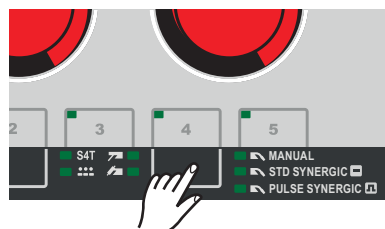


TRANSSTEEL 3000C PULSE

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.

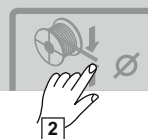
PULSE SYNERGIC

MAN Manual metal arc welding

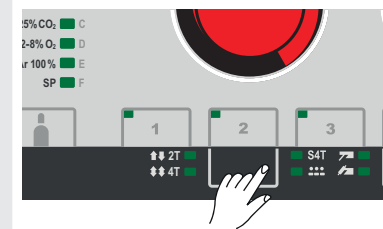
TIG TIG welding

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

SP Settings for spot welding and stitch welding

4 Set the welding power



Sheet thickness
A Welding current
W Wire speed

> select desired parameter

set set desired parameter

5 Set the correction parameters



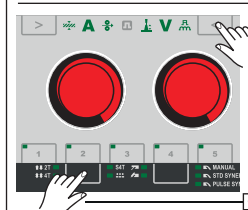
Δ Arc length correction
V Welding voltage
Δ Pulse/dynamic correction

< select desired parameter

set set desired parameter

Measuring the welding circuit resistance r

According to the Operating Instructions of the power source



Activating/deactivating the key lock

EasyJobs

1	2	3	4	5
1x	Retrieve:			
1	Save:	Pro	180	
1	Delete:	Clr		



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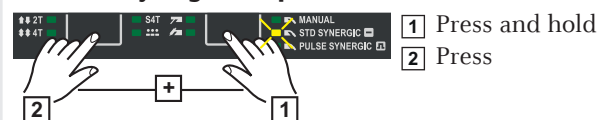
Operating Instructions:
www.fronius.com/transsteel



TRANSSTEEL 3000C PULSE

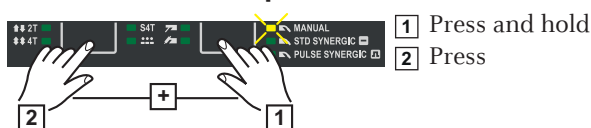
Description of Setup Parameters

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)
- FRC** Reset power source to factory settings
- 2nd** 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
- RLC** Arc length correction via [V]

MIG/MAG Manual Setup menu

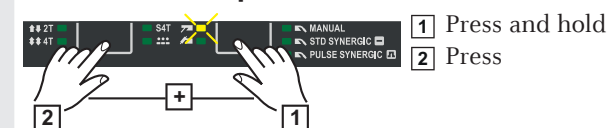


- GP_r** Gas pre-flow time
- GP_o** Gas post-flow time
- Fd_i** Feeder inching speed
- bbC** Burnback effect
- i_{CC}** Ignition current
- i_{to}** Length of wire fed before the safety cut-out trips
- SP_t** Spot welding time / interval welding time
- SP_b** Interval pause time
- i_{nt}** Interval
- FRC** Reset power source to factory settings
- 2nd** 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

Exiting the Setup menu

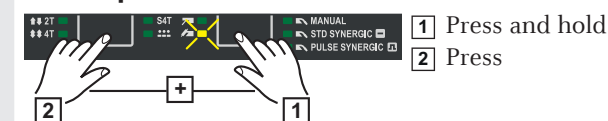


Rod electrode Setup menu



- HCU** HotStart current
- Ht_i** Hot current time
- RS_t** Anti-stick
- FRC** 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
- tUP** UpSlope
- tDo** DownSlope
- I -S** Starting current
- I -2** Lowering current
- I -E** Final current
- GP_o** Gas post-flow time
- tARC** Tacking
- FRC** Reset power source to factory settings
- 2nd** 2nd menu level
- SEt** Country-specific setting (metric/imperial)
- C-C** Cooling unit control
- C-t** Cooling unit monitoring

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.

