

DESCRIPTION OF EQUIPMENT

ENCODER D Programming: Segment Select Welding: WFS/Amps Display Select		Ready	Preflow	Run-in	Weld	Crater fill	Burnback	Postflow	Recycle
ENCODER A Programming: Time	DISP A	Arc Hours (100s) (0-999)	Time (0-25.5 s; .1 s res)	Time (0-25.5 s; .1 s res)	Time (0-25.5 s; .1 s res)	Time (0-25.5 s; .1 s res)	Time (0-2.55 s; .01 s res)	Time (0-25.5 s; .1 s res)	Time (0-25.5 s; .1 s res)
ENCODER B Programming: Delay, Volts, Cyc Cnt Welding: Volt Trim	DISP B	Arc Hours (0-99.9)	Fault Delay (Optional) (0-25.5 secs)	Volts (Prog: 10.0-44.0 V .2 V Res) (Meter: 0-100V .1 V res)	Volts (Prog: 0-44.0 V .2 V Res) (Meter: 0-100V .1 V res)	Volts (Prog: 0-44.0 V .2 V Res) (Meter: 0-100V .1 V res)	Volts (Prog: 0-44.0 V .2 V Res) (Meter: 0-100V .1 V res)	OFF	Cycle Count (1-255)
ENCODER C Programming: Sch#, WFS, Sub Seg # Welding: WFS Trim	DISP C	Schedule Number (1-10)	Schedule Number (1-10 Weld Only)	WFS (0-887 IPM; 4" Res) (0-22.5 MPM; .1M res) Amps (0-800 A; 1 A res)	WFS (0-887 IPM; 4" Res) (0-22.5 MPM; .1M res) Amps (0-800 A; 1 A res)	WFS (0-887 IPM; 4" Res) (0-22.5 MPM; .1M res) Amps (0-800 A; 1 A res)	OFF	OFF	Weld Sub Seg Number (1-4)

Table 3-1

27. **POSTFLOW Light** — When lit, the control panel is in the postflow segment of the weld sequence. Consult Table 3-1 to determine the information displayed during this segment.

28. **BURNBACK Light** — When lit, the control panel is in the burnback segment of the weld sequence. Consult Table 3-1 to determine the information displayed during this segment.

29. **CRATER FILL Light** — When lit, the control panel is in the crater fill segment of the weld sequence. Consult Table 3-1 to determine the information displayed during this segment.

30. **WELD Light** — When lit, the control panel is in the weld segment of the weld sequence. Consult Table 3-1 to determine the information displayed during this segment.

31. **RUN IN Light** — When lit, the control panel is in the run in segment of the weld sequence. Consult Table 3-1 to determine the information displayed during this segment.

32. **PREFLOW Light** — When lit, the control panel is in the preflow segment of the weld sequence. Con-

sult Table 3-1 to determine the information displayed during this segment.

33. **READY Light** — When lit, the control panel is in the ready mode. Consult Table 3-1 to determine the information displayed during this segment.

34. **Center Encoder** — This encoder is used to change programmable information displayed in the center display. In order to increment the value displayed, turn the encoder clockwise (decrement is counterclockwise). Note that ARC HOURS X1 is not programmable, and thus cannot be changed by the encoder (in order to clear, consult the Soft Switch description section).

35. **Upper Encoder** — This encoder is used to change programmable information displayed in the upper display. In order to increment the value displayed, turn the encoder clockwise (to decrement, turn counterclockwise). Note that ARC HOURS X100 is not programmable, and thus cannot be changed by the encoder (in order to clear, consult the Soft Switch description section).

36. **ERROR Light** — When lit, the control panel has noted the occurrence of a ground fault or tolerance