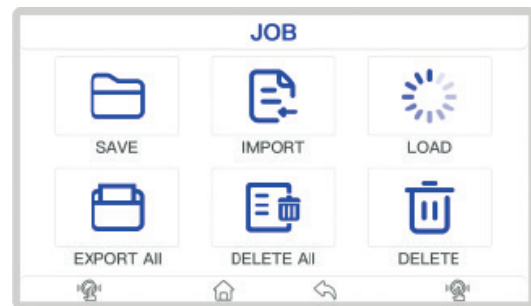
6.2.7. Job Memory

TIG series of welding machines has 10 memory/ job spaces that parameters can be saved to for easy recall.

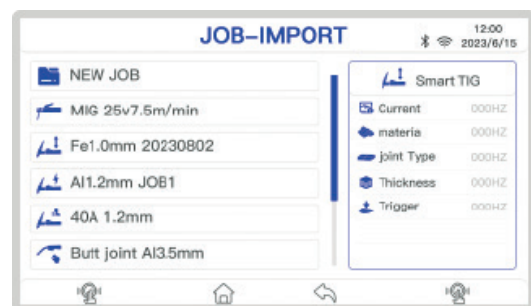
To save program, Long press the R-knob and the program number 0-9 will show on the display.

Rotate the L-Knob and select the unsaved number then press the L-Knob, the program will be saved.

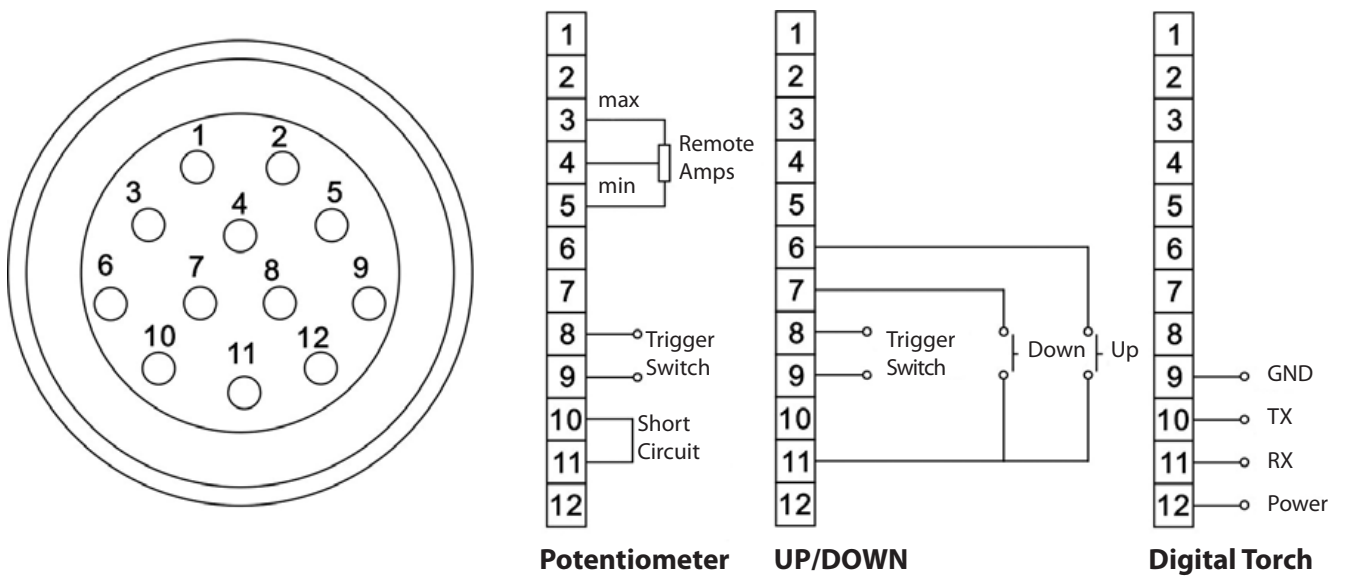
If setting parameters to save as a program, ensure that you start with a program number that the data is OK to over write, as the previous settings saved to that memory space will be lost.



To access a saved program, Long press the L-knob and the program number 0-9 will show on the display. rotate the R-Knob and select the saved number then press the R-Knob, the saved program will be recalled.



12 PIN REMOTE PLUG CONNECTION



Socket Pin	Function		
	Potentiometer	Up/down	Digital Torch
1	Not connected	Not connected	Not connected
2	Not connected	Not connected	Not connected
3	10k ohm (maximum) connection to 10k ohm remote control potentiometer	Not connected	Not connected
4	Wiper arm connection to 10k ohm remote control potentiometer	Not connected	Not connected
5	Zero ohm (minimum) connection to 10k ohm remote control potentiometer	Not connected	Not connected
6	Not connected	The button of "UP" input	Not connected
7	Not connected	The button of "DOWN" input	Not connected
8	Trigger Switch Input	Trigger Switch Input	Not connected
9	Trigger Switch Input	Trigger Switch Input	GND
10	Be shorted with 11	Not connected	Transmit
11	Be shorted with 10	The button of "UP" & "DOWN" input	Receive
12	Not connected	Not connected	Power +

6.3. REMOTE CONTROL CONFIGURATION

6.3.1. Wireless remote control Configuration

TIG series of welding machines can be configured to communicate exclusively with wireless foot pedal or remote control panel. This is done by a simple process of synchronising the wireless remote control and the machine frequencies. Each interface frequency assigned is unique, so it is possible to use several wireless control systems/ machines in the same area with no problems. The direct range of the wireless control system is approximately 100m, this will be affected by the physical location of the machine and the remote control.

To synchronise a remote control to a machine, follow these instructions:

- 1) Ensure the welding power supply is switched off.
- 2) Press and hold the parameter select/adjust knob on the front panel of the power supply (2-4 seconds) while at the same time turning the machine ON using the ON-OFF switch on the back of the welding power supply.
- 3) When the display on the front panel of the power supply is blank, release the control knob. Turn on the remote control or foot pedal while at the same time pressing any buttons on the remote control panel or foot pedal, the digital meter on the front panel of the welding power supply flick twice to indicate the synchronization is successful and complete. (Synchronization has to accomplish in 10s after the display is blank.)

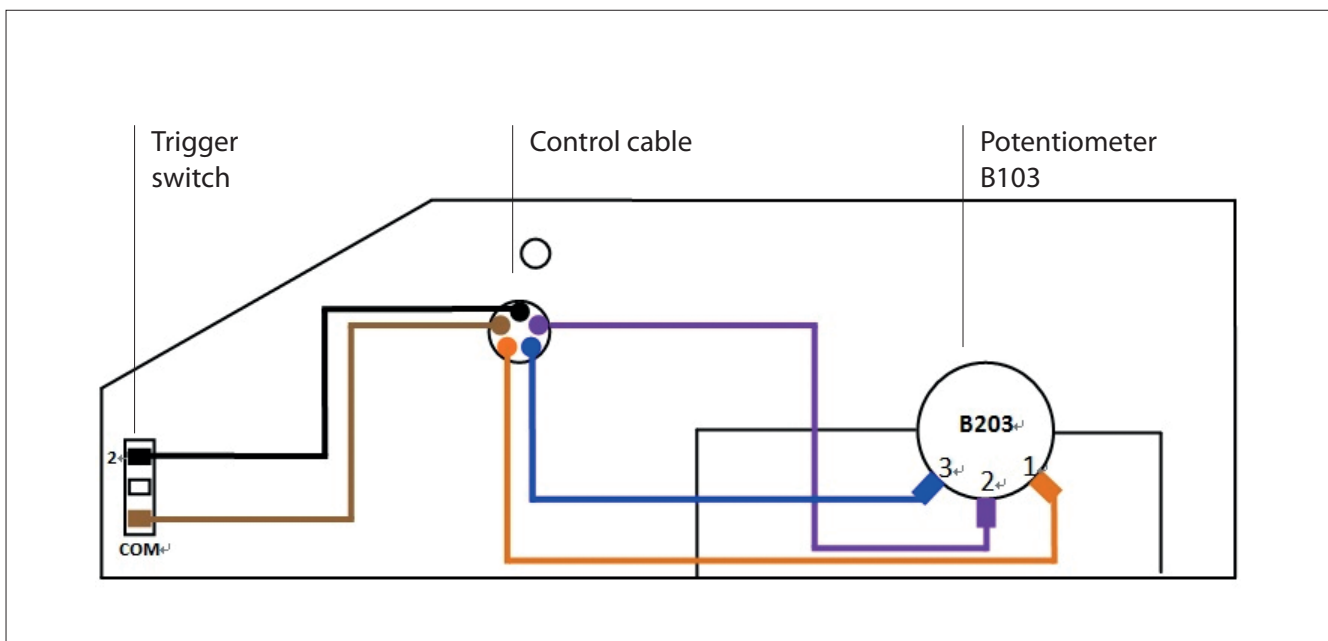
- 4) Switch the machine off and back on again to start welding operation.
- 5) If the operation is unsuccessful, repeat steps 1 to 4.
- 6) During operation, the front panel control on the power supply is still functional but the remote control panel or foot pedal has higher priority level.
- 7) When the remote control panel or foot pedal is idles for 10 seconds, it will automatically go into "sleep" mode.
- 8) Only front Panel Control is active when wireless remote control or foot pedal is in "sleep" mode. Any operation on the wireless remote control panel or foot pedal will "wake it up and resumes control of the machine.

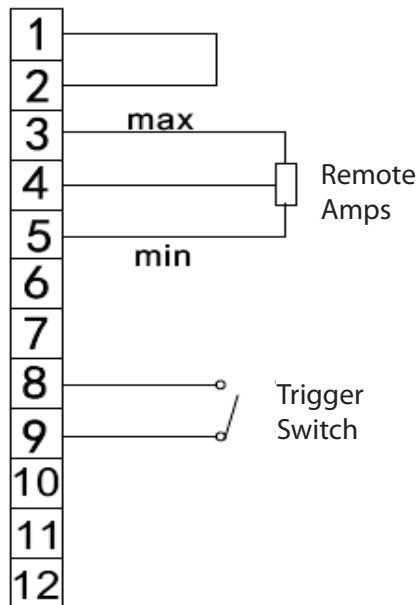
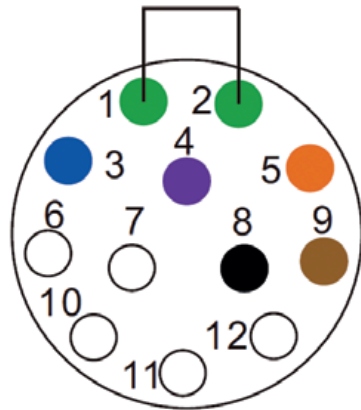
How to remove the control function of Remote control box on welding machine:

- 1) Ensure the welding power supply is switched off.
- 2) Press the encoder on the front control panel of the power supply, meanwhile turn on the machine.
- 3) Pressing the encoder about 10 seconds, until the control panel display "rSt", then it succeed.

6.3.2. Wire foot pedal Configuration

- When plug the twelve-lead aero-socket of pedal switch in it. Welder will identify the pedal switch, the welding current knob on the front panel will can't use and only 2T can be selected.
- When use the adjustment knob of max-welding current beside the pedal, can set the max-current you want.





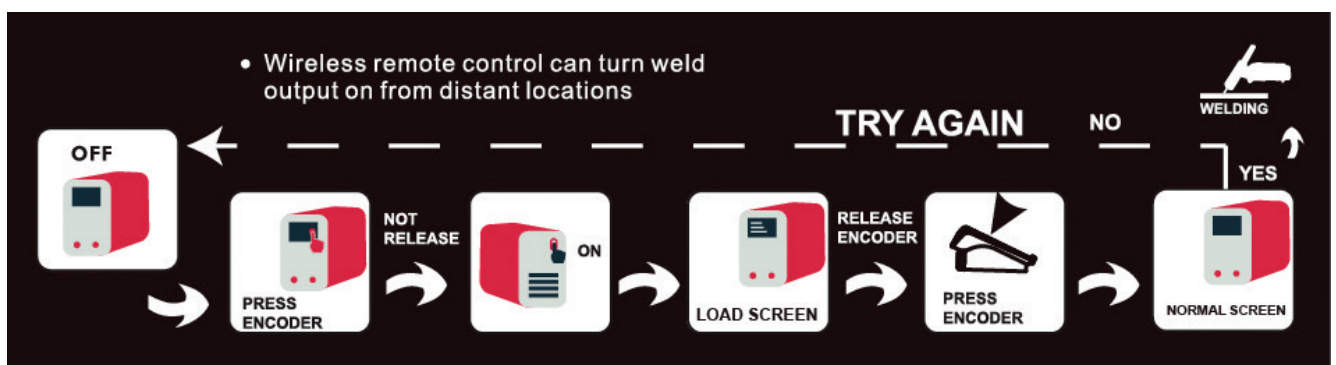
Socket Pin	Function
1	Be shorted with 2
2	Be shorted with 1
3	20k ohm (maximum) connection to 20k ohm remote control potentiometer
4	Wiper arm connection to 20k ohm remote control potentiometer
5	Zero ohm (minimum) connection to 20k ohm remote control potentiometer
6	Not connected
7	Not connected
8	Trigger Switch Input
9	Trigger Switch Input
10	Not connected
11	Not connected
12	Not connected

6.3.3. Wireless foot pedal Configuration

Wireless foot pedal is a kind of device which can control current in real time through wireless module.

How to use:

1. turn on the foot pedal;
2. press the left button in 10s and power on the machine at the same time, you can see the load screen, then loosen the left button;
3. press the foot pedal just a second, the screen is normal, you can use the wireless pedal;



6.4. START-UP

After turning on machine or line power, conduct a careful visual inspection of the entire machine and make sure that no persons or material are obstructing its normal operation, and that no objects have inadvertently been left on it.

Check that all the machine safety devices are enabled; if necessary, reset them, and in particular check for:

- Unlocked emergency stops;
- Correct operation of the safety barriers, if installed, or the guards not removed
- Protection guard.

6.5. NORMAL STOP

Turn the switch on the welder panel to **OFF**.

To completely disconnect the power supply from the power line, turn the switch on the main panel to **O**.

6.6. DECOMMISSIONING

During long periods of inactivity it is necessary to:

- Disconnect the power supply from the general electrical panel and all other power supplies (pneumatic and/or hydraulic) which the machine needs.
- Perform all maintenance operations.
- Accurately clean the machine.
- Store the machine in a protected area with a stable support surface.
- Cover the machine to avoid dust accumulation.
- Make sure that the environmental conditions are suitable for preserving the machine over time.

7. MAINTENANCE

7.1. MACHINE ISOLATION

Before carrying out any type of Maintenance or Repair, it is necessary to isolate the machine from the power supply and from all other energy sources present.

7.2. SPECIAL PRECAUTIONS

When carrying out any maintenance or repair work, the following recommendations should be followed:

- Before starting work, display a sign stating "MACHINE UNDER MAINTENANCE" in a visible spot;
- Do not use flammable materials or solvents;
- Be careful not to pollute the environment with coolants;
- To access the highest parts of the machine, use the appropriate means and procedures;
- Do not climb on the machine parts, as they are not designed to support people;
- When finished, refit and properly secure all safety guards and devices that may have been removed or opened.

IMPORTANT: The Manufacturer cannot be held liable for the failure to comply with the aforementioned recommendations nor for any other use that is inconsistent or not mentioned in these instructions.

7.3. CLEANING

Before carrying out any cleaning operation, disconnect the device from the mains and from the energy sources present.

Do not use corrosive cleaning products, flammable or containing substances harmful to health.

Make sure that the parts being cleaned are completely cold.

Do not wet the internal parts to avoid damaging the electrical and electronic components.

Do not direct any jets of compressed air directly on the electrical and electronic components so as not to damage them.

ATTENTION: Always use the appropriate PPE such as gloves, mask, glasses according to current safety standards.

7.4. ROUTINE MAINTENANCE

General requirements

The machine is designed to minimise routine maintenance, thus it is up to the operator to assess its condition and suitability for use.

It is recommended to stop and perform maintenance whenever non-optimal operation is detected, so as to ensure maximum efficiency at all times. Check the operation of safety devices monthly. In the event of faults or malfunction, entrust only qualified personnel to search for the fault or call the manufacturer's technical support. Check the continuity of the earth circuit every 2 years by performing the continuity measurement according to the provisions of the CEI 44 - 5 III Art. 19 standard. Visually check the condition of the individual parts of the machine, verifying that there is no alteration due to sagging or deformation. At each use of the machine, if equipped with a cooling unit, check the coolant level and top up if necessary.

ATTENTION: Use only "SincoFluid" coolant supplied on request by the manufacturer or an authorised dealer.

The use of different coolants automatically voids the warranty and excludes the manufacturer from any liability.

ATTENTION: Allow the system to cool before proceeding with maintenance; hot surfaces can cause serious burns.

ATTENTION: For the entire duration of maintenance, it is necessary to stop the system by disconnecting the plug from the mains power supply or by disconnecting the power supply from the main panel circuit breaker, moving it to the "O" position and locking it with a special padlock.

Always use the appropriate PPE - Personal Protective Equipment:

- Gloves;
- Non-slip shoes;
- Suitable clothing.

Scheduled maintenance

The operations described below must be carried out in line with the schedules indicated.

IMPORTANT: Failure to comply with the above shall exempt the manufacturer from any liability as specified in the Warranty.

ATTENTION: These operations, although simple, must be performed by a Qualified or Qualified and Authorised Technician.

Remove dust or foreign materials every 6 months, which may have been deposited on the transformer or on the diodes of the rectifier unit; to do this use a jet of dry, clean air.

Do not direct the compressed air jet directly onto the electrical and electronic components so as not to damage them.

When reassembling the wire feeder roller, after having cleaned or replaced it, make sure that the groove is aligned with the wire and that it corresponds to the diameter of the wire used.

Keep the inside of the gas nozzle constantly clean, so as to avoid metal bridges consisting of welding sprays between the gas nozzle and the contact tip.

Make sure that the output hole of the current collector nozzle is not excessively enlarged, otherwise replace it.

Absolutely avoid beating the torch or subjecting it to violent impacts.

7.5. WELDING MACHINE REPAIRS

Experience has shown that many accidents originate from repairs not performed to perfection.

For this reason, careful and complete control over a repaired welding machine is just as important as that performed on a new welding machine. Moreover, in this way, manufacturers can be protected from being held liable for defects, when the liability is to be attributed to others.

Welding machine repairs must be carried out exclusively by trained and qualified personnel, in possession of the necessary requisites to guarantee a workmanlike repair and in full compliance with safety standards EN 60974-4.

A) Instructions for repairs

- After rewinding the transformer or the inductances, the welding machine must pass the same applied voltage tests, passed at the time of the first test according to the regulations in force.
- If no rewinding has been carried out, a welding machine, which has been cleaned and/or overhauled, must pass a particular applied voltage test with values given by current regulations.
- After rewinding and/or replacing parts, the no-load voltage must not exceed certain values given by current regulations.

- If repairs are not carried out by the manufacturer, repaired welding machines, in which some components have been replaced or modified, must be marked so that the person who carried out the repair can be identified.

B) Additional repair Instructions

- After having carried out a repair, be careful to re-order the wiring, so that there is a secure insulation between the primary side and the secondary side of the machine.
- Do not allow the wires to come into contact with moving parts (i.e. with the fan motor) or parts that become hot during operation.
- Also re-assemble all the clamps that hold the wiring, as originally arranged on the machine, so that, if a conductor is accidentally broken or disconnected, it is still possible to avoid a connection between the primary and the secondary.
- Avoid cleaning the electronic boards with a jet of compressed air to preserve the integrity of the components.
- At the end of any repair, make sure that you have not forgotten any tools inside the machine and close the machine with all the bulkheads available and taking care to replace all the fixing devices of the bulkheads themselves.

7.6. DIAGNOSTICS AND TROUBLESHOOTING

For defects or malfunctions of the machine not described in this manual, please contact the manufacturer.

N°.	Troubles	Reasons	Solution	
1	Turn on the power source, and the power lamp is on, but fan doesn't work	There is something in the fan	Clear out	
		The start capacitor of fan damaged	Change capacitor	
		The fan motor damaged	Change fan	
2	The number on the display is not intact.	The LED in the display is broken	Change the LED	
3	The max and min value displayed doesn't accord with the set value.	The max value is not accordant	Adjust potentiometer I_{max} on the control board.	
		The min value is not accordant	Adjust potentiometer I_{min} the current meter.	
4	No no-load voltage output	The machine is damaged	Check the main circuit and the Pr4.	
5	Arc can not be ignited (TIG)	There is spark on the HF igniting board.	The welding cable is not connected with the two output of the welder.	Connect the welding cable to the welder's output.
			The welding cable damaged.	Repair or change it.
			The earth cable connected unstably.	Check the earth cable.
			The welding cable is too long.	Use an appropriate welding cable.
			There is oil or dust on the workpiece.	Check and remove it.
		There is not spark on the HF igniting board.	The distance between tungsten electrode and workpiece is too long.	Reduce the distance (about 3mm).
			The HF igniting board does not work.	Repair or change Pr8
			The distance between the discharger is too short.	Adjust this distance (about 0.7mm).
			The malfunction of the welding gun switch.	Check the welding gun switch, control cable and aero socket.
6	No gas flow (TIG)	Gas cylinder is close or gas pressure is low	Open or change the gas cylinder	
		Something in the valve	Remove it	
		Electromagnetic valve is damaged	Change it	
7	Gas always flows	The gas-test on the front panel is on	The gas-test on the front panel is off	
		Something in the valve	Remove it	
		Electromagnetic valve is damaged	Change it	
		The adjustment knob of pre-gas time on the front panel is damaged	Repair or change it	
8	The welding current can not be adjusted	The welding current potentiometer on the front panel connection is not good or damaged	Repair or change the potentiometer	
9	The welding current displayed isn't accordant with the actual value.	The min value displayed isn't accordant with the actual value.	Adjust potentiometer I_{min} on the power board.	
		The max value displayed isn't accordant with the actual value.	Regolare il potenziometro I_{max} sulla scheda di alimentazione	
10	The penetration of molten pool is not enough.	The welding current is adjusted too low	Increase the welding current	

continued...

N°.	Troubles	Reasons		Solution
11	The alarm lamp on the front panel is on	Over heat protection	Two much welding current	Reduce the welding current output
			Working time too long	Reduce the duty cycle (work intermittently)

List of error code

Error Type	Error code	Description	Lamp status
Thermal relay	E01	Over-heating (1st thermal relay)	Yellow lamp (thermal protection) always on
	E02	Over-heating (2nd thermal relay)	Yellow lamp (thermal protection) always on
	E03	Over-heating (3rd thermal relay)	Yellow lamp (thermal protection) always on
	E04	Over-heating (4th thermal relay)	Yellow lamp (thermal protection) always on
	E09	Over-heating (Program in default)	Yellow lamp (thermal protection) always on
Welding machine	E10	Phase loss	Yellow lamp (thermal protection) always on
	E11	No water	Yellow lamp (lack water) always on
	E12	No gas	Red lamp always on
	E13	Under voltage	Yellow lamp (thermal protection) always on
	E14	Over voltage	Yellow lamp (thermal protection) always on
	E15	Over current	Yellow lamp (thermal protection) always on
	E16	Wire feeder over load	
Switch	E20	Button fault on operating panel when switch on the machine	Yellow lamp (thermal protection) always on
	E21	Other faults on operating panel when switch on the machine	Yellow lamp (thermal protection) always on
	E22	Torch fault when switch on the machine	Yellow lamp (thermal protection) always on
	E23	Torch fault during normal working process	Yellow lamp (thermal protection) always on
Accessory	E30	Cutting torch disconnection	Red lamp blink
	E31	Water cooler disconnection	Yellow lamp (lack water) always on
Communication	E40	Connection problem between wire feeder and power source	
	E41	Communication error	

8. ACCESSORIES AND SPARE PARTS

8.1. CUSTOMER SERVICE

The Manufacturer is always at your disposal for any type of information regarding the use, maintenance, and installation of the equipment.

It is suggested that the Customer asks clear questions, making reference to this Manual and the instructions listed.

8.2. SPARE PARTS

IMPORTANT: ALWAYS USE ORIGINAL SPARE PARTS. The Manufacturer cannot be held liable for breakages, malfunctions or damage to persons or property arising from the use of non-original parts.

In the event that non-original spare parts are used, the conditions of the Warranty (if still in place) and of the Manufacturer's liability in the use of the machine and any damage deriving to persons and/or property are void.

9. ADDITIONAL INSTRUCTIONS

9.1. WASTE DISPOSAL

It is the responsibility of the user, in accordance with the laws in force in their country, to ensure correct disposal of the waste produced by the machine during production.

The disposal of hydraulic oil lubricants and the replaced parts must be carried out in compliance with the regulations in force in the country where the machine is in use.

9.2. DECOMMISSIONING AND DISMANTLING

With reference to the WEEE Directive 2012/19 / EU (Waste Electrical and Electronic Equipment), the user, during disposal, must dispose of the equipment in the appropriate authorised collection centres, or return it still installed to the seller at the time of a new purchase.

IMPORTANT: do not dispose of polluting materials in the environment. Dispose of such products in compliance with legislation in force.

IMPORTANT: the illegal disposal of Waste Electrical and Electronic Equipment is punished with sanctions regulated by the laws in force in the territory in which the infringement is ascertained. Waste Electrical and Electronic Equipment may contain hazardous substances with potentially harmful effects on the environment and on people's health. It is recommended to dispose of it properly.

WEEE refers to Waste Electrical and Electronic Equipment (EEE) including all components, sub-assemblies and consumables that are an integral part of the product at the time the decision is made to discard it. The law divides these into 2 main categories called **PROFESSIONAL WEEE** or **DOMESTIC WEEE**.

PROFESSIONAL WEEE means all waste electrical and electronic equipment intended for purely industrial use.

DOMESTIC WEEE means all waste electrical and electronic equipment intended for mixed use both in an industrial environment and in a domestic environment.

DOMESTIC WEEE is identified as all single-phase power supply generators with output current MAX \leq 200A with their accessories.

There are 2 ways to discard **DOMESTIC WEEE**:

- a) If you decide to buy a new equivalent equipment, the user can deliver it to the distributor, who will have to collect it for free.
- b) Alternatively, it must be deposited in the Municipal pitch, in the container or specific area identified as "GROUPING 4".

As of the date of preparation of the Instruction Manual, as the application of the Regulations is not yet definitive, please contact the distributor and/or the manufacturer for information on **PROFESSIONAL WEEE** disposal.

THE SYSTEM DESCRIBED IN THE MANUAL BELONGS TO CATEGORY: DOMESTIC "EEE"

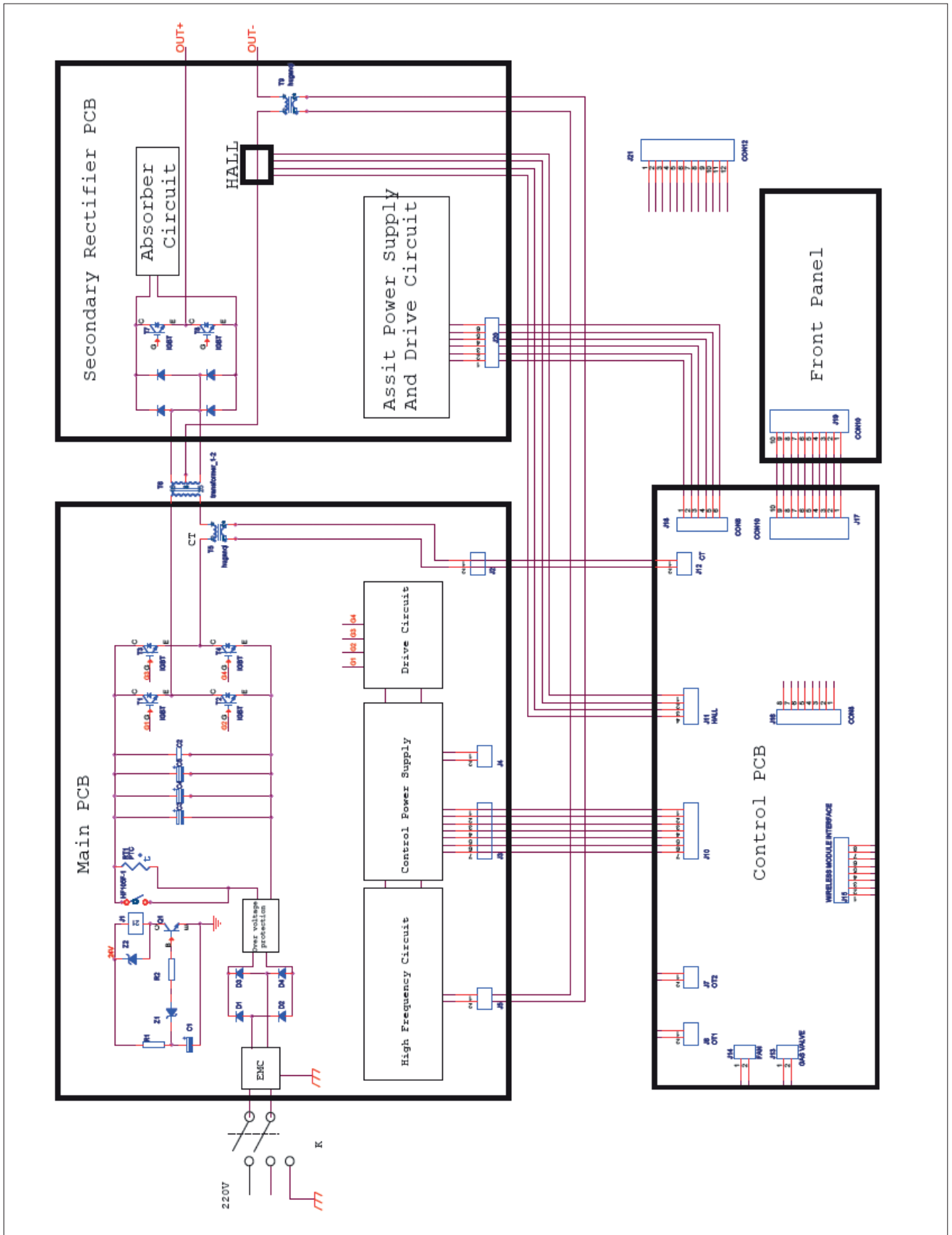
For the management of "WEEE", SINCOSALD relies on Erion Consortium.



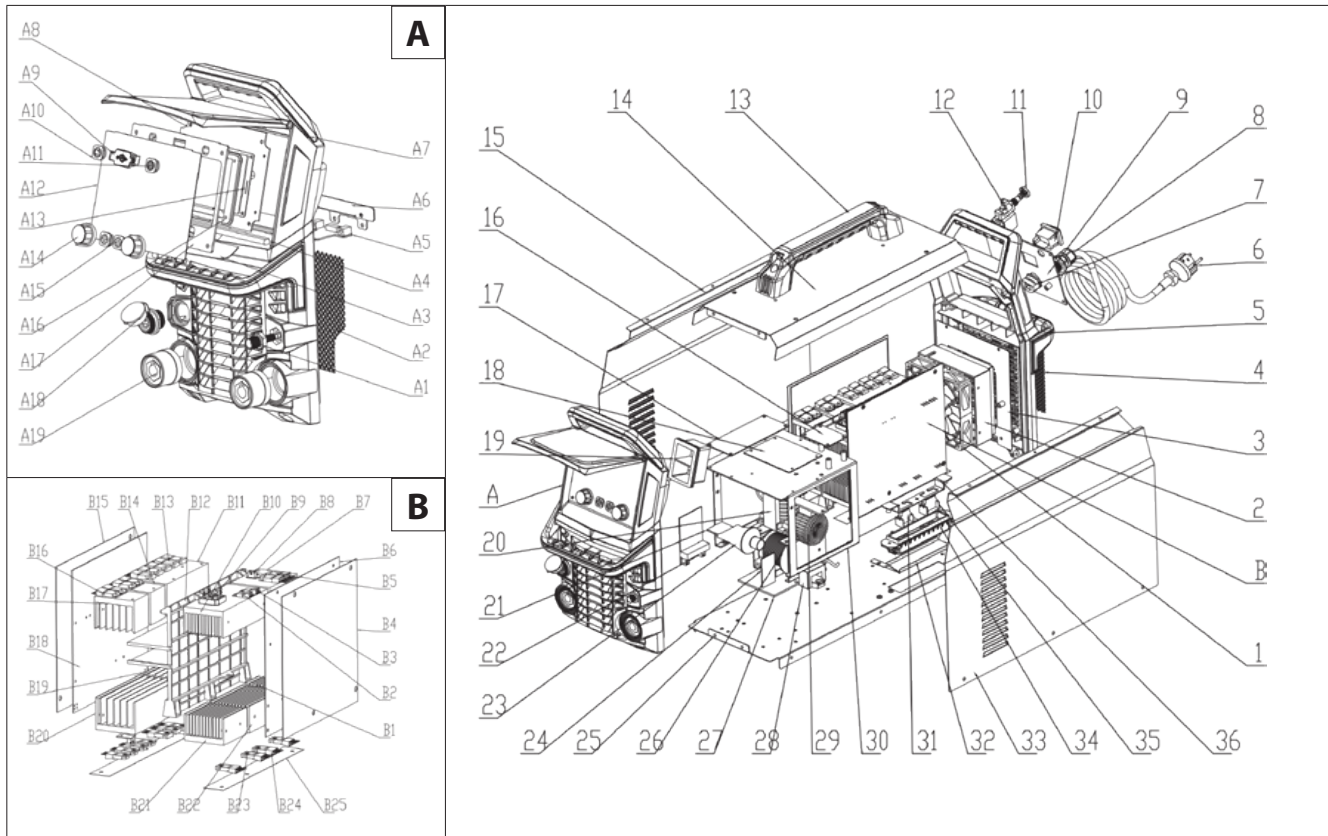
AS OF THE DATE OF THE PREPARATION OF THIS INSTRUCTION MANUAL THIS INFORMATION SHOULD BE CONSIDERED TO BE NON-DEFINITIVE AS SUBJECT TO POSSIBLE CHANGES ACCORDING TO THE OBLIGATIONS LINKED TO LEGISLATIVE DECREE N ° 151/2005 THAT WILL COMPLETE DIRECTIVE 2002/96/EC.

10. ANNEXES

10.1. WIRING DIAGRAMS



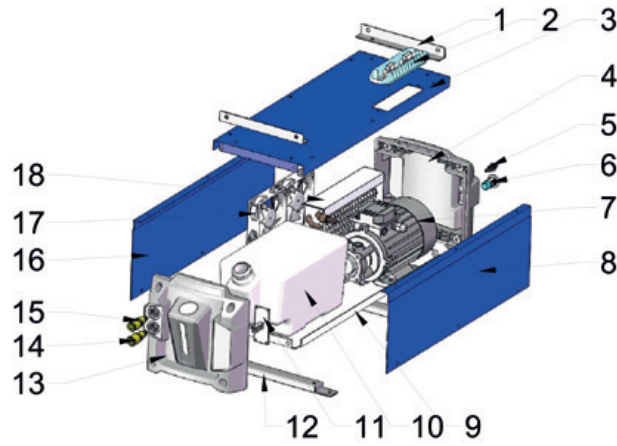
10.2. SPARE PARTS



Pos.	Code	Description
1	8.295.094	FAN
2	8.291.026	FAN COVER
3	8.221.270	MOUNTING PLATE OF FAN
4	8.221.271	REAR PANEL METAL MESH
5	8.221.059	REAR PANEL ASSEMBLY
6	8.225.310	EU STANDARD POWER CABLE
7	8.295.074	CABLE CLIP
8	8.225.085	EXTERNAL COMPRESSION CABLE GLAND
9	8.221.272	REAR PANEL COVER PLATE
10	8.225.311	ON/OFF SWITCH
11	8.225.312	COPPER NUT
12	8.225.271	TWO-WAY TWO-PORT SOLENOID VALVE
13	8.225.267	KT230 HANDLE ASSEMBLY
14	8.221.273	COVER
15	8.221.274	RIGHT SIDE PANEL
16	8.213.086	WATER TANK RELAY CONTROL PCB
17	8.293.002	POWER PCB
18		CONTROL PCB
19	8.221.251	SQUARE-HOLE GROMMET
20	8.292.004	MAIN TRANSFORMER
21	8.213.099	SINGLE-PHASE SURGE PROTECTION PCB
22	8.225.313	JACKING PLUG COMMON MODE INDUCTOR ABSORPTION BOARD
23	8.225.314	HORN WIRE HARNESS PROTECTIVE SLEEVE
24	8.213.091	HIGH-FREQUENCY ABSORPTION PCB
25	8.221.275	BASE PLATE

Pos.	Code	Description
26	8.292.007	HIGH-FREQUENCY INDUCTOR
27	8.221.276	INDUCTOR INSULATION PLATE
28	8.292.009	HALL CURRENT SENSOR
29	8.222.220	PFC INDUCTOR
30	8.221.277	SUPPORT STAND
31	8.225.330	PIN HOUSING
32	8.225.275	WATER-COOLED CONNECTOR BAFFLE
33	8.221.278	LEFT SIDE PANEL
34	8.225.331	WATER-COOLED CONNECTOR ASSEMBLY
35	8.225.315	PIN HOUSING
36	8.225.316	PIN HOUSING BAFFLE
A1	8.291.054	GAS INLET CONNECTOR
A2	8.221.279	FRONT PANEL METAL MESH
A3	8.220.030	NAME LABEL
A4	8.225.103	FLEXIBLE SILICONE LED STRIP
A5	8.233.039	BLUETOOTH COMMUNICATION PCB
A6	8.225.317	BLUETOOTH LIGHT STRIP MOUNTING PLATE
A7	8.220.017	FRONT PANEL ASSEMBLY
A8	8.223.092	LEZE5 DUAL-KNOB DISPLAY PCB
A9	8.225.256	USB PROTECTIVE SLEEVE
A10	8.225.099	SILICONE KEY
A11	8.225.097	SILICONE KEY
A12	8.220.031	FRONT STICKER
A13	8.215.211	LCD (TOUCH)
A14	8.215.209	KNOB

Pos.	Code	Description
A15	8.225.100	SILICONE KEY
A16	8.215.202	5-INCH SCREEN EDGE COVER
A17	8.221.056	PANEL MOUNTING PLATE
A18	8.225.104	12-PIN AVIATION SOCKET
A19	8.225.105	QUICK FEMALE SOCKET
B1	8.291.039	HEAT SINK
B2	8.295.080	FAST RECOVERY DIODE
B3	8.241.038	INSULATION BLOCK
B4	8.225.318	INSULATING PLATE
B5	8.225.319	IGBT
B6	8.223.255	PRIMARY INVERTER PCB
B7	8.291.037	HEAT SINK
B8	8.293.013	THERMAL SENSITIVE PCB
B9	8.292.011	RECTIFIER BRIDGE
B10	8.291.038	HEAT SINK
B11	8.291.034	HEAT SINK
B12	8.291.022	MIDDLE PARTITION PLATE
B13	8.295.083	IGBT
B14	8.291.033	HEAT SINK
B15	8.225.320	INSULATING PLATE
B16	8.245.047	FAST RECOVERY DIODE
B17	8.291.032	HEAT SINK
B18	8.223.073	SECONDARY INVERTER PCB
B19	8.291.035	HEAT SINK
B20	8.291.031	HEAT SINK
B21	8.291.040	HEAT SINK
B22	8.291.036	HEAT SINK
B23	8.245.042	IGBT
B24	8.295.103	INSULATION BLOCK
B25	8.225.321	INSULATION PAPER



Pos.	Code	Description	Qt.
1	8.261.019	CONNECTION PCB	2
2	8.265.005	CONNECTORS	1
3	8.261.020	COVER	1
4	8.261.021	REAR PANEL	1
5	8.265.006	FUSE HOLDER	1
6	8.265.007	ON/OFF SWITCH	1
7	8.263.002	WATER PUMP	1
8	8.261.022	RIGHT PANEL	1
9	8.261.023	BOTTOM PLATE	1

Pos.	Code	Description	Qt.
10	8.260.001	WATER TANK	1
11	8.261.024	DETECTION PCB	1
12	8.261.025	CONNECTION PLATE	2
13	8.261.026	FRONT PANEL	1
14	8.255.013	VENTILATION QUICK SOCKET (RED)	1
15	8.255.014	VENTILATION QUICK SOCKET (BLUE)	1
16	8.261.027	LEFT PANEL	1
17	8.263.003	FAN	2
18	8.265.010	HEAT SINKS	1



SINCOSALD S.r.l

Headquarters - Offices

via della Fisica, 26/28

20864 Agrate Brianza (MB) Italy

Tel: +39 039 641171

Fax: +39 039 6057122

export@sincosald.it

www.sincosald.it