

TransSteel 2200c

Quick Guide to synergic welding

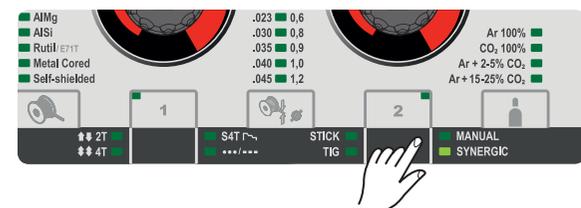


SAFETY

Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online.

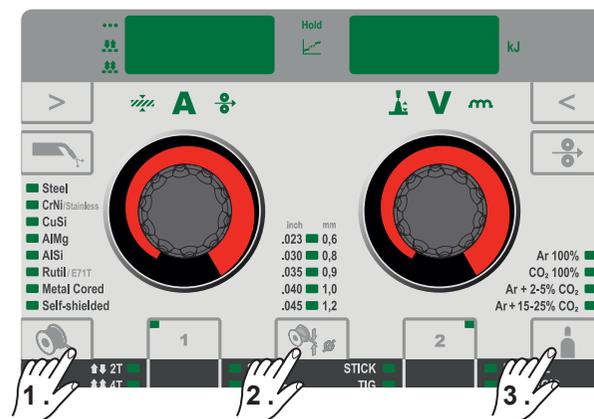
This document does not describe all the functions of the device. For a complete description of the device, refer to the Operating Instructions.

1 Set the synergic welding process

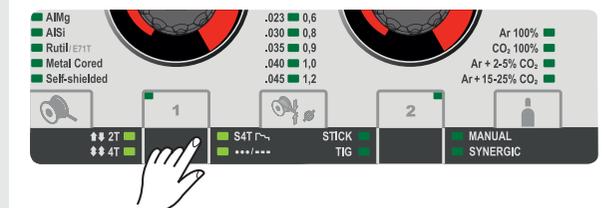


- SYNERGIC** When setting a welding power parameter, the remaining parameters are set automatically
- STICK** MMA welding
- TIG** TIG welding
- MANUAL** The welding power parameters can be adjusted individually

2 Set the filler metal and shielding gas

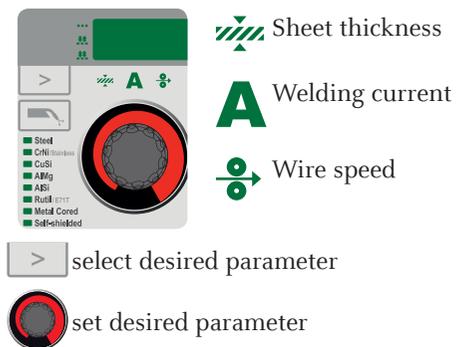


3 Set the operating mode



- 2T** 2-step mode: short weld seams, tacking work
- 4T** 4-step mode: longer weld seams, high level of comfort
- S4T** Special 4-step mode: additional settings for starting and final current
- Spot welding**: for overlapping sheets / stitch welding
- .../---** welding: light-gauge sheet welding and air-gap bridging

4 Set the welding power



Sheet thickness

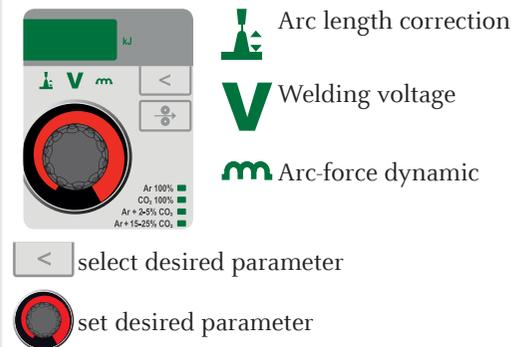
A Welding current

Wire speed

select desired parameter

set desired parameter

5 Adjust the parameters for correction



Arc length correction

V Welding voltage

m Arc-force dynamic

select desired parameter

set desired parameter

6 Optimise welding results

1. Measure the welding circuit resistance r
2. Set optimal mains fuse protection (FUS parameter in level 2 of the Setup menu)

The description of the aforementioned measures can be found in the Operating Instructions of the power source

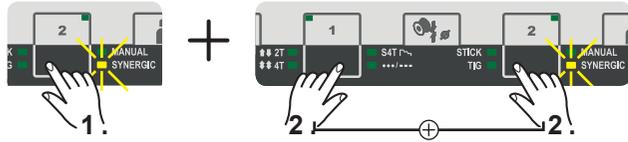


Operating Instructions:

www.fronius.com/transsteel-manuals



MIG/MAG Synergic Setup menu



Parameters:

- G P r* Gas pre-flow time
- G P o* Gas post-flow time
- S L* 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)
- F d ,* Feeder inching speed
- b b c* Burn-back effect
- l t o* Length of wire that is fed before the safety cut-out trips
- S P t* Spot welding time / interval welding time
- S P b* Interval pause time
- F A C* Restore factory setup

2nd Level 2 Setup menu

- S E t* Country-specific setting
- F U S* Mains fuse protection
- r* Welding circuit resistance
- L* Welding circuit inductivity
- E n E* Real Energy Input
- A L C* Arc length correction display

EasyJobs



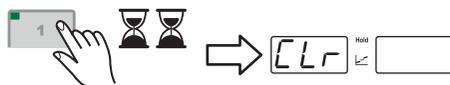
Retrieve:



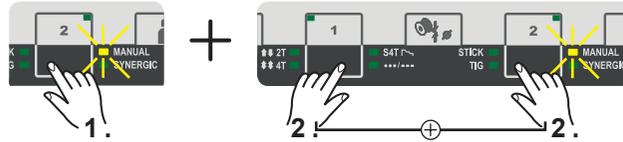
Save:



Delete:



MIG/MAG Manual Setup menu



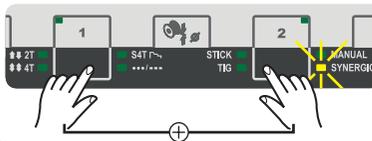
Parameters:

- G P r* Gas pre-flow time
- G P o* Gas post-flow time
- F d ,* Feeder inching speed
- b b c* Burn-back effect
- I G C* Ignition current
- l t o* Length of wire that is fed before the safety cut-out trips
- S P t* Spot welding time / interval welding time
- S P b* Interval pause time
- F A C* Restore factory setup

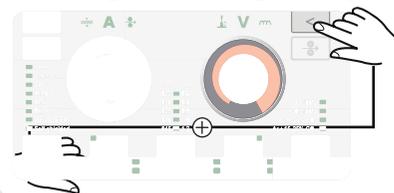
2nd Level 2 Setup menu

- S E t* Country-specific setting
- F U S* Mains fuse protection
- r* Welding circuit resistance
- L* Welding circuit inductivity
- E n E* Real Energy Input
- A L C* Arc length correction display

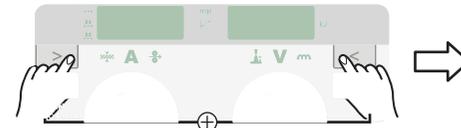
Exiting the Setup menu



Activating/deactivating the key lock



Display service parameters



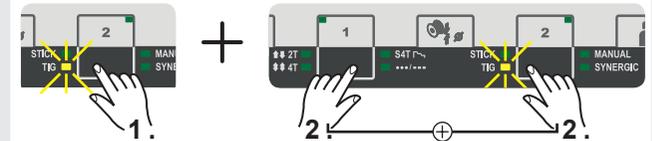
MMA Setup menu



Parameters:

- H C U* HotStart current
- H t ,* Hot current time
- A S t* Anti-stick
- F A C* Restore factory setup

TIG Setup menu



Parameters:

- F - P* Pulse frequency
- t U P* UpSlope
- t d o* DownSlope
- t - S* Starting current
- I - 2* Reduced current
- I - E* Final current
- G P o* Gas post-flow time
- t A C* Tacking
- F A C* Restore factory setup

2nd Level 2 Setup menu

- S E t* Country-specific setting
- F U S* Mains fuse protection

Available parameters:

Example of display:

Firmware version	1.00	421
Welding program configuration	3	445
Current welding program	r 2	290
Motor current for wire drive in ampere	l Fd	00
Arc time in hours	654	321
2nd menu level (Service)	2nd	