

TransSteel 3000C Pulse

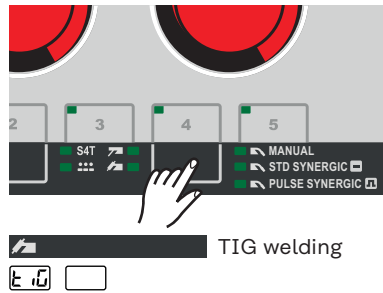
Quick Guide to Synergic Welding



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 welding process

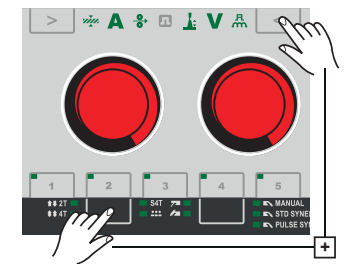


- MANUAL** (MAN, URL) The parameters for the welding power can be set individually.
- STD SYNERGIC** (Stn, lrd) When setting a welding power parameter, the remaining parameters are set automatically.
- PULSE SYNERGIC** (PUL, SE)

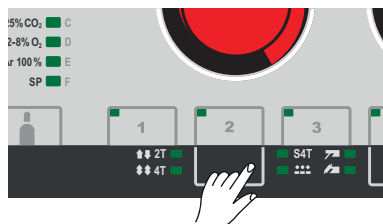
2 Set the filler metal and shielding gas

| | inch | mm | | |
|-------------------|------|-----|-----------------------------|---|
| 1 Steel/ER 70-120 | | | | |
| 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 AISi/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 |

Activating/deactivating the key lock



3 Set the operating mode

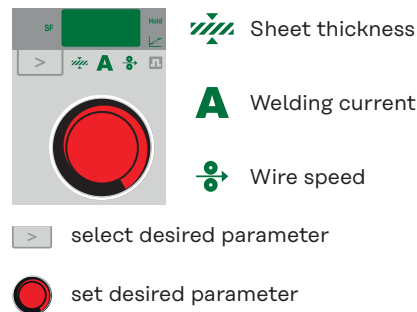


- 2-step mode:** (2T) for short weld seams, tacking work
- 4-step mode:** (4T) for longer weld seams, high level of comfort
- S4T** Special 4-step mode: in addition to 4-step mode, offers settings for starting and final current
- Int** Settings for spot welding and stitch welding

Measuring the welding circuit resistance r

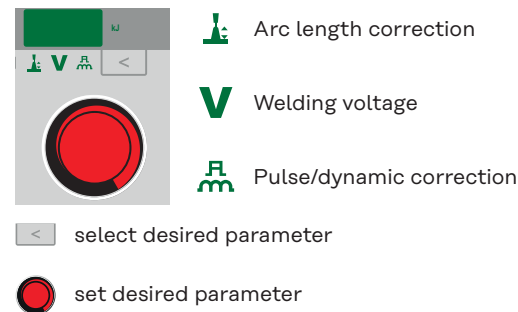
According to the Operating Instructions of the power source

4 Set the welding power



- > select desired parameter
- set desired parameter

5 Set the correction parameters



- < select desired parameter
- set desired parameter

i Operating Instructions

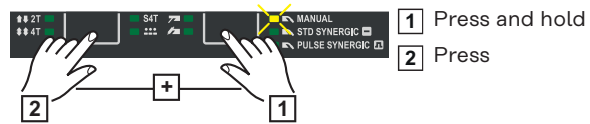


<https://manuals.fronius.com/html/4204260354>



Description of Setup Parameters

MIG/MAG Manual Setup menu



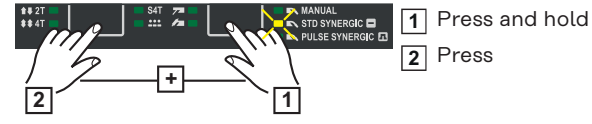
1st menu level

- GP_r** Gas pre-flow time
- GP_o** Gas post-flow time
- Fd_i** Feeder inching speed
- bbC** Burnback effect
- iGC** Ignition current
- i_{to}** Length of wire fed before the safety cut-out trips
- SPT** Spot welding time / interval welding time
- SPb** Interval pause time
- int** Interval
- FAC** Reset power source to factory settings

2nd menu level

- SEt** Country-specific setting (metric/imperial)
- C-C** Cooling unit control
- C-t** Cooling unit monitoring
- r** Welding circuit resistance
- L** Welding circuit inductivity
- EnE** Electrical energy of the arc
- EJt** EasyJob Trigger

MIG/MAG Synergic Setup menu



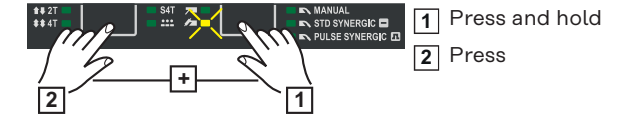
1st menu level

- 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
- SPT** Spot welding time / interval welding time
- SPb** Interval pause time
- int** Interval
- F** Frequency (SynchroPulse)
- dFd** Delta wire feed (SynchroPulse)
- AL2** Upper arc length correction (SynchroPulse)
- FAC** Reset power source to factory settings

2nd menu level

- SEt** Country-specific setting (metric/imperial)
- Syn** Synergic characteristics (EUr/US)
- C-C** Cooling unit control
- C-t** Cooling unit monitoring
- r** Welding circuit resistance
- L** Welding circuit inductivity
- EnE** Electrical energy of the arc
- ALC** Arc length correction via [V]
- EJt** EasyJob Trigger

TIG Setup menu



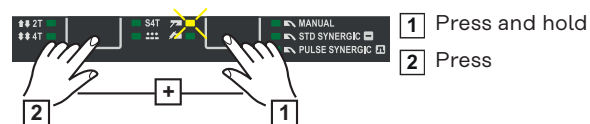
1st menu level

- F-P** Pulse frequency
- tUP** UpSlope
- tDO** DownSlope
- i-S** Starting current
- i-2** Lowering current
- i-E** Final current
- GP_o** Gas post-flow time
- tAC** Tacking
- FAC** Reset power source to factory settings

2nd menu level

- SEt** Country-specific setting (metric/imperial)
- C-C** Cooling unit control
- C-t** Cooling unit monitoring

Rod electrode Setup menu



1st menu level

- HCU** HotStart current
- Ht_i** Hot current time
- ASt** Anti-stick
- FAC** Reset power source to factory settings

2nd menu level

- SEt** Country-specific setting (metric/imperial)
- r** Welding circuit resistance
- L** Welding circuit inductivity

Exiting the Setup menu



EasyJobs



Retrieve  **1x**

Save    **Pro 180**

Delete     **CLr** 