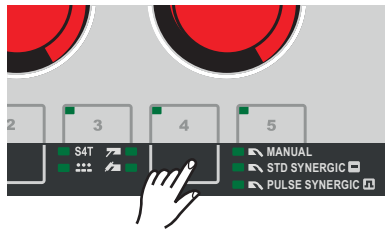


TRANSSTEEL 3000C PULSE

Quick Guide to Synergic Welding

1 Set the welding process



MANUAL The parameters for the welding power can be set individually.

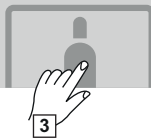
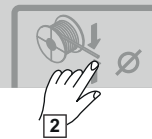
STD SYNERGIC When setting a welding power parameter, the remaining parameters are set automatically.

PULSE SYNERGIC Manual metal arc welding

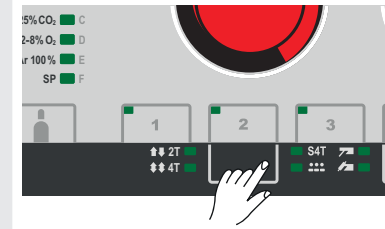
TIG welding

2 Set the filler metal and shielding gas

1	Steel/ER 70-120	inch	mm		
2	CrNi/Stainless	.030	0,8		
3	CuSi/ER CuSi-A	.035	0,9	CO ₂ 100%	A
4	AlMg/ER 5xxx	.040	1,0	Ar + 2-12% CO ₂	B
5	AlSi/ER 4xxx	.045	1,2	Ar + 13-25% CO ₂	C
6	Metal Cored	.052	1,4	Ar + 2-8% O ₂	D
7	Self-shielded	1/16	1,6	Ar 100%	E
8	SP	SP	SP	SP	F



3 Set the operating mode



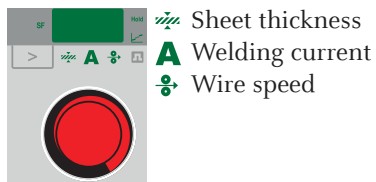
2T 2-step mode:
for short weld seams, tacking work

4T 4-step mode:
for longer weld seams, high level of comfort

S4T Special 4-step mode:
in addition to 4-step mode, offers settings for starting and final current

Settings for spot welding and stitch welding

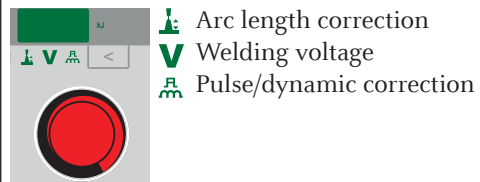
4 Set the welding power



> select desired parameter

set desired parameter

5 Set the correction parameters

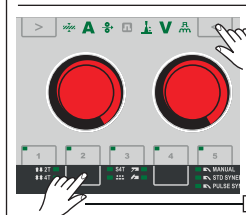


< select desired parameter

set desired parameter

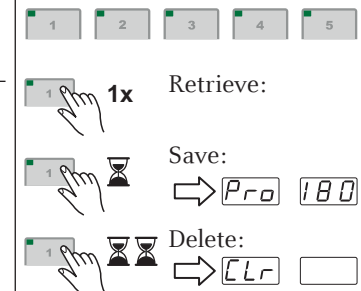
Measuring the welding circuit resistance r

According to the Operating Instructions of the power source



Activating/deactivating the key lock

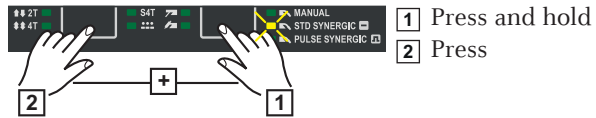
EasyJobs



TRANSSTEEL 3000C PULSE

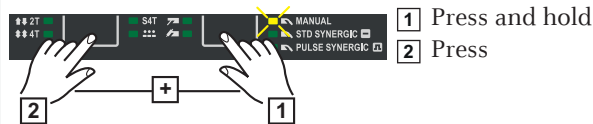
Description of Setup Parameters

MIG/MAG Synergic Setup menu



GP_r	Gas pre-flow time
GP_o	Gas post-flow time
SL	Slope (2-step, special 4-step)
I -S	Starting current (2-step, special 4-step)
I -E	Final current (2-step, special 4-step)
t-S	Starting current duration (2-step)
t-E	Final current duration (2-step)
Fd_i	Feeder inching speed
bbC	Burnback effect
i_{to}	Length of wire fed before the safety cut-out trips
SP_t	Spot welding time / interval welding time
SP_b	Interval pause time
i_{nt}	Interval
F	Frequency (SynchroPulse)
dFd	Delta wire feed (SynchroPulse)
RL₂	Upper arc length correction (SynchroPulse)
FAC	Reset power source to factory settings
2nd	2nd menu level
SEt	Country-specific setting (metric/imperial)
Syn	Synergic characteristics (EUr/US)
E-C	Cooling unit control
E-t	Cooling unit monitoring
r	Welding circuit resistance
L	Welding circuit inductivity
EnE	Electrical energy of the arc
RLC	Arc length correction via [V]

MIG/MAG Manual Setup menu

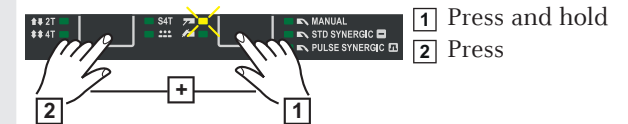


GP_r	Gas pre-flow time
GP_o	Gas post-flow time
Fd_i	Feeder inching speed
bbC	Burnback effect
i_{CC}	Ignition current
i_{to}	Length of wire fed before the safety cut-out trips
SP_t	Spot welding time / interval welding time
SP_b	Interval pause time
i_{nt}	Interval
FAC	Reset power source to factory settings
2nd	2nd menu level
SEt	Country-specific setting (metric/imperial)
E-C	Cooling unit control
E-t	Cooling unit monitoring
r	Welding circuit resistance
L	Welding circuit inductivity
EnE	Electrical energy of the arc

Exiting the Setup menu

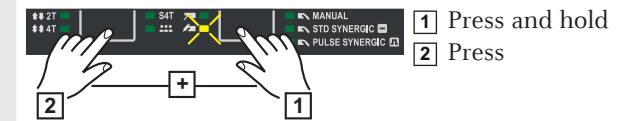


Rod electrode Setup menu



HCU	HotStart current
Ht_i	Hot current time
RS_t	Anti-stick
FAC	Reset power source to factory settings
2nd	2nd menu level
SEt	Country-specific setting (metric/imperial)
r	Welding circuit resistance
L	Welding circuit inductivity

TIG Setup menu



F-P	Pulse frequency	2nd	2nd menu level
tUP	UpSlope	SEt	Country-specific setting (metric/imperial)
tDo	DownSlope	E-C	Cooling unit control
I -S	Starting current	E-t	Cooling unit monitoring
I -2	Lowering current		
I -E	Final current		
GP_o	Gas post-flow time		
tAC	Tacking		
FAC	Reset power source to factory settings		

SAFETY

Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online. This document does not describe all the functions of the device. For a complete description of the device, refer to the Operating Instructions.

