

TransSteel 2200

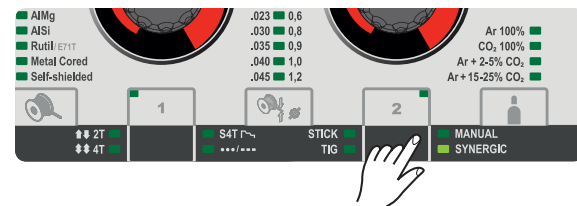
Quick Guide to synergic welding



SAFETY

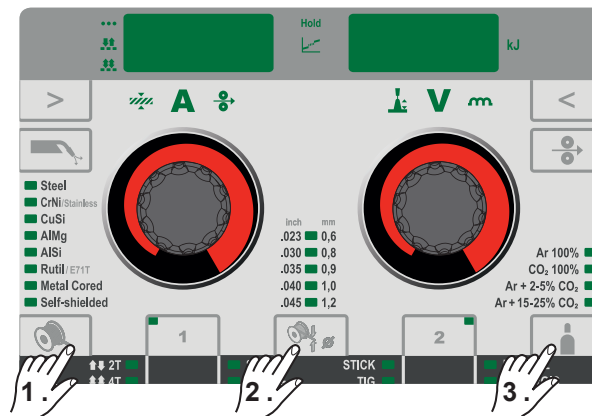
Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online. This document does not describe all the functions of the device. For a complete description of the device, refer to the Operating Instructions.

1 Set the synergic welding process

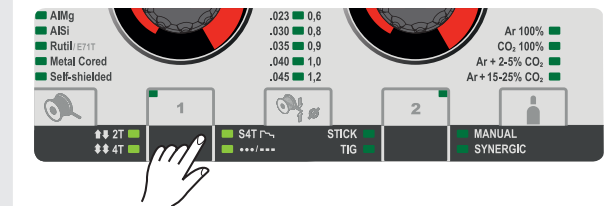


- SYNERGIC** When setting a welding power parameter, the remaining parameters are set automatically
- STICK** MMA welding
- TIG** TIG welding
- MANUAL** The welding power parameters can be adjusted individually

2 Set the filler metal and shielding gas

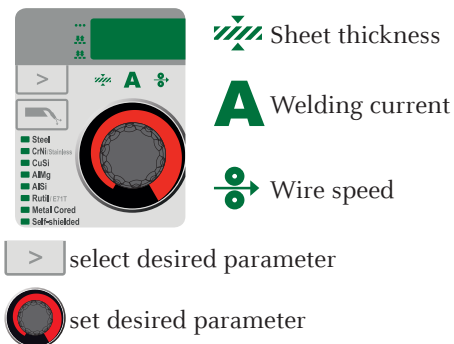


3 Set the operating mode



- 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: light-gauge sheet welding and air-gap bridging

4 Set the welding power



Sheet thickness

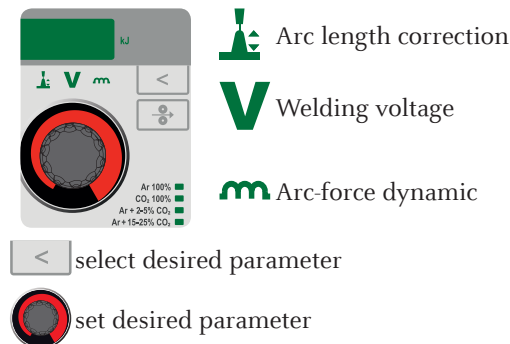
A Welding current

W 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 the mains fuse so that the device switches off before the mains fuse trips.

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

Operating Instructions:

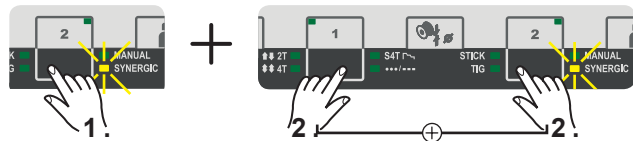


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transsteel

MIG/MAG Synergic Setup menu



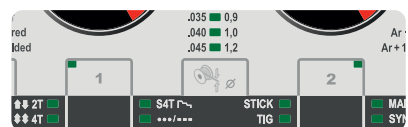
Parameters:

- $\bar{G} P r$ Gas pre-flow time
- $\bar{G} P o$ 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
- $I t o$ 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
- $I n t$ Operating mode for stitch welding
- $F A C$ Restore factory setup

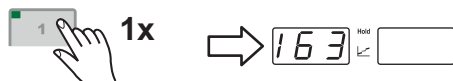
2nd Level 2 Setup menu

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

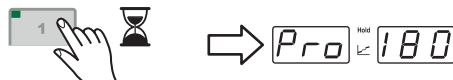
EasyJobs



Retrieve:



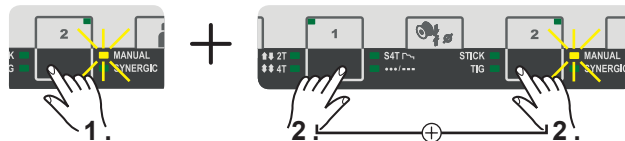
Save:



Delete:



MIG/MAG Manual Setup menu



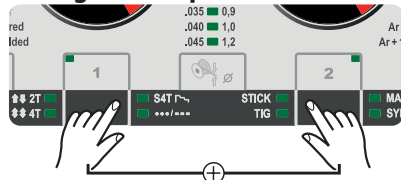
Parameters:

- $\bar{G} P r$ Gas pre-flow time
- $\bar{G} P o$ Gas post-flow time
- $F d$ Feeder inching speed
- $I G c$ Ignition current
- $I t o$ 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
- $I n t$ Operating mode for stitch welding
- $F A C$ Restore factory setup

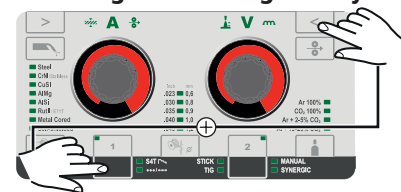
2nd Level 2 Setup menu

- $S E t$ Country-specific setting
- r Welding circuit resistance
- L Welding circuit inductivity
- $E n E$ Real Energy Input
- $F U S$ Mains fuse protection

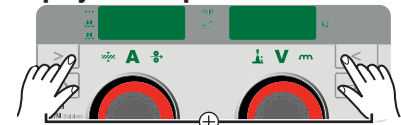
Exiting the Setup menu



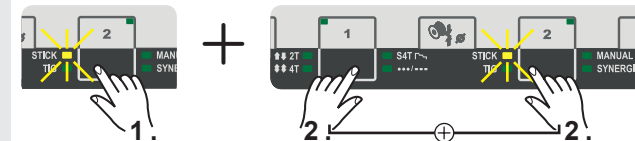
Activating/deactivating the key lock



Display service parameters



MMA Setup menu



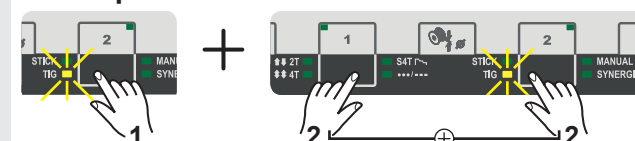
Parameters:

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

2nd Level 2 Setup menu

- $S E t$ Country-specific setting
- r Welding circuit resistance
- L Welding circuit inductivity
- $F U S$ Mains fuse protection

TIG Setup menu



Parameters:

- $F - P$ Pulse frequency
- $t U P$ UpSlope
- $t d o$ DownSlope
- $I - S$ Starting current
- $I - 2$ Reduced current
- $I - E$ Final current
- $\bar{G} P o$ 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:

Firmware version	1.00	421
Welding program configuration	3	445
Current welding program	r 2	290
Arc time in hours	654	321
Motor current for wire drive in ampere	1 Fd	00
2nd menu level (Service)	2nd	