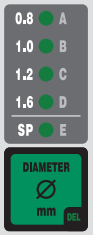
TransPuls Synergic
TransSynergic Comfort

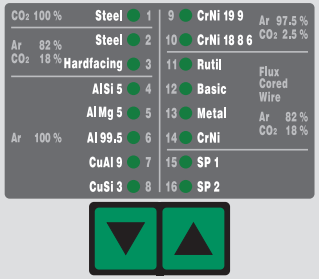
Quick Reference: English

1 Setting the wire diameter



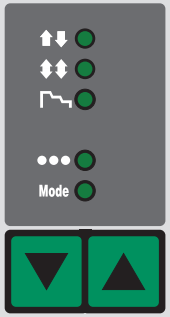
Special diameter

2 Specifying the filler metal and shielding gas



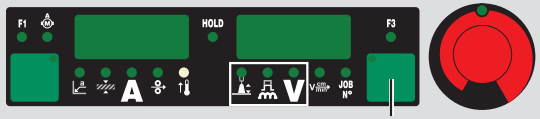
Special setting

3 Setting the mode



2-step mode
4-step mode
Special 4-step mode
(Aluminium welding start-up)
Spot welding
Special function

6 Correcting parameters

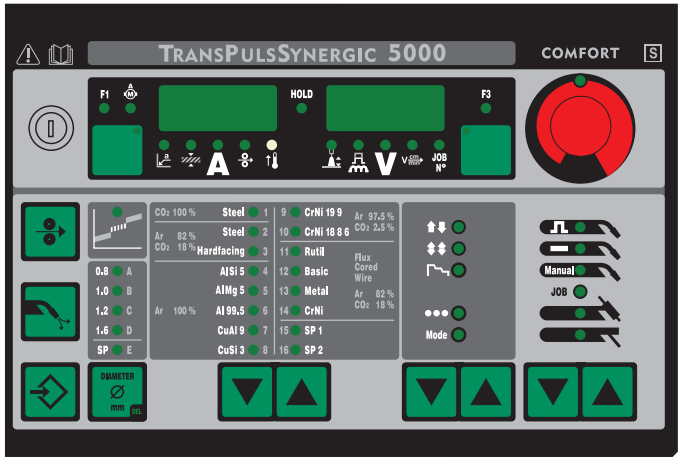


- select desired parameter
- correct desired parameter

Arc length correction

Arc-force dynamic correction / pulse correction / arc-force dynamic

Arc voltage



1-**6** Commissioning sequence

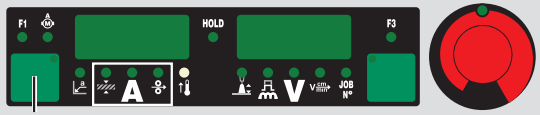
Follow operating instructions

Feeder inching

Gas test

Setup/store

5 Setting the welding power



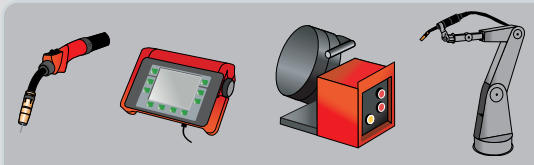
- select desired parameter
- set desired parameter

Specify sheet thickness

Specify welding current

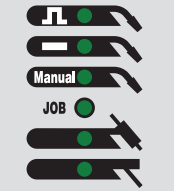
Specify wire feed speed

Important! In synergic mode, all the remaining parameters are set automatically.



Note! If external system components are connected, some parameters can be modified on those components. The power source control panel is only for display purposes.

4 Selecting the process



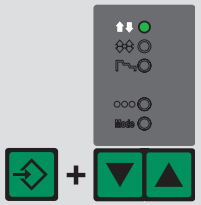
MIG/MAG pulse synergic
MIG/MAG standard synergic
MIG/MAG standard manual
Job mode
TIG
Rod electrode (MMA)

Fronius International GmbH, www.fronius.com

TransPuls Synergic
TransSynergic Comfort

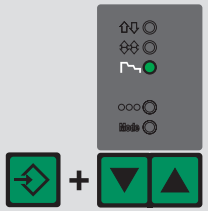
Quick Reference: English

MIG/MAG - setup
2-step mode



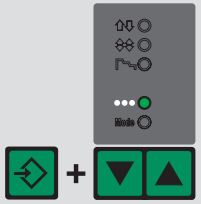
I-S	Starting current
SL	Slope
I-E	final current
t-S	time - starting current
t-E	time - end current

MIG/MAG - setup
Special 4-step mode



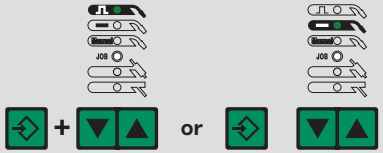
I-S	Starting current
SL	Slope
I-E	final current

MIG/MAG - setup
Spot welding



SPt	Spot-welding time

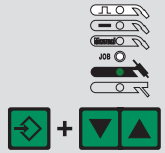
MIG/MAG - setup
Procedure



GPr	Gas pre-flow time
GPo	Gas post-flow time
Fdc	Wire feeder creep
Fd,	Feeder inching speed
bbc	Burn back correction
ALS	Hotstart current *
ALt	Hotstart time *
F	Frequency **
dFd	Wirefeed deviation **
AL.2	Arc length correction
FAC	Return to factory setting
2nd	**2nd menu level**
PPU	Select push-pull unit
C-C	Cooling unit control
C-t	Cooling unit watchdog
,to	Ignition timeout
Arc	Arc-break watchdog
FCO	Wire-end settings
SEt	Country setting
S2t	Special 2-step variants
S4t	Special 4-step variants
Gun	JobMaster mode select.
r	Welding cct resistance
L	Welding cct inductivity
COr	Gas correction ***

* only for standard synergic process
** only with SynchroPuls option
*** only with digital gas control option

WIG - setup

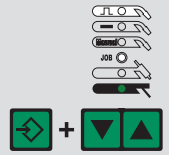


2nd	**2nd menu level**
C-C	Cooling unit control
C-t	Cooling unit watchdog
CSS	Comfort stop sensitivity
r	Welding cct resistance
L	Welding cct inductivity

Gas - setup

GPr	Gas pre-flow time
GPo	Gas post-flow time
GPU	Gas flushing
GAS	Gas flow rate ***

Electrode - setup

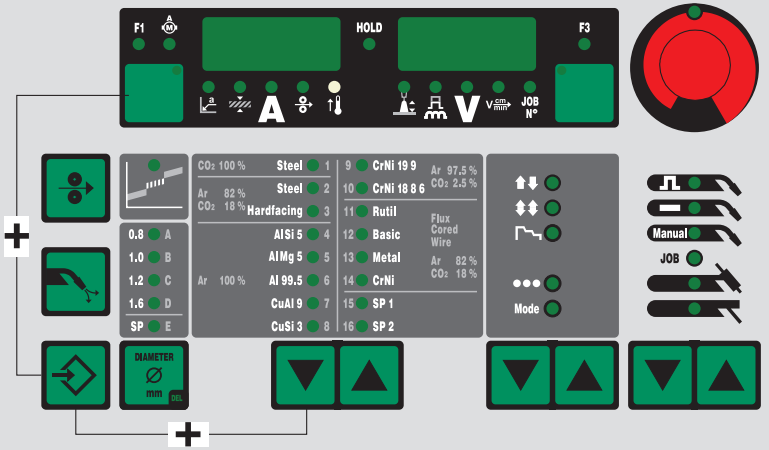


HCU	Hotstart current
Ht,	Hotstart time
2nd	**2nd menu level**
r	Welding cct resistance
L	Welding cct inductivity
EIn	Characteristic selection
ASt	Anti-stick
Uco	Break voltage

Exit setup

Exit setup
Save job

Job correction
For details of Job mode and Job correction, see operating instructions



Display firmware versions

Power source firmware	e.g.	3.2.4 .0.7.0
Wirefeeder firmware	e.g.	A.2.0 1.0.1
Welding database	e.g.	0 1.6.4
Total welding time	e.g.	0.0.3 5.2.8