

MIG



STICK



TIG



Transmig 355i

MULTI PROCESS WELDING INVERTER



CIGWELD

AN ESAB BRAND



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Please register your warranty online
immediately after purchase for
complete warranty coverage and to
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WE APPRECIATE YOUR BUSINESS!

Congratulations on your new CIGWELD product. We are proud to have you as our customer and will strive to provide you with the best service and reliability in the industry. This product is backed by our extensive warranty and world-wide service network. To locate your nearest distributor or accredited service provider call Australia: 1300 654 674, International Customers: +61 3 9474 7508, or visit us on the web at www.cigweld.com.au

This Operating Manual has been designed to instruct you on the correct use and operation of your CIGWELD product. Your satisfaction with this product and its safe operation is our ultimate concern. Therefore please take the time to read the entire manual, especially the Safety Precautions. They will help you to avoid potential hazards that may exist when working with this product.

We have made every effort to provide you with accurate instructions, drawings, and photographs of the product(s) while writing this manual. However errors do occur and we apologize if there are any contained in this manual.

Due to our constant effort to bring you the best products, we may make an improvement that does not get reflected in the manual. If you are ever in doubt about what you see or read in this manual with the product you received, then check for a newer version of the manual on our website or contact our customer support for assistance.

YOU ARE IN GOOD COMPANY!

The Brand of Choice for Contractors and Fabricators Worldwide.

CIGWELD is a Market Leading Brand of Arc Welding Products for ESAB. We are a mainline supplier to major welding industry sectors in the Asia Pacific and emerging global markets including; Manufacturing, Construction, Mining, Automotive, Engineering, Rural and DIY.

We distinguish ourselves from our competition through market-leading, dependable products that have stood the test of time. We pride ourselves on technical innovation, competitive prices, excellent delivery, superior customer service and technical support, together with excellence in sales and marketing expertise.

Above all, we are committed to develop technologically advanced products to achieve a safer working environment for industry operators.

**WARNINGS**

Read and understand this entire Manual and your employer's safety practices before installing, operating, or servicing the equipment.

While the information contained in this Manual represents the Manufacturer's best judgement, the Manufacturer assumes no liability for its use.

Operating Manual Number 0-5586 for:
Transmig 355i Compact Plant
Transmig 355i Remote Plant

Part Number: W1003511
Part Number: W1003510

Published by:

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Publication Date: 20-12-2020
Revision Date: 04-02-2021

Record the following information for Warranty purposes:

Where Purchased: _____

Purchase Date: _____

Equipment Serial #: _____

DECLARATION OF CONFORMITY

According to
AS/NZS 3820:2020, Essential Safety Requirements for Electrical Equipment
Radiocommunications Labelling (Electromagnetic Compatibility) Notice 2017

Type of equipment

Arc welding power source

Type designation

Transmig 355i with serial number from: KC048-xxxx-xxxx

Brand name or trademark

CIGWELD

Manufacturer or his authorized representative established within the EEA**Name, address, and telephone No:**

Cigweld Pty Ltd
71 Gower Street
Preston, Victoria, Australia, 3072
Phone: +61 3 9474 7400; www.cigweld.com.au

The following has been used in the design:

AS 1674.2:2007	Safety in welding and allied processes, Part 2: Electrical
AS 60974.1:2020	Arc Welding Equipment, Part 1: Welding Power Sources
AS/NZS 3760-2010	In-service Safety Inspection and Testing of Electrical Equipment
EN IEC 60974-1: 2018/A1:2019	Arc Welding Equipment, Part 1: Welding Power Sources
EN 60974-10:2014/A1:2015	Arc Welding Equipment, Part 10: EMC requirements

Additional information:

Restrictive use, Class A equipment, intended for use in location other than residential.
This equipment is also in compliance with the essential requirements of EU Directives 2014/30/EU and 2014/35/EU.

By signing this document, the undersigned declares as manufacturer, or the manufacturer's authorized representative, that the equipment in question complies with the safety requirements stated above.

Place/Date

Signature



Preston
2020-11-23

Jarrod Brennan
General Manager

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SECTION 1: ARC WELDING SAFETY INSTRUCTIONS AND WARNINGS



WARNING

PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS KEEP AWAY UNTIL CONSULTING YOUR DOCTOR. DO NOT LOSE THESE INSTRUCTIONS. READ OPERATING/INSTRUCTION MANUAL BEFORE INSTALLING, OPERATING OR SERVICING THIS EQUIPMENT.

Welding products and welding processes can cause serious injury or death, or damage to other equipment or property, if the operator does not strictly observe all safety rules and take precautionary actions.

Safe practices have developed from past experience in the use of welding and cutting. These practices must be learned through study and training before using this equipment. Some of these practices apply to equipment connected to power lines; other practices apply to engine driven equipment. Anyone not having extensive training in welding and cutting practices should not attempt to weld.

Safe practices are outlined in the Australian Standard AS1674.2-2007 entitled: Safety in welding and allied processes Part 2: Electrical. This publication and other guides to what you should learn before operating this equipment are listed at the end of these safety precautions. **HAVE ALL INSTALLATION, OPERATION, MAINTENANCE, AND REPAIR WORK PERFORMED ONLY BY QUALIFIED PEOPLE.**

1.01 Arc Welding Hazards

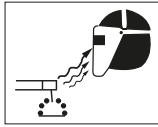


WARNING

ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

1. Do not touch live electrical parts.
2. Wear dry, hole-free insulating gloves and body protection.
3. Insulate yourself from work and ground using dry insulating mats or covers.
4. Disconnect input power or stop engine before installing or servicing this equipment. Lock input power disconnect switch open, or remove line fuses so power cannot be turned on accidentally.
5. Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
6. Turn off all equipment when not in use. Disconnect power to equipment if it will be left unattended or out of service.
7. Use fully insulated electrode holders. Never dip holder in water to cool it or lay it down on the ground or the work surface. Do not touch holders connected to two welding machines at the same time or touch other people with the holder or electrode.
8. Do not use worn, damaged, undersized, or poorly spliced cables.
9. Do not wrap cables around your body.
10. Ground the workpiece to a good electrical (earth) ground.
11. Do not touch electrode while in contact with the work (ground) circuit.
12. Use only well-maintained equipment. Repair or replace damaged parts at once.
13. In confined spaces or damp locations, do not use a welder with AC output unless it is equipped with a voltage reducer. Use equipment with DC output.
14. Wear a safety harness to prevent falling if working above floor level.
15. Keep all panels and covers securely in place.

**WARNING**

ARC RAYS can burn eyes and skin; NOISE can damage hearing.

Arc rays from the welding process produce intense heat and strong ultraviolet rays that can burn eyes and skin. Noise from some processes can damage hearing.

1. Use a Welding Helmet or Welding Faceshield fitted with a proper shade of filter (see ANSI Z49.1 and AS 1674 listed in Safety Standards) to protect your face and eyes when welding or watching.
2. Wear approved safety glasses. Side shields recommended.
3. Use protective screens or barriers to protect others from flash and glare; warn others not to watch the arc.
4. Wear protective clothing made from durable, flame-resistant material (wool and leather) and foot protection.
5. Use approved ear plugs or ear muffs if noise level is high.
6. Never wear contact lenses while welding.

Recommended Protective Filters for Electric Welding

Description of Process	Approximate Range of Welding Current in Amps	Minimum Shade Number of Filter(s)
Manual Metal Arc Welding - covered electrodes (MMAW)	Less than or equal to 100	8
	100 to 200	10
	200 to 300	11
	300 to 400	12
	Greater than 400	13
Gas Metal Arc Welding (GMAW) (MIG) other than Aluminium and Stainless Steel	Less than or equal to 150	10
	150 to 250	11
	250 to 300	12
	300 to 400	13
	Greater than 400	14
Gas Metal Arc Welding (GMAW) (MIG) Aluminium and Stainless Steel	Less than or equal to 250	12
	250 to 350	13
Gas Tungsten Arc Welding (GTAW) (TIG)	Less than or equal to 100	10
	100 to 200	11
	200 to 250	12
	250 to 350	13
	Greater than 350	14
Flux-cored Arc Welding (FCAW) -with or without shielding gas.	Less than or equal to 300	11
	300 to 400	12
	400 to 500	13
	Greater than 500	14
Air - Arc Gouging	Less than or equal to 400	12
Plasma - Arc Cutting	50 to 100	10
	100 to 400	12
	400 to 800	14
Plasma - Arc Spraying	—	15
Plasma - Arc Welding	Less than or equal to 20	8
	20 to 100	10
	100 to 400	12
	400 to 800	14
Submerged - Arc Welding	—	2(5)
Resistance Welding	—	Safety Spectacles or eye shield

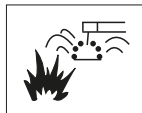
Refer to standard AS/NZS 1338.1:1992 for comprehensive information regarding the above table.

**WARNING**

FUMES AND GASES can be hazardous to your health.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

1. Keep your head out of the fumes. Do not breathe the fumes.
2. If inside, ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.
3. If ventilation is poor, use an approved air-supplied respirator.
4. Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instruction for metals, consumables, coatings, and cleaners.
5. Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Shielding gases used for welding can displace air causing injury or death. Be sure the breathing air is safe.
6. Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapours to form highly toxic and irritating gases.
7. Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and if necessary, while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.

**WARNING**

WELDING can cause fire or explosion.

Sparks and spatter fly off from the welding arc. The flying sparks and hot metal, weld spatter, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode or welding wire to metal objects can cause sparks, overheating, or fire.

1. Protect yourself and others from flying sparks and hot metal.
2. Do not weld where flying sparks can strike flammable material.

3. Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
4. Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
5. Watch for fire, and keep a fire extinguisher nearby.
6. Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
7. Do not weld on closed containers such as tanks or drums.
8. Connect work cable to the work as close to the welding area as practical to prevent welding current from travelling long, possibly unknown paths and causing electric shock and fire hazards.
9. Do not use welder to thaw frozen pipes.
10. Remove stick electrode from holder or cut off welding wire at contact tip when not in use.

**WARNING**

FLYING SPARKS AND HOT METAL can cause injury.

Chipping and grinding cause flying metal. As welds cool, they can throw off slag.

1. Wear approved face shield or safety goggles. Side shields recommended.
2. Wear proper body protection to protect skin.

**WARNING**

CYLINDERS can explode if damaged.

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

1. Protect compressed gas cylinders from excessive heat, mechanical shocks, and arcs.
2. Install and secure cylinders in an upright position by chaining them to a stationary support or equipment cylinder rack to prevent falling or tipping.
3. Keep cylinders away from any welding or other electrical circuits.

4. Never allow a welding electrode to touch any cylinder.
5. Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
6. Turn face away from valve outlet when opening cylinder valve.
7. Keep protective cap in place over valve except when cylinder is in use or connected for use.
8. Read and follow instructions on compressed gas cylinders, associated equipment, and CGA publication P-1 listed in Safety Standards.

**WARNING**

MOVING PARTS can cause injury.

Moving parts, such as fans, rotors, and belts can cut fingers and hands and catch loose clothing.

1. Keep all doors, panels, covers, and guards closed and securely in place.
2. Stop engine before installing or connecting unit.
3. Have only qualified people remove guards or covers for maintenance and troubleshooting as necessary.
4. To prevent accidental starting during servicing, disconnect negative (-) battery cable from battery.
5. Keep hands, hair, loose clothing, and tools away from moving parts.
6. Reinstall panels or guards and close doors when servicing is finished and before starting engine.

**WARNING**

This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety code Sec. 25249.5 et seq.)

NOTE

Considerations About Welding And The Effects of Low Frequency Electric and Magnetic Fields

The following is a quotation from the General Conclusions Section of the U.S. Congress, Office of Technology Assessment, Biological Effects of Power Frequency Electric & Magnetic Fields - Background Paper, OTA-BP-E-63 (Washington, DC: U.S. Government Printing Office, May 1989): "...there is now a very large volume of scientific findings based on experiments at the cellular level and from studies with animals and people which clearly establish that low frequency magnetic fields and interact with, and produce changes in, biological systems. While most of this work is of very high quality, the results are complex. Current scientific understanding does not yet allow us to interpret the evidence in a single coherent framework. Even more frustrating, it does not yet allow us to draw definite conclusions about questions of possible risk or to offer clear science-based advice on strategies to minimize or avoid potential risks."

To reduce magnetic fields in the workplace, use the following procedures.

1. Keep cables close together by twisting or taping them.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cable around the body.
4. Keep welding power source and cables as far away from body as practical.

**ABOUT PACEMAKERS:**

The above procedures are among those also normally recommended for pacemaker wearers. Consult your doctor for complete information.

1.02 Principal Safety Standards

Safety in welding and allied processes Part 1: Fire Precautions, AS 1674.1-1997 from SAI Global Limited, www.saiglobal.com.

Safety in welding and allied processes Part 2: Electrical, AS 1674.2-2007 from SAI Global Limited, www.saiglobal.com.

Filters for eye protectors - Filters for protection against radiation generated in welding and allied operations AS/NZS 1338.1:1992 from SAI Global Limited, www.saiglobal.com.

Welding Processes, Code of Practice, APRIL 2016 - Safe Work Australia. This document provides "Practical guidance on how to manage health and safety risks associated with welding". The latest version is available free of charge at:

<https://www.safeworkaustralia.gov.au/system/files/documents/1705/mcop-welding-processes-v3.pdf>

Other International Standards and Codes of Practice

Safety in Welding and Cutting, ANSI Standard Z49.1, from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

Safety and Health Standards, OSHA 29 CFR 1910, from Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances, American Welding Society Standard AWS F4.1, from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202.

Code for Safety in Welding and Cutting, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

Safe Practices for Occupation and Educational Eye and Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 1430 Broadway, New York, NY 10018.

Cutting and Welding Processes, NFPA Standard 51B, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

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SECTION 2: INTRODUCTION

2.01 How To Use This Manual

To ensure safe operation, read the entire manual, including the chapter on safety instructions and warnings.

Throughout this manual, the words WARNING, CAUTION, and NOTE may appear. Pay particular attention to the information provided under these headings. These special annotations are easily recognized as follows:

**NOTE!**

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

**WARNING**

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

**CAUTION**

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

**WARNING**

Gives information regarding possible electrical shock injury. Warnings will be enclosed in a box such as this.

**DANGER**

Means immediate hazards which, if not avoided, will result in immediate, serious personal injury or loss of life.

Additional copies of this manual may be purchased by contacting Cigweld at the address and phone number for your location listed in the inside back cover of this manual. Include the Owner's Manual number and equipment identification numbers.

2.02 Equipment Identification

The unit's identification number (specification or part number), model, and serial number usually appear on a nameplate attached to the control panel. In some cases, the nameplate may be attached to the rear panel. Equipment which does not have a control panel such as gun and cable assemblies is identified only by the specification or part number printed on the shipping container. Record these numbers on the bottom of page i for future reference.

2.03 Receipt Of Equipment

When you receive the equipment, check it against the invoice to make sure it is complete and inspect the equipment for possible damage due to shipping. If there is any damage, notify the carrier immediately to file a claim. Furnish complete information concerning damage claims or shipping errors to the location in your area listed in the inside back cover of this manual.

Include all equipment identification numbers as described above along with a full description of the parts in error.

Move the equipment to the installation site before un-crating the unit. Use care to avoid damaging the equipment when using bars, hammers, etc., to uncrate the unit.

2.04 Symbol Chart

Note that only some of these symbols will appear on your model.

	On
	Off
	Dangerous Voltage
	Increase/Decrease
	Circuit Breaker
	AC Auxiliary Power
	Fuse
A	Amperage
V	Voltage
Hz	Hertz (cycles/sec)
f	Frequency
	Negative
	Positive
	Direct Current (DC)
	Protective Earth (Ground)
	Line
	Line Connection
	Auxiliary Power
115V 15A 	Receptacle Rating- Auxiliary Power

1 ~	Single Phase
3 ~	Three Phase
	Three Phase Static Frequency Converter- Transformer-Rectifier
	Remote
X	Duty Cycle
%	Percentage
	Panel/Local
	Shielded Metal Arc Welding (SMAW)
	Gas Metal Arc Welding (GMAW)
	Gas Tungsten Arc Welding (GTAW)
	Air Carbon Arc Cutting (CAC-A)
	Constant Current
	Constant Voltage Or Constant Potential
	High Temperature
	Fault Indication
	Arc Force
	Touch Start (GTAW)
	Variable Inductance
	Voltage Input

	Wire Feed Function
	Wire Feed Towards Workpiece With Output Voltage Off.
	Welding Gun
	Purging Of Gas
	Continuous Weld Mode
	Spot Weld Mode
	Spot Time
	Preflow Time
	Postflow Time
 2 Step Trigger Operation Press to initiate wirefeed and welding, release to stop.	
 4 Step Trigger Operation Press and hold for preflow, release to start arc. Press to stop arc, and hold for preflow.	
	Burnback Time
	Disturbance In Ground System
IPM	Inches Per Minute
MPM	Metres Per Minute
	Spool Gun
AUTO SET MIG STICK TIG	Auto Settings for MIG, STICK, TIG

Art # A-04937_AD

2.05 Description

CIGWELD's Transmig 355i is a Compact 3in1 MultiProcess Inverter that offers exceptional welding results across MIG, STICK and TIG.

The Transmig 355i is loaded with advanced features to get the best out of your welding performance while also helping to make welding easy with the added convenience of CIGWELD's AUTO SET feature. The AUTO SET Process has been pre-programmed with synergic lines determined by material type, thickness and consumable diameter to ensure you are always getting the best from your welds.

2.06 User Responsibility

This equipment will perform as per the information contained herein when installed, operated, maintained and repaired in accordance with the instructions provided. This equipment must be checked periodically. Defective equipment (including welding leads) should not be used. Parts that are broken, missing, plainly worn, distorted or contaminated, should be replaced immediately. Should such repairs or replacements become necessary, it is recommended that such repairs be carried out by appropriately qualified persons approved by CIGWELD. Advice in this regard can be obtained by contacting an Accredited CIGWELD Distributor.

This equipment or any of its parts should not be altered from standard specification without prior written approval of CIGWELD. The user of this equipment shall have the sole responsibility for any malfunction which results from improper use or unauthorized modification from standard specification, faulty maintenance, damage or improper repair by anyone other than appropriately qualified persons approved by CIGWELD.

2.07 Transporting Methods



WARNING

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

FALLING EQUIPMENT can cause serious personal injury and equipment damage.

Use handcart or similar device of adequate capacity.

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

2.08 Packaged Items

Transmig 355i Compact Plant (Part No. W1003511)

- Transmig 355i Inverter Power Source
- Feedroll 0.9/1.2mm V Groove (Fitted)
- Tweco Fusion 400 Mig Torch 3.6m
- Comet Professional Argon Regulator / Flowmeter
- Work Clamp with 4m Lead
- Shielding Gas Hose Assembly
- Operation Manual

Transmig 355i Remote Plant (Part No. W1003510)

- Transmig 355i Inverter Power Source
- Feedroll 0.9/1.2mm V Groove (Fitted)
- Transmig 4RX Wirefeeder
- 8m Interconnection Lead
- Tweco Fusion 400 Mig Torch 3.6m
- Comet Professional Argon Regulator / Flowmeter
- Work Clamp with 4m Lead
- Heavy Duty Trolley with inbuilt cylinder carrier
- Shielding Gas Hose Assembly
- Operation Manual

2.09 Duty Cycle

The rated duty cycle of a Welding Power Source, is a statement of the time it may be operated at its rated welding current output without exceeding the temperature limits of the insulation of the component parts. To explain the 10 minute duty cycle period the following example is used. Suppose a Welding Power Source is designed to operate at a 60% duty cycle, 355 amperes at 31.8 volts. This means that it has been designed and built to provide the rated amperage (355A) for 6 minutes, i.e. arc welding time, out of every 10 minute period (60% of 10 minutes is 6 minutes). During the other 4 minutes of the 10 minute period the Welding Power Source must idle and allowed to cool. The thermal cut out will operate if the duty cycle is exceeded.

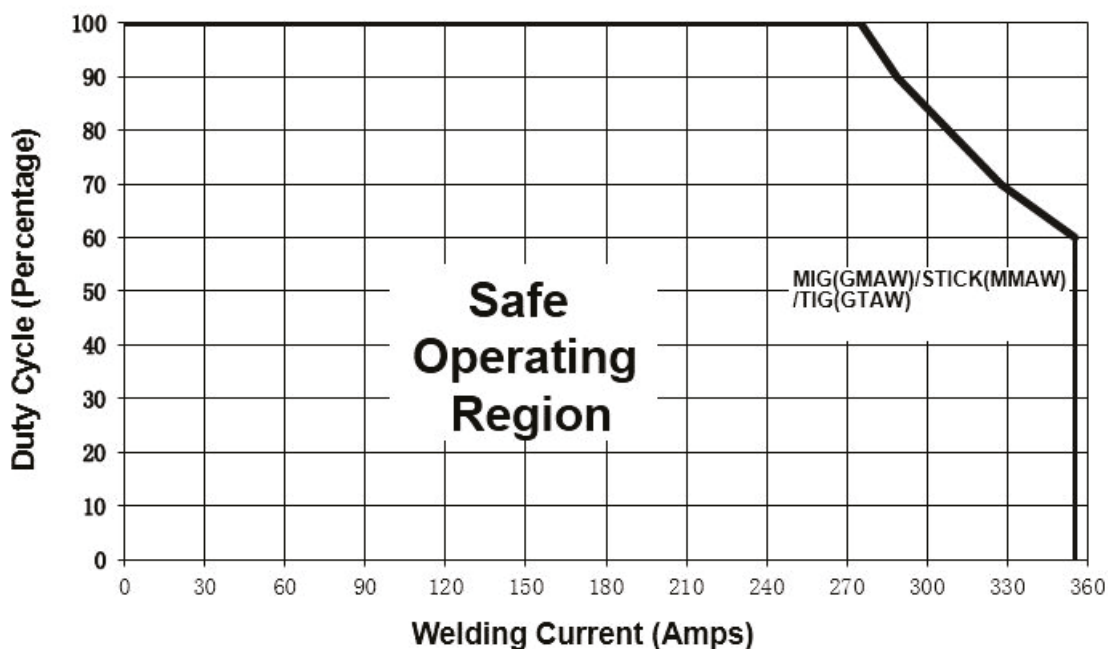


Figure 2-1: Transmig 355i Duty Cycle

2.10 Specifications

Description	TRANSMIG 355i
Transmig 355i Compact Plant Part Number	W1003511
Power Source Dimensions	H700mm x W287mm x D517mm
Power Source Weight	49kg
Cooling	Fan Cooled
Welder Type	Multi Process Inverter Power Source
Australian Standard	AS60974.1 / IEC60974-1
Number of Phases	3
Nominal Supply Voltage	415 VAC \pm 15%
Nominal Supply Frequency	50 / 60Hz
Output Terminal Type	Dinse™ Style 50
Protection Class	IP23S
Welding Environment Classification	Suitable for Welding in Category C Environments; Suitable for Indoor and Outdoor Welding
Open Circuit Voltage (VRD On)	<35V DC
Open Circuit Voltage (VRD Off)	74 V DC
Welding Current Range (MIG Mode)	30 – 355A
Welding Current Range (STICK Mode)	10 – 355A
Welding Current Range (TIG Mode)	10 – 355A
Supply Lead	4mm ²
Effective Input Current ($I_{1\text{eff}}$) [Refer Note 2]	15.5Amps
Maximum Input Current ($I_{1\text{max}}$)	20Amps
Efficiency	92%
Idle state power	30W
Minimum Three Phase Generator Recommendation [Refer Note 4]	14 kVA (at 0.8 Power Factor)
MIG (GMAW) Welding Output, 40°C, 10 min	355A @ 60%, 31.8V 275A @ 100%, 27.8V
STICK (MMAW) Welding Output, 40°C, 10 min.	355A @ 60%, 34.2V 275A @ 100%, 31V
TIG (GTAW) Welding Output, 40°C, 10 min.	355A @ 60%, 24.2V 275A @ 100%, 21V

Table 2-1: Transmig 355i Specification

**NOTE 1**

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.

**NOTE 2**

The Effective Input Current should be used for the determination of cable size & supply requirements.

**NOTE 3**

Motor start fuses or thermal circuit breakers are recommended for this application. Check local requirements for your situation in this regard.

**NOTE 4**

Minimum Generator Recommendation at the Maximum Output Duty Cycle.

Due to large variations in performance and specifications of different brands and types of generators, CIGWELD cannot guarantee full welding output power or duty cycle on every brand or type of generator.

Some small generators incorporate low cost circuit breakers on their outputs. These circuit breakers usually will have a small reset button, and will trip much faster than a switchboard type circuit breaker. This may result in not being able to achieve full output or duty cycle from the power source / generator combination. For this reason we recommend a generator that incorporates switchboard type circuit breakers.

CIGWELD recommends that when selecting a generator, that the particular power source / generator combination be adequately trialled to ensure the combination performs to the users expectations.

**NOTE 5**

CIGWELD reserves the right to change product performance and specifications without notice.

2.11 Optional Accessories

We recommend genuine CIGWELD products.

The biggest range and best quality with guaranteed performance.

Part Number	Description
OTWF412X3545	Tweco Fusion 400 MIG Torch, 3.6m, Euro
OTWX412/3545	Tweco No. 4 MIG Torch, 3.6m, Euro
OTWX415/3545	Tweco No. 4 MIG Torch, 4.5m, Euro
W3000410	Transmig 4RX Wirefeeder
W4016003	2m Interconnection Lead, 10 Pin, suits 4RX wirefeeder
W4016002	8m Interconnection Lead, 10 Pin, suits 4RX wirefeeder
W4016004	15m Interconnection Lead, 10 Pin, suits 4RX wirefeeder
W4011250	Tweco SGT 250 Spool Gun
185P958180	CIGWELD TBi Push-Pull Gun, 8m
185P9581C0	CIGWELD TBi Push-Pull Gun, 12m
185P001002	CIGWELD TBi Push-Pull Gun Neck, 40 degree
590P958000	CIGWELD TBi Synchroniser Box
W4011360	CIGWELD TBi Push-Pull Gun 8m and Sync Box
646779	Twistlock Electrode Holder Lead, 400A, 5m
W4013801	TIG Torch 17V with 4m lead (200A@20%)
W4013800	TIG Torch 17V with 4m lead and remote control (200A@20%)
W4014601	TIG Torch 26V with 4m lead (240A@20%)
W4015005	Transmig 355i Trolley with inbuilt cylinder carrier
7977729	Feed Roll 0.6/0.8mm V groove (hard)
7977703	Feed Roll 0.9/1.2mm V groove (hard) (fitted)
7977346	Feed Roll 1.2/1.6mm V groove (hard) (fitted)
7977733	Feed Roll 0.8/0.9mm U groove (soft)
7977730	Feed Roll 1.0/1.2mm U groove (soft)
7977348	Feed Roll 1.2/1.6mm U groove (soft)
7977734	Feed Roll 0.8/0.9mm V groove knurled (flux cored)
7977347	Feed Roll 1.2/1.6mm V groove knurled (flux cored)
W7004913	Shielding Gas Hose Assembly
CWPLIER	MIG Pliers
#NOTE: Exceeding TIG torch duty cycles may cause overheating and result in damage to the equipment.	

Table 2-2: Transmig 355i Optional Accessories



CAUTION

Exceeding TIG Torch Duty Cycles may cause overheating and result in damage to the equipment.

TIG Torch Consumables

Part Number	Description
BGSAK2	TIG Torch Accessories Kit
BG10N49/R	Nozzle Alumina 8mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N48/R	Nozzle Alumina 10mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N47/R	Nozzle Alumina 11mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N46/R	Nozzle Alumina 12.5mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N22/R	Collet 1.0mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N23/R	Collet 1.6mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N24/R	Collet 2.4mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N25/R	Collet 3.2mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N30/R	Collet Body 1.0mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N31/R	Collet Body 1.6mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N32/R	Collet Body 2.4mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N28/R	Collet Body 3.2mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG57Y02/R	Back Cap – Long for 17, 26 & 18 TIG Torches (pkt of 2)
BG57Y04/R	Back Cap – Short for 17, 26 & 18 TIG Torches (pkt of 2)

Table 2-3

TIG Tungsten Electrodes

Cigweld Tungsten Electrodes suitable for AC & DC TIG Welding	
Part Number	Description
699859	3T Rare Earth Tungsten Electrode 1.6mm x 175mm AC/DC Purple Band (Pkt of 2)
699860	3T Rare Earth Tungsten Electrode 2.4mm x 175mm AC/DC Purple Band (Pkt of 2)
699861	3T Rare Earth Tungsten Electrode 1.6mm x 175mm AC/DC Purple Band (Pkt of 10)
699862	3T Rare Earth Tungsten Electrode 2.4mm x 175mm AC/DC Purple Band (Pkt of 10)
699863	3T Rare Earth Tungsten Electrode 3.2mm x 175mm AC/DC Purple Band (Pkt of 10)

Table 2-4

Related Products

Part Number	Description
646768	WeldSkill TIG Welding Gloves - Medium
646754	WeldSkill TIG Welding Gloves - Large
646769	WeldSkill TIG Welding Gloves - XL
646766	WeldSkill Heavy Duty Welding Gloves - Medium
646755	WeldSkill Heavy Duty Welding Gloves - Large
646767	WeldSkill Heavy Duty Welding Gloves – XL
646771	WeldSkill Welding Jacket - Medium
646772	WeldSkill Welding Jacket - Large
646773	WeldSkill Welding Jacket - XL
646774	WeldSkill Welding Jacket - XXL
W4018001	Cigweld Heavy Duty Backpack
454337	WeldSkill Essential Auto Darkening Welding Helmet Variable Shade 9-13
454304	WeldSkill Auto Darkening Welding Helmet Fixed Shade 11 Black
454305	WeldSkill Auto Darkening Welding Helmet Variable Shade 9-13 - Blue
454314	WeldSkill Auto Darkening Welding Helmet Variable Shade 9-13 - Carbon Fibre
454321	WeldSkill Auto Darkening Welding Helmet Variable Shade 9-13 - Racer
454322	WeldSkill Auto Darkening Welding Helmet Variable Shade 9-13 - Tribal
454324	WeldSkill Auto Darkening Welding Helmet Variable Shade 9-13 - Oz Flag
454335	WeldSkill Auto Darkening Welding Helmet Variable Shade 9-13 - Flaming Skull
454336	WeldSkill Auto Darkening Welding Helmet Variable Shade 9-13 - Pink Lady
454332	ProLite Auto Darkening Welding Helmet Variable Shade 9-13 - Space
454333	ProLite Auto Darkening Welding Helmet Variable Shade 9-13 - Claw
454334	ProLite Auto Darkening Welding Helmet Variable Shade 9-13 - Shadow
454342	ProLite Auto Darkening Welding Helmet Variable Shade 9-13 - Howling Wolf
454343	ProLite Auto Darkening Welding Helmet Variable Shade 9-13 - Redback Spider
454344	ProLite Auto Darkening Welding Helmet Variable Shade 9-13 - Matrix 1.0
646764	WeldSkill Magnetic Welding Clamp/Holder - Medium
646765	WeldSkill Magnetic Welding Clamp/Holder - Large
646770	WeldSkill Welding Curtain – Dark Green, 1.74m x 1.74m
646777	WeldSkill Welding Curtain – Red, 1.74m x 1.74m
646776	Welding Curtain Frame, 1.8m x 1.8m
646778	Welding Blanket, 1.8m x 1.8m
Note: CIGWELD Electrodes see Page 7-13.	

Table 2-5

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SECTION 3: INSTALLATION

3.01 Environment

These units are designed for use in environments with increased hazard of electric shock as outlined in AS 60974.1 and AS 1674.2.

- A. Examples of environments with increased hazard of electric shock are:
1. 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;
 2. 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
 3. 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
- B. Environments with increased hazard of electric shock do not include places where electrically conductive parts in the near vicinity of the operator, which can cause increased hazard, have been insulated.

3.02 Location

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

- A. In areas, free from moisture and dust.
- B. Ambient temperature between 0° C to 40° C.
- C. In areas, free from oil, steam and corrosive gases.
- D. In areas, not subjected to abnormal vibration or shock.
- E. In areas, not exposed to direct sunlight or rain.
- F. Place at a distance of 300mm or more from walls or similar that could restrict natural air flow for cooling.
- G. The enclosure design of this power source meets the requirements of IP23S as outlined in AS60529.

This provides adequate protection against solid objects (greater than 12mm), and direct protection from vertical drops. Under no circumstances should the unit be operated or connected in a micro environment that will exceed the stated conditions. For further information please refer to AS 60529.

- H. Precautions must be taken against the power source toppling over. The power source must be located on a suitable horizontal surface in the upright position when in use.

3.03 Ventilation

Since the inhalation of welding fumes can be harmful, ensure that the welding area is effectively ventilated.

3.04 Mains Supply Voltage Requirements

The Mains supply voltage should be within $\pm 15\%$ of the rated mains supply voltage. Too low a voltage may cause poor welding performance. Too high a supply voltage will cause components to overheat and possibly fail.

The Welding Power Source must be:

- Correctly installed, if necessary, by a qualified electrician.
- Correctly earthed (electrically) in accordance with local regulations.
- Connected to the correct size power point and fuse as per the Specifications on page 2-5.



WARNING

Any electrical work must be carried out by a qualified Electrical Tradesperson.

3.05 Electromagnetic Compatibility

**WARNING**

Extra precautions for Electromagnetic Compatibility may be required when this Welding Power Source is used in a domestic situation.

A. Installation and Use - Users Responsibility

The user is responsible for installing and using the welding equipment according to the manufacturer's instructions. If electromagnetic disturbances are detected then it shall be the responsibility of the user of the welding equipment to resolve the situation with the technical assistance of the manufacturer. In some cases this remedial action may be as simple as earthing the welding circuit, see NOTE below. In other cases it could involve constructing an electromagnetic screen enclosing the Welding Power Source and the work, complete with associated input filters. In all cases, electromagnetic disturbances shall be reduced to the point where they are no longer troublesome.

**NOTE!**

The welding circuit may or may not be earthed for safety reasons. Changing the earthing arrangements should only be authorised by a person who is competent to assess whether the changes will increase the risk of injury, e.g. by allowing parallel welding current return paths which may damage the earth circuits of other equipment. Further guidance is given in IEC 60974-13 Arc Welding Equipment - Installation and use (under preparation).

B. Assessment of Area

Before installing welding equipment, the user shall make an assessment of potential electromagnetic problems in the surrounding area. The following shall be taken into account

1. Other supply cables, control cables, signalling and telephone cables; above, below and adjacent to the welding equipment.
2. Radio and television transmitters and receivers.
3. Computer and other control equipment.
4. Safety critical equipment, e.g. guarding of industrial equipment.
5. The health of people around, e.g. the use of pacemakers and hearing aids.

6. Equipment used for calibration and measurement.
7. The time of day that welding or other activities are to be carried out.
8. The immunity of other equipment in the environment: the user shall ensure that other equipment being used in the environment is compatible: this may require additional protection measures.

The size of the surrounding area to be considered will depend on the structure of the building and other activities that are taking place. The surrounding area may extend beyond the boundaries of the premises.

C. Methods of Reducing Electromagnetic Emissions

1. Mains Supply

Welding equipment should be connected to the mains supply according to the manufacturer's recommendations. If interference occurs, it may be necessary to take additional precautions such as filtering of the mains supply. Consideration should be given to shielding the supply cable of permanently installed welding equipment in metallic conduit or equivalent. Shielding should be electrically continuous throughout its length. The shielding should be connected to the Welding Power Source so that good electrical contact is maintained between the conduit and the Welding Power Source enclosure.

2. Maintenance of Welding Equipment

The welding equipment should be routinely maintained according to the manufacturer's recommendations. All access and service doors and covers should be closed and properly fastened when the welding equipment is in operation. The welding equipment should not be modified in any way except for those changes and adjustments covered in the manufacturer's instructions. In particular, the spark gaps of arc striking and stabilising devices should be adjusted and maintained according to the manufacturer's recommendations.

3. Welding Cables

The welding cables should be kept as short as possible and should be positioned close together, running at or close to the floor level.

4. Equipotential Bonding

Bonding of all metallic components in the welding installation and adjacent to it should be considered. However, Metallic components bonded to the work piece will increase the risk that the operator could receive a shock by touching the metallic components and the electrode at the same time. The operator should be insulated from all such bonded metallic components.

5. Earthing of the Workpiece

Where the workpiece is not bonded to earth for electrical safety, nor connected to earth because of its size and position, e.g. ship's hull or building steelwork, a connection bonding the workpiece to earth may reduce emissions in some, but not all instances. Care should be taken to prevent the earthing of the workpiece increasing the risk of injury to users, or damage to other electrical equipment. Where necessary, the connection of the workpiece to earth should be made by direct connection to the workpiece, but in some countries where direct connection is not permitted, the bonding should be achieved by suitable capacitance, selected according to national regulations.

6. Screening and Shielding

Selective screening and shielding of other cables and equipment in the surrounding area may alleviate problems of interference. Screening the entire welding installation may be considered for special applications.

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SECTION 4: OPERATION

4.01 Overview

Conventional operating procedures apply when using the Welding Power Source, i.e. connect work lead directly to workpiece and the electrode wire is fed via the MIG Torch (Consult the electrode wire manufacturers information for the correct polarity). 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 electrode wire, welding current at any one setting would vary according to the type of electrode wire in use. The operator should use the welding current range values as a guide, then finally adjust the current setting to suit the application.

4.02 Transmig 355i Power Source Controls, Indicators and Features

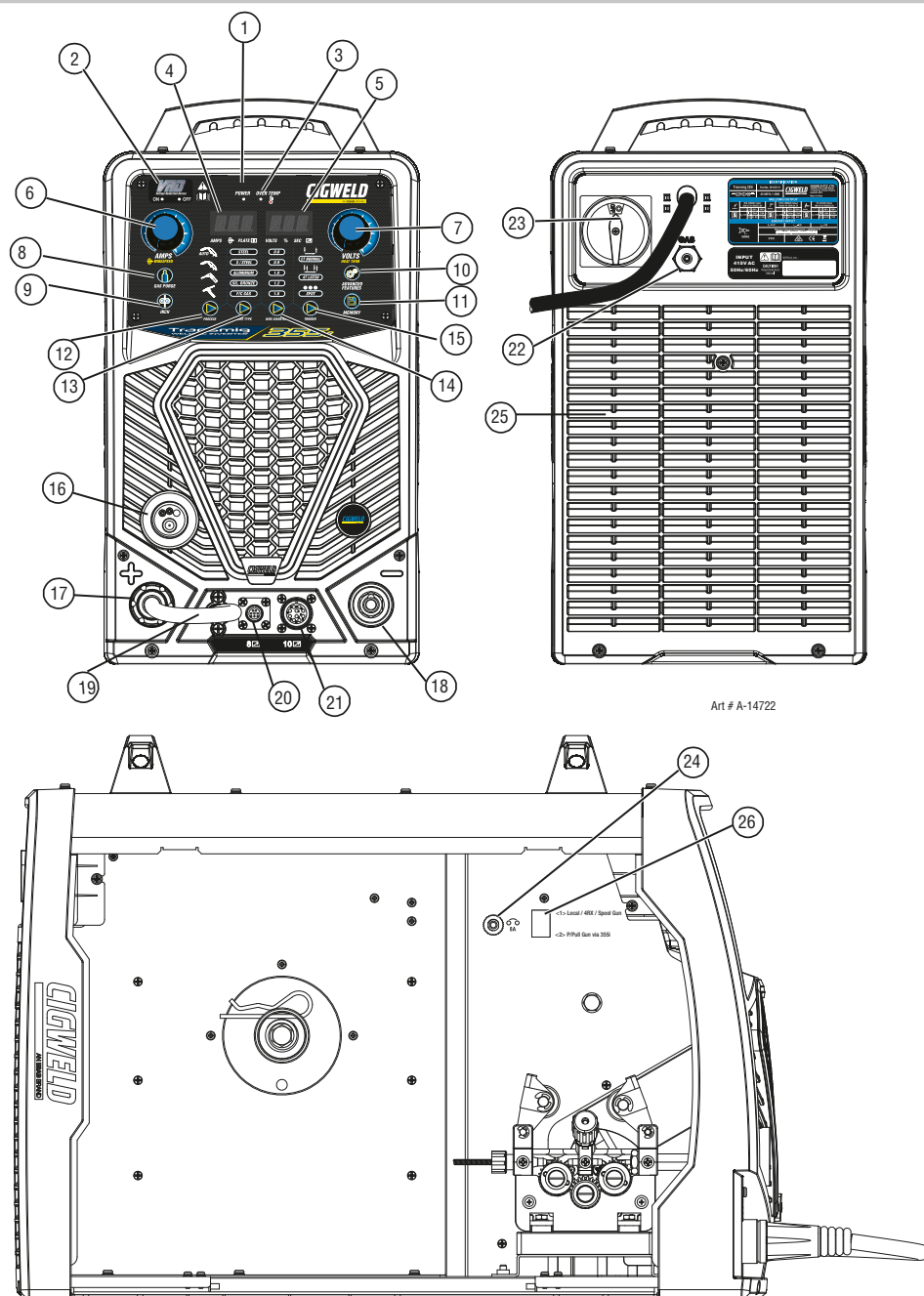


Figure 4-1: Transmig 355i Controls, Indicators and Features

1. Power Indicator

The power indicator is illuminated when the correct mains power is applied to the power source and when the ON/OFF switch located on the rear panel is in the ON position.

2. VRD Indicator ON/OFF Lights

A VRD (voltage reduction device) is a hazard reducing device designed to reduce electric shock hazards present on the output of welding power source when operating in MMAW (stick) mode. Note that the presence of VRD should not be used as a substitute for the use of appropriate safety practices as indicated in section one of this manual.

Both the green and red indicator lights only operate in MMAW (stick) mode.

The green VRD ON light illuminates (red light is off) when the VRD is active. Under this condition the open circuit voltage of the unit is limited to below 35V DC, thus reducing the potential of serious electric shock (such as when changing electrodes).

The red VRD OFF light illuminates (green light is off) when the VRD is inactive. Under this condition the output voltage of the unit will be at welding potential which in some cases may exceed 35V DC.

3. Over Temperature Indicator

This welding power source is protected by a self resetting thermostat. The Over Temp indicator will illuminate if the duty cycle of the power source has been exceeded. Should the Over Temp indicator illuminate the output of the power source will be disabled. Once the power source cools down this Over Temp indicator will go OFF and the over temperature condition will automatically reset. Note that the mains power switch should remain in the On position such that the fan continues to operate thus allowing the unit to cool sufficiently.

4. Digital Amps Meter (Left Digital Display)

MIG Mode

This digital meter is used to display the pre-set (preview) Wirefeed Speed in Meters Per Minute (MPM) in MIG mode and actual welding amperage of the power source when welding. At times of non-welding, the digital meter will display a pre-set (preview) value of Wirefeed Speed. This value can be adjusted by varying the Amperage Control Knob (6). In Auto MIG mode, the digital meter will also display the plate thickness, and the wirefeed speed and plate thickness can be alternatively displayed by pressing the Amperage Control Knob (6).

STICK and LIFT TIG Modes

The digital meter is used to display the pre-set (preview) amperage in STICK / LIFT TIG modes and actual welding amperage of the power source when welding. At times of non-welding, the amperage meter will display a pre-set (preview) value in both STICK and LIFT TIG modes. This value can be adjusted by varying the Amperage Control Knob (6).

When welding, this digital meter will display actual welding amperage in all modes.

At the completion of welding, the digital meter will hold the last recorded amperage value for a period of approximately 10 seconds in all modes. The amperage meter will hold the value until; (1) any of the front panel controls are adjusted in which case the unit will revert to preview mode, (2) welding is recommenced, in which case actual welding amperage will be displayed, or (3) a period of 10 seconds lapses following the completion of welding in which case the unit will return to preview mode.

In advanced operation, this display is also used to show the ADVANCED FEATURE, which will be explained in Section 4.03.



NOTE!

The preview functionality provided on this power source is intended to act as a guide only. Some differences may be observed between preview values and actual welding values due to factors including the mode of welding, differences in consumables/gas mixtures, individual welding techniques and the transfer mode of the welding arc (ie dip versus spray transfer). Where exact settings are required (in the case of procedural work), it is recommended that alternate measurement methods be utilised to ensure output values are accurate.

5. Digital Voltage Meter (Right Digital Display)

MIG Mode

This digital meter is used to display the pre-set (preview) Voltage in MIG mode and actual welding voltage of the power source when welding. At times of non-welding, the digital meter will display a pre-set (preview) value of Voltage. This value can be adjusted by varying the Volt Control Knob (7). In Auto MIG mode, the digital meter will also display the HEAT Value, and the pre-set voltage and heat value can be alternatively displayed by pressing the Volt Control Knob (7).

STICK and LIFT TIG Modes

This digital meter is used to display the Welding Output Terminal Voltage in STICK / LIFT TIG modes during non-welding or welding. This value cannot be adjusted by varying the Volt Control Knob (7).

When welding, this digital meter will display actual welding voltage in all modes.

At the completion of welding, the digital meter will hold the last recorded voltage value for a period of approximately 10 seconds in all modes. The voltage meter will hold the value until; (1) any of the front panel controls are adjusted in which case the unit will revert to preview mode, (2) welding is recommenced, in which case actual welding amperage will be displayed, or (3) a period of 10 seconds lapses following the completion of welding in which case the unit will return to preview mode.

In advanced operation, this display is also used to show the ADVANCED FEATURET VALUE, which will be explained in Section 4.03.



NOTE!

The preview functionality provided on this power source is intended to act as a guide only. Some differences may be observed between preview values and actual welding values due to factors including the mode of welding, differences in consumables/gas mixtures, individual welding techniques and the transfer mode of the welding arc (ie dip versus spray transfer). Where exact settings are required (in the case of procedural work), it is recommended that alternate measurement methods be utilised to ensure output values are accurate.

6. Amperage Control (Wirespeed)

The amperage control knob adjusts the amount of welding current delivered by the power source. In MMAW (stick) and GTAW (TIG) modes, the amperage control knob directly adjusts the power inverter to deliver the desired level of output current. In GMAW/FCAW modes (MIG), the amperage knob adjusts the speed of the wire feed motor (which in turn adjusts the output current by varying the amount of MIG wire delivered to the welding arc). The optimum wire speed required will be dependent on the type of welding application. The setup chart on the inside of the wire feed compartment door provides a brief summary of the required output settings for a basic range of MIG welding applications.



NOTE!

In Auto MIG mode adjusting the Wire Feed Speed Control may also Synergically adjust the voltage value.

Pressing this knob in Auto MIG selects Wirefeed speed or Plate (Material) Thickness.

Also when in Advanced Features mode pressing this knob allows the user to step through Advanced Features functions, which will be explained in section 4.03.



NOTE!

The preview functionality provided on this power source is intended to act as a guide only. Some differences may be observed between preview values and actual welding values due to factors including the mode of welding, differences in consumables/gas mixtures, individual welding techniques and the transfer mode of the welding arc (ie dip versus spray transfer). Where exact settings are required (in the case of procedural work), it is recommended that alternate measurement methods be utilised to ensure output values are accurate.

7. Voltage Control

In MIG (GMAW/FCAW) mode only, the voltage control knob is used to adjust the output voltage of the unit. The welding voltage is increased by turning the knob clockwise or decreased by turning the knob anti-clockwise. The optimum voltage level required will be dependent on the type of welding application.

In Manual MIG Mode, the setup chart on the inside of the wire feed compartment door provides a brief summary of the required output settings for a basic range of MIG welding applications.

**NOTE!**

In Auto MIG mode adjusting the Wire Feed Speed Control may also Synergically adjust the voltage value.

In Auto MIG mode pressing the Volts Control Knob will select Heat Control function which by turning the Voltage Control knob clockwise increases the voltage by 0.1V increments and the maximum value is +5V.

Adjusting the Voltage Control knob anti-clockwise decreases the voltage by 0.1V increments, the minimum value will be limited by the minimum output voltage, normally -5V.

Turning the voltage control knob will adjust the heat setting off the Auto MIG synergic line (which is set at 0 on the Heat Control).

8. Gas Purge Button

The Gas Purge button is active in GMAW/FCAW (MIG) mode only.

This will purge the Shielding Gas (MIG) through the MIG Gun when pressed.

When button is pressed and released it will purge the shielding gas for 20 seconds. If during that time the gas purge is required to be stopped press the button again to stop it.

9. Inch Button

The INCH button is active in GMAW/FCAW mode (MIG) only.

Press and hold the INCH button to Inch the MIG welding wire through the MIG Gun.

10. Advanced Features Button

Press and release the Advanced Features button to enter or exit from the advanced programming mode. To exit, simply press and release the button again. User can scroll through Advanced Features by using AMPS Control Knob (6) and can scroll through the parameters of each Advanced Features by using VOLTS Control Knob (7).

Any changes made are saved. The advanced programming menu items are described in detail for each welding mode in Section 4.03.

11. Memory Button

Frequently used weld settings for MIG, STICK, TIG can be saved to the memory for future use.

To SAVE A MEMORY

To store welding parameters to Memory, press and hold the MEMORY button for 3 seconds. The left LED shows STR (STORE).

Then turn the Right Knob (VOLTS Control No. 7) to select a memory location 1 to 15 that can be loaded or overwritten. Confirm by pressing and holding the Right Knob (VOLTS Control No. 7) for 3 seconds to save to memory.



To RECALL A MEMORY

To recall welding parameters from the stored Memory, press and release the MEMORY button. The left LED shows MEM.

Then turn the Right Knob (VOLTS Control No. 7) to select a memory location 1 to 15 that can be recalled. Confirm by pressing and holding the Right Knob (VOLTS Control No. 7) for 3 seconds to recall the stored memory.



12. Process Selection Control - Auto MIG, Manual MIG, STICK & LIFT TIG

The process selection control is used to select the desired welding mode. Four modes are available, AUTO MIG, MANUAL MIG (GMAW / FCAW (MIG)), GTAW (Lift TIG) and MMAW (Stick) modes. Refer to sections 5.13-5.17 for FCAW/GMAW (MIG) set up details, Section 6.02 for GTAW (TIG) set-up details or Section 7.01 for MMAW (stick) set-up details.

Note that when the unit is powered off the mode selection control will automatically default to MIG mode. This is necessary so as to prevent inadvertent arcing should an electrode holder be connected to the unit and mistakenly be in contact with the work piece during power up.

13. Material Type (MIG only)

The process selection control is used to select the welding material type. Five types are available, STEEL (MILD STEEL), S/STEEL (STAINLESS STEEL), ALUMINIUM, SIL.BRONZE (SILICON BRONZE) and F/C GAS (FLUX CORED MIG SHIELDED). Refer to Section 5.13 for Auto FCAW/GMAW (MIG) setup.

14. Wire Diameter Selection

The process selection control is used to select the wire diameter on AUTO MIG mode. Five types are available, 0.8mm (MILD STEEL), 0.9mm (MILD STEEL, S/STEEL, Aluminium, SIL.BRONZE), 1.0mm (MILD STEEL, Aluminium, SIL.BRONZE), 1.2mm (MILD STEEL, S/STEEL, Aluminium, SIL.BRONZE, F/C GAS) and 1.6mm (F/C GAS). Refer to Section 5.13 for Auto FCAW/GMAW (MIG) setup.

15. Trigger Mode Control (MIG and TIG Mode only)

The trigger mode control is used to switch the functionality of the torch trigger from 2T (normal), 4T (latch mode) and Spot Welding (MIG mode).

2T Normal Mode

In this mode, the torch trigger must remain depressed for the welding output to be active. Press and hold the torch trigger to activate the power source (weld). Release the torch trigger switch to cease welding.

4T Latch Mode

This mode of welding is mainly used for long welding runs to reduce operator fatigue. In this mode the operator can press and release the torch trigger and the output will remain active. To deactivate the power source, the trigger switch must again be depressed released, thus eliminating the need for the operator to hold the torch trigger.

Note that 4T mode is required to be selected for Crater Current and Crater Voltage functions.

Note that when operating in GTAW (TIG mode), the power source will remain activated until the selected downslope time has elapsed.

SPOT WELDING (MIG mode)

Spot welding is used to weld two thin plates together at a desired location by melting the top and bottom plates together to form a nugget between them.

16. MIG Torch Adaptor (Euro Style)

The MIG torch adaptor is the connection point for the MIG welding torch. Connect the torch by pushing the torch connector into the brass torch adaptor firmly and screwing the plastic torch nut clockwise to secure in position. To remove the MIG Torch simply reverse these directions.

17. Positive Welding Output Terminal

The positive welding terminal is used to connect the welding output of the power source to the appropriate welding accessory such as the MIG torch (via the MIG torch polarity lead), electrode holder lead or work lead. Positive welding current flows from the power source via this Dinse type terminal. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



CAUTION

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

18. Negative Welding Output Terminal

The negative welding terminal is used to connect the welding output of the power source to the appropriate welding accessory such as the MIG torch (via the MIG torch polarity lead), TIG torch or work lead. Negative welding current flows to the power source via this 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

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

19. MIG Torch Polarity Lead

The polarity lead is used to connect the MIG torch to the appropriate positive or negative output terminal (allowing polarity reversal for different welding applications). In general, the polarity lead should be connected in to the positive welding terminal (+) when using steel, stainless steel or aluminium electrode wire. When using gasless wire, the polarity lead is generally connected to the negative welding terminal (-). If in doubt, consult the manufacturer of the electrode wire for the correct polarity. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

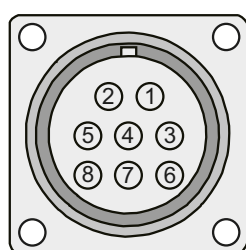


CAUTION

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

20.8 Pin Control Socket

The 8 pin Remote Control Socket is used to connect remote control devices such as Spool Gun, TIG Torch Remote Control and Push Pull Gun with Synchroniser Box to the welding power source. To make connections, align keyway, insert plug, and rotate threaded collar fully clockwise.



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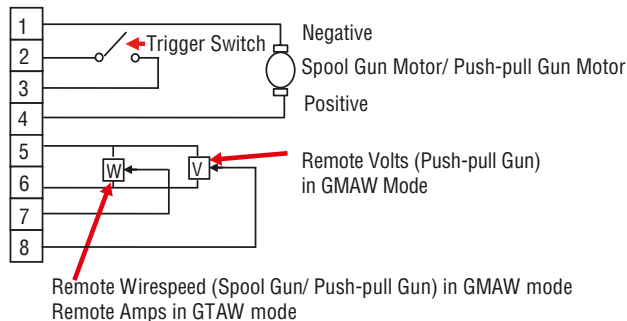


Figure 4-2: 8 Pin Control Socket

Socket Pin	Function
1	Spool gun motor negative
2	Trigger Switch Input
3	Trigger Switch Input
4	Spool gun motor positive
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 Wirespeed MIG (GMAW) mode potentiometer. Wiper arm connection to 5k ohm remote control Amps TIG (GTAW) mode potentiometer.
8	Wiper arm connection to 5k ohm remote control Volts MIG (GMAW) mode potentiometer.

Table 4-1: 8 Pin Interconnection Control Plug configuration

**NOTE!**

When using a TIG Torch with Remote Current Control via the 8 pin socket that in order to achieve full TIG current range via the torch remote control the wirefeeder 10 pin control plug must be removed from the 10 pin socket of the power source.

**NOTE!**

When using the spool gun in the 355i, the INTERNAL SWITCH in wirefeed compartment should be set to <1> position (Local, 4RX, Spool Gun).

The R/L setting in ADVANCED FEATURES should be set to 8P (8pin). See 4.03.

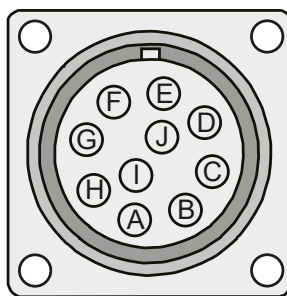
When using the push pull gun (in conjunction with Synchroniser Box) with the 355i, the INTERNAL SWITCH in wirefeed compartment should be set to <2> position (P/Pull Gun via 355i).

The R/L setting in ADVANCED FEATURES should be set to 8P (8pin). See 4.03.

21.10 Pin Control Socket

The 10 pin receptacle is used to connect a Wirefeeder remote control device to the welding Power Source circuitry:

To make connections, align keyway, insert plug, and rotate threaded collar fully clockwise. The socket information is included in the event the supplied cable is not suitable and it is necessary to wire a plug or cable to interface with the 10 pin receptacle.



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Figure 4-3: 10 Pin Control Socket

Socket Pin	Part Number / Description
A	Remote Voltage Control Potentiometer Wiper
B	Motor Negative
C	Motor Positive
D	Contactor + (Contact closure is provided between socket pins D and G to energise the contactor)
E	Remote Voltage & Wirespeed Control Potentiometers Maximum
F	Remote Wirespeed Control Potentiometer Wiper
G	Contactor Negative, Solenoid Negative
H	Remote Voltage & Wirespeed Control Potentiometers Minimum
I	Solenoid Positive
J	Not used

Table 4-2: 10 Pin Interconnection Control Plug configuration

**NOTE!**

When using the 10P (10 pin) connection, in order to get full range adjustment the 8 pin control plug must be removed from the 8 pin socket of the power source.

**NOTE!**

When connecting the 4RX Feeder, the 355i R/L setting in ADVANCED FEATURES should be set to 10P (10pin). See 4.03.

22. Gas Inlet (MIG mode only)

The Gas Inlet connection is used to supply the appropriate MIG welding gas to the unit. Refer to Section 5.13 or 5.15 for setup details.

**WARNING**

Only Inert Shielding Gases specifically designed for welding applications should be used.

23. ON/OFF Switch

This switch is used to turn the unit ON/OFF. When this switch is turned ON the LED Screen on the front panel will illuminate.

**WARNING**

When the front digital displays are lit, the machine is connected to the Mains supply voltage and the internal electrical components are at Mains voltage potential.

24. Wiredrive Motor Circuit Breaker

The 8A Circuit Breaker protects the unit from electrical faults and will operate in the event of a motor overload.

**NOTE!**

If a circuit breaker trips, a short cooling period must be allowed before an attempt is made to reset the unit by pressing the circuit breaker reset button.

25. Cooling Fan

The Transmig 355i is fitted with a fan as needed feature. Fan as needed automatically switches the cooling fan off when it is not required. This has two main advantages; (1) to minimize power consumption, and (2) to minimise the amount of contaminants such as dust that are drawn into the power source.

Note that the fan will only operate when required for cooling purposes and will automatically switch off when not required.

26. Internal Switch

The Internal Switch is used for selection of wire feeding device. When Internal Switch is in <1> Local / 4RX / Spool gun position, only a wire feeding device which is located in Transmig 355i, Transmig 4RX remote wirefeeder, or Spool Gun is active. When Internal Switch is in <2> P/Pull Gun via 355i position, both wire feeding devices in Transmig 355i and Push-Pull Gun are active.

Note that the trigger of a remote TIG torch will operate at all times irrespective of the position of the Internal Switch.

27. Anti Stick Feature (Not Shown)

This feature operates in Stick (Manual Arc) mode. The anti stick feature senses when the electrode sticks and automatically reduces the current to prevent the Stick Electrode from sticking to the work piece. This is a preset feature and is not adjustable.

4.03 Advanced Features Details

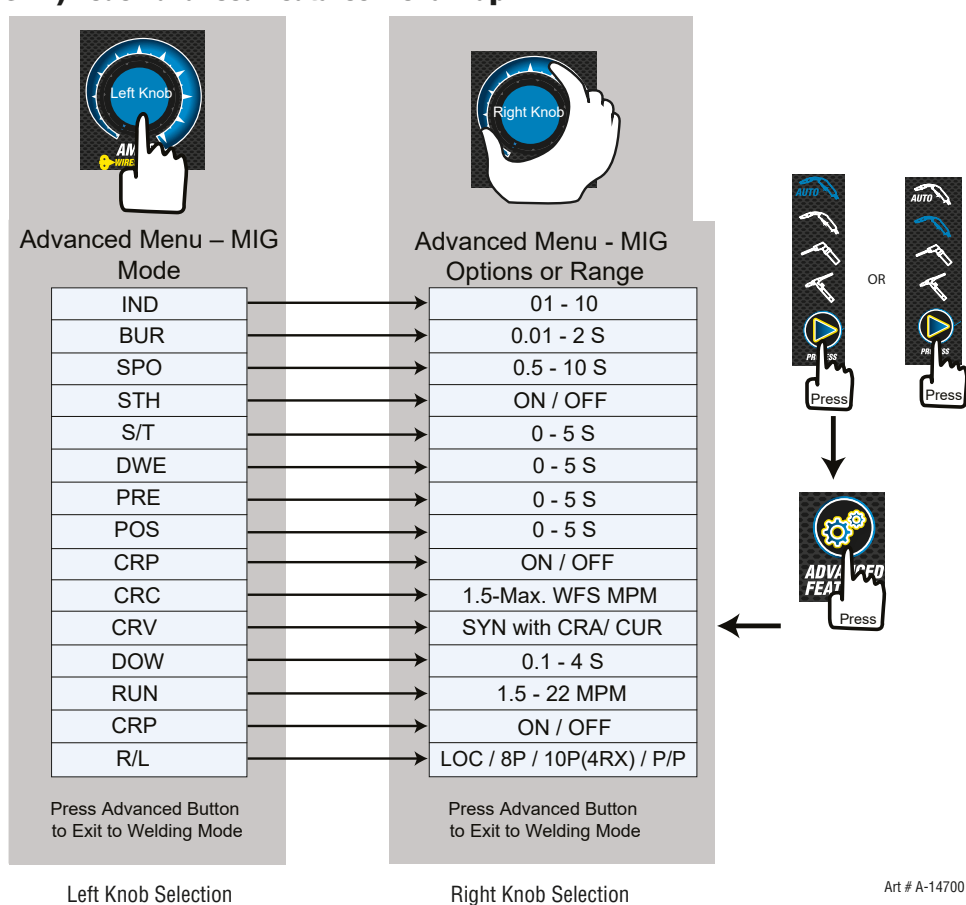
**NOTE!**

The "R/L" settings will revert to the factory default setting each time the weld process is changed. A setting other than the default will only be remembered while in that process.

If the Power Source is in Advanced Features mode and the Weld Process (Control No. 12) or other buttons are pressed, it will exit Advanced Features mode, saving any change made, and change to the next weld process function in the sequence: Auto MIG, MIG, STICK, TIG. If you wish to view the Advanced Features for the next process you will need to enter the Advanced Features function again.



If the Power Source is in Advanced Features mode and the torch trigger is pressed or welding is commenced it will exit Advanced Features mode, saving any change made.

MIG (GMAW/FCAW) Mode Advanced Features Menu Map

* SPO or STH are only active when SPOT is selected by TRIGGER button (Control No.15). S/T and DWE are only active when STH is "ON". CRP is only active when 4T is selected by TRIGGER button (Control No.15). CRC, DOW and CRV are only active when CRP is ON.

Figure 4-4: MIG Advanced Menu

Function	Left Display	Right Display (Factory Default Values)	Limits	Comments
Inductance	IND	03	01-10	Lower arc control settings make the arc softer with less weld spatter. Higher arc control settings give a stronger stiffer arc which can increase weld penetration.
Burn Back	BUN	0.05 S	0.01 – 2 S	The time difference between turning the wire feed OFF before the voltage is turned OFF.
Spot Time (Only shown/ enabled if Spot=ON)	SPO	2.0 S	0.5 – 10 S	Spot Time is the time used for the Spot weld mode.
Stitch	STH	OFF	OFF – ON	Stitch is used to weld two or more components by stitch or interval weld together. The weld time is set by the Stitch Time and the non weld time is set by the Dwell Time.
Stitch Time (Only shown/ enabled if Stitch=ON)	S/T	1.0 S	0– 5 S	Stitch Time is the time used for the weld time in Stitch weld mode.
Dwell Time (Only shown/ enabled if Stitch=ON)	DWE	1.0 S	0– 5 S	Dwell Time is the time used for the non weld time in Stitch weld mode.
Pre Flow (MIG Setting)	PRE	0.2 S	0–5 S	Shielding gas flows for the time specified before an arc is initiated.
Post Flow (MIG Setting)	POS	0.5 S	0-5 S	Shielding gas flows for the time specified after an arc has extinguished.
Crater Fill	CRF	OFF	ON - OFF	The crater fill adds slowly decreasing current at the end of a weld, this improves the end of welds.
Crater Current	CRC	3	1.5- Maximum Setting WFS	<p>This parameter operates in (4T) CRA/FIL ON and is used to set the finish current for MIG.</p> <p>The CRATER WFS remains ON until the torch trigger switch is released after it has been depressed.</p> <p>Note: The maximum crater WFS available will be limited to the set value of the weld WFS.</p>
Crater Voltage	CRV	AUTO	SYN with CRA/WFS	<p>This parameter operates in (4T) CRA/FIL ON and is used to set the finish voltage for MIG. The CRATER VOLTAGE remains ON until the torch trigger switch is released after it has been depressed.</p> <p>Note: As a Synergic feature the crater voltage will change with crater WFS and can be fine adjusted by using the heat control.</p>

Down Slope	DOW	2	0.1-4S	This parameter operates in Crater Filler ON only and is used to set the time for the weld current to ramp down, after the torch trigger switch has been pressed, to crater current. This control is used to eliminate the crater that can form at the completion of a weld.
Run In	RUN	1.5 MPM	1.5-22MPM	Wirespeed runs at the wirespeed you want until an arc is struck.
Creep Feed	CRP	ON	ON- OFF	Three seconds creep feed at minimum wire speed, if no weld power, the wire speed jumps to preview wire speed setting for 10 seconds. Once 10 seconds has expired with no weld current then the wire feed / welding power / gas solenoid is to be turned off.
Remote/Local	R/L	LOC	LOC-8P-10P-P/P	When in the local mode, the unit will not detect the remote device and will operate from the power source controls only. When in 8P or P/P Remote mode, the 8 PIN control socket is active and remote current / wirespeed controls will be active. P/P is for push/pull gun, and 8P is for spool gun. When in 10 PIN Remote mode, the 10 PIN control socket is active and remote voltage controls will be active. The 10 PIN Remote mode is available for remote wirefeeder.

**NOTE!**

The "R/L" settings will revert to the factory default setting each time the weld process is changed. A setting other than the default will only be remembered while in that process.

**NOTE!**

Inductance change influences all inductance values for plate thicknesses for that wire type. Inductance will not reset back to default once machine is turned off and on again.

LIFT TIG Mode Advanced Features Menu Map

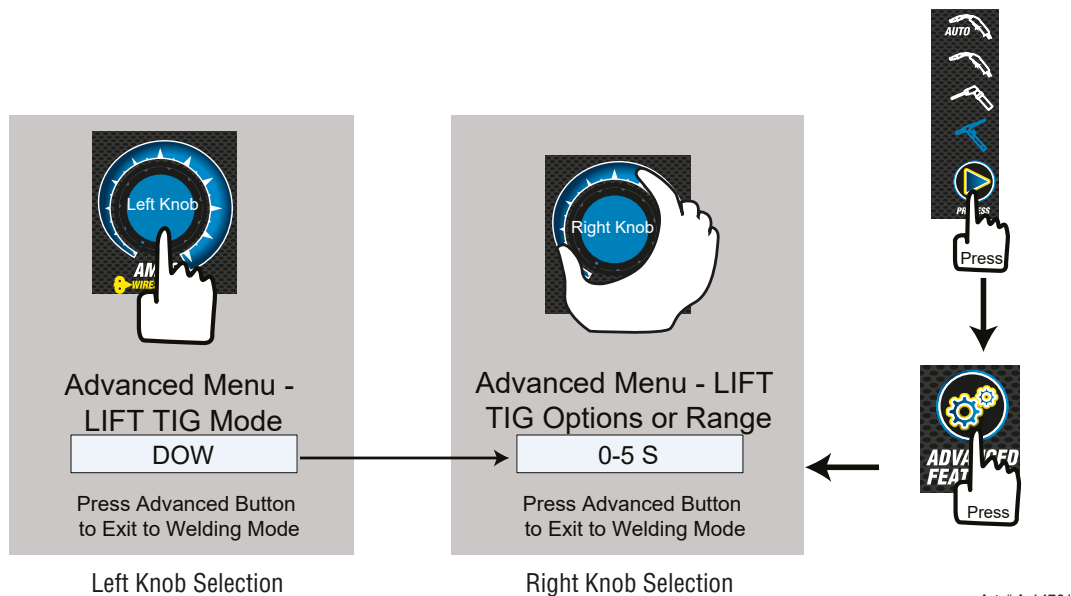


Figure 4-5: LIFT TIG Advanced Menu

Function	Left Display	"Right Display (Factory Default Values)"	Limits	Comments
Down Slope	DOW	0.0 S	0 – 5 S	<p>In "2T" (unlatched), the unit will enter down slope mode as soon as the trigger switch is released (ie if Down Slope is set to 5.0 S, the unit will ramp down from the present welding current to zero over 5 seconds).</p> <p>In "4T" (latched), to enter down slope mode the trigger switch must be held in for the selected time period (ie press and release trigger switch to commence welding, then press and hold trigger switch again to enter down slope mode). Should the trigger switch be released during the down slope time, the output will cease immediately in "4T" only.</p>

**NOTE!**

The "R/L" settings will revert to the factory default setting each time the weld process is changed. A setting other than the default will only be remembered while in that process.

STICK Mode Advanced Features

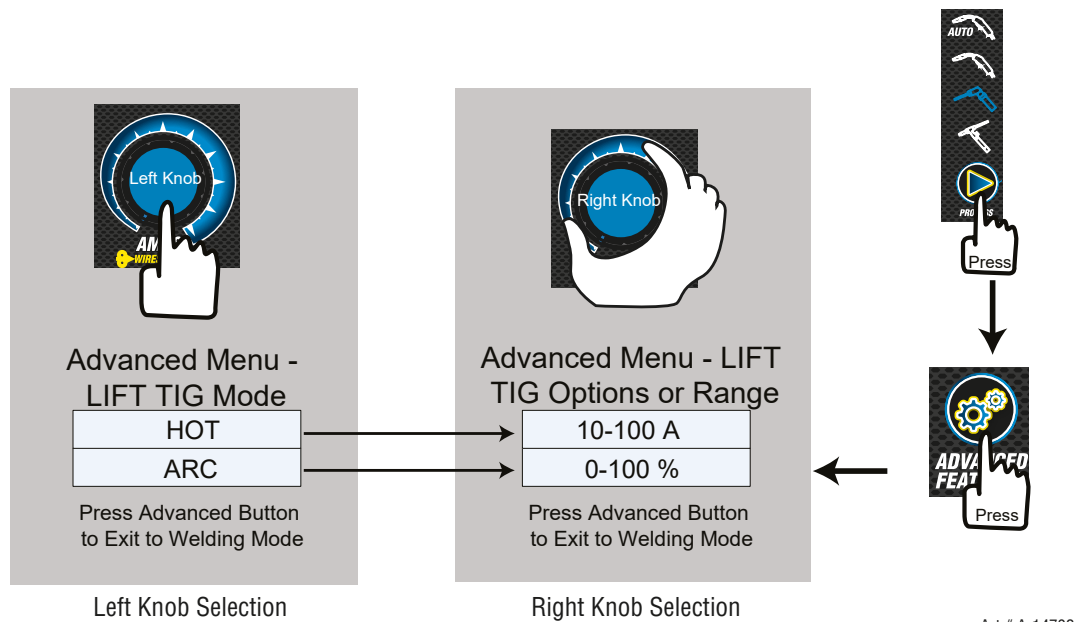


Figure 4-6: Stick Advanced Menu

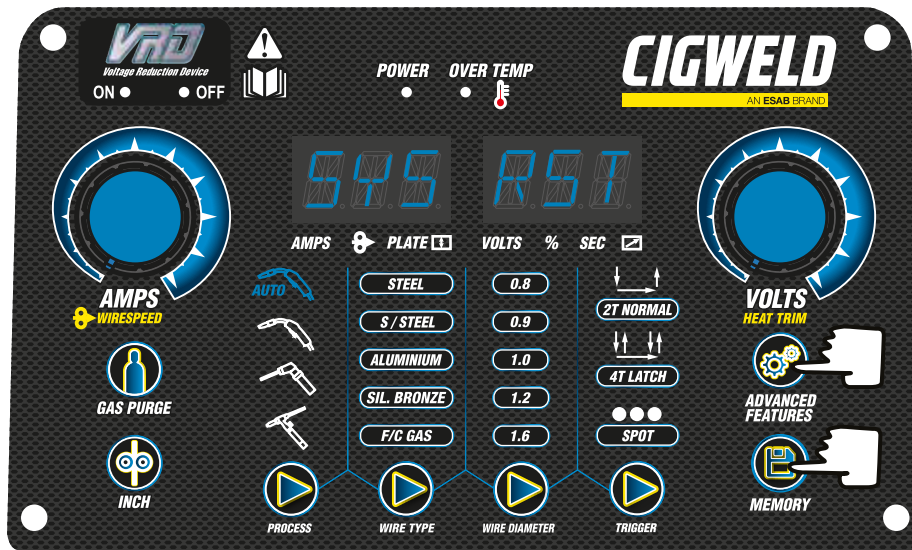
Function	Left Display	"Right Display (Factory Default Values)"	Limits	Comments
Hot Start	HOT	10 Amps	0-100 A	Hot Start is used to improve the start characteristics for stick electrode, e.g., low hydrogen electrode.
Arc Force	ARC	50	0-100 %	Arc Force control provides an adjustable amount of welding force (or "dig") control. This feature can be particularly beneficial in providing the operator the ability to compensate for variability in joint fit-up in certain situations with particular electrodes. In general increasing the arc force control toward '100%' (maximum arc force) allows greater penetration control to be achieved.

**NOTE!**

Hot Start in conjunction with Base Current setting cannot exceed a total maximum current of 355 Amps.

Restore Factory Default Settings

The Transmig 355i can have Factory Default Settings restored. This function is accessed by pressing the Advanced FEATURE and MEMORY buttons at the same time for three seconds (3s). The VOLTS and AMPS LEDs will flash 3 times displaying "SYS RST" to indicate a Factory Reset has been completed.



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Figure 4-7: Restore Factory Default Settings

SECTION 5: MIG (GMAW) WELDING

5.01 Shielding Gas Regulator/Flowmeter Operating Instructions

**WARNING**

This equipment is designed for use with welding grade (Inert) shielding gases only.

Shielding Gas Regulator/Flowmeter Safety

This regulator/flowmeter is designed to reduce and control high pressure gas from a cylinder or pipeline to the working pressure required for the equipment using it.

If the equipment is improperly used, hazardous conditions are created that may cause accidents. It is the users responsibility to prevent such conditions. Before handling or using the equipment, understand and comply at all times with the safe practices prescribed in this instruction.

SPECIFIC PROCEDURES for the use of regulators/flowmeters are listed below.

1. NEVER subject the regulator/flowmeter to inlet pressure greater than its rated inlet pressure.
2. NEVER pressurize a regulator/flowmeter that has loose or damaged parts or is in a questionable condition. NEVER loosen a connection or attempt to remove any part of a regulator/flowmeter until the gas pressure has been relieved. Under pressure, gas can dangerously propel a loose part.
3. DO NOT remove the regulator/flowmeter from a cylinder without first closing the cylinder valve and releasing gas in the regulator/flowmeter high and low pressure chambers.
4. DO NOT use the regulator/flowmeter as a control valve. When downstream equipment is not in use for extended periods of time, shut off the gas at the cylinder valve and release the gas from the equipment.
5. OPEN the cylinder valve SLOWLY. Close after use.

User Responsibilities

This equipment will perform safely and reliably only when installed, operated and maintained, and repaired in accordance with the instructions provided. Equipment must be checked periodically and repaired, replaced, or reset as necessary for continued safe and reliable performance. Defective equipment should not be used. Parts that are broken, missing, obviously worn, distorted, or contaminated should be replaced immediately.

The user of this equipment will generally have the sole responsibility for any malfunction, which results from improper use, faulty maintenance, or by repair by anyone other than an accredited repairer.

**WARNING**

Match regulator/flowmeter to cylinder. NEVER CONNECT a regulator/flowmeter designed for a particular gas or gases to a cylinder containing any other gas.

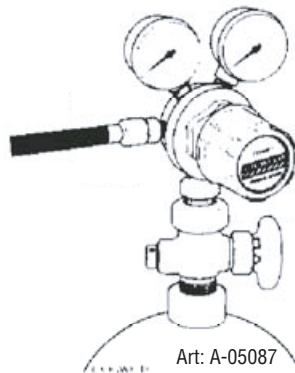


Figure 5-1: Fit Regulator/flowmeter to Cylinder

Installation

1. Remove cylinder valve plastic dust seal. Clean the cylinder valve outlet of impurities that may clog orifices and damage seats before connecting the regulator/flowmeter.

Crack the valve (open then close) momentarily, pointing the outlet away from people and sources of ignition. Wipe with a clean lint free cloth.

2. Match regulator/flowmeter to cylinder. Before connecting, check that the regulator/flowmeter label and cylinder marking agree and that the regulator/flowmeter inlet and cylinder outlet match. NEVER CONNECT a regulator/flowmeter designed for a particular gas or gases to a cylinder containing any other gas.
3. Connect the regulator/flowmeter inlet connection to cylinder or pipeline and tighten it firmly but not excessively, with a suitable spanner.
4. Connect and tighten the outlet hose firmly and attach down-stream equipment.
5. To protect sensitive down-stream equipment a separate safety device may be necessary if the regulator/flowmeter is not fitted with a pressure relief device.

Operation

With the regulator/flowmeter connected to cylinder or pipeline, and the adjustment screw/knob fully disengaged, pressurize as follows:

1. Stand to one side of regulator/flowmeter and slowly open the cylinder valve. If opened quickly, a sudden pressure surge may damage internal regulator/flowmeter parts.
2. With valves on downstream equipment closed, adjust regulator/flowmeter to approximate working pressure. It is recommended that testing for leaks at the regulator/flowmeter connection points be carried out using a suitable leak detection solution or soapy water.
3. Purge air or other unwanted welding grade shielding gas from equipment connected to the regulator/flowmeter by individually opening then closing the equipment control valves. Complete purging may take up to ten seconds or more, depending upon the length and size of the hose being purged.

Adjusting Flow Rate

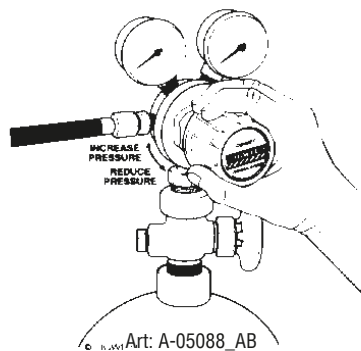


Figure 5-2: Adjust Flow Rate

With the regulator/flowmeter ready for operation, adjust working flow rate as follows:

1. Slowly turn adjusting screw/knob in (clockwise) direction until the outlet gauge indicates the required flow rate.



NOTE!

It may be necessary to re-check the shielding gas regulator/flowmeter flow rate following the first weld sequence due to back pressure present within shielding gas hose assembly.

2. To reduce flow rate, allow the welding grade shielding gas to discharge from regulator/flowmeter by opening the downstream valve. Bleed welding grade shielding gas into a well ventilated area and away from any ignition source. Turn adjusting screw counterclockwise, until the required flow rate is indicated on the gauge. Close downstream valve.

Shutdown

Close cylinder valve whenever the regulator/flowmeter is not in use. To shut down for extended periods (more than 30 minutes).

1. Close cylinder or upstream valve tightly.
2. Open downstream equipment valves to drain the lines. Bleed gas into a well ventilated area and away from any ignition source.
3. After gas is drained completely, disengage adjusting screw and close downstream equipment valves.
4. Before transporting cylinders that are not secured on a cart designed for such purposes, remove regulators/flowmeters.

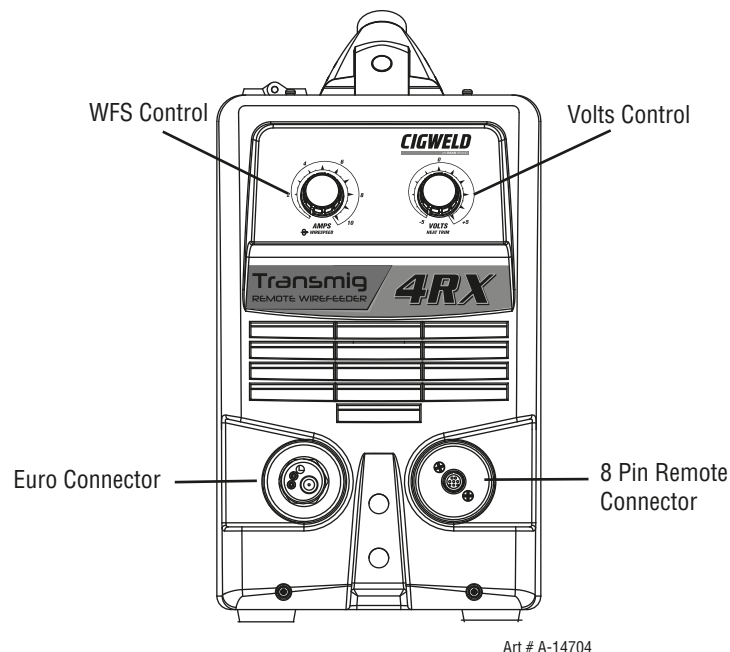
5.02 Optional Wire Feeder Controls, Indicators and Features

The optional 4RX Wirefeeder is designed to be used with the Transmig 355i. Select MIG Process and REMOTE 10P in Advanced Features to enable the controls on this wirefeeder. Set Internal Switch to <1>Local / 4RX / Spool Gun position. There are two controls on the 4RX.

1. The Left Knob controls Wirespeed in this wirefeeder. It adjusts the preview wire speed display in the power source.
2. The Right Knob controls the Volts in the power source. It adjusts the preview volts display in the power source.

In Auto MIG mode the Right Knob also controls the Heat Control Value and the value is from -5 to +5, turning the Voltage Control knob clockwise increases the voltage along the Heat Scale, and the voltage control knob will adjust the heat setting off the Auto MIG synergic line (which is set at 0 on the Heat Control).

Description	Transmig 4RX Wirefeeder
Wirefeeder Plant Part Number	W3000410
Wirefeeder Plant Dimensions	H 453mm x W 238mm x D 553mm
Wirefeeder Plant Mass	21kg
Wire Feed Motor Voltage	24 VDC
Gas Solenoid Voltage	24 VDC
Minimum Wire Speed	1.5 MPM
Maximum Wire Speed	22 MPM
Operating Temperature Range	0°C - 40°C
Interconnection Plug	10 Pin
Interconnection Length	8 metre



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Figure 5-3: 4RX Front Panel Controls

The Tweco professional MIG Torch will connect to the 4RX just as it does to the 355i power source. The electrode Polarity setting is done at the power source. See sections 5.13-5.17.

5.03 Optional Wire Feeder Setup MIG (GMAW) Welding with Gas Shielded MIG Wire

When using a Gas Shielded wire with the 4RX Wire Feeder, you need to have an external gas source attached to the 4RX.

For most Gas Shielded wire, connect the Work Lead to the negative - terminal on the front of the 355i and connect the Welding Power Cable from the back of the 4RX to the positive + terminal on the front of the 355i. Check with wire manufacturer for recommended polarity.



NOTE!

The Transmig 355i Remote Plant Part No W1003510 comes supplied with an 8m Interconnection Lead. There are three option length Interconnection Leads available for the 4RX Wirefeeder refer to Optional Accessories Table 2-2 on Page 2-7.

Connect the Interconnection cable assembly from the rear of the 4RX wirefeeder to the the front of the 355i welding power source.

Connect the MIG Torch to the front of the 4RX as you would to the front of the 355i Power Source. Refer to Section 5.06.

The R/L setting in ADVANCED FEATURES should be set to 10P (10pin) for the power source. See 4.03.

Setting for the Internal Switch located in the Power Source Wire Drive compartment is in the <1> Local / 4RX / Spool Gun position.



NOTE!

Transmig 4RX wire feeder does not automatically recall the ACTUAL programmed data set as Analogue Pot is applied. Remote pots will recall data from where ever the pot is set to within that range.

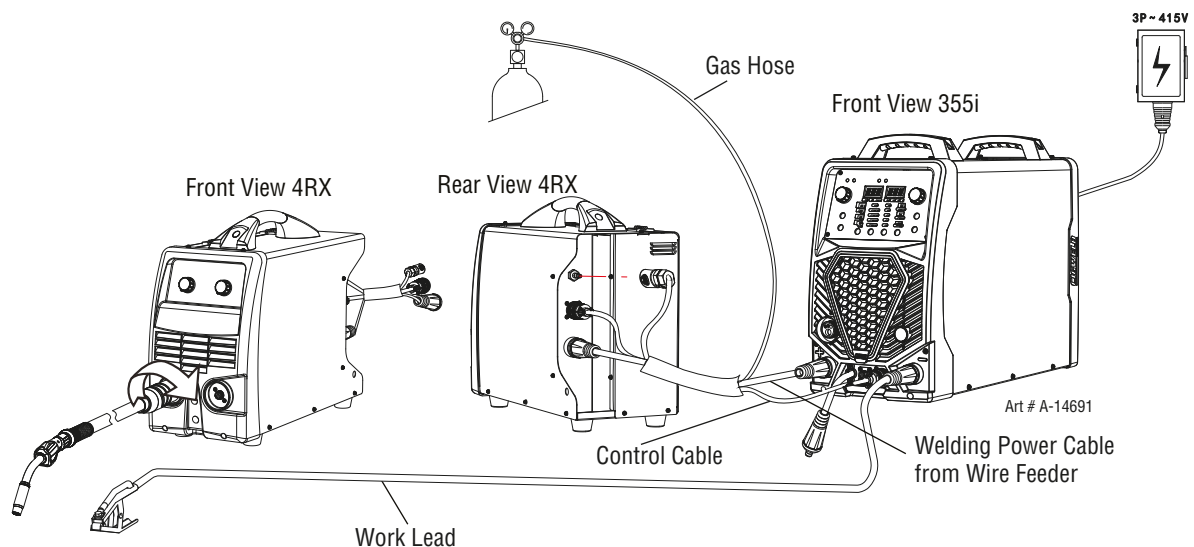


Figure 5-4: Optional 4RX Wirefeeder Setup Diagram (GMAW)

5.04 Optional Wire Feeder Setup MIG (FCAW) Welding with Gasless MIG Wire

When using a Gasless wire with the 4RX Wire Feeder, connect the Work Lead to the positive (+) terminal on the front of the 355i and connect the Welding Power Cable from the back of the 4RX to the negative (-) terminal on the front of the 355i. Check with wire manufacturer for recommended polarity.



NOTE!

The Transmig 355i Remote Plant Part No. W1003510 comes supplied with an 8m Interconnection Lead. There are three option length Interconnection Leads available for the 4RX Wirefeeder, refer to Optional Accessories Table 2-2 on Page 2-7.

The Wire Feeder is fitted with an 8M interconnection cable assembly to connect from the back of the 4RX to the front of the 355i welding power source.

Connect the MIG Torch to the front of the 4RX as you would to the front of the 355i Power Source. Refer to Section 5.06.

The R/L setting in ADVANCED FEATURES should be set to 10P (10pin) for the power source. See 4.03.

Setting the Internal Switch is in <1> Local / 4RX / Spool gun position.



NOTE!

Transmig 4RX wire feeder does not automatically recall the ACTUAL programmed data set as Analogue Pot is applied. Remote pots will recall data from where ever the pot is set to within that range.

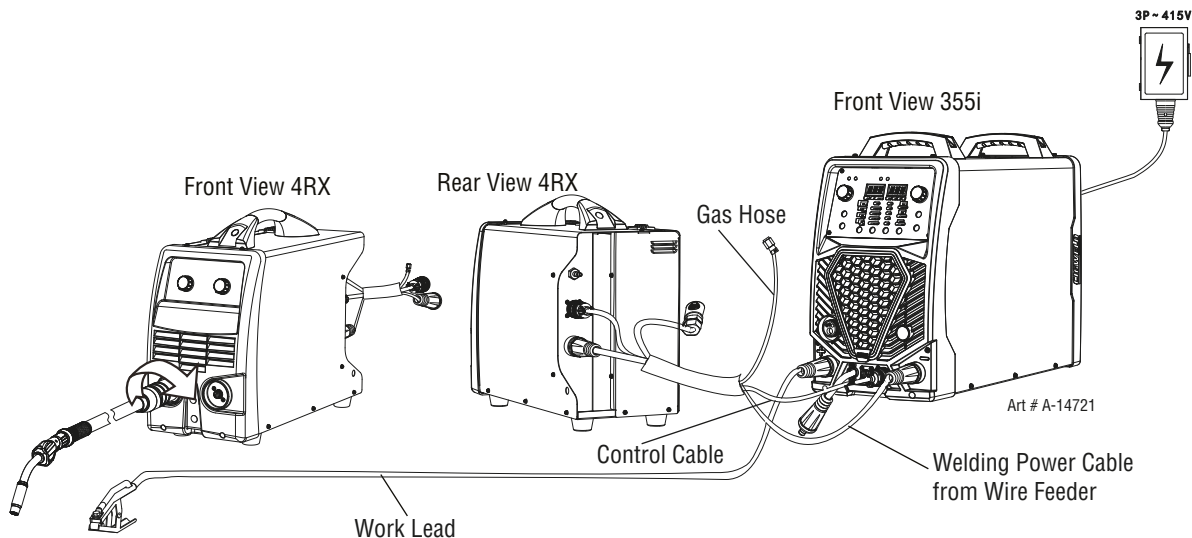


Figure 5-5: Optional 4RX Wirefeeder Setup Diagram (FCAW)

5.05 Assembly and Fitting of Optional Welding Trolley

Assemble the Welding Trolley according to Figure 5-5. Read all steps before beginning and ensure all hardware is tightened properly.

1. Refer to the Trolley Assembly Instructions included with the Trolley Kit.

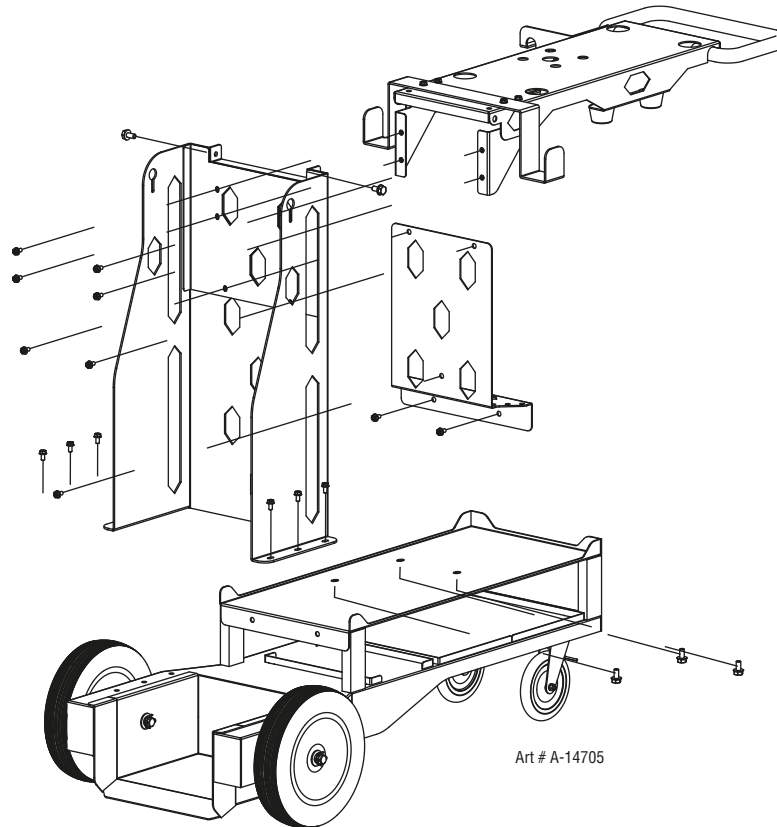


Figure 5-6: Welding Trolley Assembly

2. Mount the 355i power source to the bottom tray aligning the 3 holes in the bottom of the power source with the 3 holes in the base. Secure with the 3 screws provided.
3. Temporarily remove the top center screw in the 355i case. Attach the top tray using four screws provided ensuring the tab on the front of the tray captures the hand hold on the front of the 355i power source. Re-install the screw through the hole in the centre of the top tray into the top of the 355i case. Ensure that all fixing screws are in place and tightened.
4. Place the 4RX Wire Feeder rubber feet on the top tray hole.
5. Position a gas cylinder on the rear tray of the Trolley and lock securely to the Trolley cylinder bracket with the chain provided. If this arrangement is not used then ensure that the gas cylinder is secured to a building pillar, wall bracket or otherwise securely fixed in an upright position.
6. Attach Gas Regulator and hose per instructions found in Section 5-6.



WARNING

Secure the welding grade shielding gas cylinder in an upright position by chaining it to a suitable stationary support to prevent falling or tipping.

Warning: If Cylinder is fitted to the Trolley it must be fitted in the correct position and secured firmly in the upright position using the Chain provided to prevent it from falling or tipping.

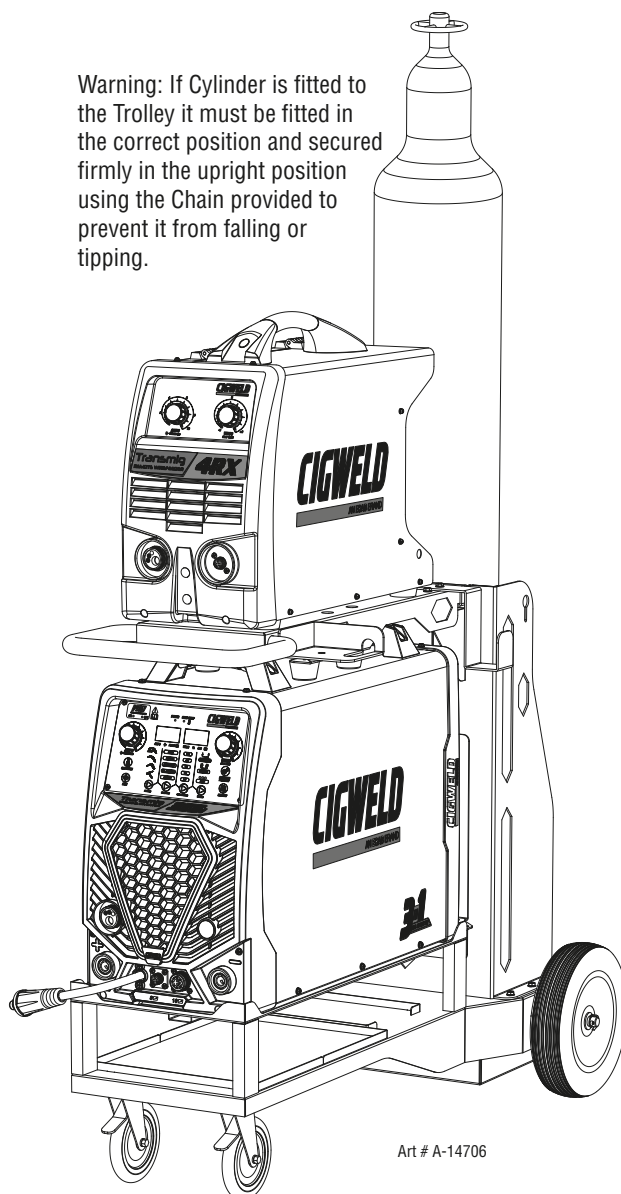


Figure 5-7: Welding Trolley and Welding Equipment

5.06 Attaching the Tweco Professional Fusion MIG Torch (Euro)

Fit the MIG Torch to the power source by pushing the MIG torch connector into the MIG torch adaptor and screwing the plastic torch nut clockwise to secure the MIG torch to the MIG torch adaptor.

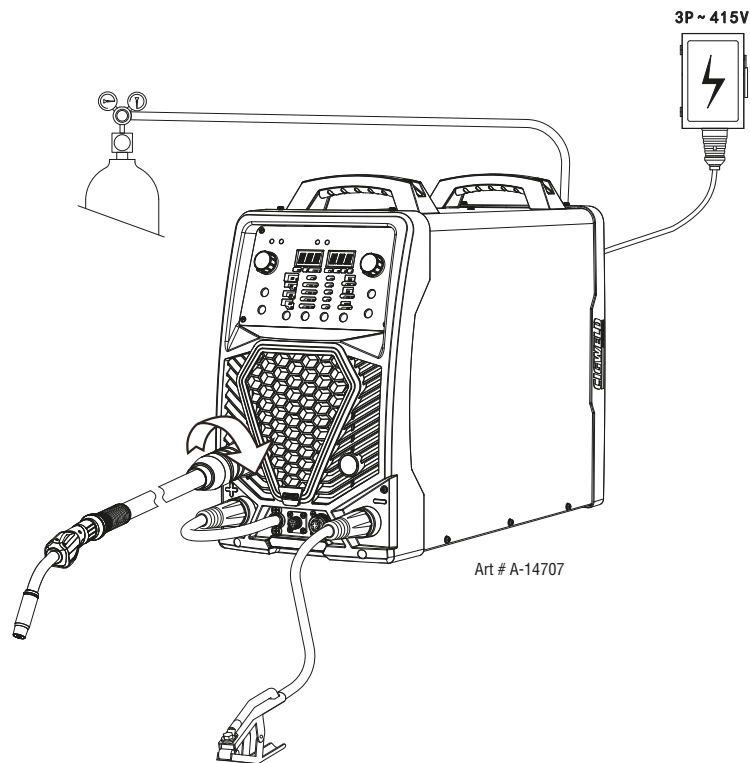


Figure 5-8: Attaching MIG Torch

5.07 Installing Spool (300mm diameter)

As delivered from the factory, the unit is fitted with a Wire Spool Hub which accepts a Spool of 300mm diameter. Remove the locking pin from the spool hub.

Install the wire spool over the spool hub, locating the hole in the spool, with the alignment pin on the spool hub. Insert the locking pin back into the spool hub.

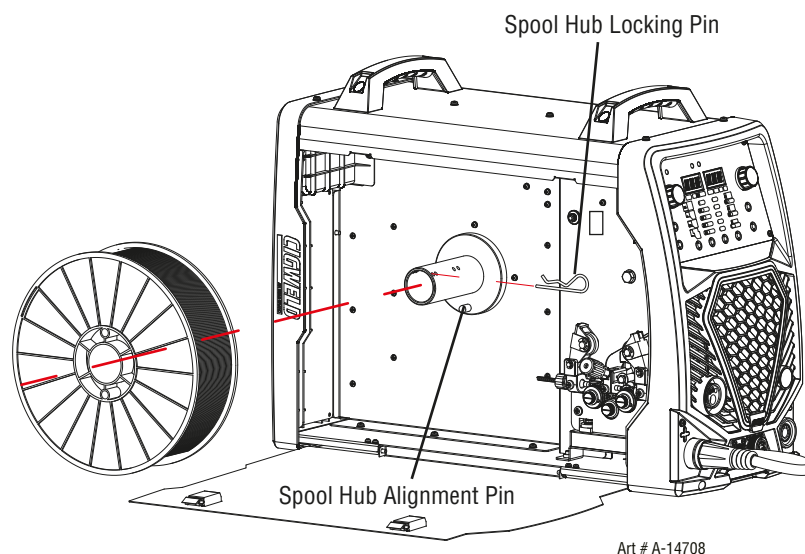


Figure 5-9: 300mm Spool Installation

5.08 Installing Handispool (200mm diameter)

Remove the locking pin from the spool hub.

Install the Handi Spool over the spool hub, locating the hole in the Handi Spool, with the alignment pin on the Spool Hub.

Insert the locking pin back into the spool hub, in the “rear” position, as shown, ensuring the wire spool is firmly secured in position.

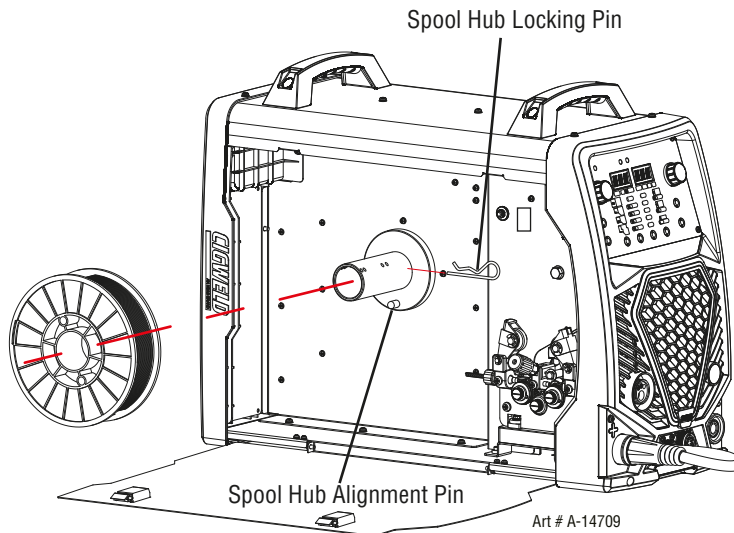
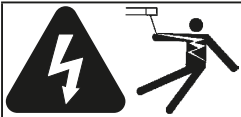


Figure 5-10: 200mm Handispool Installation

5.09 Inserting Wire into the Wire Feed Mechanism

Release the tension from the pressure roller by turning the adjustable wire drive tension screw in an anti-clockwise direction. Then to release the pressure roller arm push the tension screw toward the front of the machine which releases the pressure roller arm (Figure 5-11). With the MIG welding wire feeding from the bottom of the spool (Figure 5-12) pass the electrode wire through the inlet guide, between the rollers, through the outlet guide and into the MIG torch. Re-secure the pressure roller arm and wire drive tension screw and adjust the pressure accordingly (Figure 5-11). Remove the contact tip from the MIG torch. With the MIG Torch lead reasonably straight, feed the wire through the torch by depressing the trigger switch. Fit the appropriate contact tip.



WARNING

Before connecting the work clamp to the work make sure the mains power supply is switched off. The electrode wire will be at welding voltage potential while it is being feed through the system. Keep Mig Torch away from eyes and face.



WARNING

Moving parts, such as fans, rotors, and belts can cut fingers and hands and catch loose clothing.

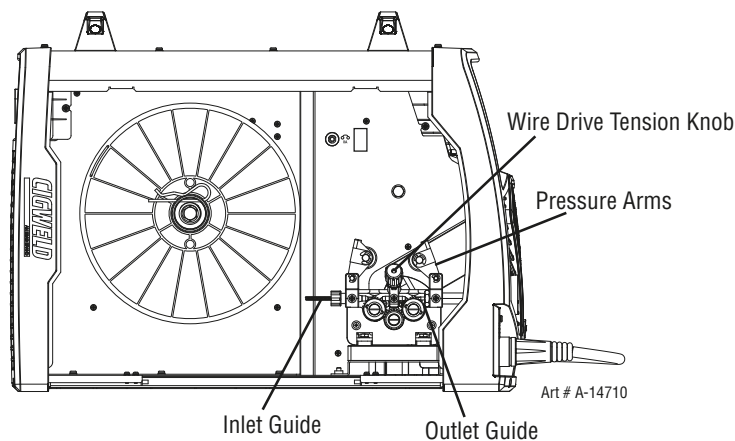


Figure 5-11: Wire Drive Assembly Components

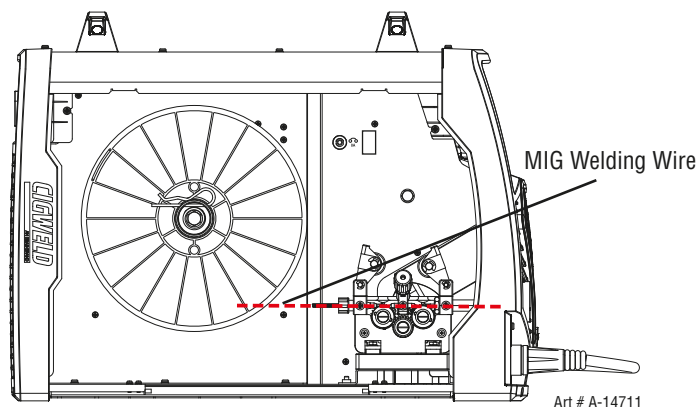


Figure 5-12: Mig Welding Wire - Installation

5.10 Feed Roller Pressure Adjustment

The pressure (top) roller applies pressure to the grooved feed roller via an adjustable pressure screw. These devices should be adjusted to a minimum pressure that will provide satisfactory WIREFEED without slippage. If slipping occurs, and inspection of the wire contact tip reveals no wear, distortion or burn back jam, the conduit liner should be checked for kinks and clogging by metal flakes and swarf. If it is not the cause of slipping, the feed roll pressure can be increased by rotating the pressure screw clockwise.

**WARNING**

Before changing the feed roller ensure that the mains supply to the power source is switched off.

**CAUTION**

The use of excessive pressure may cause rapid wear of the feed rollers, shafts and bearing.

5.11 Changing the Feed Roll

To change feed roll remove the feed roll retaining screw by turning in an anticlockwise direction. Once the feed roll is removed then to replace feed roll simply reverse these directions.

A dual groove feed roller is supplied as standard. It can accommodate 0.9/1.2mm diameter hard wires. Select the roller required with the chosen wire size marking facing outward.

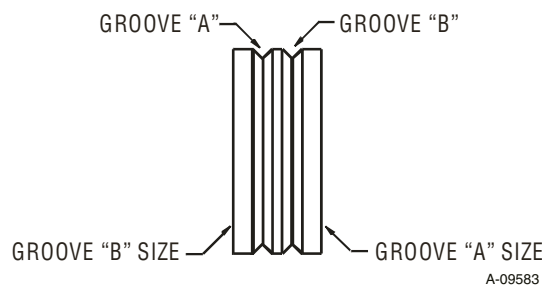


Figure 5-13: Dual Groove Feed Roller

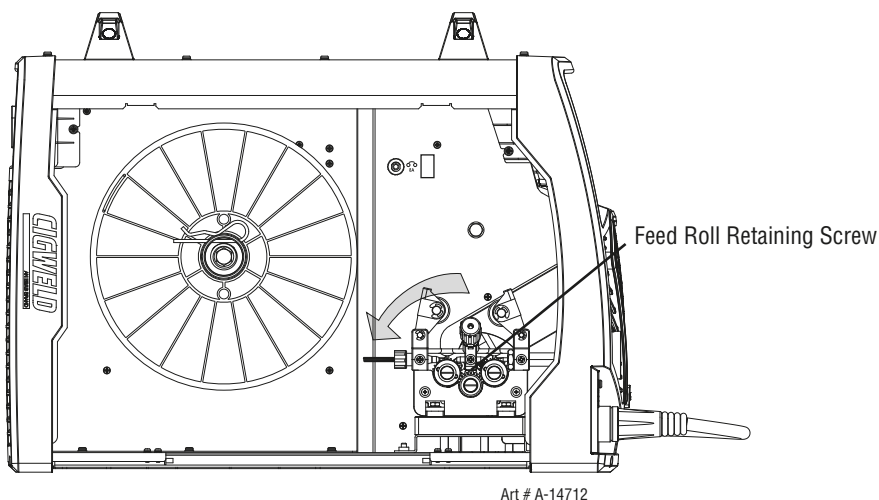


Figure 5-14: Changing the Feed Roll

5.12 Wire Reel Brake

The wire reel hub incorporates a friction brake which is adjusted during manufacture for optimum braking.

If it is considered necessary, adjustment can be made by turning the Thumb Screw inside the open end of the hub clockwise to tighten the brake. Correct adjustment will result in the wire reel circumference continuing no further than 10-20mm after release of the trigger. The electrode wire should be slack without becoming dislodged from wire spool.

**CAUTION**

Overtension of brake will cause rapid wear of mechanical WIREFEED parts, overheating of electrical componentry and possibly an increased incidence of electrode wire Burnback into contact tip.

Ensure that the alignment pin on the wire spool hub aligns with the hole allocated in the Handispool.

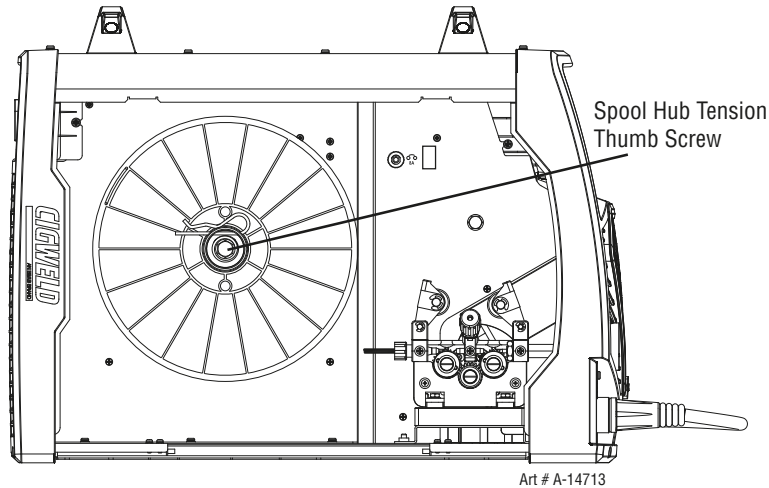


Figure 5-15: Wire Reel Brake

5.13 Setup for Auto Set (Synergic) MIG (GMAW) Welding with Gas Shielded MIG Wire

- A. Switch the Power Source ON/OFF switch located on the rear of the Power Source to the OFF position.
- B. Fit the MIG Torch to the Power Source. (Refer to Section 5.06 the Tweco Professional Fusion MIG Torch).
- C. Connect the MIG torch polarity lead to the positive welding terminal (+). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

- D. Fit the welding grade shielding gas regulator / flowmeter to the shielding gas cylinder (refer to Section 5.01) then connect the shielding gas hose from the shielding gas regulator / flowmeter outlet to the quick connect Shielding Gas Inlet fitting gas on the rear of the Transmig 355i Power Source. Ensure that the shielding gas hose connection is sufficiently tight at the regulator connection and the quick connect fitting "locks" into place correctly on the rear of the power source.



WARNING

Secure the welding grade shielding gas cylinder in an upright position by chaining it to a suitable stationary support to prevent falling or tipping.

- E. Fit the correct Feed Roll for the Gas Shielded MIG wire being used. Refer to Section 2.11 Optional Accessories for Feed Roll types and Part Numbers.
- F. Place the MIG wire spool onto the spool holder. Refer to Section 5.07 for 300mm diameter spools or 5.08 for 200mm diameter spools.
- G. Feed wire through the wire drive mechanism. Refer to Section 5.09.
- H. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the LED screen is illuminated.

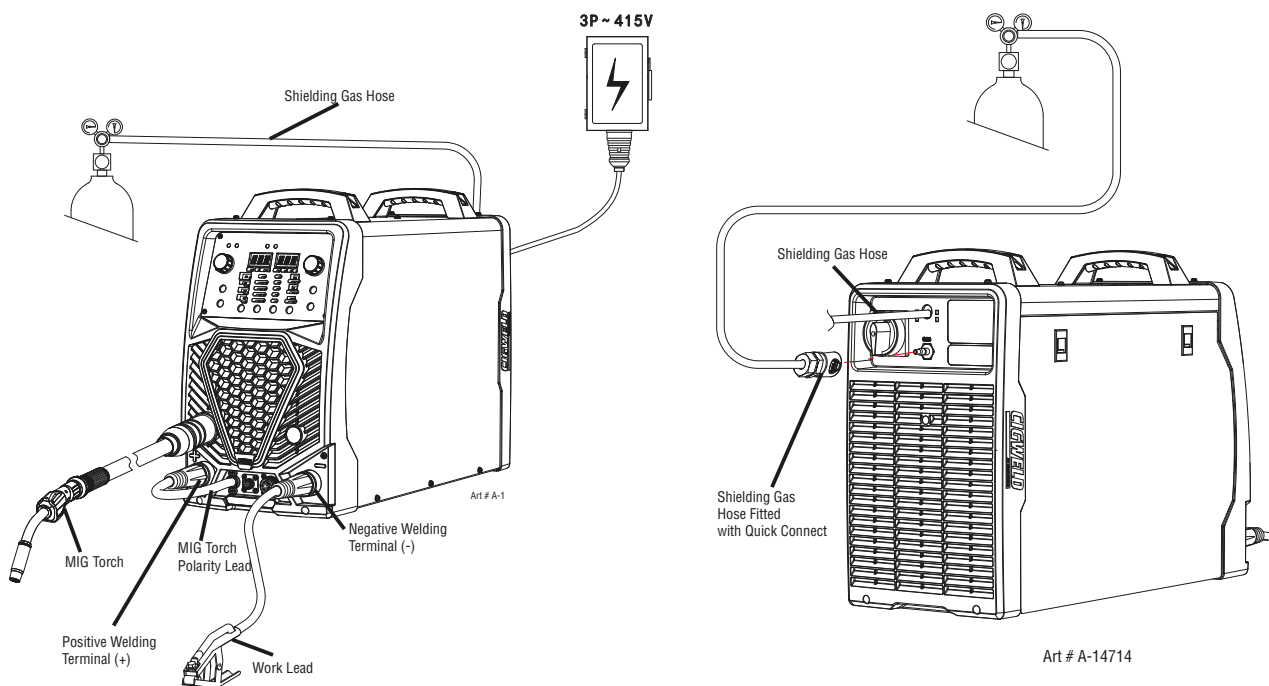


Figure 5-16: Setup for MIG (GMAW) Welding with Gas Shielded Mig Wire

I. Select MIG Auto Set mode.

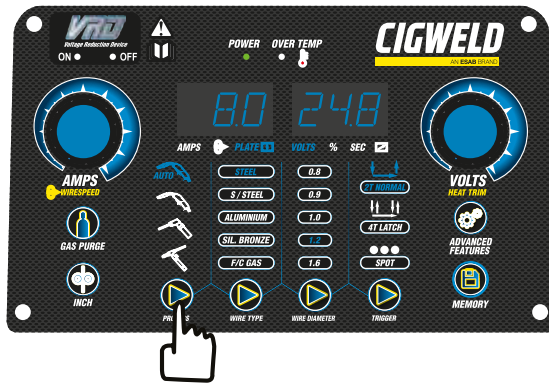


Figure 5-17: Select MIG Auto Set Mode

J. Select MIG Welding Wire Type.



Figure 5-18: Select MIG Welding Wire Type

K. Select welding wire diameter.



Figure 5-19: Welding Wire Diameter

**NOTE!**

Not all wire sizes are available in certain Wire types.

L. Select Plate (Material) Thickness.

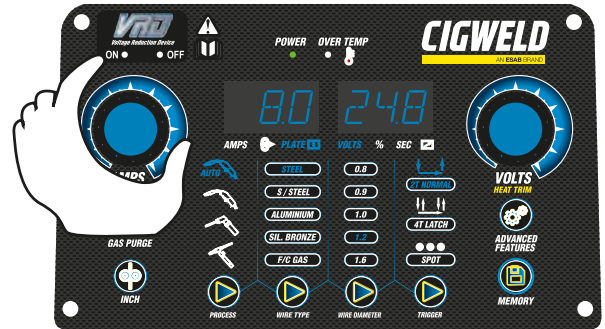


Figure 5-20: Select Plate (Material) Thickness

Press left knob to switch between the wirefeed speed and plate thickness, and then the left digital meter can display wirefeed speed and plate thickness.

Note: once an Arc is established, the left digital display will keep displaying the wirefeed speed, if you desire to display the plate thickness again, you need to press the left knob.

M. Heat Control



Figure 5-21: Heat Control

In Auto MIG mode adjusting the Wire Feed Speed Control may also Synergically adjust the voltage value.

In Auto MIG mode adjusting the voltage control knob will adjust the heat control setting for the Auto MIG synergic line.

To select the Heat Control setting press the VOLTS control knob. Turning the Volts control knob clockwise increases the Heat Control value (volts) 0 to 5V. Turning the Volts control knob anti-clockwise decreases the Heat Control value (volts) 0 to 5V.



Figure 5-22: Select to Display Heat Control Value

Press the Voltage Control Knob, and the Heat Control value or pre-set volts will be displayed in the right display in turn.

Note: when switching from pre-set volts to Heat Control value display, the Heat Control value will remain for 5s and then return to pre-set volts if there is no more adjustment; if you adjust the Heat Control value, it will keep displaying the Heat Control value.

5.14 Setup for Manual MIG (GMAW) Welding with Gas Shielded MIG Wire

- A. Fit the MIG Torch to the Power Source. (Refer to Section 5.06 the Tweco Professional Fusion MIG Torch).
- B. Connect the Mig Torch polarity lead to the positive welding terminal (+). If in doubt, consult the electrode wire manufacturer. Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- C. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the Power indicator on the Front Panel is illuminated. Set the MIG Torch trigger switch operation either 2T or 4T mode. Refer to Section 4.02.15.
- D. Select MIG mode with the process selection control (refer to Section 4.02.12 for further information).
- E. Fit the correct Feed Roll for the Gas Shielded MIG wire being used. Refer to Section 2.11 Options and Accessories for Feed Roll types and Part Numbers
- F. Place the MIG wire spool onto the spool holder. Refer to Section 5.07 for 300mm diameter spools or 5.08 for 200mm diameter spools.
- G. Feed wire through the wire drive mechanism. Refer to Section 5.09.
- H. Connect the work lead to the negative welding terminal (-). If in doubt, consult the electrode wire manufacturer. Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- I. Set Internal Switch in the wirefeeder compartment to <1> Local / 4RX / Spool Gun position. Refer to Section 4.02.26.
- J. As a guide for the welding parameter settings for the welding job refer to the Weld Guide located on the inside of the wirefeed compartment door. Power Source settings are adjusted using the front panel controls. Refer to Section 4.02.

**WARNING**

Before connecting the work clamp to the work make sure the mains power supply is switched off.

**CAUTION**

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

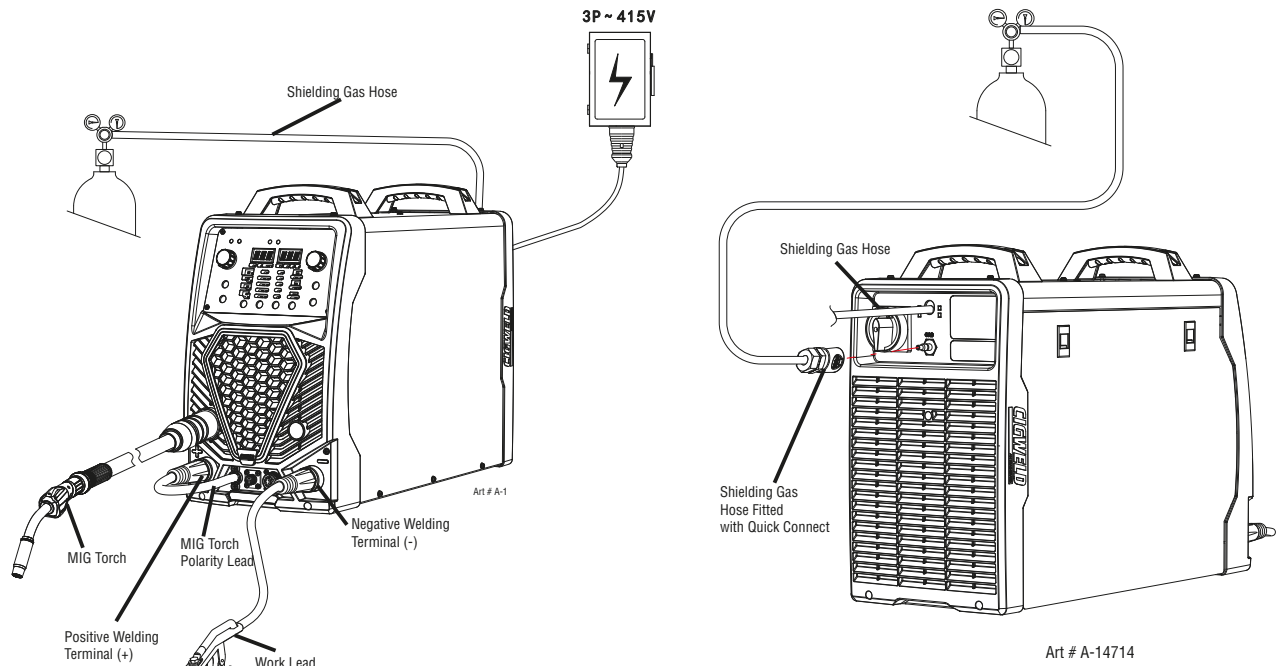


Figure 5-23: Setup for Manual MIG (GMAW) Welding with Gas Shielded MIG Wire

5.15 Setup for Manual MIG (FCAW) Welding with Gasless MIG Wire

- A. Fit the MIG Torch to the Power Source. (Refer to Section 5.06 the Tweco Professional Fusion MIG Torch).
- B. Connect the Mig Torch polarity lead to the negative welding terminal (-). If in doubt, consult the electrode wire manufacturer. Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- C. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the Power indicator on the Front Panel is illuminated. Set the MIG Torch trigger switch operation either 2T or 4T mode. Refer to Section 4.02.15.
- D. Select MIG mode with the process selection control (refer to Section 4.02.12 for further information).
- E. Fit the correct V Knurled Feed Roll for the Gasless MIG wire being used. Refer to Section 2.11 Options and Accessories for Feed Roll types and Part Numbers
- F. Place the MIG wire spool onto the spool holder. Refer to Section 5.07 for 300mm diameter spools or 5.08 for 200mm diameter spools.
- G. Feed wire through the wire drive mechanism. Refer to Section 5.09.
- H. Connect the work lead to the positive welding terminal (+). If in doubt, consult the electrode wire manufacturer. Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- I. Set Internal Switch in the wirefeeder compartment to <1> Local / 4RX / Spool Gun position. Refer to Section 4.02.26.
- J. As a guide for the welding parameter settings for the welding job refer to the Weld Guide located on the inside of the wirefeed compartment door. Power Source settings are adjusted using the front panel controls. Refer to Section 4.02.

**WARNING**

Before connecting the work clamp to the work make sure the mains power supply is switched off.

**CAUTION**

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

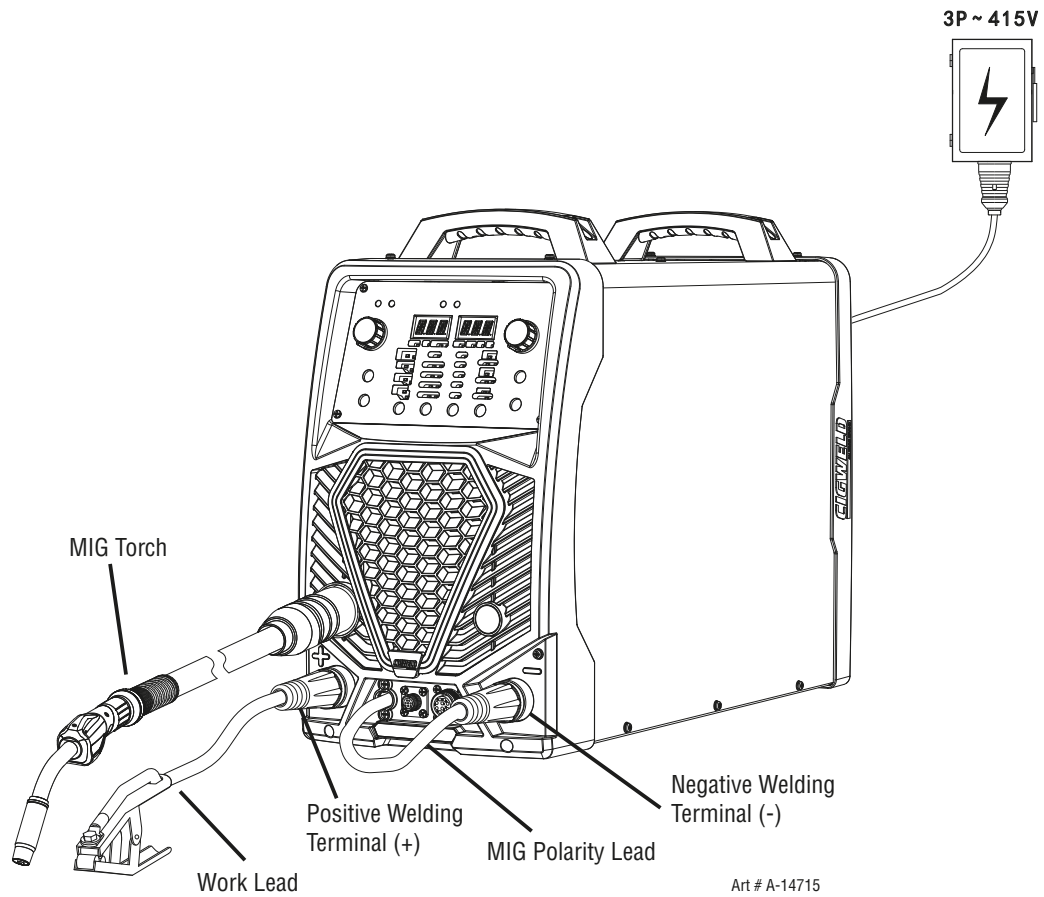


Figure 5-24: Setup for MIG (GMAW) Welding with Gasless Mig Wire

5.16 Setup for SPOOL GUN MIG (GMAW) Welding with Gas Shielded Mig Wire

- A. Select MIG mode with the process selection control (refer to Section 4.02.12 for further information).
- B. Connect the Mig torch polarity lead to the positive welding terminal (+). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via Dinse type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- C. Fit the Euro Spool Gun to the power source using the front panel EURO torch adaptor (refer also to Section 5.06 the Tweco Professional Fusion MIG Torch). Connect the 8 pin Remote Control Plug to the 8 pin Remote Control Socket on the power source.
- D. Connect the work lead to the negative welding terminal (-). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via Dinse type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- E. Fit the welding grade shielding gas regulator/flowmeter to the shielding gas cylinder (refer to Section 5.01) then connect the shielding gas hose from the shielding gas regulator/flowmeter outlet to the quick connect Shielding Gas Inlet fitting gas on the rear of the Transmig 355i Power Source. Ensure that the shielding gas hose connection is sufficiently tight at the regulator connection and the quick connect fitting "locks" into place correctly on the rear of the power source.
- F. Refer to the Weld Guide located on the inside of the wirefeed compartment door for further information.
- G. Select MIG mode with the process selection control (refer to Section 4.02.12 for further information).
- H. In MIG (GMAW/FCAW) Mode Advanced Features Menu Map, select Remote/ Local to 8 P. Refer to Section 4.03 for further information.
- I. Set Internal Switch in the wirefeeder compartment to <1> Local / 4RX / Spool Gun position. Refer to Section 4.02.26.

**WARNING**

Before connecting the work clamp to the work make sure the mains power supply is switched off.

Secure the welding grade shielding gas cylinder in an upright position by chaining it to a suitable stationary support to prevent falling or tipping.

**CAUTION**

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

**NOTE!**

Spool Gun does not automatically recall the ACTUAL programmed data set as Analogue Pot is applied. Remote pots will recall data from where ever the pot is set to within that range.

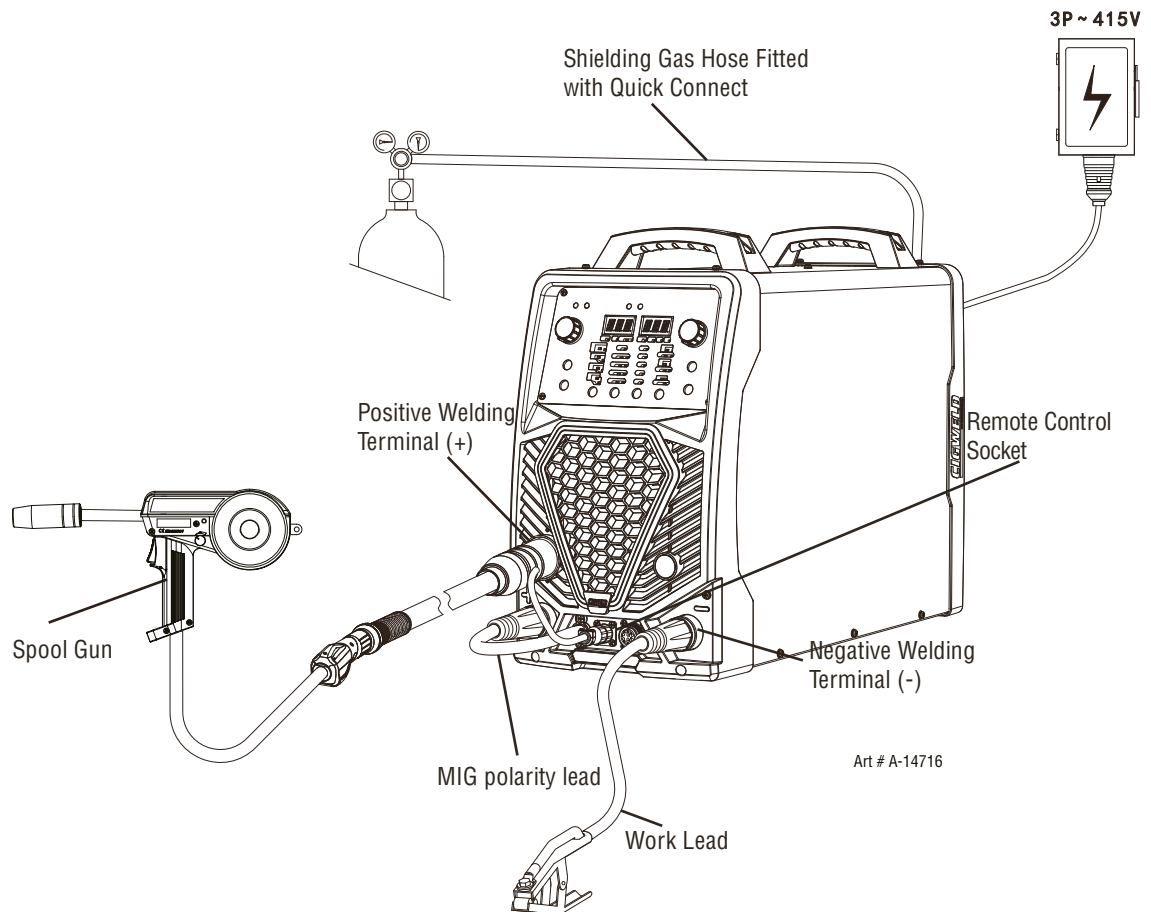
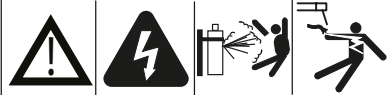


Figure 5-25: Setup for Spool Gun Welding with Gas Shielded Mig Wire

5.17 Setup for PUSH PULL GUN MIG (GMAW) Welding with Gas Shielded Mig Wire

- A. Select MIG mode with the process selection control (refer to Section 4.02.12 for further information).
- B. Connect the Mig torch polarity lead to the positive welding terminal (+). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via Dinse type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- C. Fit the Euro Push-pull Gun to the power source using the front panel EURO torch adaptor (refer also to Section 5.06 the Tweco Professional Fusion MIG Torch). Connect the push-pull gun 10 pin Remote Control Plug to the 10 pin Synergic Control Socket on Synchroniser Box. Connect the Synchroniser Box 8 pin Remote Control Plug to the 8 pin Remote Control Socket on the power source.
- D. Connect the work lead to the negative welding terminal (-). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via Dinse type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- E. Fit the welding grade shielding gas regulator/flowmeter to the shielding gas cylinder (refer to Section 5.01) then connect the shielding gas hose from the shielding gas regulator/flowmeter outlet to the quick connect Shielding Gas Inlet fitting gas on the rear of the Transmig 355i Power Source. Ensure that the shielding gas hose connection is sufficiently tight at the regulator connection and the quick connect fitting "locks" into place correctly on the rear of the power source.
- F. Refer to the Weld Guide located on the inside of the wirefeed compartment door for further information.
- G. Select MIG mode with the process selection control (refer to Section 4.02.12 for further information).
- H. In MIG (GMAW/FCAW) Mode Advanced Features Menu Map, select Remote/ Local to P/P. Refer to Section 4.03 for further information.
- I. Set the Internal Switch located in the Power Source Wire Drive compartment to <2> P/Pull Gun via 355i position. Refer to Section 4.02.26 for further information.



WARNING

Before connecting the work clamp to the work make sure the mains power supply is switched off.

Secure the welding grade shielding gas cylinder in an upright position by chaining it to a suitable stationary support to prevent falling or tipping.



CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.



CAUTION

Please keep control leads of Push-Pull Gun and Synchroniser Box away from hot torch end or door panel of Transmig 355i and Transmig 4RX remote wirefeeder.

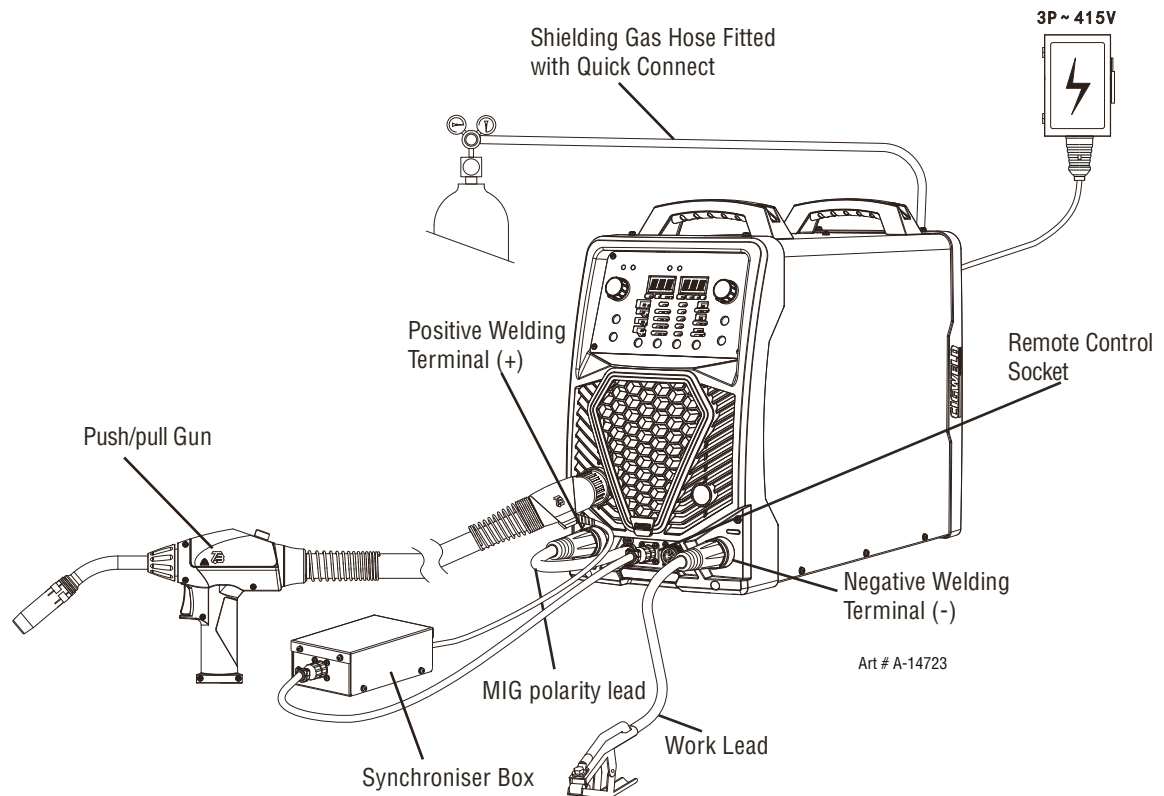


Figure 5-26: Setup for PUSH PULL GUN MIG (GMAW) Welding with Gas Shielded Mig Wire

5.18 MIG (GMAW/FCAW) Basic Welding Technique

Two different welding processes are covered in this section (GMAW and FCAW), with the intention of providing the very basic concepts in using the Mig mode of welding, where a welding gun is hand held, and the electrode (welding wire) is fed into a weld puddle, and the arc is shielded by an inert welding grade shielding gas or inert welding grade shielding gas mixture.

GAS METAL ARC WELDING (GMAW): This process, also known as MIG welding, CO Setup for PUSH PULL GUN MIG (GMAW) Welding with Gas Shielded Mig Wire₂ welding, Micro Wire Welding, short arc welding, dip transfer welding, wire welding etc., is an electric arc welding process which fuses together the parts to be welded by heating them with an arc between a solid continuous, consumable electrode and the work. Shielding is obtained from an externally supplied welding grade shielding gas or welding grade shielding gas mixture. The process is normally applied semi automatically; however the process may be operated automatically and can be machine operated. The process can be used to weld thin and fairly thick steels, and some non-ferrous metals in all positions.

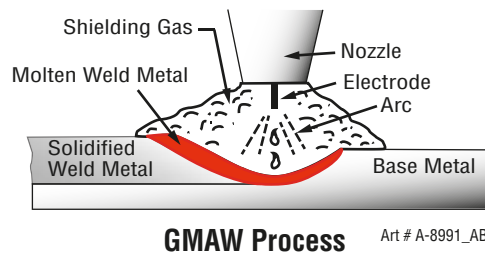


Figure 5-27

FLUX CORED ARC WELDING (FCAW): This is an electric arc welding process which fuses together the parts to be welded by heating them with an arc between a continuous flux filled electrode wire and the work. Shielding is obtained through decomposition of the flux within the tubular wire. Additional shielding may or may not be obtained from an externally supplied gas or gas mixture. The process is normally applied semi automatically; however the process may be applied automatically or by machine. It is commonly used to weld large diameter electrodes in the flat and horizontal position and small electrode diameters in all positions. The process is used to a lesser degree for welding stainless steel and for overlay work.

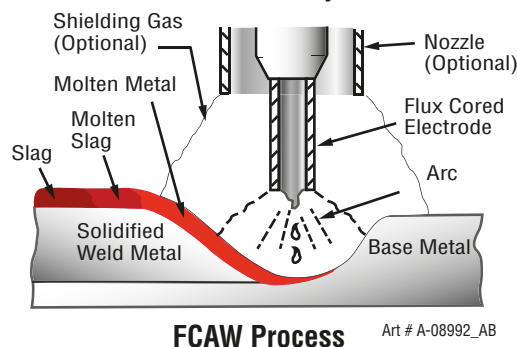


Figure 5-28

Position of MIG Torch

The angle of MIG torch to the weld has an effect on the width of the weld.

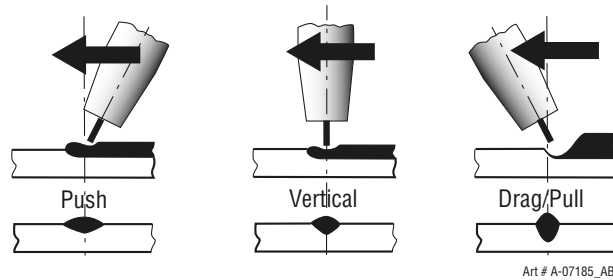


Figure 5-29

The welding gun should be held at an angle to the weld joint. (see Secondary Adjustment Variables below)

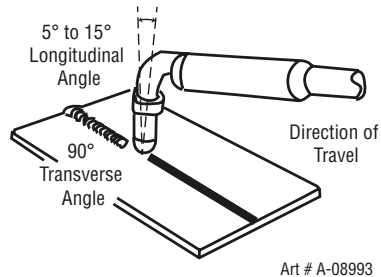
Hold the gun so that the welding seam is viewed at all times. Always wear the welding helmet with proper filter lenses and use the proper safety equipment.



CAUTION

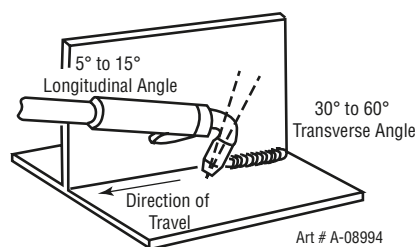
Do not pull the welding gun back when the arc is established. This will create excessive wire extension (stick-out) and make a very poor weld.

The electrode wire is not energized until the gun trigger switch is depressed. The wire may therefore be placed on the seam or joint prior to lowering the helmet.



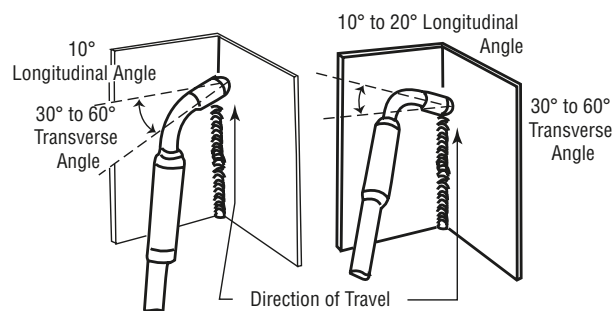
Butt & Horizontal Welds

Figure 5-30



Horizontal Fillet Weld

Figure 5-31



Vertical Fillet Welds

Figure 5-32

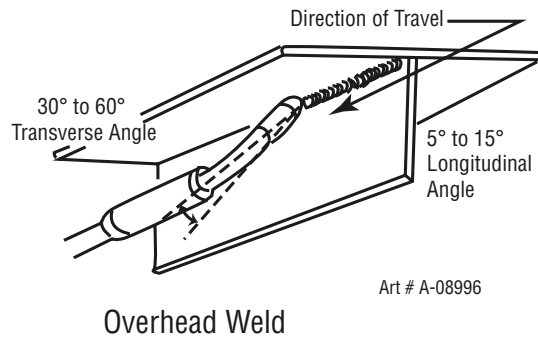


Figure 5-33

Distance from the MIG Torch Nozzle to the Work Piece

The electrode wire stick out from the MIG Torch nozzle should be between 10mm to 20.0mm. This distance may vary depending on the type of joint that is being welded.

Travel Speed

The speed at which the molten pool travels influences the width of the weld and penetration of the welding run.

MIG Welding (GMAW) Variables

Most of the welding done by all processes is on carbon steel. The items below describe the welding variables in short-arc welding of 24 gauge (0.024", 0.6mm) to 1/4" (6.4mm) mild sheet or plate. The applied techniques and end results in the GMAW process are controlled by these variables.

Preselected Variables

Preselected variables depend upon the type of material being welded, the thickness of the material, the welding position, the deposition rate and the mechanical properties. These variables are:

- Type of electrode wire
- Size of electrode wire
- Type of gas (not applicable to self shielding wires FCAW)
- Gas flow rate (not applicable to self shielding wires FCAW)

Primary Adjustable Variables

These control the process after preselected variables have been found. They control the penetration, bead width, bead height, arc stability, deposition rate and weld soundness. They are:

- Arc Voltage
- Welding current (wire feed speed)
- Travel speed

Secondary Adjustable Variables

These variables cause changes in primary adjustable variables which in turn cause the desired change in the bead formation. They are:

1. Stick-out (distance between the end of the contact tube (tip) and the end of the electrode wire). Maintain at about 10mm stick-out.
2. Wire Feed Speed. Increase in wire feed speed increases weld current, Decrease in wire feed speed decreases weld current.

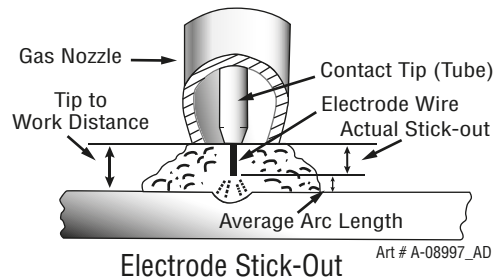


Figure 5-34

3. Nozzle Angle. This refers to the position of the welding gun in relation to the joint. The transverse angle is usually one half the included angle between plates forming the joint. The longitudinal angle is the angle between the centre line of the welding gun and a line perpendicular to the axis of the weld. The longitudinal angle is generally called the Nozzle Angle and can be either trailing (pulling) or leading (pushing). Whether the operator is left handed or right handed has to be considered to realize the effects of each angle in relation to the direction of travel.

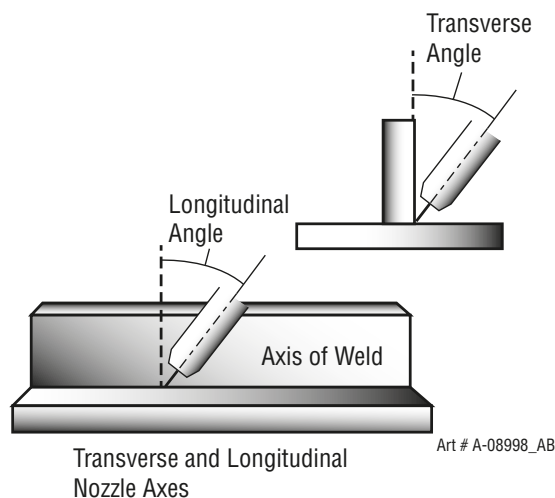


Figure 5-35

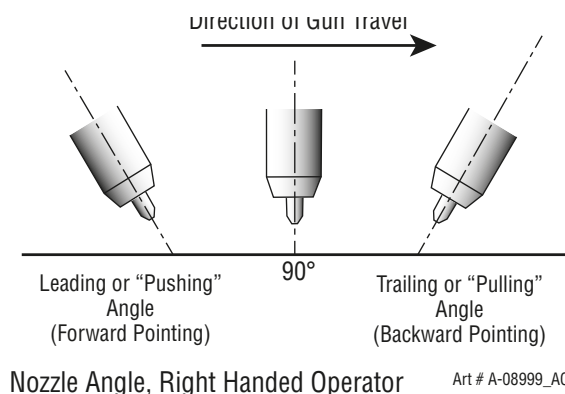


Figure 5-36

Establishing the Arc and Making Weld Beads

Before attempting to weld on a finished piece of work, it is recommended that practice welds be made on a sample metal of the same material as that of the finished piece.

The easiest welding procedure for the beginner to experiment with MIG welding is the flat position. The equipment is capable of flat, vertical and overhead positions.

For practicing MIG welding, secure some pieces of 16 or 18 gauge (0.06" 1.5mm or 0.08" 2.0mm) mild steel plate 6" x 6" (150 x 150mm). Use 0.030" (0.8mm) flux cored gasless wire or a solid wire with shielding gas.

Setting of the Power Source

Power source and Wirefeeder setting requires some practice by the operator, as the welding plant has two control settings that have to balance. These are the Wirespeed control (refer to Section 4.02.6) and the welding Voltage Control (refer to Section 4.02.7). The welding current is determined by the Wirespeed control, the current will increase with increased Wirespeed, resulting in a shorter arc. Less wire speed will reduce the current and lengthen the arc. Increasing the welding voltage hardly alters the current level, but lengthens the arc. By decreasing the voltage, a shorter arc is obtained with a little change in current level.

When changing to a different electrode wire diameter, different control settings are required. A thinner electrode wire needs more Wirespeed to achieve the same current level.

A satisfactory weld cannot be obtained if the Wirespeed and Voltage settings are not adjusted to suit the electrode wire diameter and the dimensions of the work piece.

If the Wirespeed is too high for the welding voltage, "stubbing" will occur as the wire dips into the molten pool and does not melt. Welding in these conditions normally produces a poor weld due to lack of fusion. If, however, the welding voltage is too high, large drops will form on the end of the wire, causing spatter. The correct setting of voltage and Wirespeed can be seen in the shape of the weld deposit and heard by a smooth regular arc sound. Refer to the Weld Guide located on the inside of the wirefeed compartment door for setup information.

Electrode Wire Size Selection

The choice of Electrode wire size and shielding gas used depends on the following

- Thickness of the metal to be welded
- Type of joint
- Capacity of the wire feed unit and Power Source
- The amount of penetration required
- The deposition rate required
- The bead profile desired
- The position of welding
- Cost of the wire

5.19 CIGWELD MIG Wire Selection Chart

Transmig 355i

WELDING WIRE SELECTION CHART

DESCRIPTION	DIAMETER	PACK	PART NUMBER	APPLICATION
AUTOCRAFT LW1-6	0.6mm	Spool 15kg	720103	General purpose welding wire suitable for the all positional Gas Metal Arc Welding (GMAW) of mild and low alloy steels, used in general fabrication and for welding of light to medium gauge sheet and tubular steel sections. Note that a suitable shielding gas is required.
	0.8mm	Spool 15kg	720114	
	0.9mm	Spool 15kg	720090	
	1.2mm	Spool 15kg	720096	
WELDSKILL SOLID WIRE	0.6mm	Handispool 5kg	WS5006	WeldSkill precision layer wound solid wires are copper-coated steel wires for all positional GMA (Gas Metal Arc) welding of mild and low alloy steels. They are suitable for use with Argon-Based or CO shield gases.
	0.8mm	Handispool 5kg	WS5008	
	0.9mm	Handispool 5kg	WS5009	
WELDSKILL E71T-11 GASLESS WIRE	0.8mm	Handispool 4.5kg	WG4508	WeldSkill Gasless wire is an E71T-11 formulated for both single & multi pass applications. Versatile, all positional capability, smooth ripple fillets with good edge wetting, ideal for welding thin section mild & galvanised steels. Full cover slag easily removed. Gauged galvanised and mild steels.
	0.9mm	Handispool 4.5kg	WG4509	
	1.2mm	Handispool 4.5kg	WG4512	
AUTOCRAFT 316LSI SOLID STAINLESS STEEL MIG WIRE	0.8mm	Handispool 5kg	720288	General purpose all positional stainless steel wire providing excellent results when used with correct shielding gas. Suitable for the general welding of a wide range of stainless steels (300 & 400 series).
	0.9mm	Handispool 5kg	720283	
	0.9mm	Spool 15kg	721286	
	1.2mm	Spool 15kg	721287	
AUTOCRAFT HF650	0.8mm	Handispool 5kg	720059	A copper-coated solid hardfacing wire for surfacing of steel components subject to wet or dry hard particle abrasion combined with low to moderate impact loading.
AUTOCRAFT AL5356 SOLID ALUMINIUM MIG WIRE	0.9mm	Spool 7kg	722226	Excellent general purpose Aluminium MIG wire suitable for the welding of a wide range of wrought and cast Aluminium alloys containing Magnesium. Note that a suitable shielding gas is required.
	1.0mm	Handispool 2kg	723224	
	1.0mm	Spool 7kg	722224	
	1.2mm	Spool 7kg	722227	
AUTOCRAFT SILICON BRONZE MIG WIRE	0.8mm	Handispool 5kg	720159	Used for lower strength welding of steels in automotive applications. It can also be used for welding copper-silicon alloys in hot water systems, heat exchangers and marine components.
	0.9mm	Spool 13kg	720015	
	1.2mm	Spool 13kg	720255	
VERTI-COR 3XP - H4	1.2mm	15kg	722919	Verti-Cor 3XP H4 is a seamless, rutile type Flux Cored wire designed for downhand, vertical-up and overhead fillet and butt welding applications. Low fume Excellent feedability, producing a low hydrogen level of H4. (PLW)
	1.6mm	15kg	722921	
VERTI-COR 3XP	1.2mm	15kg	720919	Verti-Cor 3XP is a micro-alloyed, user-friendly rutile type Flux Cored wire designed for downhand, vertical-up and overhead fillet and butt welding applications. Excellent feedability. (PLW)
	1.6mm	15kg	720921	
VERTI-COR 71T	1.2mm	15kg	720800	Verti-Cor 71T is a smooth running all positional flux cored wire which offers improved operator appeal and lower fume and spatter levels under welding grade Argon + 18 to 25% CO ₂ and 100% CO ₂ shielding gas. (PLW)
	1.6mm	15kg	720802	
METAL-COR XP	1.2mm	15kg	720912	METAL-COR XP - is a full iron powder cored wire recommended for a wide range of high speed fillet and butt welding applications in all downhand positions, producing a low hydrogen level of H4. (PLW)
	1.6mm	15kg	720913	

NOTE: HANDISPOOL = 200MM DIAMETER, SPOOL = 300MM DIAMETER

Table 5-1: Cigweld MIG Wire Selection Chart

5.20 MIG (GMAW/FCAW) Welding Troubleshooting

Solving Problems Beyond the Welding Terminals

The general approach to fix Gas Metal Arc Welding (GMAW) problems is to start at the wire spool then work through to the MIG torch. There are two main areas where problems occur with GMAW, Porosity and Inconsistent wire feed

Solving Problems Beyond the Welding Terminals - Porosity

When there is a gas problem the result is usually porosity within the weld metal. Porosity always stems from some contaminant within the molten weld pool which is in the process of escaping during solidification of the molten metal. Contaminants range from no gas around the welding arc to dirt on the work piece surface. Porosity can be reduced by checking the following points.

FAULT	CAUSE
1 Shielding gas cylinder contents and flow meter.	Ensure that the shielding gas cylinder is not empty and the flow meter is correctly adjusted to 15 litres per minute.
2 Gas leaks.	Check for gas leaks between the regulator/cylinder connection and in the gas hose to the Power Source.
3 Internal gas hose in the Power Source.	Ensure the hose from the solenoid valve to the torch adaptor has not fractured and that it is connected to the torch adaptor.
4 Welding in a windy environment.	Shield the weld area from the wind or increase the gas flow.
5 Welding dirty, oily, painted, oxidised or greasy plate.	Clean contaminates off the work piece.
6 Distance between the MIG torch nozzle and the work piece.	Keep the distance between the MIG torch nozzle and the work piece to a minimum. Refer to Section 5.12
7 Maintain the MIG torch in good working order.	A Ensure that the gas holes are not blocked and gas is exiting out of the torch nozzle. B Do not restrict gas flow by allowing spatter to build up inside the torch nozzle. C Check that the MIG torch O-rings are not damaged.

Table 5-2: Solving Problems beyond the Welding Terminals-Porosity



WARNING

Disengage the feed roll when testing for gas flow by ear.

Solving Problems Beyond the Welding Terminals - Inconsistent Wire Feed

Wire feeding problems can be reduced by checking the following points.

FAULT	CAUSE
1 Feed roller driven by motor in the cabinet slipped.	Wire spool brake is too tight.
2 Wire spool unwinded and tangled.	Wire spool brake is too loose.
3 Worn or incorrect feed roller size	A Use a feed roller matched to the size you are welding. B Replace feed roller if worn.
4 Wire rubbed against the mis-aligned guides and reduced wire feedability.	Mis-alignment of inlet/outlet guides
5 Liner blocked with swarf	A Increased amounts of swarf are produced by the wire passing through the feed roller when excessive pressure is applied to the pressure roller adjuster. B Swarf can also be produced by the wire passing through an incorrect feed roller groove shape or size. C Swarf is fed into the conduit liner where it accumulates thus reducing wire feedability.
6 Incorrect or worn contact tip	A The contact tip transfers the weld current to the electrode wire. If the hole in the contact tip is too large then arcing may occur inside the contact tip resulting in the wire jamming in the contact tip B When using soft wire such as aluminium it may become jammed in the contact tip due to expansion of the wire when heated. A contact tip designed for soft wires should be used.
7 Poor work lead contact to work piece	If the work lead has a poor electrical contact to the work piece then the connection point will heat up and result in a reduction of power at the arc.
8 Bent liner	This will cause friction between the wire and the liner thus reducing wire feedability

Table 5-3: Wire Feeding Problems

Basic GMAW (MIG) Welding Troubleshooting

FAULT	CAUSE	REMEDY
1 Undercut	A Welding arc voltage too high. B Incorrect torch angle C Excessive heat input	A Decrease voltage or increase the wire feed speed. B Adjust angle. C Increase the torch travel speed and/or decrease welding current by decreasing the voltage or decreasing the wire feed speed.
2 Lack of penetration	A Welding current too low B Joint preparation too narrow or gap too tight C Shielding gas incorrect	A Increase welding current by increasing wire feed speed and increasing voltage. B Increase joint angle or gap. C Change to a gas which gives higher penetration.
3 Lack of fusion	Voltage too low	Increase voltage.
4 Excessive spatter	A Voltage too high B Voltage too low	A Decrease voltage or increase the wirespeed control. B Increase the voltage or decrease wirespeed.
5 Irregular weld shape	A Incorrect voltage and current settings. Convex, voltage too low. Concave, voltage too high. B Wire is wandering. C Incorrect shielding gas D Insufficient or excessive heat input	A Adjust voltage and current by adjusting the voltage control and the wirespeed control. B Replace contact tip. C Check shielding gas. D Adjust the wirespeed control or the voltage control.
6 Weld cracking	A Weld beads too small B Weld penetration narrow and deep C Excessive weld stresses D Excessive voltage E Cooling rate too fast	A Decrease travel speed B Reduce current and voltage and increase Mig torch travel speed or select a lower penetration shielding gas. C Increase weld metal strength or revise design D Decrease voltage. E Slow the cooling rate by preheating part to be welded or cool slowly.
7 Cold weld puddle	A Loose welding cable connection. B Low primary voltage C Fault in power source	A Check all welding cable connections. B Contact supply authority. C Have an Accredited CIGWELD Service Provider to test then replace the faulty component.
8 Arc does not have a crisp sound that short arc exhibits when the wirefeed speed and voltage are adjusted correctly.	The MIG torch has been connected to the wrong voltage polarity on the front panel.	Connect the MIG torch to the positive (+) welding terminal for solid wires and gas shielded flux cored wires. Refer to the electrode wire manufacturer for the correct polarity.

Table 5-4: GMAW (MIG) Welding Problems

SECTION 6: TIG (GTAW) WELDING

6.01 Shielding Gas Regulator Operating Instructions

**WARNING**

This equipment is designed for use with welding grade (Inert) shielding gases only.

Shielding Gas Regulator Safety

This regulator is designed to reduce and control high pressure gas from a cylinder or pipeline to the working pressure required for the equipment using it.

If the equipment is improperly used, hazardous conditions are created that may cause accidents. It is the users responsibility to prevent such conditions. Before handling or using the equipment, understand and comply at all times with the safe practices prescribed in this instruction.

SPECIFIC PROCEDURES for the use of regulators are listed below.

1. NEVER subject the regulator to inlet pressure greater than its rated inlet pressure.
2. NEVER pressurize a regulator that has loose or damaged parts or is in a questionable condition. NEVER loosen a connection or attempt to remove any part of a regulator until the gas pressure has been relieved. Under pressure, gas can dangerously propel a loose part.
3. DO NOT remove the regulator from a cylinder without first closing the cylinder valve and releasing gas in the regulator high and low pressure chambers.
4. DO NOT use the regulator as a control valve. When downstream equipment is not in use for extended periods of time, shut off the gas at the cylinder valve and release the gas from the equipment.
5. OPEN the cylinder valve SLOWLY. Close after use.

User Responsibilities

This equipment will perform safely and reliably only when installed, operated and maintained, and repaired in accordance with the instructions provided. Equipment must be checked periodically and repaired, replaced, or reset as necessary for continued safe and reliable performance. Defective equipment should not be used. Parts that are broken, missing, obviously worn, distorted, or contaminated should be replaced immediately.

The user of this equipment will generally have the sole responsibility for any malfunction, which results from improper use, faulty maintenance, or by repair by anyone other than an accredited repairer.

**WARNING**

Match regulator/flowmeter to cylinder. NEVER CONNECT a regulator/flowmeter designed for a particular gas or gases to a cylinder containing any other gas.

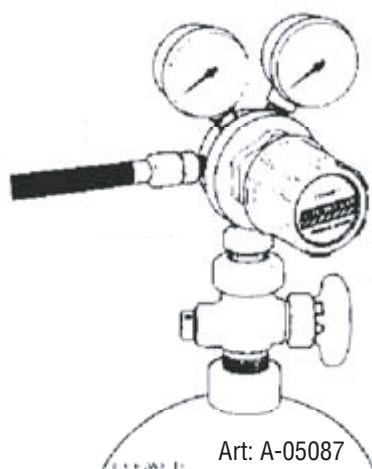


Figure 6-1: Fit Regulator to Cylinder

Installation

1. Remove cylinder valve plastic dust seal. Clean the cylinder valve outlet of impurities that may clog orifices and damage seats before connecting the regulator.

Crack the valve (open then close) momentarily, pointing the outlet away from people and sources of ignition. Wipe with a clean lint free cloth.

2. Match regulator to cylinder. Before connecting, check that the regulator label and cylinder marking agree and that the regulator inlet and cylinder outlet match. NEVER CONNECT a regulator designed for a particular gas or gases to a cylinder containing any other gas.
3. Connect the regulator inlet connection to cylinder or pipeline and tighten it firmly but not excessively, with a suitable spanner.
4. Connect and tighten the outlet hose firmly and attach down-stream equipment.
5. To protect sensitive down-stream equipment a separate safety device may be necessary if the regulator is not fitted with a pressure relief device.

Operation

With the regulator connected to cylinder or pipeline, and the adjustment screw/knob fully disengaged, pressurize as follows:

1. Stand to one side of regulator and slowly open the cylinder valve. If opened quickly, a sudden pressure surge may damage internal regulator parts.
2. With valves on downstream equipment closed, adjust regulator to approximate working pressure. It is recommended that testing for leaks at the regulator connection points be carried out using a suitable leak detection solution or soapy water.
3. Purge air or other unwanted welding grade shielding gas from equipment connected to the regulator by individually opening then closing the equipment control valves. Complete purging may take up to ten seconds or more, depending upon the length and size of the hose being purged.

Adjusting Flow Rate

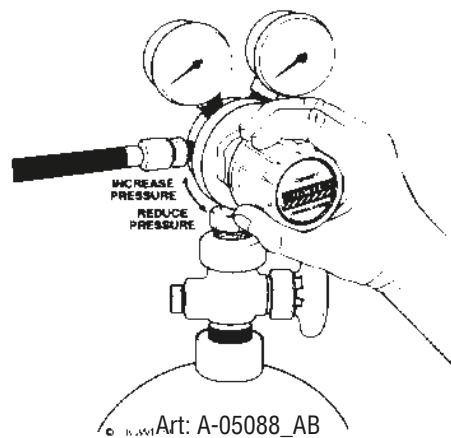


Figure 6-2: Adjust Flow Rate

With the regulator ready for operation, adjust working flow rate as follows:

1. Slowly turn adjusting screw/knob in (clockwise) direction until the outlet gauge indicates the required flow rate.



NOTE!

It may be necessary to re-check the shielding gas regulator/flowmeter flow rate following the first weld sequence due to back pressure present within shielding gas hose assembly.

2. To reduce flow rate, allow the welding grade shielding gas to discharge from regulator by opening the downstream valve. Bleed welding grade shielding gas into a well ventilated area and away from any ignition source. Turn adjusting screw counterclockwise, until the required flow rate is indicated on the gauge. Close downstream valve.

Shutdown

Close cylinder valve whenever the regulator is not in use. To shut down for extended periods (more than 30 minutes).

1. Close cylinder or upstream valve tightly.
2. Open downstream equipment valves to drain the lines. Bleed gas into a well ventilated area and away from any ignition source.
3. After gas is drained completely, disengage adjusting screw and close downstream equipment valves.
4. Before transporting cylinders that are not secured on a cart designed for such purposes, remove regulators.

6.02 Setup for TIG (GTAW) Welding

- A. Connect the TIG Torch to the negative welding terminal (-). Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- B. Connect the TIG torch trigger switch via the 8 pin socket located on the front of the power source as shown below. The TIG torch will require a trigger switch to operate in Lift TIG Mode.

**NOTE!**

If the TIG torch has a remote TIG torch current control fitted then it will require to be connected to the 8 pin socket. (Refer to Section 4.02.20 8 Pin Control Socket for further information).

- C. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the Power indicator on the Front Panel is illuminated.
- D. Select Lift TIG mode with the process selection control (refer to Section 4.02.12 for further information).
- E. Connect the work lead to the positive welding terminal (+). Welding current flows from the Power Source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- F. Fit the welding grade shielding gas regulator/flowmeter to the shielding gas cylinder (refer to Section 6.01) then connect the shielding gas hose from the TIG torch to the regulator/flowmeter outlet. Note that the TIG torch shielding gas hose is connected directly to the regulator/flowmeter. Before turning on shielding gas check that all fittings are tight and the gas valve on the TIG torch is turned off. The power source is not fitted with a shielding gas solenoid to control the gas flow in TIG mode therefore the TIG torch will require a gas valve (refer to Section 2.11 for optional TIG Torches). Before commencing to TIG weld open TIG torch gas valve to allow sufficient shielding gas flow when welding. Refer to Section 6.03 for recommended Shielding Gas flow rates and other TIG Welding information.

Note in TIG Mode an additional feature for Downslope is available. Refer to TIG Mode Advanced Features Page 4-12.

Note when using a TIG Torch with Remote Current Control via the 8 Pin socket that in order to achieve full TIG current range via the torch remote control the wirefeeder 10 pin control plug must be removed from the 10 pin socket of the power source.

**WARNING**

Before connecting the work clamp to the work make sure the mains power supply is switched off.

**WARNING**

Secure the welding grade shielding gas cylinder in an upright position by chaining it to a suitable stationary support to prevent falling or tipping.

**CAUTION**

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

See over page for Setup for Lift TIG (GTAW) Welding diagram.

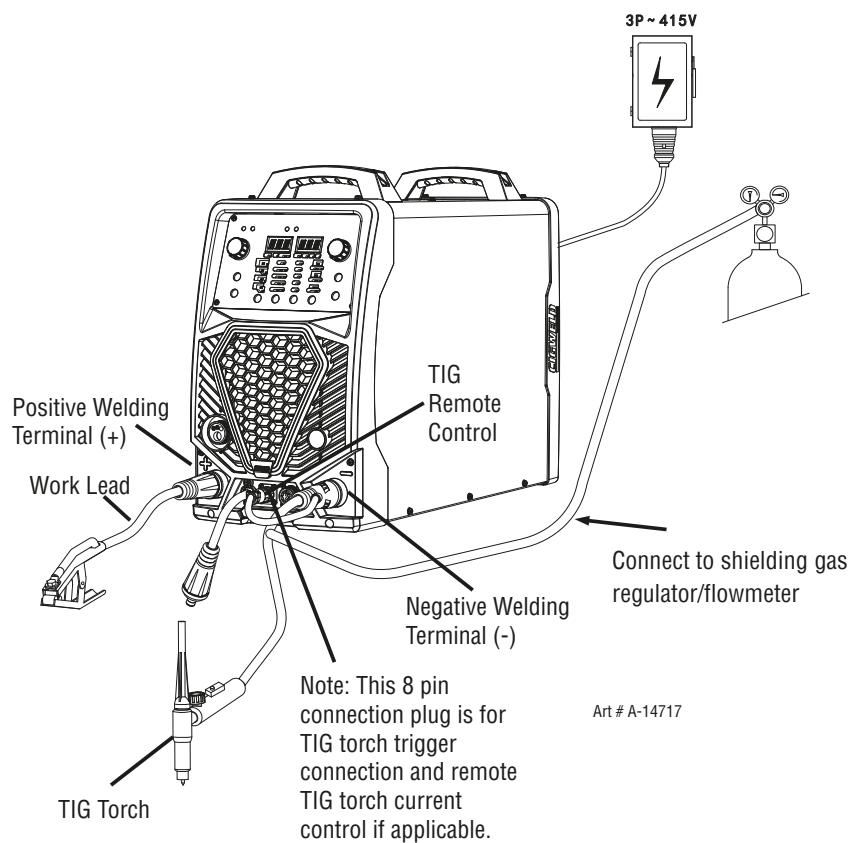


Figure 6-3: Setup for Lift TIG (GTAW) Welding

6.03 TIG (GTAW) Basic Welding Technique

Gas Tungsten Arc Welding (GTAW) or TIG (Tungsten Inert Gas) as it is commonly referred to, is a welding process in which fusion is produced by an electric arc that is established between a single tungsten (non-consumable) electrode and the work piece. Shielding is obtained from a welding grade shielding gas or welding grade shielding gas mixture which is generally Argon based. A filler metal may also be added manually in some circumstances depending on the welding application.

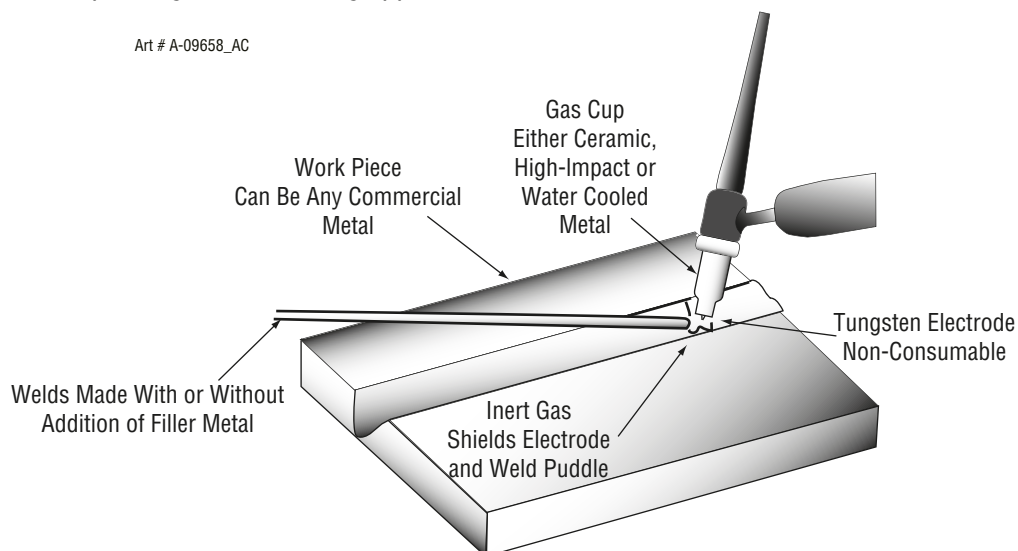


Figure 6-4: TIG Welding Application Shot

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 6-1: Current Ranges for Various Tungsten Electrode Sizes

Guide for Selecting Filler Wire Diameter

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

Table 6-2: Filler Wire Selection Guide

Tungsten Electrode Types

Electrode Type (Ground Finish)	Welding Application	Features	Colour Code
3T Rare Earth	Suitable for AC and DC TIG welding	Excellent ignition characteristics and consistent welding properties. Long service life compared to Thoriated Electrodes. Non Radioactive to improve health and safety for operator and environment.	Purple

Table 6-3

**NOTE!**

The Transmig 355i Inverter is not suited for AC Tig welding.

TIG Welding Filler Rods

Comweld Rod	Aust Std	AWS Std	Part No. 1.6mm	Part No. 2.4mm	Part No. 3.2mm	Type/Application
LW1	R4	ER70S-4	321411	—	—	For mild-medium strength steels. Pipes, tubing, roll cages, etc.
LW1-6	R6	ER70S-6	321417	—	—	
Supersteel	R2	ER70S-2	321370	—	—	
CrMo1	RB2	ER80S-B2	—	321379	—	For welding of high strength Cr-Mo steels used at elevated temperatures.
CrMo2	RB3	ER90S-B3	—	321383	—	
308L	R308L	ER308L	321406	321407	—	For stainless steels. Stainless pipes, tubing, architectural uses, etc.
309L	R309L	ER309L	321403	321404	—	
316L	R316L	ER316L	321400	321401	—	

Table 6-4

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 Litres/min	Joint Type
0.040" 1.0mm	35-45 40-50	20-30 25-35	0.040" 1.0mm	1/16" 1.6mm	5-7	Butt/Corner Lap/Fillet
0.045" 1.2mm	45-55 50-60	30-45 35-50	0.040" 1.0mm	1/16" 1.6mm	5-7	Butt/Corner Lap/Fillet
1/16" 1.6mm	60-70 70-90	40-60 50-70	1/16" 1.6mm	1/16" 1.6mm	7	Butt/Corner Lap/Fillet
1/8" 3.2mm	80-100 90-115	65-85 90-110	1/16" 1.6mm	3/32" 2.4mm	7	Butt/Corner Lap/Fillet
3/16" 4.8mm	115-135 140-165	100-125 125-150	3/32" 2.4mm	1/8" 3.2mm	10	Butt/Corner Lap/Fillet
1/4" 6.4mm	160-175 170-200	135-160 160-180	1/8" 3.2mm	5/32" 4.0mm	10	Butt/Corner Lap/Fillet

Table 6-5

TIG Welding is generally regarded as a specialised process that requires operator competency. While many of the principles outlined in the previous Arc Welding section are applicable a comprehensive outline of the TIG Welding process is outside the scope of this Operating Manual. For further information please refer to www.cigweld.com.au or contact Cigweld.

6.04 TIG (GTAW) Welding Problems

FAULT	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 or oxidises when an arc is struck.	A Torch lead connected to positive welding terminal. B No gas flowing to welding region. C Torch is clogged with dust or dirt. D Gas hose is cut. E Gas passage contains impurities. F Gas regulator turned off. G Torch valve is turned off. H The electrode is too small for the welding current. I Power source is set for MIG welding.	A Connect torch lead to negative welding terminal. B Check the gas lines for kinks or breaks and gas cylinder contents. C Clean torch. D Replace gas hose. E Disconnect gas hose from the rear of Power Source then raise gas pressure and blow out impurities. F Turn on. G Turn on. H Increase electrode diameter or reduce the welding current. I Set Power Source to Lift TIG mode.

7 Dirty weld pool	<p>A Electrode contaminated by contact with work piece or filler rod material.</p> <p>B Work piece surface has foreign material on it.</p> <p>C Gas contaminated with air.</p>	<p>A Clean the electrode by grinding off the contaminates.</p> <p>B Clean surface.</p> <p>C Check gas lines for cuts and loose fitting or change gas cylinder.</p>
8 Poor weld finish	Inadequate shielding gas.	Increase gas flow or check gas line for gas flow problems.
9 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 Table 6-1 Cigweld Electrode Selection Chart.</p> <p>B Select the right electrode type. Refer to Table 6-3 Cigweld Electrode Selection Chart.</p> <p>C Select the right rate for the welding job. Refer to Table 6-5.</p> <p>D Select the right shielding gas.</p> <p>E Improve connection to work piece.</p>
10 Arc flutters during TIG welding.	Tungsten electrode is too large for the welding current.	Select the right size electrode. Refer to Table 6-1 Tungsten Electrode Current Ranges.

Table 6-6: GTAW (TIG) Welding Problems

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SECTION 7: MANUAL ARC (MMAW) WELDING

7.01 Setup for STICK (MMAW) Welding

- Connect the Electrode Holder lead to the positive welding terminal (+). If in doubt, consult the electrode manufacturer. Welding current flows from the Power Source via Dinse type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- Connect the work lead to the negative welding terminal (-). If in doubt, consult the electrode manufacturer. Welding current flows from the power source via Dinse type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- Select STICK mode with the process selection control (refer to Section 4.02.12 for further information).

Note in Stick Mode additional features for Hot Start and Arc force are available. Refer to Stick Mode Advanced Features Page 4-13.

**WARNING**

Before connecting the work clamp to the work make sure the mains power supply is switched off.

**CAUTION**

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

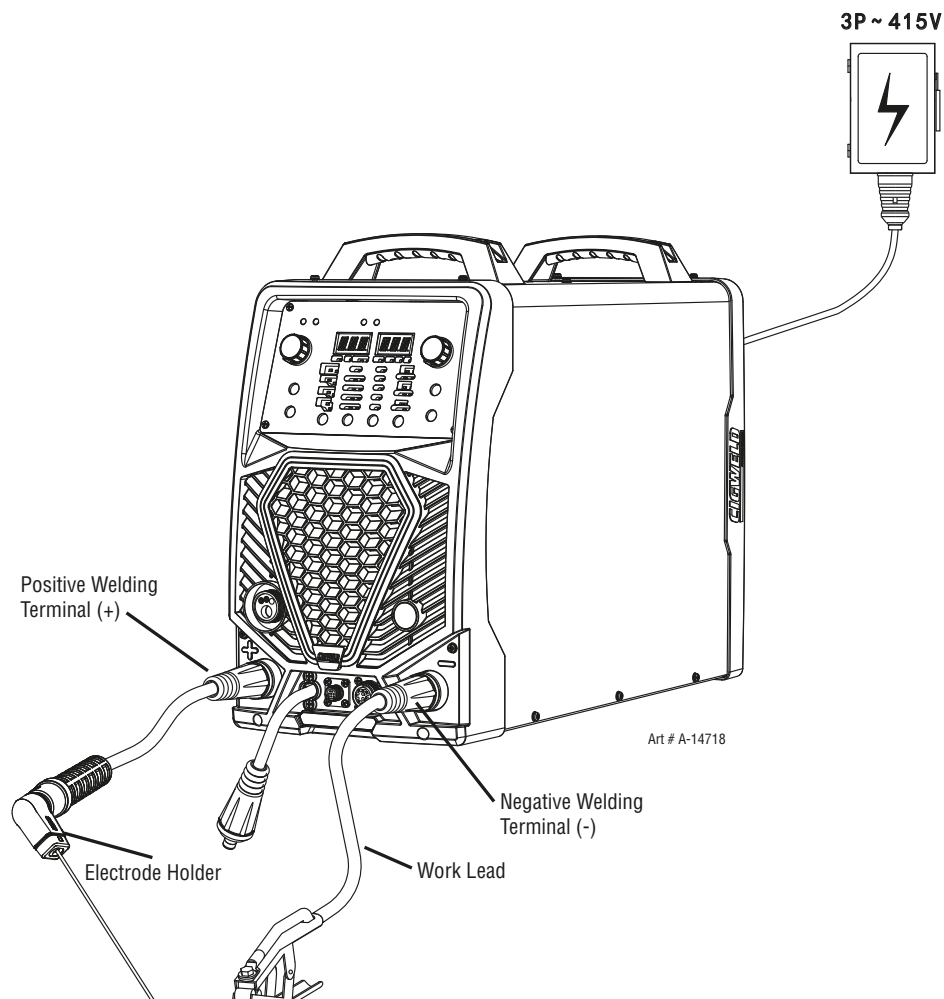


Figure 7-1: Setup for Manual Arc Welding

7.02 Stick (MMAW) Basic Welding Technique

Size of Electrode

The electrode size is determined by the thickness of metals being joined and can also be governed by the type of welding machine available. Small welding machines will only provide sufficient current (amperage) to run the smaller size electrodes.

For thin sections, it is necessary to use smaller electrodes otherwise the arc may burn holes through the job. A little practice will soon establish the most suitable electrode for a given application.

Storage of Electrodes

Always store electrodes in a dry place and in their original containers.

Electrode Polarity

Electrodes are generally connected to the ELECTRODE HOLDER with the Electrode Holder connected positive polarity. The WORK LEAD is connected negative polarity and is connected to the work piece. If in doubt consult the electrode data sheet or your nearest Accredited CIGWELD Distributor.

Effects of Arc Welding Various Materials

A. 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 may result. 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 electrodes sizes, short runs for larger electrode deposits or tempering in a furnace.

Hydrogen controlled Electrodes must be used for this application. Use Ferrocraft 61 or 16TXP for normal strength (500 MPa) steels, and Alloycraft range for higher strength steels.

B. Austenitic 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. Suitable Electrode types are Cobalarc Austex or Cobalarc Mangcraft.

C. 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. Suitable Electrode types are Castcraft 55 or Castcraft 100.

D. Copper and alloys

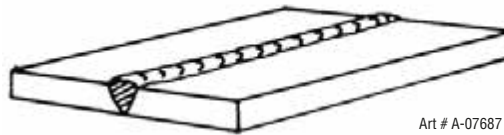
The most important factor is the high rate of heat conductivity of copper, making preheating of heavy sections necessary to give proper fusion of weld and base metal. Suitable Electrode types are Bronzecraft AC-DC electrodes.

Arc Welding Practice

The techniques used for arc welding are almost identical regardless of what types of metals are being joined. Naturally enough, different types of electrodes would be used for different metals as described in the preceding section.

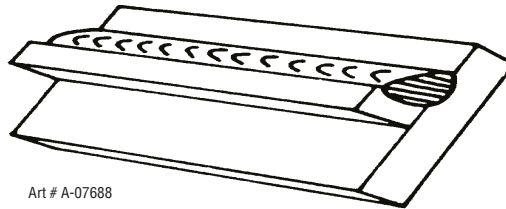
Welding Position

The electrodes dealt with in this publication can be used in most positions, i.e. they are suitable for welding in flat, horizontal, vertical and overhead positions. Numerous applications call for welds to be made in positions intermediate between these. Some of the common types of welds are shown in Figures 7-2 through 7-9.



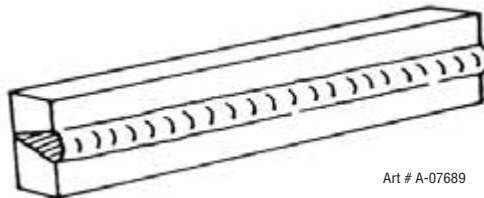
Art # A-07687

Figure 7-2: Flat Position, Down Hand Butt Weld



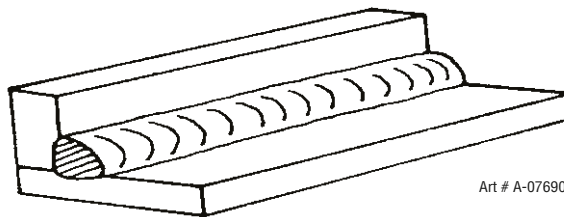
Art # A-07688

Figure 7-3: Flat Position, Gravity Fillet Weld



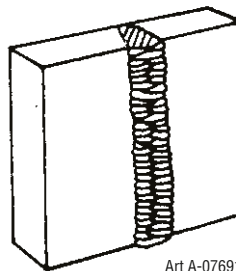
Art # A-07689

Figure 7-4: Horizontal Position, Butt Weld



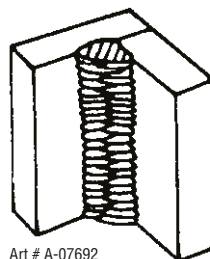
Art # A-07690

Figure 7-5: Horizontal-Vertical (HV) Position



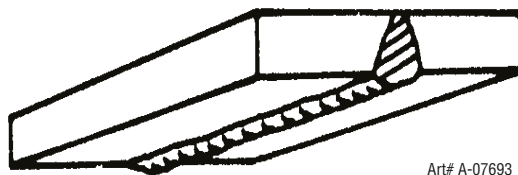
Art A-07691

Figure 7-6: Vertical Position, Butt Weld



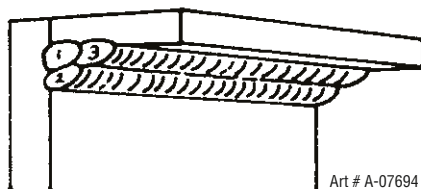
Art # A-07692

Figure 7-7: Vertical Position, Fillet Weld



Art# A-07693

Figure 7-8: Overhead Position, Butt Weld



Art # A-07694

Figure 7-9: Overhead Position, Fillet Weld

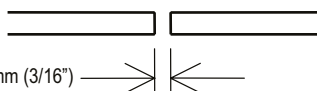
Joint Preparations

In many cases, it will be possible to weld steel sections without any special preparation. For heavier sections and for repair work on castings, etc., it will be necessary to cut or grind an angle between the pieces being joined to ensure proper penetration of the weld metal and to produce sound joints.

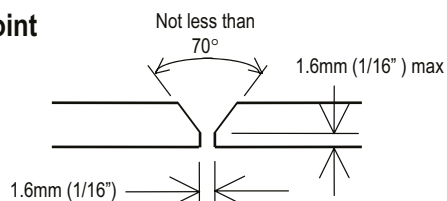
In general, surfaces being welded should be clean and free of rust, scale, dirt, grease, etc. Slag should be removed from oxy-cut surfaces. Typical joint designs are shown in Figure 7-10.

Open Square Butt Joint

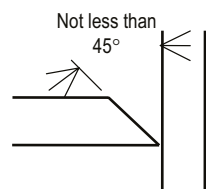
Gap varies from
1.6mm (1/16") to 4.8mm (3/16")
depending on plate thickness



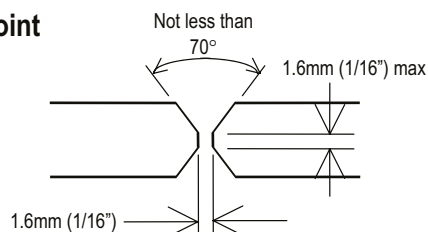
Single Vee Butt Joint



Single Vee Butt Joint



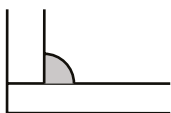
Double Vee Butt Joint



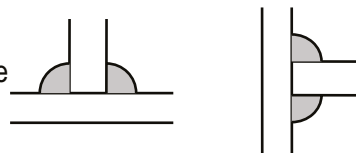
Lap Joint



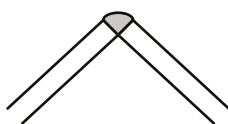
Fillet Joint



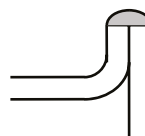
Tee Joints (Fillet both sides of the joint)



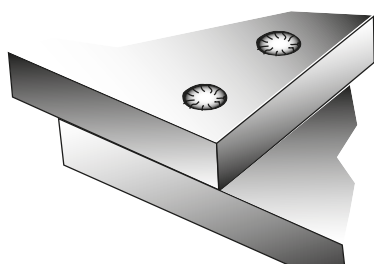
Corner Weld



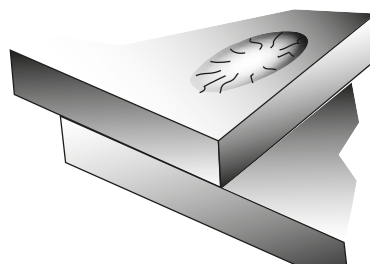
Edge Joint



Plug Weld



Plug Weld



Art # A-07695_AE

Figure 7-10: Typical Joint Designs for Arc Welding

Arc Welding Technique - A Word to Beginners

For those who have not yet done any welding, the simplest way to commence is to run beads on a piece of scrap plate. Use mild steel plate about 6.0mm thick and a 3.2mm electrode. Clean any paint, loose scale or grease off the plate and set it firmly on the work bench so that welding can be carried out in the downhand position. Make sure that the work clamp is making good electrical contact with the work, either directly or through the work table. For light gauge material, always clamp the work lead directly to the job, otherwise a poor circuit will probably result.

The Welder

Place yourself in a comfortable position before beginning to weld. Get a seat of suitable height and do as much work as possible sitting down. Don't hold your body tense. A taut attitude of mind and a tensed body will soon make you feel tired. Relax and you will find that the job becomes much easier. You can add much to your peace of mind by wearing a leather apron and gauntlets. You won't be worrying then about being burnt or sparks setting alight to your clothes.

Place the work so that the direction of welding is across, rather than to or from, your body. The electrode holder lead should be clear of any obstruction so that you can move your arm freely along as the electrode burns down. If the lead is slung over your shoulder, it allows greater freedom of movement and takes a lot of weight off your hand. Be sure the insulation on your cable and electrode holder is not faulty, otherwise you are risking an electric shock.

Striking the Arc

Practice this on a piece of scrap plate before going on to more exacting work. You may at first experience difficulty due to the tip of the electrode "sticking" to the work piece. This is caused by making too heavy a contact with the work and failing to withdraw the electrode quickly enough. A low amperage will accentuate it. This freezing-on of the tip may be overcome by scratching the electrode along the plate surface in the same way as a match is struck. As soon as the arc is established, maintain a 1.6mm to 3.2mm gap between the burning electrode end and the parent metal. Draw the electrode slowly along as it melts down.

Another difficulty you may meet is the tendency, after the arc is struck, to withdraw the electrode so far that the arc is broken again. A little practice will soon remedy both of these faults.

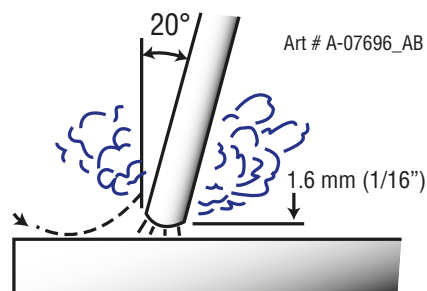


Figure 7-11: Striking an Arc

Arc Length

The securing of an arc length necessary to produce a neat weld soon becomes almost automatic. You will find that a long arc produces more heat. A very long arc produces a crackling or spluttering noise and the weld metal comes across in large, irregular blobs. The weld bead is flattened and spatter increases. A short arc is essential if a high quality weld is to be obtained although if it is too short there is the danger of it being blanketed by slag and the electrode tip being solidified in. If this should happen, give the electrode a quick twist back over the weld to detach it. Contact or "touch-weld" electrodes such as Ferrocrafter 21 do not stick in this way, and make welding much easier.

Rate of Travel

After the arc is struck, your next concern is to maintain it, and this requires moving the electrode tip towards the molten pool at the same rate as it is melting away. At the same time, the electrode has to move along the plate to form a bead. The electrode is directed at the weld pool at about 20° from the vertical. The rate of travel has to be adjusted so that a well-formed bead is produced.

If the travel is too fast, the bead will be narrow and strung out and may even be broken up into individual globules. If the travel is too slow, the weld metal piles up and the bead will be too large.

Making Welded Joints

Having attained some skill in the handling of an electrode, you will be ready to go on to make up welded joints.

A. Butt Welds

Set up two plates with their edges parallel, as shown in Figure 7-12, allowing 1.6mm to 2.4mm gap between them and tack weld at both ends. This is to prevent contraction stresses from the cooling weld metal pulling the plates out of alignment. Plates thicker than 6.0mm should have their mating edges bevelled to form a 70° to 90° included angle. This allows full penetration of the weld metal to the root. Using a 3.2mm Ferrocrafter 21 electrode at 100 amps, deposit a run of weld metal on the bottom of the joint.

Do not weave the electrode, but maintain a steady rate of travel along the joint sufficient to produce a well-formed bead. At first you may notice a tendency for undercut to form, but keeping the arc length short, the angle of the electrode at about 20° from vertical, and the rate of travel not too fast, will help eliminate this. The electrode needs to be moved along fast enough to prevent the slag pool from getting ahead of the arc. To complete the joint in thin plate, turn the job over, clean the slag out of the back and deposit a similar weld.

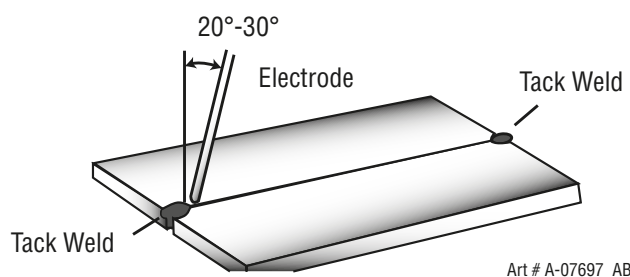


Figure 7-12: Butt Weld

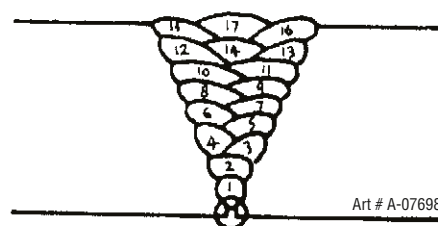


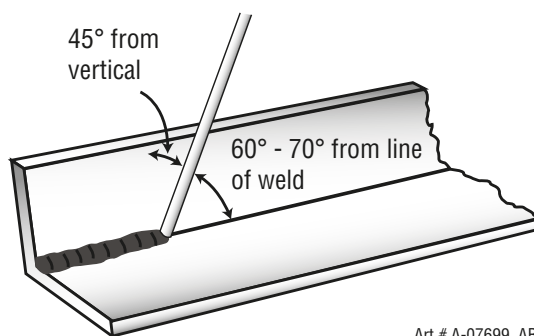
Figure 7-13: Weld Build up Sequence

Heavy plate will require several runs to complete the joint. After completing the first run, chip the slag out and clean the weld with a wire brush. It is important to do this to prevent slag being trapped by the second run. Subsequent runs are then deposited using either a weave technique or single beads laid down in the sequence shown in Figure 7-13. The width of weave should not be more than three times the core wire diameter of the electrode. When the joint is completely filled, the back is either machined, ground or gouged out to remove slag which may be trapped in the root, and to prepare a suitable joint for depositing the backing run. If a backing bar is used, it is not usually necessary to remove this, since it serves a similar purpose to the backing run in securing proper fusion at the root of the weld.

B. Fillet Welds

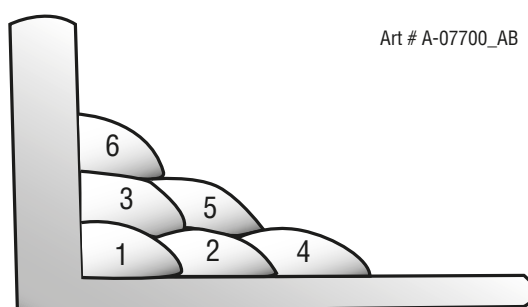
These are welds of approximately triangular cross-section made by depositing metal in the corner of two faces meeting at right angles. Refer to Figure 7-5.

A piece of angle iron is a suitable specimen with which to begin, or two lengths of strip steel may be tacked together at right angles. Using a 3.2mm Ferrocrafter 21 electrode at 100 amps, position angle iron with one leg horizontal and the other vertical. This is known as a horizontal-vertical (HV) fillet. Strike the arc and immediately bring the electrode to a position perpendicular to the line of the fillet and about 45° from the vertical. Some electrodes require to be sloped about 20° away from the perpendicular position to prevent slag from running ahead of the weld. Refer to Figure 7-14. Do not attempt to build up much larger than 6.4mm width with a 3.2mm electrode, otherwise the weld metal tends to sag towards the base, and undercut forms on the vertical leg. Multi-runs can be made as shown in Figure 7-15. Weaving in HV fillet welds is undesirable.



Art # A-07699_AB

Figure 7-14: Electrode Position for HV Fillet Weld



Art # A-07700_AB

Figure 7-15: Multi-runs in HV Fillet Weld

C. Vertical Welds

1. Vertical Up

Tack weld a three feet length of angle iron to your work bench in an upright position. Use a 3.2mm Ferrocrafter 21 electrode and set the current at 100 amps. Make yourself comfortable on a seat in front of the job and strike the arc in the corner of the fillet. The electrode needs to be about 10° from the horizontal to enable a good bead to be deposited. Refer Figure 7-16. Use a short arc, and do not attempt to weave on the first run. When the first run has been completed de-slag the weld deposit and begin the second run at the bottom. This time a slight weaving motion is necessary to cover the first run and obtain good fusion at the edges. At the completion of each side motion, pause for a moment to allow weld metal to build up at the edges, otherwise undercut will form and too much metal will accumulate in the centre of the weld. Figure 7-17 illustrates multi-run technique and Figure 7-18 shows the effects of pausing at the edge of weave and of weaving too rapidly.

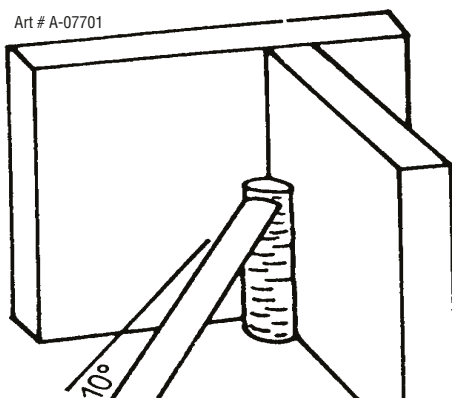


Figure 7-16: Single Run Vertical Fillet Weld

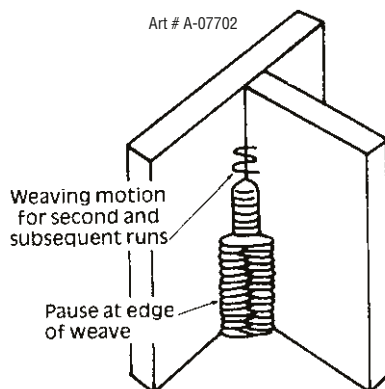


Figure 7-17: Multi Run Vertical Fillet Weld

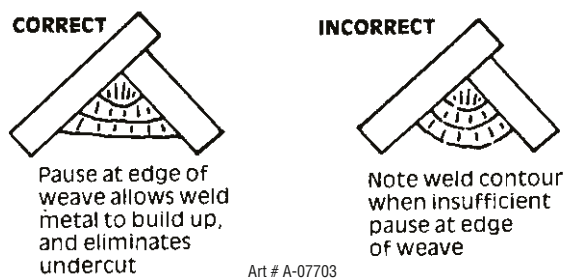


Figure 7-18: Examples of Vertical Fillet Welds

2. Vertical Down

The Ferrocrafter 21 electrode makes welding in this position particularly easy. Use a 3.2mm electrode at 100 amps. The tip of the electrode is held in light contact with the work and the speed of downward travel is regulated so that the tip of the electrode just keeps ahead of the slag. The electrode should point upwards at an angle of about 45° .

3. Overhead Welds

Apart from the rather awkward position necessary, overhead welding is not much more difficult than downhand welding. Set up a specimen for overhead welding by first tacking a length of angle iron at right angles to another piece of angle iron or a length of waste pipe. Then tack this to the work bench or hold in a vice so that the specimen is positioned in the overhead position as shown in the sketch. The electrode is held at 45° to the horizontal and tilted 10° in the line of travel (Figure 7-19). The tip of the electrode may be touched lightly on the metal, which helps to give a steady run. A weave technique is not advisable for overhead fillet welds. Use a 3.2mm Ferrocrafter 12XP electrode at 100 amps, and deposit the first run by simply drawing the electrode along at a steady rate. You will notice that the weld deposit is rather convex, due to the effect of gravity before the metal freezes.

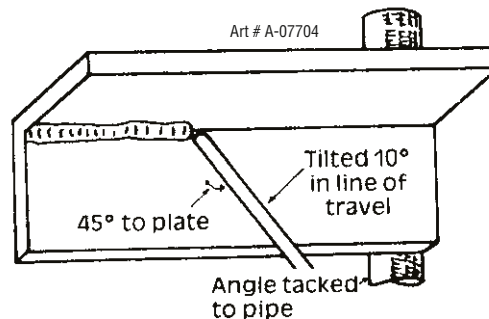


Figure 7-19: Overhead Fillet Weld

Distortion

Distortion in some degree is present in all forms of welding. In many cases it is so small that it is barely perceptible, but in other cases allowance has to be made before welding commences for the distortion that will subsequently occur. The study of distortion is so complex that only a brief outline can be attempted here.

The Cause of Distortion

Distortion is caused by:

A. Contraction of Weld Metal:

Molten steel shrinks approximately 11 per cent in volume on cooling to room temperature. This means that a cube of molten metal would contract approximately 2.2 per cent in each of its three dimensions. In a welded joint, the metal becomes attached to the side of the joint and cannot contract freely. Therefore, cooling causes the weld metal to flow plastically, that is, the weld itself has to stretch if it is to overcome the effect of shrinking volume and still be attached to the edge of the joint. If the restraint is very great, as, for example, in a heavy section of plate, the weld metal may crack. Even in cases where the weld metal does not crack, there will still remain stresses "Locked-up" in the structure. If the joint material is relatively weak, for example, a butt joint in 2.0mm sheet, the contracting weld metal may cause the sheet to become distorted.

B. Expansion and Contraction of Parent Metal in the Fusion Zone:

While welding is proceeding, a relatively small volume of the adjacent plate material is heated to a very high temperature and attempts to expand in all directions. It is able to do this freely at right angles to the surface of the plate (i.e., "through the weld", but when it attempts to expand "across the weld" or "along the weld", it meets considerable resistance, and to fulfil the desire for continued expansion, it has to deform plastically, that is, the metal adjacent to the weld is at a high temperature and hence rather soft, and, by expanding, pushes against the cooler, harder metal further away, and tends to bulge (or is "upset"). When the weld area begins to cool, the "upset" metal attempts to contract as much as it expanded, but, because it has been "upset" it does not resume its former shape, and the contraction of the new shape exerts a strong pull on adjacent metal. Several things can then happen.

The metal in the weld area is stretched (plastic deformation), the job may be pulled out of shape by the powerful contraction stresses (distortion), or the weld may crack, in any case, there will remain "locked-up" stresses in the job. Figures 7-20 and 7-21 illustrate how distortion is created.

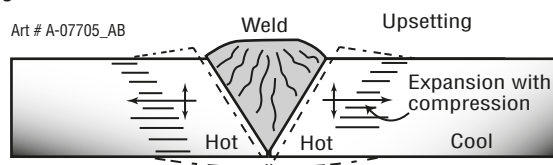


Figure 7-20: Parent Metal Expansion

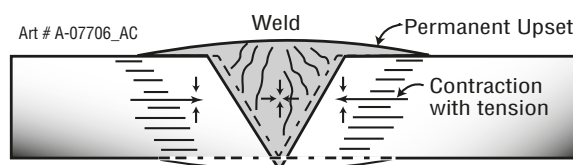


Figure 7-21: Parent Metal Contraction

Overcoming Distortion Effects

There are several methods of minimizing distortion effects.

A. Peening

This is done by hammering the weld while it is still hot. The weld metal is flattened slightly and because of this the tensile stresses are reduced a little. The effect of peening is relatively shallow, and is not advisable on the last layer.

B. Distribution of Stresses

Distortion may be reduced by selecting a welding sequence which will distribute the stresses suitably so that they tend to cancel each other out. See Figures 7-21 through 7-24 for various weld sequences. Choice of a suitable weld sequence is probably the most effective method of overcoming distortion, although an unsuitable sequence may exaggerate it. Simultaneous welding of both sides of a joint by two welders is often successful in eliminating distortion.

C. Restraint of Parts

Forcible restraint of the components being welded is often used to prevent distortion. Jigs, positions, and tack welds are methods employed with this in view.

D. Presetting

It is possible in some cases to tell from past experience or to find by trial and error (or less frequently, to calculate) how much distortion will take place in a given welded structure. By correct pre-setting of the components to be welded, constructional stresses can be made to pull the parts into correct alignment. A simple example is shown in Figure 7-22.

E. Preheating

Suitable preheating of parts of the structure other than the area to be welded can be sometimes used to reduce distortion. Figure 7-23 shows a simple application. By removing the heating source from b and c as soon as welding is completed, the sections b and c will contract at a similar rate, thus reducing distortion.

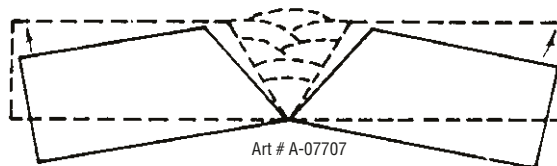
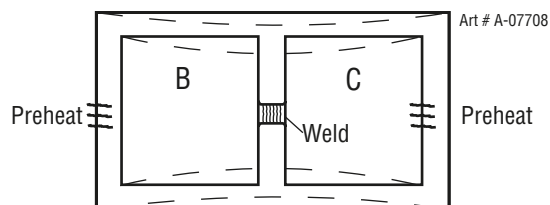


Figure 7-22: Principle of Presetting



Dotted lines show effect if no preheat is used

Figure 7-23: Reduction of Distortion by Preheating

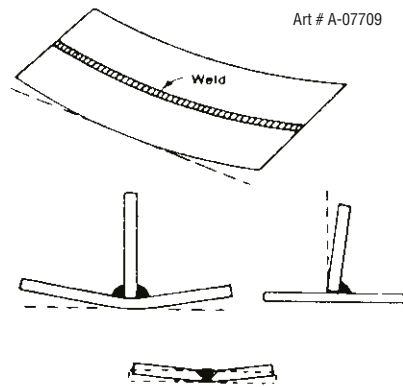


Figure 7-24: Examples of Distortion

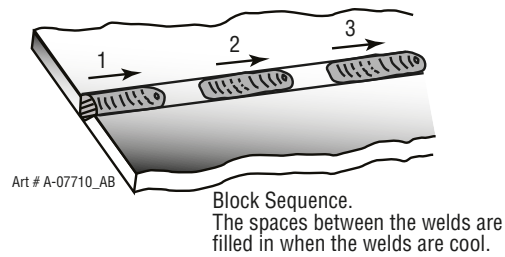


Figure 7-25: Welding Sequence

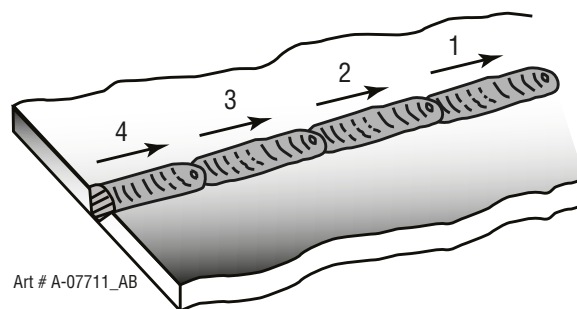


Figure 7-26: Step back Sequence

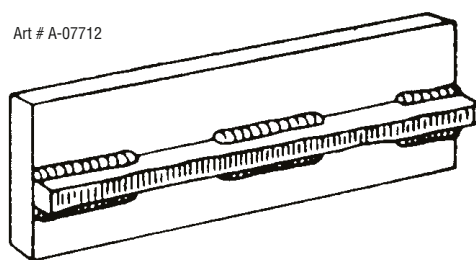


Figure 7-27: Chain Intermittent Welding

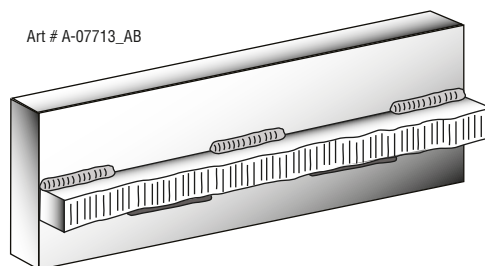


Figure 7-28: Staggered Intermittent Welding

7.03 Electrode Selection Chart

CIGWELD Electrode Selection Chart				
Description	Diameter	Pack	Part No.	Application
Satincraft 13	2.5mm	1kg	322135	General purpose electrode suitable for all positional welding and galvanised steel. Satincraft 13 is easily identified with a blue flux on the electrode.
	2.5mm	2.5kg	612182	
	3.2mm	1kg	322136	
	3.2mm	2.5kg	612183	
	4.0mm	5kg	611184	
Ferrocraft 12XP	2.5mm	1kg	322129	General purpose, Xtra performance electrode recommended for all positional (inc. Vertical down) welding of mild and galvanised steel.
	2.5mm	2.5kg	612232	
	3.2mm	2.5kg	612233	
	4.0mm	5kg	611234	
WeldSkill GP	2.0mm	1 kg	WEG1020	User-friendly GP electrode for welding thin section mild and galvanised steels. Excellent for vertical down fillet welding applications.
	2.0mm	2.5 kg	WEG2520	
	2.5mm	1 kg	WEG1025	
	2.5mm	2.5 kg	WEG2525	
	2.5mm	5 kg	WEG5025	
	3.2mm	1 kg	WEG1032	
	3.2mm	2.5 kg	WEG2532	
	3.2mm	5 kg	WEG5032	
OK53.16 Spezial	2.5mm	1.8 kg	53162534G1	Hydrogen Controlled type offering exceptional AC/DC performance in all welding positions.
	3.2mm	1.6 kg	53163234G0	
	4.0mm	2.2 kg	53164044G0	
Satincrome 308L-17	2.5mm	2.5 kg	611602	Stainless Steel type for 19Cr/10Ni stainless grades including 201, 202, 301, 302, 303, 304, 304L, 305, 308, etc
	3.2mm	2.5 kg	611603	
Satincrome 309Mo-17	2.5mm	2.5 kg	611692	Stainless Steel type for 309 and 309L grades. It is also suitable for welding of dissimilar welding of other 300 series stainless steels.
	3.2mm	2.5 kg	611693	
	4.0mm	2.5 kg	611694	
Satincrome 316L-17	2.0mm	2.5 kg	611661	Stainless Steel type for welding of matching Mo bearing grades, 316 and 316L.
	2.5mm	2.5 kg	611662	
	3.2mm	2.5 kg	611663	
	2.5/3.2mm	Blisterpack	322215	
	4.0mm	2.5 kg	611664	
Weldall	2.5mm	2.5 kg	611702	High alloy stainless steel type for welding of unknown steels, repair of die or tool steels and for joining dissimilar steels. (Not recommended for cast iron).
	3.2mm	2.5 kg	611703	
	2.5/3.2mm	Blisterpack	322216	
	4.0mm	2.5 kg	611704	
Castcraft 55	3.2mm	2.5 kg	611723	For repair and maintenance welding of S.G. cast iron, meehanite and other cast irons. It produces high strength weld than Castcraft 100.
Castcraft 100	2.5mm	2.5 kg	611732	Soft, Ductile Nickel type electrode for repair and maintenance welding of a wide range of cast irons. It has better "wetting" action than Castcraft 55.
	3.2mm	2.5 kg	611733	
	2.5/3.2mm	Blisterpack	322217	
	4.0mm	2.5 kg	611734	

Table 7-1: Cigweld Electrode Selection Chart

Further information on CIGWELD electrodes can be found at the website www.cigweld.com.au

7.04 Stick (MMAW) Welding Troubleshooting

FAULT	CAUSE	REMEDY
1 Welding current varying	ARC FORCE control knob is set at a value that causes the welding current to vary excessively with the arc length.	Reduce the ARC FORCE control knob until welding current is reasonably constant while prohibiting the electrode from sticking to the work piece when you "dig" the electrode into the workpiece.
2 A gap is left by failure of the weld metal to fill the root of the weld.	A Welding current too low B Electrode too large for joint. C Insufficient gap.	A Increase welding current. B Use smaller diameter electrode. C Allow wider gap.
3 Non-metallic particles are trapped in the weld metal.	A Non-metallic particles may be trapped in undercut from previous run. B Joint preparation too restricted. C Irregular deposits allow slag to be trapped. D Lack of penetration with slag trapped beneath weld bead. E Rust or mill scale is preventing full fusion. F Wrong electrode for position in which welding is done.	A If a bad undercut is present clean slag bout and cover with a run from a smaller gauge electrode. B Allow for adequate penetration and room for cleaning out the slag. C If very bad, chip or grind out irregularities. D Use smaller electrode with sufficient current to give adequate penetration. Use suitable tools to remove all slag from comers. E Clean joint before welding. F Use electrodes designed for position in which welding is done, otherwise proper control of slag is difficult.

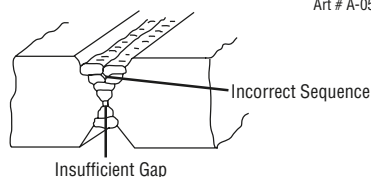
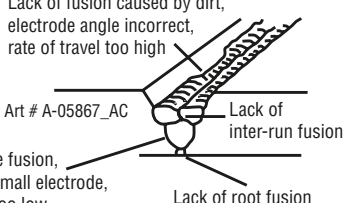
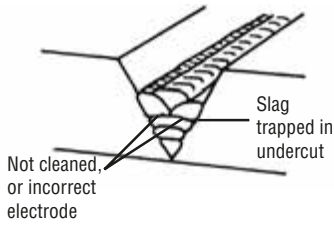
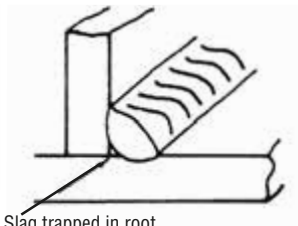


Figure 1-Example of insufficient gap or incorrect sequence

FAULT	CAUSE	REMEDY
4 A groove has been formed in the base metal adjacent to the toe of a weld and has not been filled by the weld metal (undercut).	A Welding current is too high. B Welding arc is too long. C Angle of the electrode is incorrect. D Joint preparation does not allow correct electrode angle. E Electrode too large for joint. F Insufficient deposit time at edge of weave. G Power source is set for MIG (GMAW) welding.	A Reduce welding current. B Reduce the length of the welding arc. C Electrode should not be inclined less than 45° to the vertical face. D Allow more room in joint for manipulation of the electrode. E Use smaller gauge electrode. F Pause for a moment at edge of weave to allow weld metal buildup. G Set power source to STICK (MMAW) mode.
5 Portions of the weld run do not fuse to the surface of the metal or edge of the joint.	A Small electrodes used on heavy cold plate. B Welding current is too low. C Wrong electrode angle. D Travel speed of electrode is too high. E Scale or dirt on joint surface.	A Use larger electrodes and preheat the plate. B Increase welding current. C Adjust angle so the welding arc is directed more into the base metal. D Reduce travel speed of electrode. E Clean surface before welding.
<div style="display: flex; align-items: center;"> <div style="flex: 1;"> <p>Lack of fusion caused by dirt, electrode angle incorrect, rate of travel too high</p> <p>Art # A-05867_AC</p> <p>Lack of side fusion, scale dirt, small electrode, amperage too low</p> <p>Lack of inter-run fusion</p> <p>Lack of root fusion</p>  </div> <div style="flex: 1; text-align: center;"> <p>Figure 2: Example of Lack of Fusion</p> </div> </div>		
6 Gas pockets or voids in weld metal (porosity)	A High levels of sulphur in steel. B Electrodes are damp. C Welding current is too high. D Surface impurities such as oil, grease, paint, etc. E Welding in a windy environment. F Electrode damaged ie flux coating incomplete.	A Use an electrode that is designed for high sulphur steels. B Dry electrodes before use. C Reduce welding current. D Clean joint before welding. E Shield the weld area from the wind. F Discard damaged electrodes and only use electrodes with a complete flux coating.
7 Crack occurring in weld metal soon after solidification commences	A Rigidity of joint. B Insufficient throat thickness. C Weld current is too high.	A Redesign to relieve weld joint of severe stresses or use crack resistance electrodes. B Travel slightly slower to allow greater build up in throat. C Decrease welding current.

FAULT	CAUSE	REMEDY
 <p>Not cleaned, or incorrect electrode</p> <p>Slag trapped in undercut</p>	 <p>Slag trapped in root</p>	

Art # A-05868_AC

Figure 3: Example of Slag Inclusion

Table 7-2: Welding Problems MMAW (Stick)

SECTION 8: ROUTINE SERVICE REQUIREMENTS AND POWER SOURCE PROBLEMS

8.01 Routine Service and Calibration Requirements



WARNING

There are extremely dangerous voltage and power levels present inside this Inverter Power Source. Do not attempt to open or repair unless you are an accredited CIGWELD Service Provider. Disconnect the Welding Power Source from the Mains Supply Voltage before disassembling.

Routine Inspection, Testing & Maintenance

The inspection and testing of the power source and associated accessories shall be carried out in accordance with Section 5 of AS 1674.2 - 2007: Safety in Welding and Allied Processes-Part 2 Electrical. This includes an insulation resistance test and an earthing test to ensure the integrity of the unit is compliant with Cigweld's original specifications.

If equipment is to be used in a hazardous location or environments with a high risk of electrocution as outlined in AS 1674.2 - 2007, then the above tests should be carried out prior to entering this location.

A. Testing Schedule

1. For transportable equipment, at least once every 3 months; and
2. For fixed equipment, at least once every 12 months.

The owners of the equipment shall keep a suitable record of the periodic tests and a system of tagging, including the date of the most recent inspection.

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

B. Insulation Resistance

Minimum insulation resistance for in-service Cigweld Inverter Power Sources shall be measured at a voltage of 500V between the parts referred to in Table 8-1 below. Power sources that do not meet the insulation resistance requirements set out below shall be withdrawn from service and not returned until repairs have been performed such that the requirements outlined below are met.

Components to be Tested	Minimum Insulation Resistance (M Ω)
Input circuit (including any connected control circuits) to welding circuit (including any connected control circuits)	5
All circuits to exposed conductive parts	2.5
Welding circuit (including any connected control circuits) to any auxiliary circuit which operates at a voltage exceeding extra low voltage	10
Welding circuit (including any connected control circuits) to any auxiliary circuit which operates at a voltage not exceeding extra low voltage	1
Separate welding circuit to separate welding circuit	1

Table 8-1: Minimum Insulation Resistance Requirements: Cigweld Inverter Power Sources

C. Earthing

The resistance shall not exceed 1Ω between any metal of a power source where such metal is required to be earthed, and -

1. The earth terminal of a fixed power source; or
2. The earth terminal of the associated plug of a transportable power source

Note that due to the dangers of stray output currents damaging fixed wiring, the integrity of fixed wiring supplying Cigweld welding power sources should be inspected by a licensed electrical worker in accordance with the requirements below -

1. For outlets/wiring and associated accessories supplying transportable equipment - at least once every 3 months; and
2. For outlets/wiring and associated accessories supplying fixed equipment - at least once every 12 months.

D. Voltage Reduction Device (VRD)

Units fitted with VRD's, shall have the periodic tests outlined in Table 8-2 below conducted by an accredited CIGWELD service provider. Testing shall be conducted at intervals as outlined below -

1. For transportable equipment, at least once every 3 months; and
2. For fixed equipment, at least once every 12 months.

Description	Required Parameters
VRD Open Circuit Voltage	Less than 35V; at nominal input voltage
VRD Turn ON Resistance	Less than 200 ohms
VRD Turn OFF Time	Less than 0.3 seconds

Table 8-2: VRD Periodic Tests

E. General Maintenance Checks

Welding equipment should be regularly checked by an accredited Cigweld Service Provider to ensure that:

1. Flexible cord is of the multi-core tough rubber or plastic sheathed type of adequate rating, correctly connected and in good condition.
2. Welding terminals are in suitable condition and are shrouded to prevent inadvertent contact or short circuit.
3. The Welding System is clean internally, especially from metal filing, slag, and loose material.

F. Accessories

Accessory equipment, including output leads, electrode holders, torches, wire feeders and the like shall be inspected at least monthly by a competent person to ensure that the equipment is in a safe and serviceable condition. All unsafe accessories shall not be used.

G. Repairs

If any parts are damaged for any reason, it is recommended that replacement be performed by an accredited Cigweld Service Provider.

Power Source Calibration

A. Schedule

Output testing of all Cigweld Inverter Power Sources and applicable accessories shall be conducted at regular intervals to ensure they fall within specified levels. Calibration intervals shall be as outlined below -

1. For transportable equipment, at least once every 3 months; and
2. For fixed equipment, at least once every 12 months.

If equipment is to be used in a hazardous location or environments with a high risk of electrocution as outlined in AS 1674.2 - 2007, then the above tests should be carried out prior to entering this location.

B. Calibration Requirements

Where applicable, the tests outlined in Table 8-3 below shall be conducted by an accredited CIGWELD service agent.

Testing Requirements
Output current (A) to be checked to ensure it falls within applicable Cigweld power source specifications
Output Voltage (V) to be checked to ensure it falls within applicable Cigweld power source specifications
Motor Speed (RPM) of wire drive motors to be checked to ensure it falls within required Cigweld power source / wire feeder specifications
Accuracy of digital meters to be checked to ensure it falls within applicable Cigweld power source specifications

Table 8-3: Calibration Parameters

Periodic calibration of other parameters such as timing functions are not required unless a specific fault has been identified.

C. Calibration Equipment

All equipment used for Power Source calibration shall be in proper working condition and be suitable for conducting the measurement in question. Only test equipment with valid calibration certificates (NATA certified laboratories) shall be utilized.

8.02 Cleaning the Welding Power Source



WARNING

There are extremely dangerous voltage and power levels present inside this Inverter Power Source. Do not attempt to open or repair unless you are an accredited CIGWELD Service Provider. Disconnect the Welding Power Source from the Mains Supply Voltage before disassembling.

To clean the Welding Power Source, open the enclosure and use a vacuum cleaner to remove any accumulated dirt, metal filings, slag and loose material. Keep the shunt and lead screw surfaces clean as accumulated foreign material may reduce the welders output welding current.

8.03 Cleaning the Feed Rolls

Clean the grooves in the drive rolls frequently. This can be done by using a small wire brush. Also wipe off, or clean the grooves on the upper feed roll. After cleaning, tighten the feed roll retaining knobs.



CAUTION

Do not use compressed air to clean the Welding Power Source. Compressed air can force metal particles to lodge between live electrical parts and earthed metal parts within the Welding Power Source. This may result in arcing between this parts and their eventual failure.

8.04 Power Source Problems

FAULT	CAUSE	REMEDY
1 Mains Supply Voltage is On, the On/Off switch on the rear panel is in the On position and the Power indicator on the front panel is illuminated however the power source will not MIG weld.	<p>A Power source is not in the correct mode of operation.</p> <p>B MIG Torch Polarity Lead is not connected.</p> <p>C Work Lead is not connected to the work piece.</p> <p>D MIG torch is not correctly connected to the Euro Style MIG Torch Adaptor.</p>	<p>A Set the power source to MIG mode. Refer to Section 4.02.12.</p> <p>B Connect the MIG Torch Polarity Lead to the positive or negative output terminal. Refer to Section 4.02.17.</p> <p>C Ensure that the Work Lead is connected to the work piece and has a good connection to the work piece. Refer to Setup for MIG Section 5.13-5.18.</p> <p>D Ensure that the MIG torch is correctly connected to the Euro Style MIG Torch Adaptor. Refer to Section 4.02.16 & 5.06.</p>
2 Mains Supply Voltage is On, the On/Off switch on the rear panel is in the On position and the Power indicator on the front panel is illuminated however the power source will not STICK weld.	<p>A Power source is not in the correct mode of operation.</p> <p>B Work Lead is not connected to the work piece.</p>	<p>A Set the power source to STICK mode. Refer to Section 4.02.12.</p> <p>B Ensure that the Work Lead is connected to the work piece and has a good connection to the work piece.</p>
3 Mains Supply Voltage is On, the On/Off switch on the rear panel is in the On position and the Power indicator on the front panel is illuminated however the power source will not TIG weld.	<p>A Power source is not in the correct mode of operation.</p> <p>B Work Lead is not connected to the work piece.</p> <p>C TIG Torch 8 Pin Control Plug not connected correctly or loose/faulty connection in plug.</p> <p>D Faulty TIG Torch Trigger.</p>	<p>A Set the power source to LIFT TIG mode. Refer to Section 4.02.12.</p> <p>B Ensure that the Work Lead is connected to the work piece and has a good connection to the work piece.</p> <p>C Connect 8 Pin TIG Torch control plug securely and correctly to the 8 Pin control socket of the front of the Transmig 355i Power Source. Repair or replace if faulty.</p> <p>D Repair or replace TIG Torch Trigger switch/lead.</p>
4 Over Temp Indicator is illuminated and unit will not commence welding when the torch trigger switch is depressed.	Duty cycle of power source has been exceeded.	Leave the power source switched ON and allow it to cool. Note that Over Temp indicator must be extinguished prior to commencement of welding.

<p>5 Unit will not feed wire in MIG mode.</p>	<p>A Incorrect Feed Roll fitted for wire type being used.</p> <p>B Pressure Roller Arm is not secured in the down position or not correctly adjusted.</p> <p>C Electrode wire stuck in conduit liner or contact tip (burn-back jam).</p> <p>D The Wire Drive Motor 8A circuit breaker located in the Power Source Wire Drive Compartment has tripped.</p>	<p>A Fit the correct feed roll for MIG wire type being used. Refer to Section 2.11 for optional feed rolls available and Section 5.11 for feed roll fitting details.</p> <p>B Secure Pressure Roller in the down position and ensure that it is correctly adjusted. Refer to sections 5.09 and 5.10.</p> <p>C Check for clogged / kinked MIG torch conduit liner or worn contact tip. Replace faulty components.</p> <p>D Press in the 8A Circuit Breaker to reset it. If it does not reset or will still not feed wire, contact a Cigweld Service Provider.</p>
<p>6 Welding wire continues to feed when torch trigger is released.</p>	<p>A Trigger mode selection switch is in 4T latch mode.</p> <p>B Torch trigger leads shorted.</p>	<p>A Change the trigger mode selection switch from 4T latch mode to 2T normal mode.</p> <p>B Repair or replace torch trigger switch/lead.</p>
<p>7 Welding arc cannot be established in MIG mode.</p>	<p>A MIG torch polarity lead is not connected into a welding output terminal.</p> <p>B Poor or no work lead contact.</p>	<p>A Connect the MIG torch polarity lead to either the positive welding output terminal or the negative welding output terminal as required.</p> <p>B Clean work clamp area and ensure good electrical contact.</p>
<p>8 Inconsistent wire feed.</p>	<p>A Worn or dirty contact tip.</p> <p>B Worn feed roll.</p> <p>C Excessive brake tension on wire reel hub.</p> <p>D Worn, kinked or dirty conduit liner</p>	<p>A Replace if necessary.</p> <p>B Replace.</p> <p>C Reduce brake tension on spool hub</p> <p>D Clean or replace conduit liner</p>
<p>9 No gas flow in MIG mode.</p>	<p>A Gas hose is damaged.</p> <p>B Gas passage contains impurities.</p> <p>C Gas regulator turned off.</p> <p>D Empty gas cylinder.</p>	<p>A Replace or repair.</p> <p>B Disconnect gas hose from the rear of power source or wirefeeder and blow out impurities.</p> <p>C Turn on regulator.</p> <p>D Replace gas cylinder.</p>
<p>10 Gas flow continues after the torch trigger switch has been released (MIG mode).</p>	<p>Gas valve has jammed open due to impurities in the gas or the gas line.</p>	<p>Have an accredited CIGWELD service provider repair or replace gas valve.</p>
<p>11 Power indicator will not illuminate and welding arc cannot be established.</p>	<p>The mains supply voltage has exceeded voltage limits of the power source.</p>	<p>Ensure that the mains supply voltage is within 415VAC \pm 15%.</p>

12	TIG electrode melts when arc is struck.	TIG torch is connected to the (+) VE terminal.	Connect the TIG torch to the (-) VE terminal.
13	Arc flutters during TIG welding.	Tungsten electrode is too large for the welding current.	Select the correct size of tungsten electrode. Refer to Table 6-1.

Table 8-4

Error Code	CAUSE	REMEDY
1 Err102 Err103	Over temperature for IGBT or main transformer	A Duty cycle exceeded. Wait until the machine cools down.
		B Check front and rear Panel Air Louvers are clean and not blocked by any dirt or obstacles. If damaged they should be replaced by an Accredited Cigweld Service Provider.
		C Check that the fan is running normally during welding. If the fan is not running during welding it may be faulty and need replacing. Contact an accredited CIGWELD Service Provider.
2 Err107	Primary overcurrent	Turn the Power On/Off switch on the Rear of Power Source to the OFF position and wait a few minutes. Then turn the Power On/Off switch on the Rear of Power Source to the ON position. If this Err107 still occurs the power source may be faulty. Contact an Accredited Cigweld Service Provider.
3 Err311 Err314	Internal communication error	Reset to the Factory Default Settings, refer to Section 4.03. If after that this error still occurs contact an accredited CIGWELD service provider.
4 Err402	A Remote 10 pin mode is not selected if using the 4RX wirefeeder.	A Check if the Remote 10 Pin mode has been selected on the advanced menu. Refer to Section 4.03 Remote/ Local setting details.
	B The 4RX wirefeeder 10 Pin plug is not connected correctly to the power source 10 Pin socket.	B Ensure that the 10 Pin plug from the 4RX wirefeeder is correctly connected to the 10 Pin Power Source socket.
	C 10 Pin plug, Socket or control lead may be damaged.	C 10 Pin Plug, Socket or Lead may be damaged. Contact an accredited CIGWELD Service Provider.
5 Err601	Torch Trigger Signal Issue	A Check that the Torch Trigger Switch is not depressed On when the Power Source is first switch ON.
		B When releasing the trigger, check if the torch switch is short circuit.
		C Contact an accredited CIGWELD service provider.
6 Err801 Err802 Err803 Err804 Err805 Err806 Err807	Data communication error	A Turn Power Source OFF then back ON to see if this clears this error code. B Restore the Power Source back to factory default settings. Refer to Section 4.03 Page 4-14. C If the above steps do not correct this Contact a Cigweld Service Provider.

Table 8-5

SECTION 9: KEY SPARE PARTS

9.01 Tweco Fusion 400 Mig Torch

MIG Torch Part No: OTWF412X3545, 3.6 metre

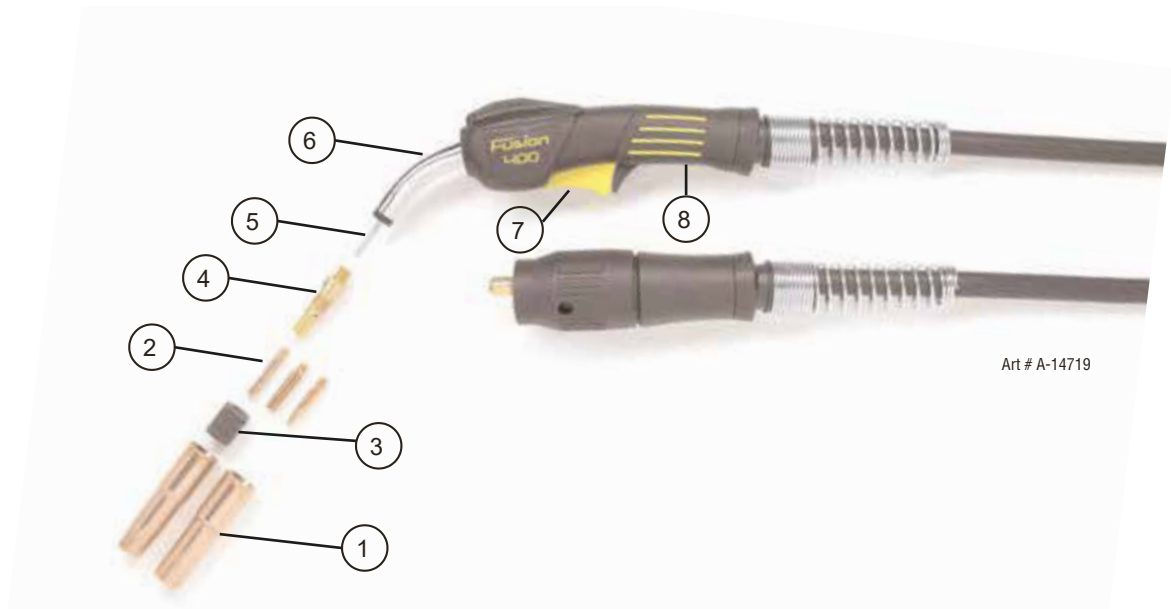
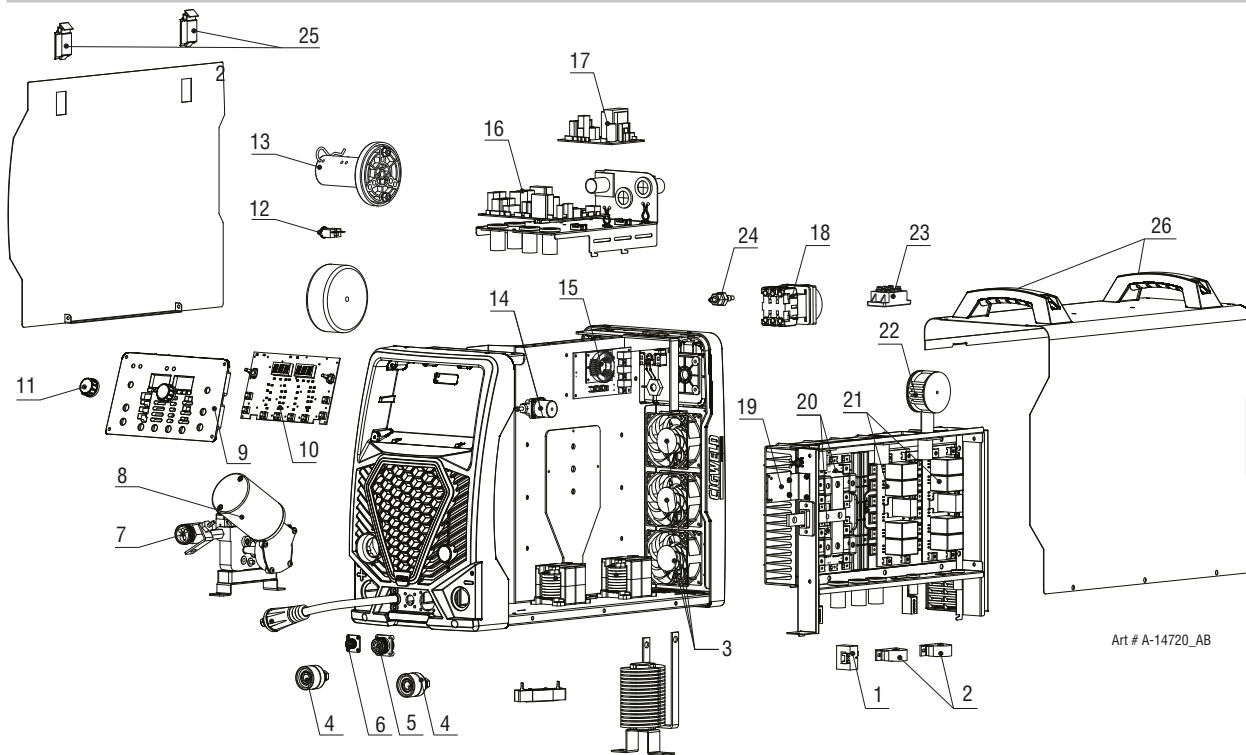


Figure 9-1

TWECO FUSION MIG TORCH PARTS		
ITEM	PART NO.	DESCRIPTION
1	717309	Nozzle 24AT/37/SS Tweco 4, TWE4 Adjustable 10mm Recess Tip
	OTW24A/50	Adjustable Nozzle 13mm
	OTW24A/62	Adjustable Nozzle 16mm
	OTW24AH/62	Adjustable Nozzle Heavy Duty 16mm
	OTW24AH/75	Adjustable Nozzle Heavy Duty 19mm
2	OTW14H/35	Contact Tip Heavy Duty 0.9mm
	OTW14H/40	Contact Tip Heavy Duty 1.0mm
	OTW14H/45	Contact Tip Heavy Duty 1.2mm
	OTW14H/116	Contact Tip Heavy Duty 1.6mm
	OTW14H/564	Contact Tip Heavy Duty 2.0mm
	OTW14T/30	Contact Tip 0.8mm Tapered
	OTW14T/35	Contact Tip 0.9mm Tapered
	OTW14T/45	Contact Tip 1.2mm Tapered
3	OTW34A	Insulator
4	OTW54A	Gas Diffuser
5	OTW44/3545	Liner 4.5M 0.9-1.2mm Hard
6	64J-45S	Conductor Tube 45 degree Steel Jacket
7	W7005001	Trigger Assembly
8	W7005000	Handle Moulding

Table 9-1

9.02 Power Source



Art # A-14720_AB

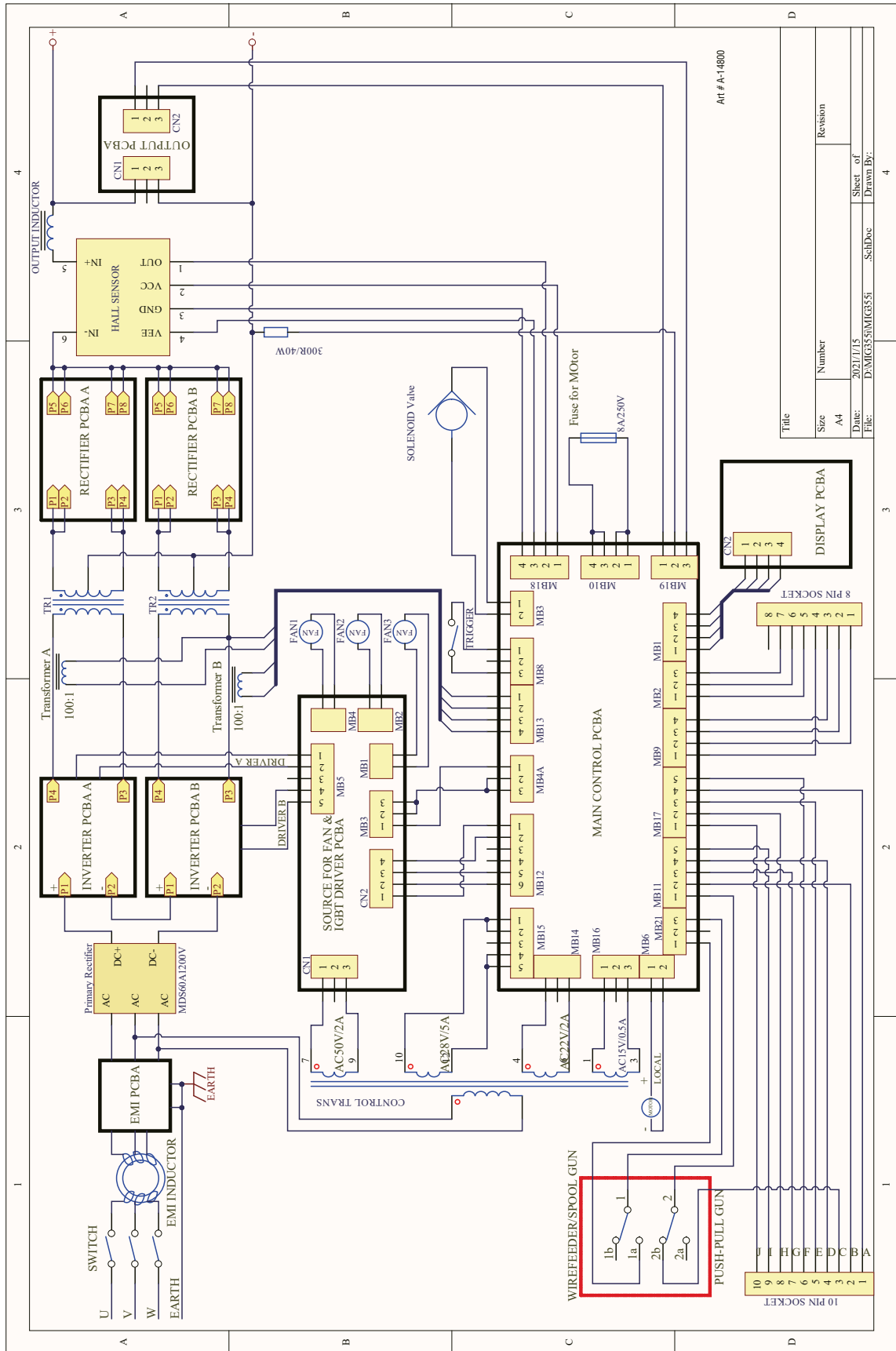
Figure 9-2

TRANSMIG 355i POWER SOURCE SPARE PARTS		
Item	Part Number	Description
1	W7006650	Current Sensor, Primary
2	W7006651	Current Transformer
3	W7006652	Fan
4	W7006658	Dinse Socket 50mm ²
5	W7006659	Control Socket 10 Pin
6	W7006660	Control Socket 8 Pin
7	W7006661	Adaptor, Euro
8	W7006662	Wiredrive Assembly
9	W7006663	Control Panel
10	W7006664	PCB Control
11	W7006665	Control Knob
12	W7006667	Circuit Breaker, 8A
13	W7006668	Spool Hub
14	W7006669	Gas Solenoid Valve
15	W7006670	PCB EMC
16	W7006671	PCB Control
17	W7006672	PCB Bias Supply
18	W7006673	Input Supply ON/OFF Switch
19	W7006675	PCB Filter
20	W7006676	PCB Output
21	W7006677	PCB Inverter
22	W7006678	Filter EMC
23	W7006679	Input Rectifier
24	W7006854	Gas Inlet Fitting
25	W7006874	Door Latch
26	W7006680	Handle
27	W7006681	Local/Remote Mode Switch (not shown)

Table 9-2 Key Spare Parts

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APPENDIX: TRANSMIG 355i CIRCUIT DIAGRAM



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CIGWELD – LIMITED WARRANTY TERMS

LIMITED WARRANTY: CIGWELD Pty Ltd, An ESAB Brand, hereafter, “CIGWELD” warrants to customers of its authorized distributors hereafter “Purchaser” 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 CIGWELD products as stated below, CIGWELD shall, upon notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with CIGWELD’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 CIGWELD’s sole option, of any components or parts of the product determined by CIGWELD to be defective.

CIGWELD 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: CIGWELD 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 CIGWELD 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 CIGWELD 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 CIGWELD 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 CIGWELD’S SOLE JUDGEMENT MAY IMPAIR THE SAFETY OR PERFORMANCE OF ANY CIGWELD 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 CIGWELD delivered the product to the authorized distributor.

Any claim under this warranty must be made within the warranty period which commences on the date of purchase of the product. To make a claim under the warranty, take the product (with proof of purchase from a Cigweld Accredited Seller) to the store where you purchased the product or contact Cigweld Customer Care 1300 654 674 for advice on your nearest Service Provider. CIGWELD reserves the right to request documented evidence of date of purchase. CIGWELD or our Accredited Distributor must be notified in writing of its claim within seven (7) days of becoming aware of the basis thereof, and at its own expense returning the goods which are the subject of the claim to CIGWELD or nominated Accredited Distributor/Accredited Service Provider

This warranty is given.

Cigweld Pty Ltd

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Victoria, Australia, 3072

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Email: enquiries@cigweld.com.au

Website: www.cigweld.com.au

This warranty is provided in addition to other rights and remedies you have under law: Our goods come with guarantees which cannot be excluded under the Australian Consumer Law. You are entitled to replacement or refund for a major failure and to compensation for other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

Please note that the information detailed in this statement supersedes any prior published data produced by CIGWELD.

WARRANTY SCHEDULE – TRANSMIG 355i

WARRANTY	WARRANTY PERIOD – (Parts and Labour)
Transmig 355i Inverter Power Source	3 Years
ACCESSORIES	WARRANTY PERIOD
MIG torch and work lead.	3 Months
MIG torch consumable items.	NIL
Gas regulator/flowmeter (excluding seat assembly, pressure gauges, elastomer seals and “O” rings).	1 Year
Regulator seat assemblies and pressure gauges.	6 Months
Elastomer seals and “O” rings used in the equipment.	3 Months

CIGWELD Limited Warranty does not apply to;

- Obsolete goods sold at auction, second-hand goods and prototype goods.
- Consumable Parts for MIG, TIG, Plasma welding, Plasma cutting and Oxy fuel torches, O-rings, fuses, filters or other parts that fail due to normal wear.

Note:

* No employee, agent, or representative of CIGWELD is authorized to change this warranty in any way or grant any other warranty, and CIGWELD shall not be bound by any such attempt. Correction of non-conformities, in the manner and time provided herein, constitutes fulfilment of CIGWELD's obligations to purchaser with respect to the product.

* This warranty is void, and seller bears no liability hereunder, if purchaser used replacement parts or accessories which, in CIGWELD's sole judgment, impaired the safety or performance of any CIGWELD product and if the unit is altered or serviced by an unauthorised CIGWELD Service Provider. Purchaser's rights under this warranty are void if the product is sold to purchaser by unauthorized persons.

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