



INVERTER  
ARC  
WELDER

MODEL 160S DC CC  
STICK  
TIG - Lift Start

**OPERATING MANUAL**




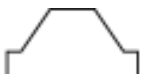


















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## SYMBOL LEGEND

|   |   |
|---|---|
| <b>A</b>  | Amperage                                  |
| <b>V</b>  | Voltage                                   |
| <b>Hz</b>   | Hertz (frequency)                         |
| <b>SEC</b>  | Seconds                                   |
| <b>%</b>  | Percent                                   |
|    | DC (Direct Current)                       |
|    | AC (Alternating Current)                  |
|  | Standard Function                         |
|  | Slope Function                            |
|  | Slope W/Repeat Function                   |
|  | Spot Function                             |
|  | Impulse Starting (High Frequency GTAW)    |
|  | Touch Start (Lift Start TIG circuit GTAW) |

|  |                                  |
|--|----------------------------------|
|    | STICK (Shielded Metal Arc SMAW)  |
|    | Pulse Current Function           |
|    | Spot Time (GTAW)                 |
|    | Remote Control (Panel/Remote)    |
|    | Remote Function                  |
|    | Arc Control (SMAW)               |
|    | Gas Post-Flow                    |
|  | Gas Pre-Flow                     |
| <b>VRD</b>   | Voltage Reduction Device Circuit |
|  | Negative                         |
|  | Positive                         |
|  | Gas Input                        |
|  | Gas Output                       |

## STATEMENT OF WARRANTY

**LIMITED WARRANTY:** Thermal Arc®, Inc., A Thermadyne Company, hereafter, "Thermal Arc" warrants to customers of its authorized distributors hereafter "Thermal; Arc" that its products will be free of defects in workmanship or material. Should any failure to conform to this warranty appear within the time period applicable to the Thermal Arc products as stated below, Thermal Arc shall, upon notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with Thermal Arc's specifications, instructions, recommendations and recognized standard industry practice, and not subject to misuse, repair, neglect, alteration, or accident, correct such defects by suitable repair or replacement, at Thermal Arc's sole option, of any components or parts of the product determined by Thermal Arc to be defective.

**THERMAL ARC MAKES NO OTHER WARRANTY, EXPRESS OR IMPLIED. THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHERS, INCLUDING, BUT NOT LIMITED TO ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE.**

**LIMITATION OF LIABILITY:** Thermal Arc shall not under any circumstances be liable for special, indirect or consequential damages, such as, but not limited to, lost profits and business interruption. The remedies of the Purchaser set forth herein are exclusive and the liability of Thermal Arc with respect to any contract, or anything done in connection therewith such as the performance or breach thereof, or from the manufacture, sale, delivery, resale, or use of any goods covered by or furnished by Thermal Arc whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not, except as expressly provided herein, exceed the price of the goods upon which such liability is based. No employee, agent, or representative of Thermal Arc is authorized to change this warranty in any way or grant any other warranty.

**PURCHASER'S RIGHTS UNDER THIS WARRANTY ARE VOID IF REPLACEMENT PARTS OR ACCESSORIES ARE USED WHICH IN THERMAL ARC'S SOLE JUDGEMENT MAY IMPAIR THE SAFETY OR PERFORMANCE OF ANY THERMAL ARC PRODUCT.**

**PURCHASER'S RIGHTS UNDER THIS WARRANTY ARE VOID IF THE PRODUCT IS SOLD TO PURCHASER BY NON-AUTHORIZED PERSONS.**

The warranty is effective for the time stated below beginning on the date that the authorized distributor delivers the products to the Purchaser. Notwithstanding the foregoing, in no event shall the warranty period extend more than the time stated plus one year from the date Thermal Arc delivered the product to the authorized distributor.

| <u>POWER SUPPLIES</u>  | <u>POWER SUPPLIES &amp; WIRE FEEDERS</u> | <u>LABOR</u> |
|--|--|--------------|
| MAIN POWER MAGNETICS (STATIC & ROTATING)   | 3 YEAR                                   | 3 YEAR       |
| ORIGINAL MAIN POWER RECTIFIER  | 3 YEAR                                   | 3 YEAR       |
| POWER SWITCHING SEMI-CONDUCTORS & CONTROL PC BOARD   | 3 YEAR                                   | 3 YEAR       |
| ALL OTHER CIRCUITS AND COMPONENTS INCLUDING<br>BUT NOT LIMITED TO, CONTACTORS, RELAYS,<br>SOLENOIDS, PUMPS, SWITCHES, MOTORS   | 1 YEAR                                   | 1 YEAR       |
| <b><u>ENGINES: ENGINES ARE NOT WARRANTED BY THERMAL ARC, ALTHOUGH MOST ARE WARRANTED BY THE ENGINE MANUFACTURER, SEE THE ENGINE MANUFACTURES WARRANTY FOR DETAILS.</u></b> |  |              |
| <b><u>CONSOLES, CONTROL EQUIPMENT, HEAT EXCHANGES, AND ACCESSORY EQUIPMENT</u></b>   | 1 YEAR                                   | 1 YEAR       |
| <b><u>PLASMA TORCH AND LEADS, AND REMOTE CONTROLS</u></b>  | 180 DAYS                                 | 180 DAYS     |
| <b><u>REPAIR/REPLACEMENT PARTS</u></b>   | 90 DAYS                                  | 90 DAYS      |

Warranty repairs or replacement claims under this limited warranty must be submitted to Thermal Arc by an authorized Thermal Arc repair facility within thirty (30) days of purchaser's notice of any Warranty Claim. No transportation costs of any kind will be paid under this warranty. Transportation charges to send products to an authorized warranty repair facility shall be the responsibility of the Purchaser. All returned goods shall be at the Purchaser's risk and expense. This warranty supersedes all previous Thermal Arc warranties.

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Effective April 1, 2002

## 1.0 GENERAL INFORMATION

### 1.01 Notes, Cautions and Warnings

Throughout this manual, notes, cautions, and warnings are used to highlight important information. These highlights are categorized as follows:

#### **NOTE**

*An operation, procedure, or background information which requires additional emphasis or is helpful in efficient operation of the system.*

#### **CAUTION**

*A procedure which, if not properly followed, may cause damage to the equipment.*



#### **WARNING**

*A procedure which, if not properly followed, may cause injury to the operator or others in the operating area.*

### 1.02 Important Safety Precautions



#### **WARNING**

**OPERATION AND MAINTENANCE OF ARC WELDING EQUIPMENT CAN BE DANGEROUS AND HAZARDOUS TO YOUR HEALTH.**

*To prevent possible injury, read, understand and follow all warnings, safety precautions and instructions before using the equipment. Call 1-800-462-2782 or your local distributor if you have any questions.*



#### **GASES AND FUMES**

Gases and fumes produced during the Arc welding/cutting process can be dangerous and hazardous to your health.

- Keep all fumes and gases from the breathing area. Keep your head out of the welding fume plume.

- Use an air-supplied respirator if ventilation is not adequate to remove all fumes and gases.
- The kinds of fumes and gases from the arc welding/cutting depend on the kind of metal being used, coatings on the metal, and the different processes. You must be very careful when cutting or welding any metals which may contain one or more of the following:

|           |           |          |
|-----------|-----------|----------|
| Antimony  | Chromium  | Mercury  |
| Arsenic   | Cobalt    | Nickel   |
| Barium    | Copper    | Selenium |
| Beryllium | Lead      | Silver   |
| Cadmium   | Manganese |          |
| Vanadium  |           |          |

- Always read the Material Safety Data Sheets (MSDS) that should be supplied with the material you are using. These MSDSs will give you the information regarding the kind and amount of fumes and gases that may be dangerous to your health.
- For information on how to test for fumes and gases in your workplace, refer to item 1 in Subsection 1.03, Publications in this manual.
- Use special equipment, such as water or down draft welding/cutting tables, to capture fumes and gases.
- Do not use the welding torch in an area where combustible or explosive gases or materials are located.
- Phosgene, a toxic gas, is generated from the vapors of chlorinated solvents and cleansers. Remove all sources of these vapors.



#### **ELECTRIC SHOCK**

Electric Shock can injure or kill. The arc welding process uses and produces high voltage electrical energy. This electric energy can cause severe or fatal shock to the operator or others in the workplace.

- Never touch any parts that are electrically “live” or “hot.”
- Wear dry gloves and clothing. Insulate yourself from the work piece or other parts of the welding circuit.
- Repair or replace all worn or damaged parts.
- Extra care must be taken when the workplace is moist or damp.

- Install and maintain equipment according to NEC code, refer to item 4 in Subsection 1.03, Publications.
- Disconnect power source before performing any service or repairs.
- Read and follow all the instructions in the Operating Manual.



### FIRE AND EXPLOSION

Fire and explosion can be caused by hot slag, sparks, or the arc weld.

- Be sure there is no combustible or flammable material in the workplace. Any material that cannot be removed must be protected.
- Ventilate all flammable or explosive vapors from the workplace.
- Do not cut or weld on containers that may have held combustibles.
- Provide a fire watch when working in an area where fire hazards may exist.
- Hydrogen gas may be formed and trapped under aluminum workpieces when they are cut underwater or while using a water table. **DO NOT** cut aluminum alloys underwater or on a water table unless the hydrogen gas can be eliminated or dissipated. Trapped hydrogen gas that is ignited will cause an explosion.



### NOISE

Noise can cause permanent hearing loss. Arc welding/cutting processes can cause noise levels to exceed safe limits. You must protect your ears from loud noise to prevent permanent loss of hearing.

- To protect your hearing from loud noise, wear protective ear plugs and/or ear muffs. Protect others in the workplace.
- Noise levels should be measured to be sure the decibels (sound) do not exceed safe levels.
- For information on how to test for noise, see item 1 in Subsection 1.03, Publications, in this manual.



### ARC WELDING RAYS

Arc Welding/Cutting Rays can injure your eyes and burn your skin. The arc welding/cutting process produces very bright ultra violet and infra red light. These arc rays will damage your eyes and burn your skin if you are not properly protected.

- To protect your eyes, always wear a welding helmet or shield. Also always wear safety glasses with side shields, goggles or other protective eye wear.
- Wear welding gloves and suitable clothing to protect your skin from the arc rays and sparks.
- Keep helmet and safety glasses in good condition. Replace lenses when cracked, chipped or dirty.
- Protect others in the work area from the arc rays. Use protective booths, screens or shields.
- Use the shade of lens as recommended in Subsection 1.03, item 4.

### 1.03 Publications

Refer to the following standards or their latest revisions for more information:

1. OSHA, SAFETY AND HEALTH STANDARDS, 29CFR 1910, obtainable from the Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402
2. ANSI Standard Z49.1, SAFETY IN WELDING AND CUTTING, obtainable from the American Welding Society, 550 N.W. LeJeune Rd, Miami, FL 33126
3. NIOSH, SAFETY AND HEALTH IN ARC WELDING AND GAS WELDING AND CUTTING, obtainable from the Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402
4. ANSI Standard Z87.1, SAFE PRACTICES FOR OCCUPATION AND EDUCATIONAL EYE AND FACE PROTECTION, obtainable from American National Standards Institute, 1430 Broadway, New York, NY 10018
5. ANSI Standard Z41.1, STANDARD FOR MEN'S SAFETY-TOE FOOTWEAR, obtainable from the American National Standards Institute, 1430 Broadway, New York, NY 10018



6. ANSI Standard Z49.2, FIRE PREVENTION IN THE USE OF CUTTING AND WELDING PROCESSES, obtainable from American National Standards Institute, 1430 Broadway, New York, NY 10018
7. AWS Standard A6.0, WELDING AND CUTTING CONTAINERS WHICH HAVE HELD COMBUSTIBLES, obtainable from American Welding Society, 550 N.W. LeJeune Rd, Miami, FL 33126
8. NFPA Standard 51, OXYGEN-FUEL GAS SYSTEMS FOR WELDING, CUTTING AND ALLIED PROCESSES, obtainable from the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269
9. NFPA Standard 70, NATIONAL ELECTRICAL CODE, obtainable from the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269
10. NFPA Standard 51B, CUTTING AND WELDING PROCESSES, obtainable from the National Fire Protection Association, Batterymarch Park, Quincy, MA 02269
11. CGA Pamphlet P-1, SAFE HANDLING OF COMPRESSED GASES IN CYLINDERS, obtainable from the Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202
12. CSA Standard W117.2, CODE FOR SAFETY IN WELDING AND CUTTING, obtainable from the Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3
13. NWSA booklet, WELDING SAFETY BIBLIOGRAPHY obtainable from the National Welding Supply Association, 1900 Arch Street, Philadelphia, PA 19103
14. American Welding Society Standard AWSF4.1, RECOMMENDED SAFE PRACTICES FOR THE PREPARATION FOR WELDING AND CUTTING OF CONTAINERS AND PIPING THAT HAVE HELD HAZARDOUS SUBSTANCES, obtainable from the American Welding Society, 550 N.W. LeJeune Rd, Miami, FL 33126
15. ANSI Standard Z88.2, PRACTICE FOR RESPIRATORY PROTECTION, obtainable from American National Standards Institute, 1430 Broadway, New York, NY 10018

#### 1.04 Note, Attention et Avertissement

Dans ce manuel, les mots “note,” “attention,” et “avertissement” sont utilisés pour mettre en relief des informations à caractère important. Ces mises en relief sont classifiées comme suit :

#### NOTE

*Toute opération, procédure ou renseignement général sur lequel il importe d'insister davantage ou qui contribue à l'efficacité de fonctionnement du système.*

#### ATTENTION

*Toute procédure pouvant résulter l'endommagement du matériel en cas de non-respect de la procédure en question.*



#### AVERTISSEMENT

*Toute procédure pouvant provoquer des blessures de l'opérateur ou des autres personnes se trouvant dans la zone de travail en cas de non-respect de la procédure en question.*

### 1.05 Precautions De Securite Importantes



#### AVERTISSEMENT

*L'OPÉRATION ET LA MAINTENANCE DU MATÉRIEL DE SOUDAGE À L'ARC AU JET DE PLASMA PEUVENT PRÉSENTER DES RISQUES ET DES DANGERS DE SANTÉ.*

*Il faut communiquer aux opérateurs et au personnel TOUS les dangers possibles. Afin d'éviter les blessures possibles, lisez, comprenez et suivez tous les avertissements, toutes les précautions de sécurité et toutes les consignes avant d'utiliser le matériel. Composez le + 1-800-462-2782 ou votre distributeur local si vous avez des questions.*



FUMÉE et GAZ

La fumée et les gaz produits par le procédé de jet de plasma peuvent présenter des risques et des dangers de santé.

- Eloignez toute fumée et gaz de votre zone de respiration. Gardez votre tête hors de la plume de fumée provenant du chalumeau.

- Utilisez un appareil respiratoire à alimentation en air si l'aération fournie ne permet pas d'éliminer la fumée et les gaz.
- Les sortes de gaz et de fumée provenant de l'arc de plasma dépendent du genre de métal utilisé, des revêtements se trouvant sur le métal et des différents procédés. Vous devez prendre soin lorsque vous coupez ou soudez tout métal pouvant contenir un ou plusieurs des éléments suivants:

|           |           |          |
|-----------|-----------|----------|
| antimoine | cadmium   | mercure  |
| argent    | chrome    | nickel   |
| arsenic   | cobalt    | plomb    |
| baryum    | civre     | sélénium |
| béryllium | manganèse |          |
| vanadium  |           |          |

- Lisez toujours les fiches de données sur la sécurité des matières (sigle américain "MSDS"); celles-ci devraient être fournies avec le matériel que vous utilisez. Les MSDS contiennent des renseignements quant à la quantité et la nature de la fumée et des gaz pouvant poser des dangers de santé.
- Pour des informations sur la manière de tester la fumée et les gaz de votre lieu de travail, consultez l'article 1 et les documents cités à la page 5.
- Utilisez un équipement spécial tel que des tables de coupe à débit d'eau ou à courant descendant pour capter la fumée et les gaz.
- N'utilisez pas le chalumeau au jet de plasma dans une zone où se trouvent des matières ou des gaz combustibles ou explosifs.
- Le phosgène, un gaz toxique, est généré par la fumée provenant des solvants et des produits de nettoyage chlorés. Éliminez toute source de telle fumée.



### CHOC ELECTRIQUE

Les chocs électriques peuvent blesser ou même tuer. Le procédé au jet de plasma requiert et produit de l'énergie électrique haute tension. Cette énergie électrique peut produire des chocs graves, voire mortels, pour l'opérateur et les autres personnes sur le lieu de travail.

- Ne touchez jamais une pièce "sous tension" ou "vive"; portez des gants et des vêtements secs. Isolez-vous de la pièce de travail ou des autres parties du circuit de soudage.
- Réparez ou remplacez toute pièce usée ou endommagée.

- Prenez des soins particuliers lorsque la zone de travail est humide ou moite.
- Montez et maintenez le matériel conformément au Code électrique national des États-Unis. (Voir la page 5, article 9.)
- Débranchez l'alimentation électrique avant tout travail d'entretien ou de réparation.
- Lisez et respectez toutes les consignes du Manuel de consignes.



### INCENDIE ET EXPLOSION

Les incendies et les explosions peuvent résulter des scories chaudes, des étincelles ou de l'arc de plasma. Le procédé à l'arc de plasma produit du métal, des étincelles, des scories chaudes pouvant mettre le feu aux matières combustibles ou provoquer l'explosion de fumées inflammables.

- Soyez certain qu'aucune matière combustible ou inflammable ne se trouve sur le lieu de travail. Protégez toute telle matière qu'il est impossible de retirer de la zone de travail.
- Procurez une bonne aération de toutes les fumées inflammables ou explosives.
- Ne coupez pas et ne soudez pas les conteneurs ayant pu renfermer des matières combustibles.
- Prévoyez une veille d'incendie lors de tout travail dans une zone présentant des dangers d'incendie.
- Le gaz hydrogène peut se former ou s'accumuler sous les pièces de travail en aluminium lorsqu'elles sont coupées sous l'eau ou sur une table d'eau. NE PAS couper les alliages en aluminium sous l'eau ou sur une table d'eau à moins que le gaz hydrogène peut s'échapper ou se dissiper. Le gaz hydrogène accumulé explosera si enflammé.



### RAYONS D'ARC DE PLASMA

Les rayons provenant de l'arc de plasma peuvent blesser vos yeux et brûler votre peau. Le procédé à l'arc de plasma produit une lumière infra-rouge et des rayons ultra-violet très forts. Ces rayons d'arc nuiront à vos yeux et brûleront votre peau si vous ne vous protégez pas correctement.

- Pour protéger vos yeux, portez toujours un casque ou un écran de soudeur. Portez toujours des lunettes de sécurité munies de

parois latérales ou des lunettes de protection ou une autre sorte de protection oculaire.

- Portez des gants de soudeur et un vêtement protecteur approprié pour protéger votre peau contre les étincelles et les rayons de l'arc.
- Maintenez votre casque et vos lunettes de protection en bon état. Remplacez toute lentille sale ou comportant fissure ou rognure.
- Protégez les autres personnes se trouvant sur la zone de travail contre les rayons de l'arc en fournissant des cabines ou des écrans de protection.
- Respectez le teint de lentille recommandé dans le article 4, page 5.
- Hydrogen gas may be present under aluminum workpieces during the cutting process when being cut underwater or using a water table. DO NOT cut aluminum underwater or on a water table unless the hydrogen gas can be eliminated as the hydrogen gas may detonate.



#### BRUIT

Le bruit peut provoquer une perte permanente de l'ouïe. Les procédés de soudage à l'arc de plasma peuvent provoquer des niveaux sonores supérieurs aux limites normalement acceptables. Vous devez vous protéger les oreilles contre les bruits forts afin d'éviter une perte permanente de l'ouïe.

- Pour protéger votre ouïe contre les bruits forts, portez des tampons protecteurs et/ou des protections auriculaires. Protégez également les autres personnes se trouvant sur le lieu de travail.
- Il faut mesurer les niveaux sonores afin d'assurer que les décibels (le bruit) ne dépassent pas les niveaux sûrs.
- Pour des renseignements sur la manière de tester le bruit, consultez l'article 1, page 5.

### 1.06 Documents De Reference

Consultez les normes suivantes ou les révisions les plus récentes ayant été faites à celles-ci pour de plus amples renseignements :

1. OSHA, NORMES DE SÉCURITÉ DU TRAVAIL ET DE PROTECTION DE LA SANTÉ, 29CFR 1910, disponible auprès du

Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402

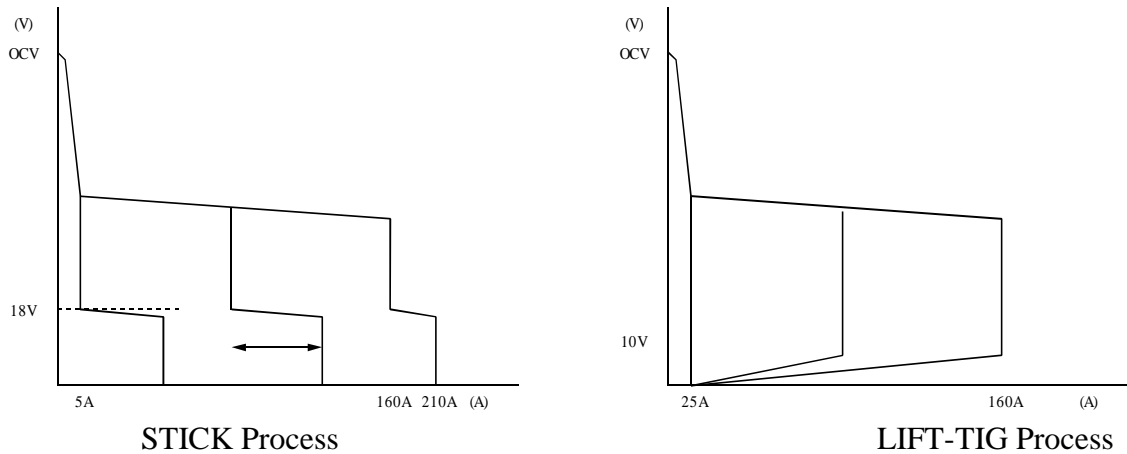
2. Norme ANSI Z49.1, LA SÉCURITÉ DES OPÉRATIONS DE COUPE ET DE SOUDAGE, disponible auprès de la Société Américaine de Soudage (American Welding Society), 550 N.W. LeJeune Rd., Miami, FL 33126
3. NIOSH, LA SÉCURITÉ ET LA SANTÉ LORS DES OPÉRATIONS DE COUPE ET DE SOUDAGE À L'ARC ET AU GAZ, disponible auprès du Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402
4. Norme ANSI Z87.1, PRATIQUES SURES POUR LA PROTECTION DES YEUX ET DU VISAGE AU TRAVAIL ET DANS LES ECOLES, disponible de l'Institut Américain des Normes Nationales (American National Standards Institute), 1430 Broadway, New York, NY 10018
5. Norme ANSI Z41.1, NORMES POUR LES CHAUSSURES PROTECTRICES, disponible auprès de l'American National Standards Institute, 1430 Broadway, New York, NY 10018
6. Norme ANSI Z49.2, PRÉVENTION DES INCENDIES LORS DE L'EMPLOI DE PROCÉDÉS DE COUPE ET DE SOUDAGE, disponible auprès de l'American National Standards Institute, 1430 Broadway, New York, NY 10018
7. Norme A6.0 de l'Association Américaine du Soudage (AWS), LE SOUDAGE ET LA COUPE DE CONTENEURS AYANT RENFERMÉ DES PRODUITS COMBUSTIBLES, disponible auprès de la American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126
8. Norme 51 de l'Association Américaine pour la Protection contre les Incendies (NFPA), LES SYSTEMES À GAZ AVEC ALIMENTATION EN OXYGENE POUR LE SOUDAGE, LA COUPE ET LES PROCÉDÉS ASSOCIÉS, disponible auprès de la National Fire Protection Association, Batterymarch Park, Quincy, MA 02269
9. Norme 70 de la NFPA, CODE ELECTRIQUE NATIONAL, disponible auprès de la National Fire Protection Association, Batterymarch Park, Quincy, MA 02269

10. Norme 51B de la NFPA, LES PROCÉDÉS DE COUPE ET DE SOUDAGE, disponible auprès de la National Fire Protection Association, Batterymarch Park, Quincy, MA 02269
11. Brochure GCA P-1, LA MANIPULATION SANS RISQUE DES GAZ COMPRIMÉS EN CYLINDRES, disponible auprès de l'Association des Gaz Comprimés (Compressed Gas Association), 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202
12. Norme CSA W117.2, CODE DE SÉCURITÉ POUR LE SOUDAGE ET LA COUPE, disponible auprès de l'Association des Normes Canadiennes, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada, M9W 1R3
13. ivret NWSA, BIBLIOGRAPHIE SUR LA SÉCURITÉ DU SOUDAGE, disponible auprès de l'Association Nationale de Fournitures de Soudage (National Welding Supply Association), 1900 Arch Street, Philadelphia, PA 19103
14. Norme AWSF4.1 de l'Association Américaine de Soudage, RECOMMANDATIONS DE PRATIQUES SURES POUR LA PRÉPARATION À LA COUPE ET AU SOUDAGE DE CONTENEURS ET TUYAUX AYANT RENFERMÉ DES PRODUITS DANGEREUX , disponible auprès de la American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126
15. Norme ANSI Z88.2, PRATIQUES DE PROTECTION RESPIRATOIRE, disponible auprès de l'American National Standards Institute, 1430 Broadway, New York, NY 10018

## 2.0 INTRODUCTION AND DESCRIPTION

### 2.01 Description

The Thermal Arc™ Model P-Wee 160S is a self contained single-phase DC arc welding power source with Constant Current (CC) output characteristics. This unit is equipped with a Digital Volt/Amperage Meter and lift arc starter, for use with Gas Tungsten Arc Welding (GTAW) and Shielded Metal Arc Welding (SMAW) processes. The power source is totally enclosed in an impact resistant, flame resistant and non-conductive plastic case.



**Figure 1. Model 160S Volt-Ampere curve**

---

***Note 1***

Volt-Ampere curves show the maximum Voltage and Amperage output capabilities of the welding power source. Curves of other settings will fall between the curves shown.

## 2.02 Functional Block Diagrams

Figure 2 illustrates the functional block diagram of the 160S-power supply.

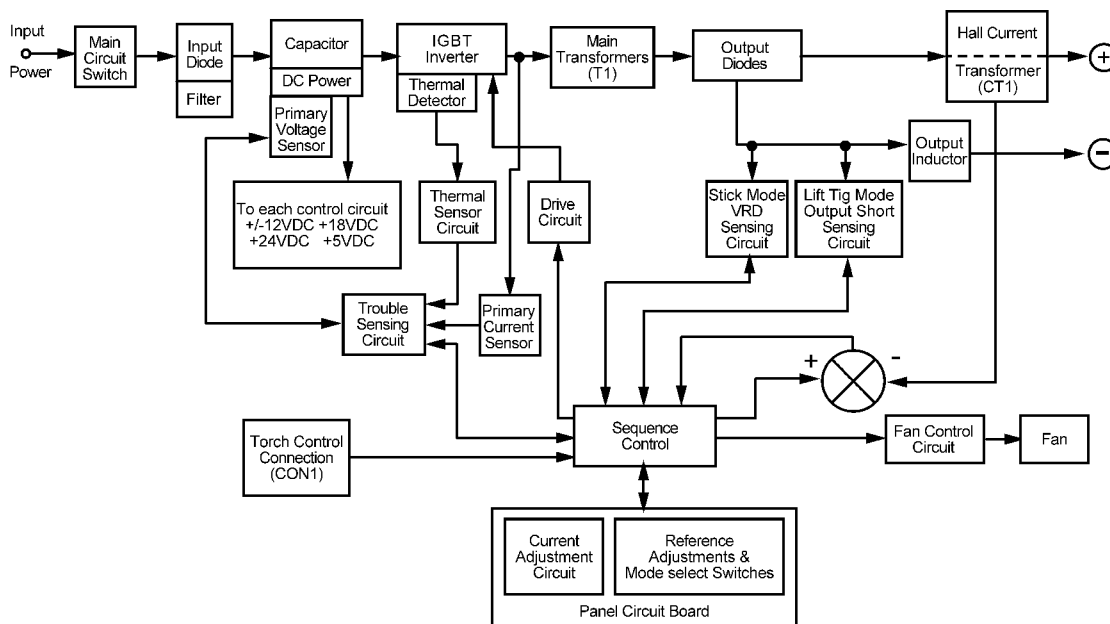


Figure 2. Model 160S Functional Block Diagram

## 2.03 Transporting Methods

These units are equipped with a handle for carrying purposes.



### WARNING 1

*ELECTRIC SHOCK can kill. DO NOT TOUCH live electrical parts. Disconnect input power conductors from de-energized supply line before moving the welding power source.*



### WARNING 2

*FALLING EQUIPMENT can cause serious personal injury and equipment damage.*

Lift unit with handle on top of case.

Use handcart or similar device of adequate capacity.

If using a fork lift vehicle, place and secure unit on a proper skid before transporting.

## 2.04 Installation Recommendations

### 2.04.01 Environment

The P-Wee 160S is designed for use in hazardous environments.

*Examples of environments with increased hazardous environments are -*

- a. In locations in which freedom of movement is restricted, so that the operator is forced to perform the work in a cramped (kneeling, sitting or lying) position with physical contact with conductive parts;
- b. In locations which are fully or partially limited by conductive elements, and in which there is a high risk of unavoidable or accidental contact by the operator, or
- c. In wet or damp hot locations where humidity or perspiration considerably reduces the skin resistance of the human body and the insulation properties of accessories.

*Environments with hazardous environments do not include places where electrically conductive parts in the near vicinity of the operator, which can cause increased hazard, have been insulated.*

### 2.04.02 Location

Be sure to locate the welder according to the following guidelines:

- *In areas, free from moisture and dust.*
- *Ambient temperature between 0 degrees C to 40 degrees C.*
- *In areas, free from oil, steam and corrosive gases.*
- *In areas, not subjected to abnormal vibration or shock.*
- *In areas, not exposed to direct sunlight or rain.*
- *Place at a distance of 12" (304.79mm) or more from walls or similar that could restrict natural airflow for cooling.*



#### **WARNING 3**

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*Thermal Arc advises that this equipment be electrically connected by a qualified electrician.*

---

## 2.05 Electrical Input Connections



### WARNING 4

---

*ELECTRIC SHOCK can kill; SIGNIFICANT DC VOLTAGE is present after removal of input power.*

---

DO NOT TOUCH live electrical parts.

SHUT DOWN welding power source, disconnect input power employing lockout/tagging procedures. Lockout/tagging procedures consist of padlocking line disconnect switch in open position, removing fuses from fuse box, or shutting off and red-tagging circuit breaker or other disconnecting device.

### 2.05.01 Electrical Input Requirements

Operate the welding power source from a single-phase 50/60 Hz, AC power supply. The input voltage must match one of the electrical input voltages shown on the input data label on the unit nameplate. Contact the local electric utility for information about the type of electrical service available, how proper connections should be made, and inspection required.

The line disconnect switch provides a safe and convenient means to completely remove all electrical power from the welding power supply whenever necessary to inspect or service the unit.

---

#### *Note 2*

---

These units are equipped with a two-conductor with earth power cable that is connected at the welding power source end for single phase electrical input power.

**Do not** connect an input (WHITE or BLACK) conductor to the ground terminal.

**Do not** connect the ground (GREEN) conductor to an input line terminal.



Refer to figure 3 and:

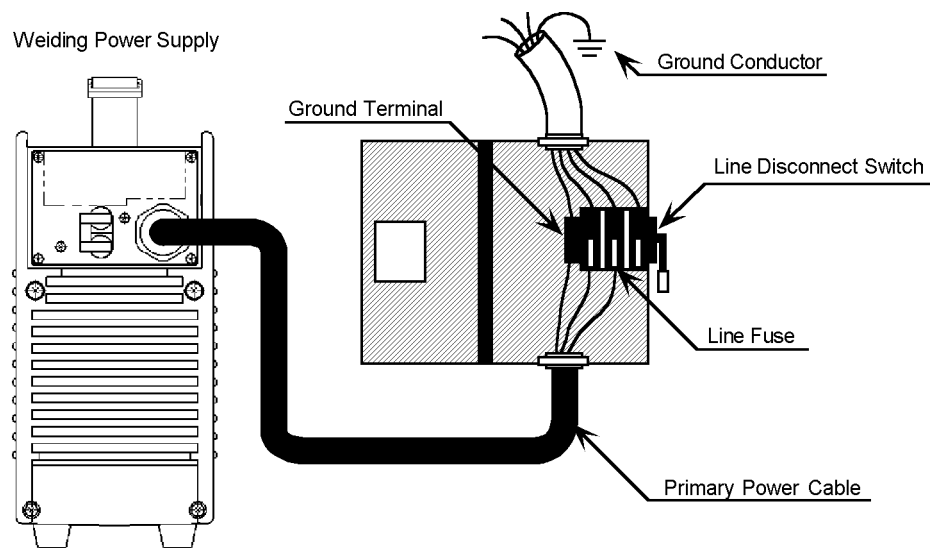
1. Connect end of ground (GREEN) conductor to a suitable ground. Use a grounding method that complies with all applicable electrical codes.
2. Connect ends of line 1 (BLACK) and line 2 (WHITE) input conductors to a de-energized line disconnect switch.
3. Use Table 1 and Table 2 as a guide to select line fuses for the disconnect switch.

| Input Voltage | Fuse Size |
|---------------|-----------|
| 115 VAC       | 40 Amps   |
| 208-230 VAC   | 45 Amps   |

**Table 1 Electrical Input Connections**

*Note 3*

Fuse size is based on not more than 200 percent of the rated input amperage of the welding power source (Based on Article 630, National Electrical Code).



**Figure 3. Electrical Input Connections**

## 2.05.02 Input Power

Each unit incorporates an INRUSH circuit and input voltage sensing circuit. When the MAIN CIRCUIT SWITCH is turned on, the inrush circuit provides a pre-charging of the input capacitors. SCR's in the Power Control Assembly (PCA) will turn on after the input capacitors have charged to full operating voltage (after approximately 5 seconds).

### *Note 4*

Note the available input power. Damage to the PCA could occur if 460VAC or higher is applied.

The following 115/230V Primary Current recommendations are required to obtain the maximum welding current and duty cycle from this welding equipment:

| Model      | Primary Supply Lead Size (Factory Fitted) | Minimum Primary Current Circuit Size (Vin/Amps) | Current & Duty Cycle |            |
|------------|---|---|----------------------|------------|
|            |   |   | TIG                  | STICK      |
| P-Wee 160S | 12/3 AWG minimum                          | 115/22  | 85A @ 100%           | -          |
|            |   | 208/25  | 160A @ 35%           | -          |
|            |   | 230/23  |                      | -          |
|            |   | 115/38  | -                    | 85A @ 100% |
|            |   | 208/42  | -                    | 160A @ 35% |
|            |   | 230/38  | -                    |            |

**Table 2 – 115/230V Primary Current Circuit sizes to achieve maximum current**

### 2.05.03 High Frequency Introduction

The importance of correct installation of high frequency welding equipment cannot be over-emphasized. Interference due to high frequency initiated or stabilized arc is almost invariably traced to improper installation. The following information is intended as a guide for personnel installing high frequency welding machines.

#### *Warning*

##### *Explosives*

The high frequency section of this machine has an output similar to a radio transmitter. The machine should NOT be used in the vicinity of blasting operations due to the danger of premature firing.

##### *Computers*

It is also possible that operation close to computer installations may cause computer malfunction.

### 2.05.04 High Frequency Interference

Interference may be transmitted by a high frequency initiated or stabilized arc welding machine in the following ways:

#### *Direct Radiation*

Radiation from the machine can occur if the case is metal and is not properly grounded. It can occur through apertures such as open access panels. The shielding of the high frequency unit in the Power Source will prevent direct radiation if the equipment is properly grounded.

#### *Transmission via the Supply Lead*

Without adequate shielding and filtering, high frequency energy may be fed to the wiring within the installation (mains) by direct coupling. The energy is then transmitted by both radiation and conduction. Adequate shielding and filtering is provided in the Power Source.

#### *Radiation from Welding Leads*

Radiated interference from welding leads, although pronounced in the vicinity of the leads, diminishes rapidly with distance. Keeping leads as short as possible will minimize this type of interference. Looping and suspending of leads should be avoided where possible.

#### *Re-radiation from Unearthed Metallic Objects*

A major factor contributing to interference is re-radiation from unearthed metallic objects close to the welding leads. Effective grounding of such objects will prevent re-radiation in most cases.

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## 2.06 Specifications

|                                 |       |                               |                |
|---------------------------------|-------|-------------------------------|----------------|
| Parameter                       |       | 160S                          |                |
| Rated Output                    |       | 115VAC                        | 230VAC         |
| Amperes                         |       | 85                            | 160            |
| Volts                           |       | 23                            | 26             |
| Duty Cycle                      |       | 100%                          | 35%            |
| Duty Cycle                      | TIG   | 160A / 16V @ 35%              | 230VAC         |
|                                 |       | 130A / 15V @ 60%              | 230VAC         |
|                                 |       | 100A / 14V @ 100%             | 230VAC         |
|                                 |       | 85A / 13V @ 100%              | 115VAC         |
| Duty Cycle                      | STICK | 160A / 26V @ 35%              | 230VAC         |
|                                 |       | 130A / 25V @ 60%              | 230VAC         |
|                                 |       | 100A / 24V @ 100%             | 230VAC         |
|                                 |       | 85A/23V @ 100%                | 115VAC         |
| Output Current Range            | TIG   | 5 – 160 (230V), 5 - 85 (115V) |                |
|                                 | STICK | 5 – 160 (230V), 5 – 85 (115V) |                |
| Open Circuit Voltage            |       | 64V                           |                |
| <b>Dimensions</b>               |       |                               |                |
| Width                           |       | 5.12” (130mm)                 |                |
| Height                          |       | 10.24” (260mm)                |                |
| Length                          |       | 12.60” (320mm)                |                |
| Weight                          |       | 18.95 lb. 8.6 kg              |                |
| Output @ Rated Load             |       | 115V                          | 230V           |
| Output Amperes                  |       | 85A                           | 160A           |
| Output Volts                    |       | 23V                           | 26V            |
| Duty Cycle                      |       | 100%                          | 35%            |
| KVA                             |       | 4.4                           | 8.7            |
| KW                              |       | 2.4                           | 5.2            |
| <b>Output @ No Load</b>         |       |                               |                |
| KVA                             |       | 0.2                           |                |
| KW                              |       | 0.1                           |                |
| <b>Input Volts Single Phase</b> |       | Amperage Draw @ Rated Load    |                |
| 115V                            |       | 38                            | No Load<br>1.5 |
| 208V                            |       | 42                            | 1.1            |
| 230V                            |       | 38                            | 1.0            |

Thermal Arc continuously strives to produce the best product possible and therefore reserves the right to change, improve or revise the specifications or design of this or any product without prior notice. Such updates or changes do not entitle the buyer of equipment previously sold or shipped to the corresponding changes, updates, improvements or replacement of such items.

## 2.07 Duty Cycle

The duty cycle of a welding power source is the percentage of a ten (10) minute period that it can be operated at a given output without causing overheating and damage to the unit. If the welding amperes decrease, the duty cycle increases. If the welding amperes are increased beyond the rated output, the duty cycle will decrease.



### **WARNING 5**

---

*Exceeding the duty cycle ratings will cause the thermal overload protection circuit to become energized and shut down the output until the unit has cooled to normal operating temperature.*

---

### **CAUTION 1**

---

*Continually exceeding the duty cycle ratings can cause damage to the welding power source and will void the manufactures warranty.*

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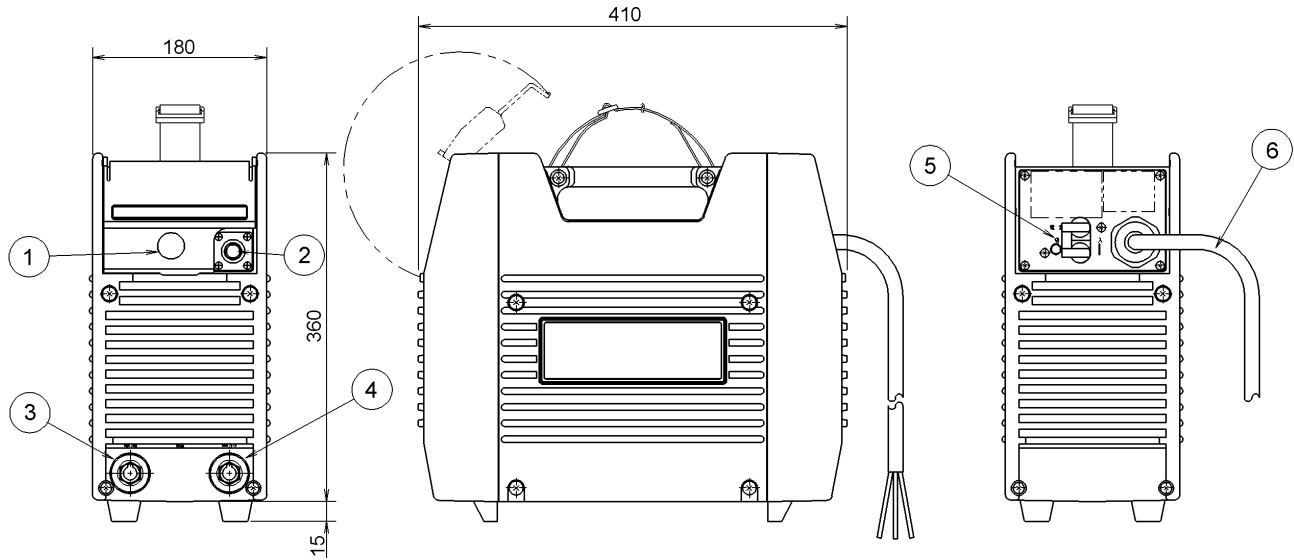
### **NOTE 5**

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Due to variations that can occur in manufactured products, claimed performance, voltages, ratings, all capacities, measurements, dimensions and weights quoted are approximate only. Achievable capacities and ratings in use and operation will depend upon correct installation, use, applications, maintenance and service.

### 3.0 OPERATOR CONTROLS

#### 3.01 P-Wee 160S Controls



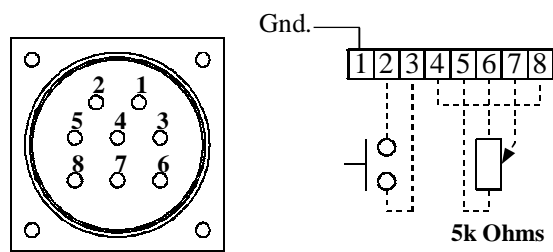
**Figure 4 – P-Wee 160S Power Source**

**1 Control Knob**

This control sets the selected weld parameter, rotating it clockwise increases the parameter and is indicated on the digital meter. Pushing the knob inward displays the actual welding voltage.

**2 Remote Control Socket**

The 8 pin Remote Control Socket is used to connect remote current control devices to the welding Power Source. To make connections, align keyway, insert plug, and rotate threaded collar fully clockwise.



Front view of 8-Socket Receptacle

| Socket Pin | Function   |
|------------|--|
| 1          | Earth (Ground)   |
| 2          | Torch Switch Input (24V) to energize weld current.<br>(connect pins 2 & 3 to turn on welding current)        |
| 3          | Torch Switch Input (0V) to energize weld current<br>(connect pins 2 & 3 to turn on welding current)          |
| 4          | Connect pin 4 to pin 8 to instruct machine that a remote current control device is connected (12V DC supply) |
| 5          | 5k ohm (maximum) connection to 5k ohm remote control potentiometer   |
| 6          | Zero ohm (minimum) connection to 5k ohm remote control potentiometer   |
| 7          | Wiper arm connection to 5k ohm remote control potentiometer  |
| 8          | Connect pin 4 to pin 8 to instruct machine that a remote current control device is connected (0V)            |

### 3 Positive Terminal

Welding current flows from the Power Source via heavy duty Dinse type terminal. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

### 4 Negative Terminal

Welding current flows from the Power Source via heavy duty Dinse type terminal. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

---

#### **CAUTION 2**

---

*Loose welding terminal connections can cause overheating and result in the male plug being fused in the bayonet terminal.*

### 5 ON/OFF Switch

This switch connects the Primary supply voltage to the inverter when in the ON position. This enables the Power Supply.



#### **WARNING 6**

---

*When the welder is connected to the Primary supply voltage, the internal electrical components maybe at 230V potential with respect to earth.*

---

### 6 Input Cable

The input cable connects the Primary supply voltage to the equipment.



### 3.02 Weld Parameter Description for the 160S

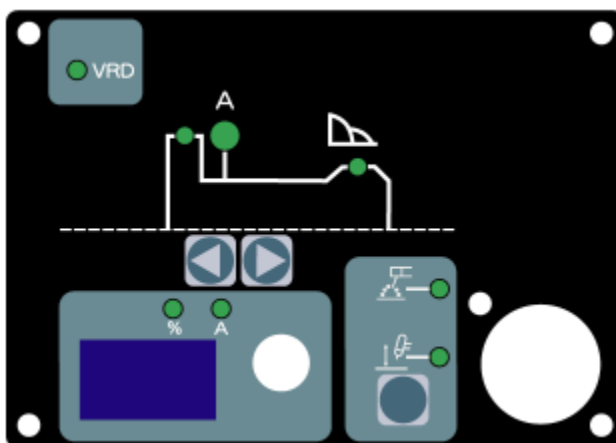


Figure 5. P-Wee 160S Front Panel with Parameter Description




| Parameter   | Description   |
|---|---|
| <i>HOT START</i>  | This parameter operates in STICK weld mode and is used to improve the start characteristics for stick electrodes. e.g. low hydrogen electrodes. It sets the peak start current on top of the ( <i>WELD</i> ) current. |
| <b>A</b>  | Weld Current (Amperage)- sets the STICK and TIG WELD current.   |
|  | ARC CONTROL - This parameter provides a suitable short circuit current in STICK welding to improve electrode sticking and arc stability.  |
|  | LIFT TIG mode of operation. A remote control device is required for use during LIFT TIG operation. See section 3.01, section 2 “Remote Control Socket”, for complete details of the remote device.                    |
|  | STICK Mode of operation.  |

Table 3 – Weld Parameter Descriptions for P-Wee 160S

| Weld Parameter     | Parameter Range | Factory Setting | Incremental Unit | Weld Mode |          |
|--------------------|-----------------|-----------------|------------------|-----------|----------|
|                    |                 |                 |                  | STICK     | LIFT TIG |
| <i>HOT START</i>   | 0 to 70A        | 20A             | 1A               | Yes       | No       |
| <i>WELD CUR</i>    | 5 to 85A 115V   | -               | 1A               | Yes       | Yes      |
|                    | 5 to 160A 230V  | 80A             | 1A               | Yes       | Yes      |
| <i>ARC CONTROL</i> | 0 to 100%       | 10%             | 1%               | Yes       | No       |

### 3.03 Power Source Features

| Feature                                 | Description   |
|---|---|
| <i>New Digital Control</i>              | <ul style="list-style-type: none"> <li>• Almost all welding parameters are adjustable</li> </ul>  |
| <i>Touch Panel Switches</i>             | <ul style="list-style-type: none"> <li>• Touch switches eliminate mechanical damage</li> </ul>  |
| <i>Front Control Cover</i>              | <ul style="list-style-type: none"> <li>• Protects front panel controls</li> </ul>   |
| <i>Digital Meter</i>                    | <ul style="list-style-type: none"> <li>• Displays selected weld parameter value</li> <li>• Displays weld current when welding</li> <li>• Displays weld current for 20 seconds after weld has been completed</li> <li>• A selected weld parameter value can be adjusted at any time even while welding</li> </ul>  |
| <i>ON/OFF switch</i>                    | <ul style="list-style-type: none"> <li>• Primary voltage Supply ON/OFF switch located on rear panel</li> </ul>  |
| <i>Voltage Reduction Device (VRD)</i>   | <p>Reduces the OCV when the power supply is not in use. Eliminates the need for add on voltage reducers and has no effect on arc starting.</p> <ul style="list-style-type: none"> <li>• VRD fully complies to IEC 60974-1</li> <li>• When Stick mode is selected the green VRD light is ON when not welding and red when welding.</li> <li>• When in TIG modes VRD is off.</li> </ul> |
| <i>Control Knob</i>                     | <ul style="list-style-type: none"> <li>• For the selected weld parameter, rotating the knob clockwise increases the parameter</li> <li>• Rotating the knob counterclockwise decreases the parameter</li> <li>• A selected weld parameter value can be adjusted at any time even while welding</li> <li>• Pushing the knob in displays actual arc voltage.</li> </ul>                  |
| <i>Self Diagnosis Using Error Codes</i> | <ul style="list-style-type: none"> <li>• An error code is displayed on the <i>Digital Meter</i> when a problem occurs with Primary supply voltage or internal component problems. Refer to troubleshooting guide.</li> </ul>  |

## 4.0 SET-UP FOR SMAW (STICK) AND GTAW (TIG)

Conventional operating procedures apply when using the Welding Power Source, i.e. connect work lead directly to work piece and electrode lead is used to hold electrode. Wide safety margins provided by the coil design ensure that the Welding Power Source will withstand short-term overload without adverse effects. The welding current range values should be used as a guide only. Current delivered to the arc is dependent on the welding arc voltage, and as welding arc voltage varies between different classes of electrodes, welding current at any one setting would vary according to the type of electrode in use. The operator should use the welding current range values as a guide, then finally adjust the current setting to suit the application.

**Figure 6 – 160S Set-up**



**WARNING 7**

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*Before connecting the work clamp to the work and inserting the electrode in the electrode holder make sure the Primary power supply is switched off.*

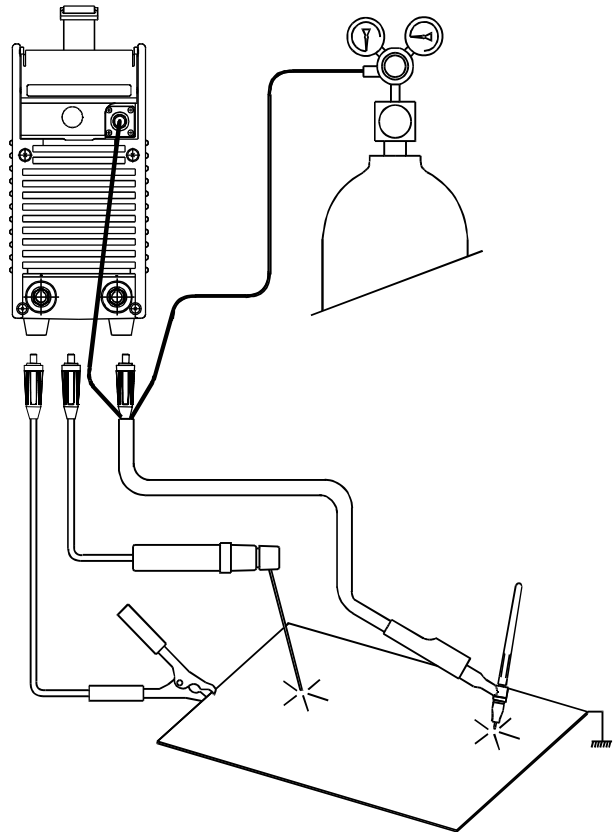
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**CAUTION 3**

---

*Remove any packaging material prior to use.  
Do not block the air vents at the front or rear  
or sides of the Welding Power Source.*

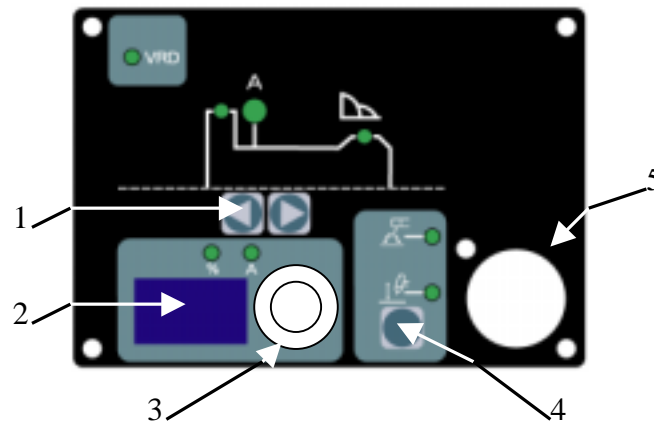
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## 5.0 SEQUENCE OF OPERATION



**NOTE:** Scroll Buttons are used to select the parameters to be set. The LED's show which function is being adjusted on the weld sequence graph. Refer to Symbols Table located in the front of the manual for Symbol descriptions.



**Figure 7 160S Front Panel**

1. Scroll Buttons – used to select the parameters to be set. The LED's show which function is being adjusted on the weld sequence graph.
2. Digital LED display – Welding amperage and parameter values are displayed in this window. Internal warnings such as over temperature, low or high input voltage applied are signaled to the operator by a warning sound and error message on the screen.
3. Control knob – allows the operator to adjust the output amperage within the entire range of the power source also used to set each parameter value. Pushing the knob inward displays the actual welding voltage.
4. Process Button – This button selects between STICK or Lift TIG mode.
5. 8 pin remote control receptacle for connecting remote devices.

## **5.0 Stick Welding**

Connect work lead to negative terminal  
Connect electrode lead to positive terminal  
Switch machine on  
Connect remote control device if required

Use the Scroll Buttons to move to the parameter to be set. The LED will show which function is being adjusted on the weld sequence graph. Use the control knob to adjust each parameter.

Set *HOT START*

Set *WELD* current

Set Arc Control

Commence welding

## **5.02 DC LIFT TIG Welding**

- Connect work lead to positive terminal  
Connect TIG torch to negative terminal  
Switch machine on  
Set weld current.
- Connect remote control device. A remote control device is required for use during LIFT TIG operation. See section 3.01, section 2 “*Remote Control Socket*”, for complete details of the remote device.

Use the Scroll Buttons to move to the parameter to be set. The LED will show which function is being adjusted on the weld sequence graph. Use the control knob to adjust each parameter.

Set *WELD* current

Commence welding

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## 6.0 BASIC TIG WELDING GUIDE

### 6.01 Electrode Polarity

Connect the TIG torch to the - / *TORCH* terminal and the work lead to the + / *WORK* terminal for direct current straight polarity. Direct current straight polarity is the most widely used polarity for DC TIG welding. It allows limited wear of the electrode since 70% of the heat is concentrated at the work piece.

### 6.02 Tungsten Electrode Current Ranges

| Electrode Diameter | DC Current (Amps) |
|--------------------|-------------------|
| 0.040" (1.0mm)     | 30 – 60           |
| 1/16" (1.6mm)      | 60 – 115          |
| 3/32" (2.4mm)      | 100 – 165         |
| 1/8" (3.2mm)       | 135 – 200         |
| 5/32" (4.0mm)      | 190 – 280         |
| 3/16" (4.8mm)      | 250 – 340         |

Table 4 – Current ranges for varies tungsten electrode sizes

### 6.03 Tungsten Electrode Types

| Electrode Type (Ground Finish) | Welding Application  | Features  | Color Code |
|--------------------------------|--|---|------------|
| Thoriated 2%                   | DC welding of mild steel, stainless steel and copper.                                    | Excellent arc starting, Long life, High current carrying capacity.                                  | Red        |
| Ceriated 2%                    | DC welding of mild steel, stainless steel, copper, aluminium, magnesium and their alloys | Longer life, More stable arc, Easier starting, Wider current range, Narrower more concentrated arc. | Grey       |

Table 5 – Tungsten electrode types

#### 6.04 Guide for Selecting Filler Wire Diameter

| Filler Wire Diameter | DC Current Range (Amps) |
|----------------------|-------------------------|
| 1/16" (1.6 mm)       | 20 - 90                 |
| 3/32" (2.4 mm)       | 65 - 115                |
| 1/8" (3.2 mm)        | 100 - 165               |
| 3/16" (4.8 mm)       | 200-350                 |

**Table 6 – Filler wire selection guide**

**NOTE 6**

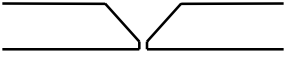
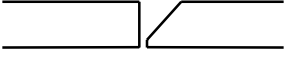

*The filler wire diameter specified in Table 6 is a guide only, other diameter wires may be used according to the welding application*

#### 6.05 Shielding Gas Selection

| Alloy              | Shielding Gas |
|--------------------|---------------|
| Aluminium & alloys | Argon         |
| Carbon Steel       | Argon         |
| Stainless Steel    | Argon         |
| Nickel Alloy       | Argon         |
| Copper             | Argon         |
| Titanium           | Argon         |

**Table 7 – Shielding gas selection**

#### 6.06 TIG Welding Parameters for Low Carbon & Low Alloy Steel Pipe

| Electrode Type & Diameter      | Current Range DC Amperes | Filler Rod for Root Pass | Joint Preparation   |
|--------------------------------|--------------------------|--------------------------|---|
| Thoriated 2%<br>3/32" (2.4 mm) | 120 - 170                | Yes                      |  |
| Thoriated 2%<br>3/32" (2.4 mm) | 100 - 160                | Yes                      |  |
| Thoriated 2%<br>3/32" (2.4 mm) | 90 - 130                 | No                       |  |

**Table 8 – TIG welding parameters for low carbon & low alloy steel pipe**



### 6.07 Welding Parameters for Steel

| Base Metal Thickness | DC Current for Mild Steel | DC Current for Stainless Steel | Tungsten Electrode Diameter | Filler Rod Diameter (if required) | Argon Gas Flow Rate Liters/min | Joint Type                 |
|----------------------|---------------------------|--------------------------------|-----------------------------|-----------------------------------|--------------------------------|----------------------------|
| 0.040"<br>1.0mm      | 35-45<br>40-50            | 20-30<br>25-35                 | 0.040"<br>1.0mm             | 1/16"<br>1.6mm                    | 5-7                            | Butt/Corner<br>Lap/ Fillet |
| 0.045"<br>1.2mm      | 45-55<br>50-60            | 30-45<br>35-50                 | 0.040"<br>1.0mm             | 1/16"<br>1.6mm                    | 5-7                            | Butt/Corner<br>Lap/ Fillet |
| 1/16"<br>1.6mm       | 60-70<br>70-90            | 40-60<br>50-70                 | 1/16"<br>1.6mm              | 1/16"<br>1.6mm                    | 7                              | Butt/Corner<br>Lap/ Fillet |
| 1/8"<br>3.2mm        | 80-100<br>90-115          | 65-85<br>90-110                | 1/16"<br>1.6mm              | 3/32"<br>2.4mm                    | 7                              | Butt/Corner<br>Lap/ Fillet |
| 3/16"<br>4.8mm       | 115-135<br>140-165        | 100-125<br>125-150             | 3/32"<br>2.4mm              | 1/8"<br>3.2mm                     | 10                             | Butt/Corner<br>Lap/ Fillet |
| 1/4"<br>6.4mm        | 160-175<br>170-200        | 135-160<br>160-180             | 1/8"<br>3.2mm               | 5/32"<br>4.0mm                    | 10                             | Butt/Corner<br>Lap/ Fillet |

**Table 9 – DC TIG welding parameters**

## 7.0 Basic Arc Welding Guide

### 7.01 Electrode Polarity

Stick electrodes are generally connected to the '+' terminal and the work lead to the '-' terminal but if in doubt consult the electrode manufacturers literature.

### 7.02 Effects of Stick Welding Various Materials

#### *High tensile and alloy steels*

The two most prominent effects of welding these steels are the formation of a hardened zone in the weld area, and, if suitable precautions are not taken, the occurrence in this zone of under-bead cracks. Hardened zone and under-bead cracks in the weld area may be reduced by using the correct electrodes, preheating, using higher current settings, using larger electrode sizes, short runs for larger electrode deposits or tempering in a furnace.

#### *Manganese steels*

The effect on manganese steel of slow cooling from high temperatures is to embrittle it. For this reason it is absolutely essential to keep manganese steel cool during welding by quenching after each weld or skip welding to distribute the heat.

#### *Cast Iron*

Most types of cast iron, except white iron, are weldable. White iron, because of its extreme brittleness, generally cracks when attempts are made to weld it. Trouble may also be experienced when welding white-heart malleable, due to the porosity caused by gas held in this type of iron.

#### *Copper and alloys*

The most important factor is the high rate of heat conductivity of copper, making preheating of heavy sections necessary to give proper fusion of weld and base metal.

#### *Types of Electrodes*

Arc Welding electrodes are classified into a number of groups depending on their applications. There are a great number of electrodes used for specialized industrial purposes which are not of particular interest for everyday general work. These include some low hydrogen types for high tensile steel, cellulose types for welding large diameter pipes, etc. The range of electrodes dealt with in this publication will cover the vast majority of applications likely to be encountered; are all easy to use and all will work on even the most basic of welding machines.

| <b>Metals being joined</b> | <b>Electrode</b> | <b>Comments</b>   |
|----------------------------|------------------|---|
| Mild steel                 | 6013             | Ideal electrodes for all general purpose work. Features include outstanding operator appeal, easy arc starting and low spatter.                                     |
| Mild steel                 | 7014             | All positional electrode for use on mild and galvanized steel furniture, plates, fences, gates, pipes and tanks etc. Especially suitable for vertical-down welding. |
| Cast iron                  | 99% Nickel       | Suitable for joining all cast irons except white cast iron.   |
| Stainless steel            | 318L-16          | High corrosion resistance. Ideal for dairy work, etc. On stainless steels.  |

| <b>Metals being joined</b>   | <b>Electrode</b>       | <b>Comments</b>   |
|--|------------------------|---|
| Copper, Bronze, Brass, etc.  | Bronze<br>5.7 ERCUSI-A | Easy to use electrode for marine fittings, water taps and valves, water trough float arms, etc. Also for joining copper to steel and for bronze overlays on steel shafts. |
| High Alloy Steels, Dissimilar Metals, Crack Resistance. All Hard-To-Weld Jobs. | 312-16                 | It will weld most problematical jobs such as springs, shafts, broken joins mild steel to stainless and alloy steels.<br>Not suitable for Aluminum.                        |

**Table 10 - Types of Electrodes**

## 8.0 ROUTINE MAINTENANCE

The only routine maintenance required for the power supply is a thorough cleaning and inspection, with the frequency depending on the usage and the operating environment.



### **WARNING 8**

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*Disconnect primary power at the source before opening the enclosure. Wait at least two minutes before opening the enclosure to allow the primary capacitors to discharge.*

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To clean the unit, open the enclosure (please refer to Section 8.01.01, Opening the Enclosure in the 160S Service Manual P/N 430429-513) and use a vacuum cleaner to remove any accumulated dirt and dust. The unit should also be wiped clean, if necessary; with solvents that are recommended for cleaning electrical apparatus.

### **CAUTION 4**

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*Do not blow air into the power supply during cleaning. Blowing air into the unit can cause metal particles to interfere with sensitive electrical components and cause damage to the unit.*

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## 9.0 BASIC TROUBLESHOOTING



### WARNING 9

*There are extremely dangerous voltages and power levels present inside this product. Do not attempt to open or repair unless you are an Accredited Thermal Arc Service Agent and you have had training in power measurements and troubleshooting techniques.*

If major complex subassemblies are faulty, then the Welding Power Source must be returned to an Accredited Thermal Arc Service Agent for repair.

The basic level of troubleshooting is that which can be performed without special equipment or knowledge.

### 9.01 TIG Welding Problems

Weld quality is dependent on the selection of the correct consumables, maintenance of equipment and proper welding technique.

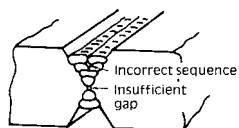
| Description  | Possible Cause                                | Remedy  |
|--|---|---|
| 1 Excessive bead build-up or poor penetration or poor fusion at edges of weld.               | Welding current is too low                    | Increase weld current and/or faulty joint preparation |
| 2 Weld bead too wide and flat or undercut at edges of weld or excessive burn through         | Welding current is too high                   | Decrease weld current                                 |
| 3 Weld bead too small or insufficient penetration or ripples in bead are widely spaced apart | Travel speed too fast                         | Reduce travel speed                                   |
| 4 Weld bead too wide or excessive bead build up or excessive penetration in butt joint       | Travel speed too slow                         | Increase travel speed                                 |
| 5 Uneven leg length in fillet joint  | Wrong placement of filler rod                 | Re-position filler rod                                |
| 6 Electrode melts when arc is struck.  | A Electrode is connected to the '+' terminal. | A Connect the electrode to the '-' terminal.          |

| Description  | Possible Cause  | Remedy   |
|--|---|--|
| 7 Dirty weld pool.                                   | <p>A Electrode contaminated through contact with work piece or filler rod material.</p> <p>B Gas contaminated with air.</p>   | <p>A Clean the electrode by grinding off the contaminates.</p> <p>B Check gas lines for cuts and loose fitting or change gas cylinder.</p>   |
| 8 Electrode melts or oxidizes when an arc is struck. | <p>A No gas flowing to welding region.</p> <p>B Torch is clogged with dust.</p> <p>C Gas hose is cut.</p> <p>D Gas passage contains impurities.</p> <p>E Gas regulator turned off.</p> <p>F Torch valve is turned off.</p> <p>G The electrode is too small for the welding current.</p> | <p>A Check the gas lines for kinks or breaks and gas cylinder contents.</p> <p>B Clean torch</p> <p>C Replace gas hose.</p> <p>D Disconnect gas hose from torch then raise gas pressure and blow out impurities.</p> <p>E Turn on.</p> <p>F Turn on.</p> <p>G Increase electrode diameter or reduce the welding current.</p> |
| 9 Poor weld finish.                                  | Inadequate shielding gas.   | Increase gas flow or check gas line for gas flow problems.   |
| 10 Arc flutters during TIG welding.                  | <p>A Tungsten electrode is too large for the welding current.</p> <p>B Absence of oxides in the weld pool.</p>  | <p>A Select the right size electrode. Refer to Basic TIG Welding guide.</p> <p>B Refer Basic TIG Welding Guide for ways to reduce arc flutter.</p>   |
| 11 Welding arc can not be established.               | <p>A Work clamp is not connected to the work piece or the work/torch leads are not connected to the right welding terminals.</p> <p>B Torch lead is disconnected.</p> <p>C Gas flow incorrectly set, cylinder empty or the torch valve is off.</p>                                      | <p>A Connect the work clamp to the work piece or connect the work/torch leads to the right welding terminals.</p> <p>B Connect it to the ‘-‘ terminal.</p> <p>C Select the right flow rate, change cylinders or turn torch valve on.</p>   |

| Description                 | Possible Cause  | Remedy   |
|-----------------------------|---|--|
| 12 Arc start is not smooth. | <p>A Tungsten electrode is too large for the welding current.</p> <p>B The wrong electrode is being used for the welding job</p> <p>C Gas flow rate is too high.</p> <p>D Incorrect shielding gas is being used.</p> <p>E Poor work clamp connection to work piece.</p> | <p>A Select the right size electrode. Refer to Basic TIG Welding Guide.</p> <p>B Select the right electrode type. Refer to Basic TIG Welding Guide</p> <p>C Select the correct rate for the welding job. Refer to Basic TIG Welding Guide.</p> <p>D Select the right shielding gas. Refer to Basic TIG Welding Guide.</p> <p>E Improve connection to work piece.</p> |

### 9.02 Stick Welding Problems

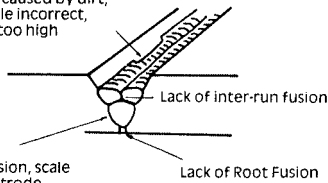
| Description  | Possible Cause   | Remedy  |
|--|--|---|
| 1 Gas pockets or voids in weld metal (Porosity).                           | <p>A Electrodes are damp.</p> <p>B Welding current is too high.</p> <p>C Surface impurities such as oil, grease, paint, etc.</p>     | <p>A Dry electrodes before use.</p> <p>B Reduce welding current.</p> <p>C Clean joint before welding.</p>   |
| 2 Crack occurring in weld metal soon after solidification commences        | <p>A Rigidity of joint.</p> <p>B Insufficient throat thickness.</p> <p>C Cooling rate is too high.</p>                               | <p>A Redesign to relieve weld joint of severe stresses or use crack resistance electrodes.</p> <p>B Travel slightly slower to allow greater build up in throat.</p> <p>C Preheat plate and cool slowly.</p> |
| 3 A gap is left by failure of the weld metal to fill the root of the weld. | <p>A Welding current is too low.</p> <p>B Electrode too large for joint.</p> <p>C Insufficient gap.</p> <p>D Incorrect sequence.</p> | <p>A Increase welding current</p> <p>B Use smaller diameter electrode.</p> <p>C Allow wider gap.</p> <p>D Use correct build-up sequence.</p>  |



**Figure 8 – Example of insufficient gap or incorrect sequence**

|   |   |   |
|---|---|---|
| <p>4 Portions of the weld run do not fuse to the surface of the metal or edge of the joint.</p> | <p>A Small electrodes used on heavy cold plate.<br/> B Welding current is too low.<br/> C Wrong electrode angle.<br/> D Travel speed of electrode is too high.<br/> E Scale or dirt on joint surface.</p> | <p>A Use larger electrodes and pre-heat the plate.<br/> B Increase welding current<br/> C Adjust angle so the welding arc is directed more into the base metal<br/> D Reduce travel speed of electrode<br/> E Clean surface before welding.</p> |
|---|---|---|

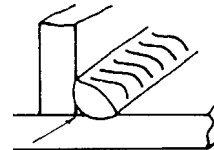
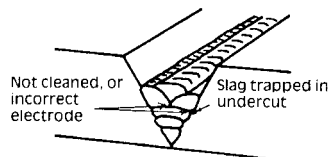
Lack of fusion caused by dirt, electrode angle incorrect, rate of travel too high



Lack of side fusion, scale dirt, small electrode, amperage too low

**Figure 9 – Example of lack of fusion**

|   |   |  |
|---|---|--|
| <p>5 Non-metallic particles are trapped in the weld metal (slag inclusion).</p> | <p>A Non-metallic particles may be trapped in undercut from previous run.<br/> B Joint preparation too restricted.<br/> C Irregular deposits allow slag to be trapped.<br/> D Lack of penetration with slag trapped beneath weld bead.<br/> E Rust or mill scale is preventing full fusion.<br/> F Wrong electrode for position in which welding is done.</p> | <p>A If bad undercut is present, clean slag out and cover with a run from a smaller diameter electrode.<br/> B Allow for adequate penetration and room for cleaning out the slag.<br/> C If very bad, chip or grind out irregularities.<br/> D Use smaller electrode with sufficient current to give adequate penetration. Use suitable tools to remove all slag from corners.<br/> E Clean joint before welding.<br/> F Use electrodes designed for position in which welding is done, otherwise proper control of slag is difficult.</p> |
|---|---|--|



**Figure 10 – Examples of slag inclusion**



### 8.03 Power Source Problems

| Description   | Possible Cause  | Remedy  |
|---|---|---|
| 1 The welding arc cannot be established   | A The Primary supply voltage has not been switched ON.<br>B The Welding Power Source switch is switched OFF.<br>C Loose connections internally. | A Switch ON the Primary supply voltage.<br>B Switch ON the Welding Power Source.<br>C Have an Accredited Thermal Arc Service Agent repair the connection. |
| 2 Maximum output welding current can not be achieved with nominal Mains supply voltage. | Defective control circuit   | Have an Accredited Thermal Arc Service Agent inspect then repair the welder.  |
| 3 Welding current reduces when welding  | Poor work lead connection to the work piece.  | Ensure that the work lead has a positive electrical connection to the work piece.   |
| 4 No gas flow when the torch trigger switch is depressed.                               | A Gas hose is cut.<br>B Gas passage contains impurities.<br>C Gas regulator turned off.   | A Replace gas hose.<br>B Disconnect gas hose from the rear of Power Source then raise gas pressure and blow out impurities.<br>C Turn gas regulator on.   |

## 10.0 Voltage Reduction Device (VRD)

### 10.01 VRD Specification

| Description              | P-Wee 160S         | Notes   |
|--------------------------|--------------------|---|
| VRD Open Circuit Voltage | 15.3 to 19.8V      | Open circuit voltage between welding terminals                                    |
| VRD Resistance           | 148 to 193 ohms    | The required resistance between welding terminals to turn ON the welding power    |
| VRD Turn OFF Time        | 0.2 to 0.3 seconds | The time taken to turn OFF the welding power once the welding current has stopped |

### 10.02 VRD Maintenance

#### Routine inspection and testing (power source)

An inspection of the power source, an insulation resistance test and an earth resistance test shall be carried out.

- a) For transportable equipment, at least once every 3 months; and
- b) For fixed equipment, at least once every 12 months.

The owners of the equipment shall keep a suitable record of the periodic tests.

#### *Note 7*

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*A transportable power source is any equipment that is not permanently connected and fixed in the position in which it is operated.*

In addition to the above tests and specifically in relation to the VRD fitted to this machine, the following periodic tests should also be conducted by an accredited Thermal Arc service agent.

| Description              | IEC 60974-1 Requirements                |
|--------------------------|---|
| VRD Open Circuit Voltage | Less than 20V; at $V_{in}=115V$ or 230V |
| VRD Turn ON Resistance   | Less than 200 ohms                      |
| VRD Turn OFF Time        | Less than 0.3 seconds                   |

If this equipment is used in a hazardous location or environments with a high risk of electrocution then the above tests should be carried out prior to entering this location.

## 11.0 Power Source Error Codes

| Description   | Possible Cause   | Remedy   | Remarks   |
|---|--|--|---|
| <p>1 <u>E01 error code displayed</u><br/>Temperature sensor TH1 (protects IGBTs) is greater than 80°C for about 1 second</p>      | <p>A The Welding Power Source's duty cycle has been exceeded.<br/>B Fan ceases to operate.<br/>C Air flow is restricted by vents being blocked</p> | <p>A Let Power Source cool down then keep within its duty cycle.<br/>B Have an Accredited Thermal Arc Service Agent investigate<br/>C Unblock vents then let Power Source cool down.</p> | <p>Weld current ceases.<br/>Buzzer sounds constantly.<br/>E01 resets when TH1 decreases to 70°C for about 30 seconds.</p>       |
| <p>2 <u>E03 error code displayed</u><br/>Primary (input) current too high</p>   | <p>A Primary current is too high because welding arc is too long.<br/>B Mains supply voltage is more than 10% below nominal voltage</p>            | <p>A Reduce length of welding arc.<br/>B Have an Accredited Thermal Arc Service Agent or a qualified electrician check for low Mains voltage.</p>  | <p>Weld current ceases.<br/>Buzzer sounds constantly.<br/>Switch machine off then on to reset E03 error.</p>                    |
| <p>3 <u>E11 error code displayed</u><br/>Over Primary supply (input) voltage at primary capacitors is exceeded for one second</p> | <p>Primary supply voltage is greater than the nominal voltage plus 10%</p>   | <p>Have an Accredited Thermal Arc Service Agent or a qualified electrician check the Primary voltage.</p>  | <p>Weld current ceases.<br/>Buzzer sounds constantly.<br/>Error code E11 automatically will reset when the voltage reduces.</p> |

| Description  | Possible Cause  | Remedy   | Remarks   |
|--|---|--|---|
| <p>4 <u>E12</u> error code displayed<br/>Under mains supply (input) voltage primary capacitors is reduced for one second</p> | <p>Mains supply voltage is down to a dangerously low level.</p>           | <p>A Have an Accredited Thermal Arc Service Agent or a qualified electrician check the Mains voltage</p> <p>B Have an Accredited Thermal Arc Service Agent or a qualified electrician check the primary cable &amp; fuses.</p> | <p>Weld current ceases.<br/>Buzzer sounds constantly.<br/>Error code E12 automatically will reset when the voltage increases.</p> |
| <p>5 <u>E93</u> error code displayed<br/><u>Memory chip (EEPROM)</u> on control PCB can not read/write weld parameters</p>   | <p>Memory chip (EEPROM) error</p>   | <p>Have an Accredited Thermal Arc Service Agent check the control PCB</p>  | <p>Weld current ceases.<br/>Buzzer sounds constantly.<br/>Switch machine off.</p>   |
| <p>6 <u>E94</u> error code displayed<br/>Temperature sensor TH1 for IGBT's is an open circuit.</p>                           | <p>The Welding Power Source's temperature sensors have malfunctioned.</p> | <p>Have an Accredited Thermal Arc Service Agent check or replace the temperature sensors.</p>  | <p>Weld current ceases.<br/>Buzzer sounds constantly.<br/>Switch machine off.</p>   |

## 12.0 PARTS LIST

| DWG. No. | Description           | Type & Rating                           | QTY. | Code No.    | Order No. |
|----------|-----------------------|---|------|-------------|-----------|
| C1       | Capacitor             | SS351206PPQ1 DC 350V 20uF               | 1    | 42601003900 | 10-6685   |
| C2       | Capacitor             | ECKATS103MF 0.01uF                      | 1    | 42442007100 | 10-2219   |
| C3       | Capacitor             | ECKATS103MF 0.01uF                      | 1    | 42442007100 | 10-2219   |
| C4       | Capacitor             | ECW-H10H683JR DC1KV 0.068uF             | 1    | 42421138500 | 10-5013   |
| C5-6     | Capacitor             | ECW-H12H472JR 1200V .0047uF             | 2    | 42421141100 | 10-2216   |
| CON1     | Remote Socket         | 206433-1 8P<br>(with Wiring Assembly)   | 1    | U0A706200   | 10-6838   |
| CT1      | Current Sensor        | HC-TN200V4B15M 200A 4V                  | 1    | 11251003000 | 10-5003   |
| D1       | Diode                 | GBPC3508 800V 35A                       | 1    | 44913000100 | 10-6686   |
| D2-3     | Diode                 | DBA200UA40                              | 2    | 4582A0040   | 10-6687   |
| FAN1     | Fan                   | D12T24PS101 DC 24V                      | 1    | U0A738100   | 10-6840   |
| L1       | Inductor              | F2A753900 200A STICK FCH                | 1    | F2A753900   | 10-6688   |
| L104     | Inductor              | 1615MRE RING CORE                       | 1    | 63200006500 | 10-6538   |
| PCB1     | Printed Circuit Board | WK-4980 U01 MAIN2<br>with Thunder Label | 1    | U0A706300   | 10-6689   |
| PCB2     | Printed Circuit Board | WK-4977 U01 MAIN1<br>with Thunder Label | 1    | U0A706400   | 10-6690   |
| PCB4     | Printed Circuit Board | WK-4985 U07 STICK PANEL                 | 1    | P0A498507   | 10-6691   |
| PCB5     | Printed Circuit Board | WK-4986 U01 CNTL1                       | 1    | P0A498601   | 10-6692   |
| PCB6     | Printed Circuit Board | WK-4987 U01 CNTL2                       | 1    | P0A498701   | 10-6693   |
| PCB7     | Printed Circuit Board | WK-5015 U01 DIODE PCB                   | 1    | P0A501501   | 10-6694   |
| PCB8     | Printed Circuit Board | WK-5071 U01 CONNECT PCB                 | 1    | P0A507101   | 10-6695   |

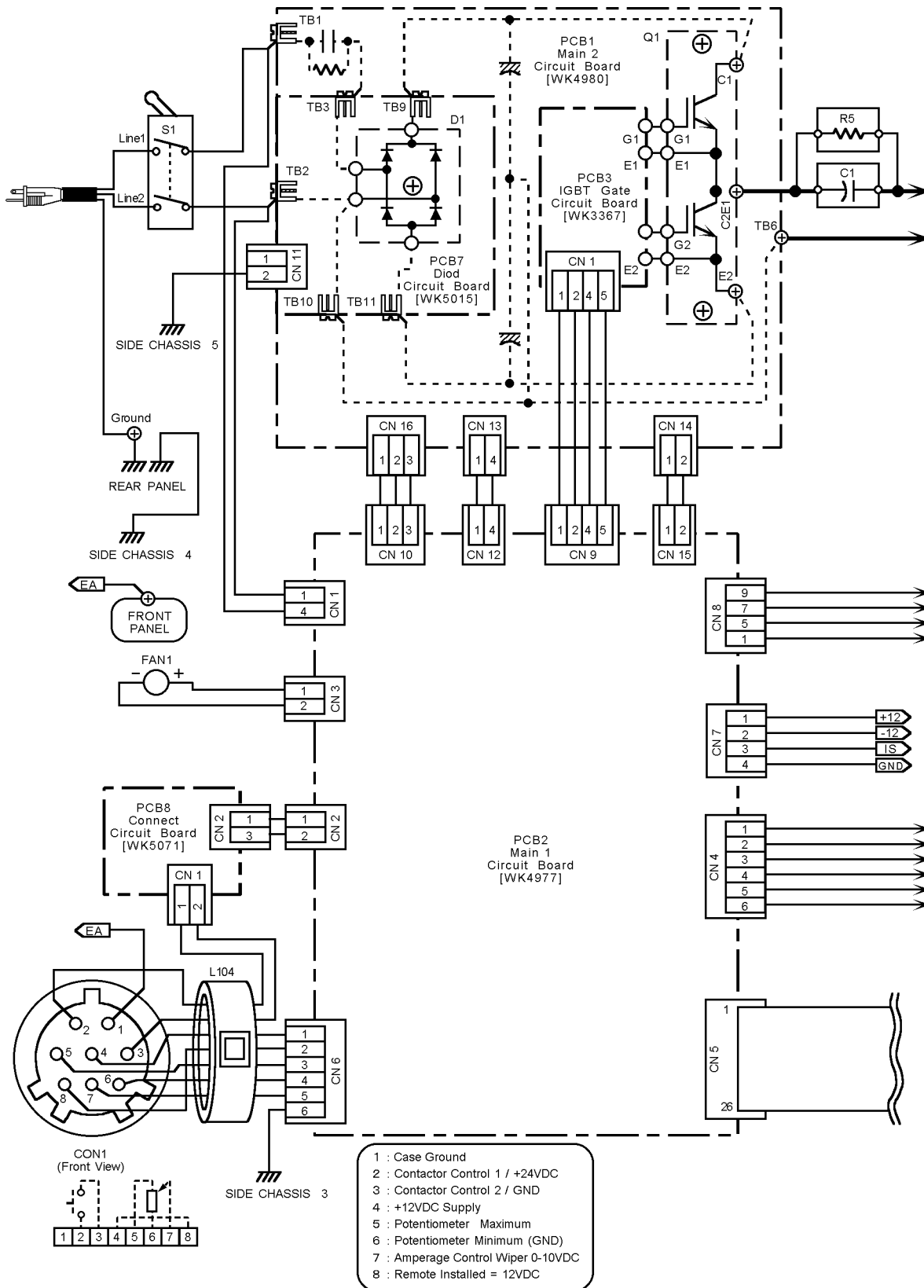
## 12.0 PARTS LIST Continued

| DWG. No. | Description         | Type & Rating                                 | QTY. | Code No.    | Order No. |
|----------|---------------------|---|------|-------------|-----------|
| Q1       | Transistor          | CM100DUS12F-2 600V 100A<br>(with WK-3367 U04) | 1    | U0A706500   | 10-6696   |
| R1       | Resistor            | ERG-3ANJ 472 3W 4.7k $\Omega$                 | 1    | 40305147200 | 10-5010   |
| R3A      | Resistor            | ERG3SJ330 3W 33 $\Omega$                      | 1    | 40305010100 | 10-6697   |
| R3B      | Resistor            | ERG3SJ330 3W 33 $\Omega$                      | 1    | 40305010100 | 10-6697   |
| R4A      | Resistor            | ERG3SJ330 3W 33 $\Omega$                      | 1    | 40305010100 | 10-6697   |
| R4B      | Resistor            | ERG3SJ330 3W 33 $\Omega$                      | 1    | 40305010100 | 10-6697   |
| R5       | Resistor            | ERG-3ANJ 103 3W 10k $\Omega$                  | 1    | 40305110300 | 10-5009   |
| S1       | Switch              | DCP-52SR50C-480V 2P-480V                      | 1    | 25850003500 | 10-6644   |
| T1       | Transformer         | F2A704300                                     | 1    | F2A704300   | 10-6698   |
| TH1      | Thermistor          | ERTA53D203 20K"/25°C B=3950K                  | 1    | U0A733200   | 10-6841   |
|          | Front Panel         | E0D004500                                     | 1    | U0A749600   | 10-6880   |
|          | Rear Panel          | E0D004600                                     | 1    | U0A749700   | 10-6881   |
|          | Side Panel          | E0D006000                                     | 2    | E0D006000   | 10-6701   |
|          | Front Control Cover | J4B515400                                     | 1    | J4B515400   | 10-6702   |
|          | Rear Control Cover  | JDA111800 (with Label)                        | 1    | U0A706800   | 10-6703   |
|          | Protection Cover    | E1B500700                                     | 1    | E1B500700   | 10-6704   |
|          | Encoder Cover       | EBA514400                                     | 1    | EBA514400   | 10-6654   |
|          | PCB Cover           | E1B550900 (with Caution Label)                | 1    | U0A706700   | 10-6705   |
|          | Strap               | E5A937000                                     | 1    | E5A937000   | 10-5069   |
|          | Name Label          | N4A007300                                     | 2    | N4A007300   | 10-6706   |
|          | Side Label          | N4A009100                                     | 2    | N4A009100   | 10-6707   |

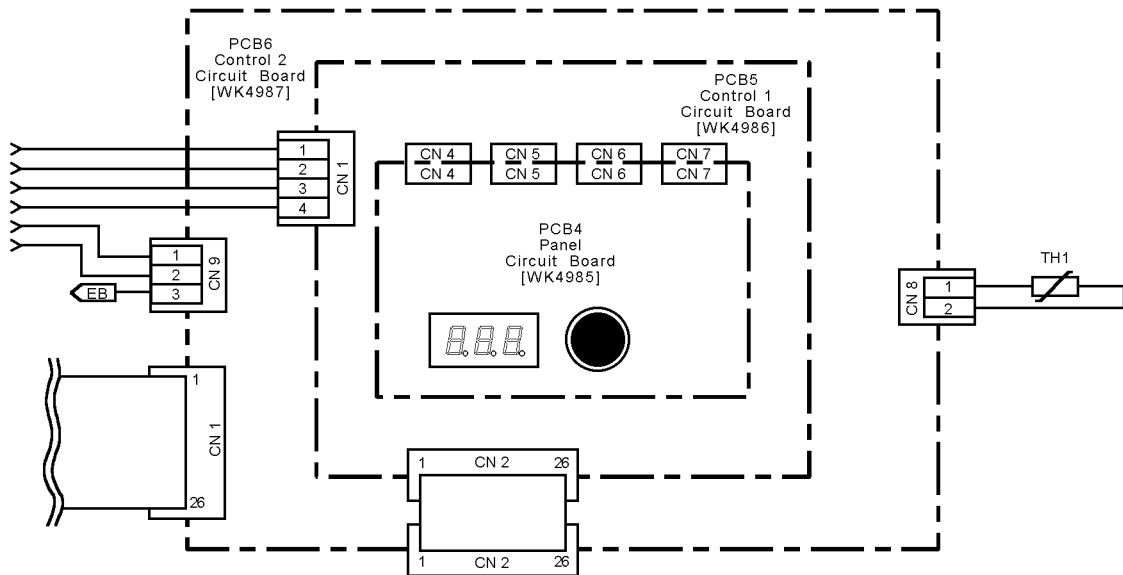
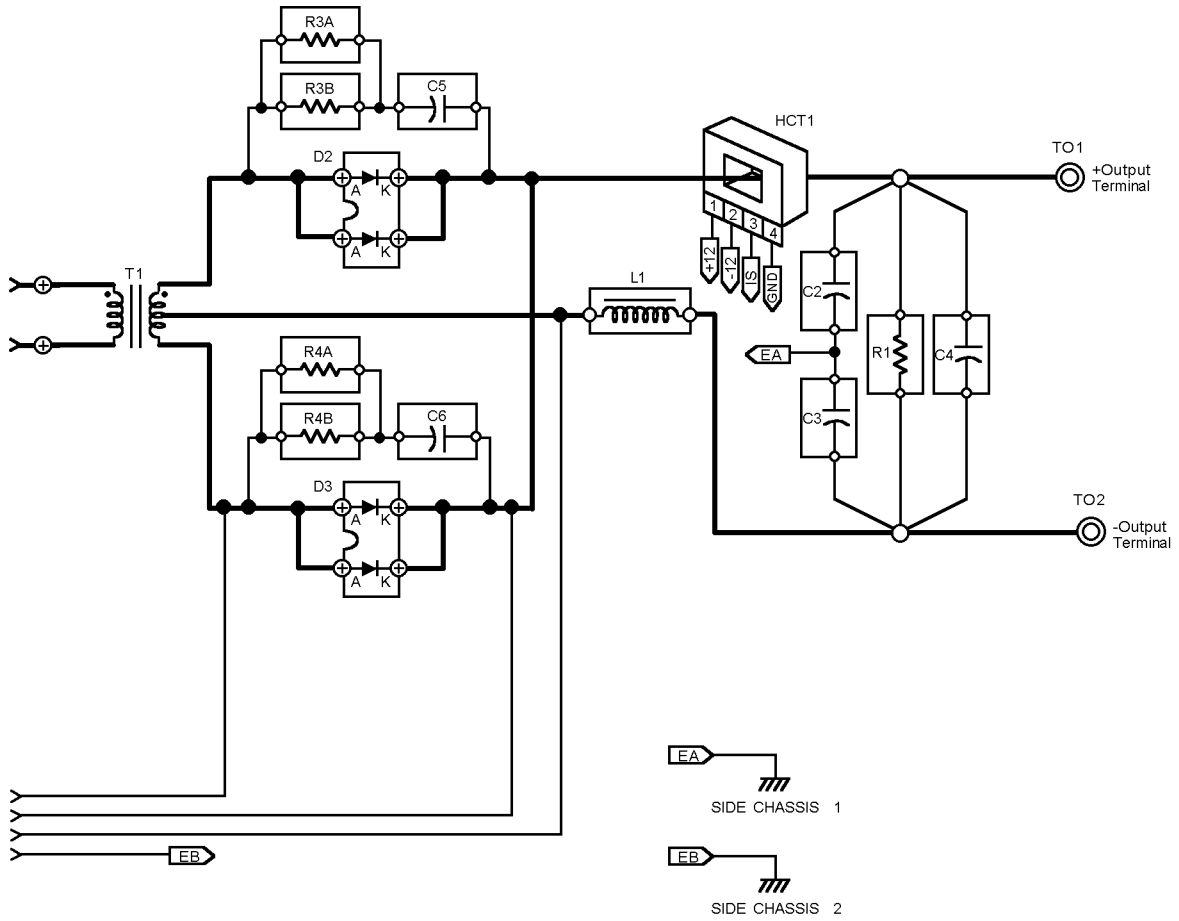
## 12.0 PARTS LIST Continued

| DWG. No. | Description              | Type & Rating            | QTY. | Code No.    | Order No.  |
|----------|--------------------------|--------------------------|------|-------------|------------|
|          | Warning Label 1          | N4A072400                | 1    | N4A072400   | 10-6708    |
|          | Warning Label 2          | N4A072500                | 1    | N4A072500   | 10-6709    |
|          | Output Terminal Label    | N4A057700                | 1    | N4A057700   | 10-6710    |
|          | Output Terminal (female) | TRAK-BE 10-25            | 2    | 26999025700 | 10-6711    |
|          | Input Cable              | 132" 12/3SOW BLK W/5-15P | 1    | 52031130100 | N/A        |
|          | Input Cable Clamp        | SCLB18A                  | 1    | 53613021800 | 10-6712    |
|          | Heatsink                 | E1B575400                | 1    | E1B575400   | 10-6713    |
|          | Knob                     | 2615603                  | 1    | 50990001500 | 10-6714    |
|          | Knob Cap                 | 3015104                  | 1    | 50990003500 | 10-6715    |
|          | Control Cover Sheet      | N0B883100                | 1    | N0B883100   | 10-6716    |
|          | Flat Cable (Long)        | EAA547301                | 1    | EAA547301   | 10-6668    |
|          | Flat Cable (Short)       | EBA420200                | 1    | EBA420200   | 10-6717    |
|          | Q-Post (M5)              | EBA436000                | 1    | EBA436000   | 10-6674    |
|          | D-T Bus Bar              | EBA447900                | 2    | EBA447900   | 10-6718    |
|          | Q Bus Bar1               | EBA448200                | 2    | EBA448200   | 10-6719    |
|          | Q Bus Bar2 (C2E1)        | EBA551900                | 1    | EBA551900   | 10-6720    |
|          | Diode Bus Bar            | EBA508300                | 1    | EBA508300   | 10-6721    |
|          | Clip                     | #74 NATURAL              | 4    | 60602422000 | 10-5259    |
|          | Front Chassis            | J3C009200                | 1    | J3C009200   | 10-6722    |
|          | Rear Chassis             | J3C010800                | 1    | J3C010800   | 10-6723    |
|          | Capacitor Chassis        | JDA117700                | 1    | JDA117700   | 10-6724    |
|          | HF. Unit Chassis         | J4B549700                | 1    | J4B549700   | 10-6725    |
|          | Output Terminal (male)   | TRAK-SK10-25             | 2    | 26999025600 | 10-1068    |
|          | Operating Manual         |                          | 1    |             | 430429-504 |
|          | Service Manual           |                          |      |             | 430429-513 |

# APPENDIX A - INTERCONNECT DIAGRAM







# APPENDIX B - AUTOMATION

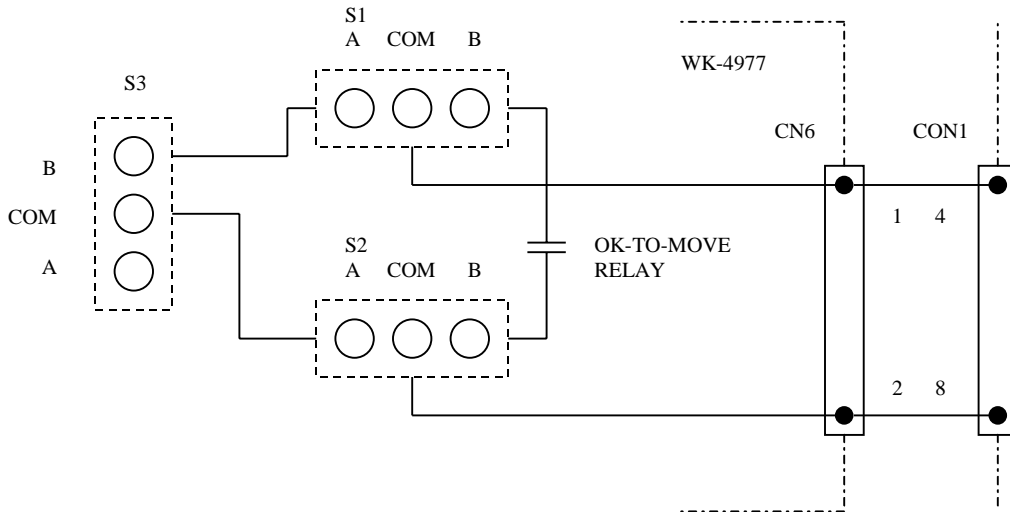
## SLIDE SWITCH SETTING FOR "OK-TO-MOVE". Models 160S/TS

Three slide switches (S1, S2 and S3) are provided on PC Board WK-4977 for automation purposes. This PCB is the units right side main PCB. This PCB can be accessed by removing the side covers by loosening 4 screws on each the front and rear panel, then removing the 4 side panel screws as well as the 2 handle screws. Carefully pull the front and rear panels outward to release and remove the side cover. Lift up the protective PCB cover sheet from the bottom and the slide switches will be accessible through a slot in the PCB Board. See figure on next page for details.

All units are shipped from the factory with the slide switches set in position "A". This is for normal semi-automatic operation utilizing a remote device, such as a foot control. The 8-pin remote operates as described earlier in this manual.

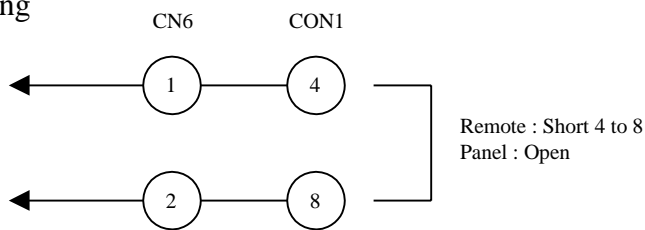
Placing all slide switches in position "B" would be primarily used for automation with an arc establish relay, remote amperage and contactor. An arc-establish signal is located from pins 4 and 8 when in this mode.

Placing slide switches S1 and S2 in "B" position and slide switch S3 in "A" position would have the configuration of an arc-establish signal and remote contactor, but the unit's front panel would control the amperage.



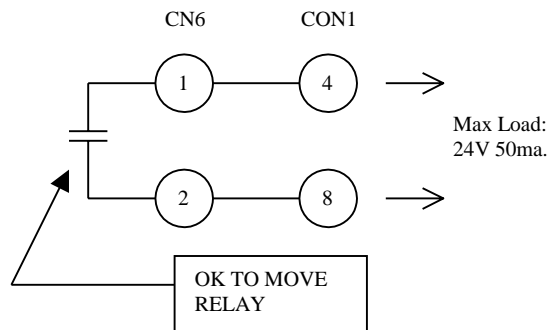
- Set All "A" position : factory shipping

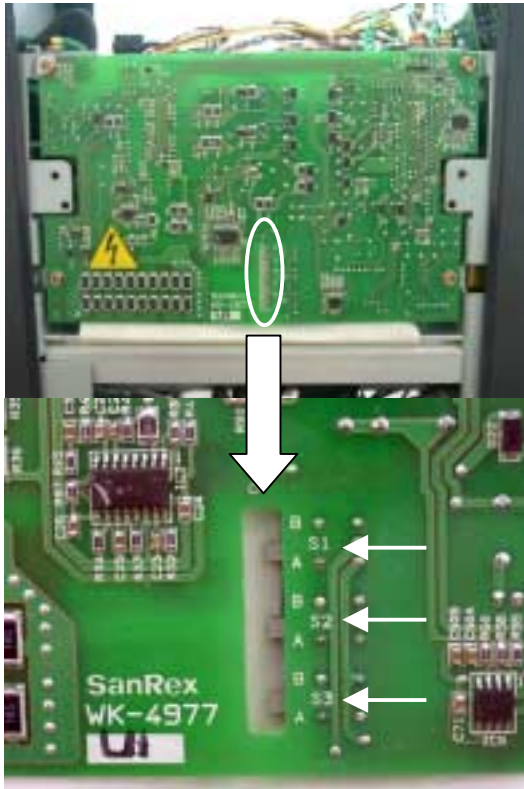
|    | POSITION |
|----|----------|
| S1 | A        |
| S2 | A        |
| S3 | A        |



- Use "OK TO MOVE signal"

|     | POSITION |       |
|-----|----------|-------|
| S1  | B        | B     |
| S2  | B        | B     |
| S3  | B        | A     |
| A/V | REMOTE   | PANEL |





**Figure 11 – Slide Switch Location**