



Arc Quip cc

PO Box 1681, Fourways, 2055

Unit 70D, Van Dyk Secure Business Park, cnr Van Dyk & Brakpan rd
Boksburg

Tel: 011 914 4696

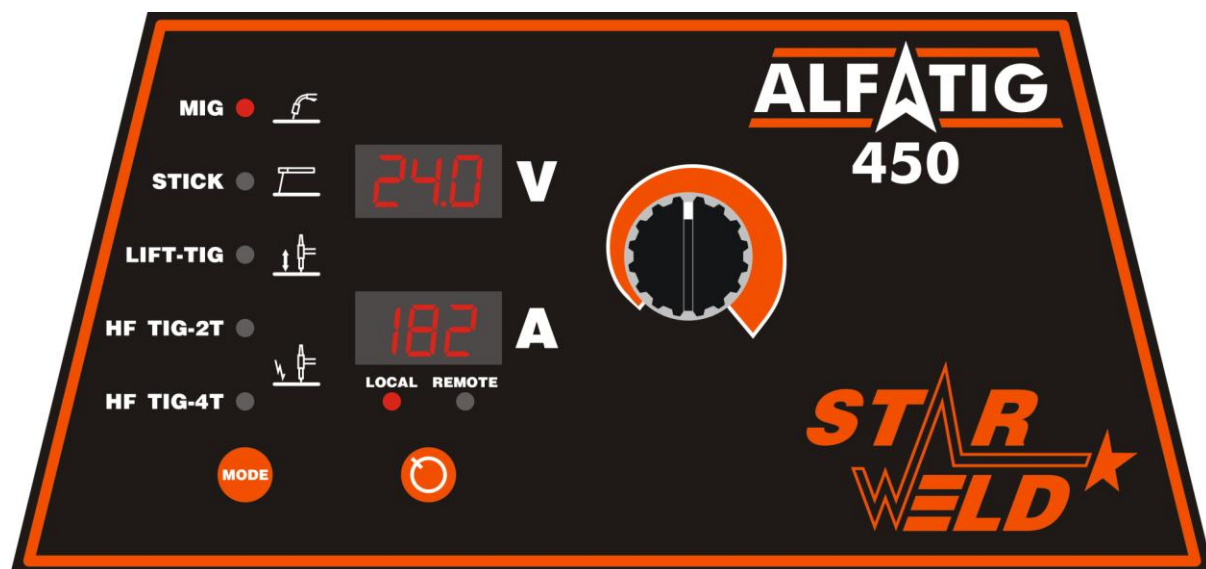
Fax: 011 914 3224



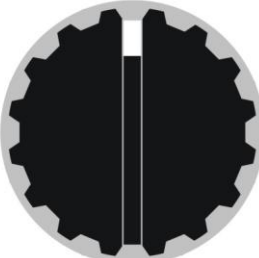
Email: sales@starweld.co.za



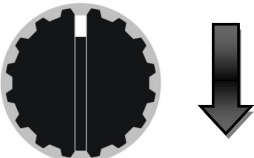
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STARWELD ALFATIG 450 OPERATION

CONTROL PANEL



<p>MODE BUTTON</p>		<p>This button is used when selecting the Welding Process to be used. With each press of the button, one scrolls down through the modes. An accompanying LED indicates the selected mode.</p>
<p>LOCAL/REMOTE BUTTON</p>		<p>Used to select the input reference. Either from the main encoder (local) or from a suitable remote controlling device. When in the TIG and Stick modes the remote device will control from 0 – local setting.</p>
<p>ENCODER</p>		<p>This control is used to select the required Amperage or Voltage to be used. The Encoder is also used to set values in Menu Settings. (To be discussed later)</p>

DIGITAL DISPLAYS		In the MIG mode the preset welding voltage is displayed before welding commences, once welding the actual voltage is displayed. All other modes displays the actual voltage.
		Before welding the preset welding current is displayed, once welding the actual current is displayed.
MENU BUTTON		This button allows for the setting of the various welding parameters, subject to the selected mode.

MENU OPERATION

METHOD	<ol style="list-style-type: none"> 1. Push the Menu Button twice. 2. Use the Encoder to select the parameter to be set. (This will appear on the Voltage Display) 3. Push the Menu Button a second time. 4. The parameter in the Voltage Display will begin to flash, indicating that this has been selected for change. 5. Use the Encoder to now adjust this parameter. 6. After the desired value is selected, press the Menu Button again, to exit.
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PARAMETERS OPTIONS

MIG Process	SLOPE <i>SLP</i>	Setting: 1 – 10 This is an inductance control that sets the speed at which the current picks up, after each short of the arc. A high setting is recommended for Aluminium and a low setting for Steels.
Stick Process	DIG	Setting: 1 – 10 Controls the amount of added current during the deposition of welding material to prevent freezing of the puddle. The higher the setting, the greater the added current.
Lift TIG Process	Nothing	
HF TIG Process	2T	Manually trigger controlled DC TIG
	4T	Latched trigger controlled DC TIG
	PREFLOW <i>PrE</i>	Setting: 0.1 – 5.0 s Preflow shown as seconds.
	BEGINNING	Setting: 10 – 100 %

	CURRENT	Starting current. This is the initial current, as a percentage of requested local setting. Eg. 30% of the requested 120amps, will be 36 amps.
	RAMP UP <i>rUP</i>	Setting: 0.1 – 10.0 s Ramp up, shown as the number of seconds taken to reach the requested amperage setting.
	RAMP DOWN <i>rDn</i>	Setting: 1 – 30 s Ramp down, shown as the number of seconds, taken to decrease down to the finishing current (end) current.
	END CURRENT <i>End</i>	Setting: 10 – 100 % Finishing (crater fill) current, set as a percentage of the requested operating current.
	PULSE ON / OFF <i>PUL</i>	Setting: On / Off Turns built-in pulsing on or off.
	PULSE FREQUENCY <i>PUF</i>	Setting: 0.5 – 10.0 Hz Pulse frequency in Hertz (cycles per second)
	PULSE DUTY <i>PUd</i>	Setting: 20 – 80 % Pulse duty cycle. A high value leads to a longer duration of peak current.
	BASE CURRENT <i>ILo</i>	Setting: 20 – 100 % Base current as a percentage of the requested current setting.