



EN

Welding machine

Pico 160 cel puls

Pico 160 cel puls VRD (RU)

Pico 160 cel puls VRD (AUS)

099-002129-EW501

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19.09.2023

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General instructions

WARNING



Read the operating instructions!

The operating instructions provide an introduction to the safe use of the products.

- Read and observe the operating instructions for all system components, especially the safety instructions and warning notices!
- Observe the accident prevention regulations and any regional regulations!
- The operating instructions must be kept at the location where the machine is operated.
- Safety and warning labels on the machine indicate any possible risks. Keep these labels clean and legible at all times.
- The machine has been constructed to state-of-the-art standards in line with any applicable regulations and industrial standards. Only trained personnel may operate, service and repair the machine.
- Technical changes due to further development in machine technology may lead to a differing welding behaviour.

In the event of queries on installation, commissioning, operation or special conditions at the installation site, or on usage, please contact your sales partner or our customer service department on +49 2680 181-0.

A list of authorised sales partners can be found at www.ewm-group.com/en/specialist-dealers.

Liability relating to the operation of this equipment is restricted solely to the function of the equipment. No other form of liability, regardless of type, shall be accepted. This exclusion of liability shall be deemed accepted by the user on commissioning the equipment.

The manufacturer is unable to monitor whether or not these instructions or the conditions and methods are observed during installation, operation, usage and maintenance of the equipment.

An incorrectly performed installation can result in material damage and injure persons as a result. For this reason, we do not accept any responsibility or liability for losses, damages or costs arising from incorrect installation, improper operation or incorrect usage and maintenance or any actions connected to this in any way.

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Data security

The user is responsible for backing up data of all changes from the factory setting. The user is liable for erased personal settings. The manufacturer does not assume any liability for this.

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2 For your safety

2.1 Notes on using these operating instructions

DANGER

Working or operating procedures which must be closely observed to prevent imminent serious and even fatal injuries.

- Safety notes include the "DANGER" keyword in the heading with a general warning symbol.
- The hazard is also highlighted using a symbol on the edge of the page.

WARNING

Working or operating procedures which must be closely observed to prevent serious and even fatal injuries.

- Safety notes include the "WARNING" keyword in the heading with a general warning symbol.
- The hazard is also highlighted using a symbol in the page margin.

CAUTION

Working or operating procedures which must be closely observed to prevent possible minor personal injury.

- The safety information includes the "CAUTION" keyword in its heading with a general warning symbol.
- The risk is explained using a symbol on the edge of the page.



Technical aspects which the user must observe to avoid material or equipment damage.

Instructions and lists detailing step-by-step actions for given situations can be recognised via bullet points, e.g.:

- Insert the welding current lead socket into the relevant socket and lock.

2.2 Explanation of icons

Symbol	Description	Symbol	Description
	Indicates technical aspects which the user must observe.		Activate and release / Tap / Tip
	Switch off machine		Release
	Switch on machine		Press and hold
	Incorrect / Invalid		Switch
	Correct / Valid		Turn
	Input		Numerical value – adjustable
	Navigation		Signal light lights up in green
	Output		Signal light flashes green
	Time representation (e.g.: wait 4 s / actuate)		Signal light lights up in red
	Interruption in the menu display (other setting options possible)		Signal light flashes red
	Tool not required/do not use		Signal light lights up in blue
	Tool required/use		Signal light flashes blue

2.3 Safety instructions

WARNING



Risk of accidents due to non-compliance with the safety instructions!
Non-compliance with the safety instructions can be fatal!

- Carefully read the safety instructions in this manual!
- Observe the accident prevention regulations and any regional regulations!
- Inform persons in the working area that they must comply with the regulations!



Risk of injury from electrical voltage!

Voltages can cause potentially fatal electric shocks and burns on contact. Even low voltages can cause a shock and lead to accidents.

- Never touch live components such as welding current sockets or stick, tungsten or wire electrodes!
- Always place torches and electrode holders on an insulated surface!
- Wear the full personal protective equipment (depending on the application)!
- The machine may only be opened by qualified personnel!
- The device must not be used to defrost pipes!



Hazard when interconnecting multiple power sources!

If a number of power sources are to be connected in parallel or in series, only a technical specialist may interconnect the sources as per standard IEC 60974-9:2010: Installation and use and German Accident Prevention Regulation BVG D1 (formerly VBG 15) or country-specific regulations.

Before commencing arc welding, a test must verify that the equipment cannot exceed the maximum permitted open circuit voltage.

- Only qualified personnel may connect the machine.
- When taking individual power sources out of operation, all mains and welding current leads must be safely disconnected from the welding system as a whole. (Hazard due to reverse polarity voltage!)
- Do not interconnect welding machines with pole reversing switch (PWS series) or machines for AC welding since a minor error in operation can cause the welding voltages to be combined, which is not permitted.



Risk of injury due to radiation or heat!

Arc radiation can lead to skin and eye injuries.

Contact with hot workpieces and sparks can lead to burns.

- Use hand shield or welding helmet with the appropriate safety level (depends on the application).
- Wear dry protective clothing (e.g. hand shield, gloves, etc.) in accordance with the applicable regulations of your country.
- Persons who are not directly involved should be protected with a welding curtain or suitable safety screen against radiation and the risk of blinding!

WARNING



Risk of injury due to improper clothing!

During arc welding, radiation, heat and voltage are sources of risk that cannot be avoided. The user has to be equipped with the complete personal protective equipment at all times. The protective equipment has to include:

- Respiratory protection against hazardous substances and mixtures (fumes and vapours); otherwise implement suitable measures such as extraction facilities.
- Welding helmet with proper protection against ionizing radiation (IR and UV radiation) and heat.
- Dry welding clothing (shoes, gloves and body protection) to protect against warm environments with conditions comparable to ambient temperatures of 100 °C or higher and arcing and work on live components.
- Hearing protection against harming noise.



Explosion risk!

Apparently harmless substances in closed containers may generate excessive pressure when heated.

- Move containers with inflammable or explosive liquids away from the working area!
- Never heat explosive liquids, dusts or gases by welding or cutting!



Fire hazard!

Due to the high temperatures, sparks, glowing parts and hot slag that occur during welding, there is a risk of flames.

- Be watchful of potential sources of fire in the working area!
- Do not carry any easily inflammable objects, e.g. matches or lighters.
- Ensure suitable fire extinguishers are available in the working area!
- Thoroughly remove any residue of flammable materials from the workpiece prior to starting to weld.
- Only further process workpieces after they have cooled down. Do not allow them to contact any flammable materials!

⚠ CAUTION**Smoke and gases!**

Smoke and gases may lead to shortness of breath and poisoning! The ultraviolet radiation of the arc may also convert solvent vapours (chlorinated hydrocarbon) into poisonous phosgene.

- Ensure sufficient fresh air!
- Keep solvent vapours away from the arc beam field!
- Wear suitable respiratory protection if necessary!
- To prevent the formation of phosgene, residues of chlorinated solvents on workpieces must first be neutralised using appropriate measures.

**Noise exposure!**

Noise exceeding 70 dBA can cause permanent hearing damage!

- Wear suitable ear protection!
- Persons located within the working area must wear suitable ear protection!



According to IEC 60974-10, welding machines are divided into two classes of electromagnetic compatibility (the EMC class can be found in the Technical data) > see 8 chapter:



Class A machines are not intended for use in residential areas where the power supply comes from the low-voltage public mains network. When ensuring the electromagnetic compatibility of class A machines, difficulties can arise in these areas due to interference not only in the supply lines but also in the form of radiated interference.



Class B machines fulfil the EMC requirements in industrial as well as residential areas, including residential areas connected to the low-voltage public mains network.

Setting up and operating

When operating arc welding systems, in some cases, electro-magnetic interference can occur although all of the welding machines comply with the emission limits specified in the standard. The user is responsible for any interference caused by welding.

In order to **evaluate** any possible problems with electromagnetic compatibility in the surrounding area, the user must consider the following: (see also EN 60974-10 Appendix A)

- Mains, control, signal and telecommunication lines
- Radios and televisions
- Computers and other control systems
- Safety equipment
- The health of neighbouring persons, especially if they have a pacemaker or wear a hearing aid
- Calibration and measuring equipment
- The immunity to interference of other equipment in the surrounding area
- The time of day at which the welding work must be carried out

Recommendations for reducing interference emission

- Mains connection, e.g. additional mains filter or shielding with a metal tube
- Maintenance of the arc welding system
- Welding leads should be as short as possible and run closely together along the ground
- Potential equalization
- Earthing of the workpiece. In cases where it is not possible to earth the workpiece directly, it should be connected by means of suitable capacitors.
- Shielding from other equipment in the surrounding area or the entire welding system

**Electromagnetic fields!**

The power source can create electrical or electromagnetic fields that may impair the function of electronic systems such as EDP and CNC devices, telecommunication, power and signal lines as well as pacemakers and defibrillators.



- Follow the maintenance instructions > see 6.2 chapter!
- Unwind the welding leads completely!
- Shield radiation-sensitive equipment or facilities appropriately!
- The function of pacemakers may be impaired (seek medical advice if necessary).

CAUTION



Obligations of the operator!

The respective national directives and laws must be complied with when operating the machine!

- Implementation of national legislation relating to framework directive 89/391/EEC on the introduction of measures to encourage improvements in the safety and health of workers at work and associated individual guidelines.
- In particular, directive 89/655/EEC concerning the minimum safety and health requirements for the use of work equipment by workers at work.
- The regulations applicable to occupational safety and accident prevention in the country concerned.
- Setting up and operating the machine as per IEC 60974.-9.
- Brief the user on safety-conscious work practices on a regular basis.
- Regularly inspect the machine as per IEC 60974.-4.



The manufacturer's warranty becomes void if non-genuine parts are used!

- ***Only use system components and options (power sources, welding torches, electrode holders, remote controls, spare parts and replacement parts, etc.) from our range of products!***
- ***Only insert and lock accessory components into the relevant connection socket when the machine is switched off.***

Requirements for connection to the public mains network

High-performance machines can influence the mains quality by taking current from the mains network. For some types of machines, connection restrictions or requirements relating to the maximum possible line impedance or the necessary minimum supply capacity at the interface with the public network (Point of Common Coupling, PCC) can therefore apply. In this respect, attention is also drawn to the machines' technical data. In this case, it is the responsibility of the operator, where necessary in consultation with the mains network operator, to ensure that the machine can be connected.

2.4 Transport and installation

WARNING



Risk of injury due to improper handling of shielding gas cylinders!

Improper handling and insufficient securing of shielding gas cylinders can cause serious injuries!

- Observe the instructions from the gas manufacturer and any relevant regulations concerning the use of compressed air!
- Do not attach any element to the shielding gas cylinder valve!
- Prevent the shielding gas cylinder from heating up.

⚠ CAUTION**Risk of accidents due to supply lines!**

During transport, attached supply lines (mains leads, control cables, etc.) can cause risks, e.g. by causing connected machines to tip over and injure persons!

- Disconnect all supply lines before transport!

**Risk of tipping!**

There is a risk of the machine tipping over and injuring persons or being damaged itself during movement and set up. Tilt resistance is guaranteed up to an angle of 10° (according to IEC 60974-1).

- Set up and transport the machine on level, solid ground.
- Secure add-on parts using suitable equipment.

**Risk of accidents due to incorrectly installed leads!**

Incorrectly installed leads (mains, control and welding leads or intermediate hose packages) can present a tripping hazard.

- Lay the supply lines flat on the floor (avoid loops).
- Avoid laying the leads on passage ways.

**Risk of injury from heated coolant and its connections!**

The coolant used and its connection or connection points can heat up significantly during operation (water-cooled version). When opening the coolant circuit, escaping coolant may cause scalding.

- Open the coolant circuit only when the power source or cooling unit is switched off!
- Wear proper protective equipment (protective gloves)!
- Seal open connections of the hose leads with suitable plugs.



The units are designed for operation in an upright position!

Operation in non-permissible positions can cause equipment damage.

- ***Only transport and operate in an upright position!***



Accessory components and the power source itself can be damaged by incorrect connection!

- ***Only insert and lock accessory components into the relevant connection socket when the machine is switched off.***
- ***Comprehensive descriptions can be found in the operating instructions for the relevant accessory components.***
- ***Accessory components are detected automatically after the power source is switched on.***



Protective dust caps protect the connection sockets and therefore the machine against dirt and damage.

- ***The protective dust cap must be fitted if there is no accessory component being operated on that connection.***
- ***The cap must be replaced if faulty or if lost!***

3 Intended use

WARNING



Hazards due to improper usage!

The machine has been constructed to the state of the art and any regulations and standards applicable for use in industry and trade. It may only be used for the welding procedures indicated at the rating plate. Hazards may arise for persons, animals and material objects if the equipment is not used correctly. No liability is accepted for any damages arising from improper usage!

- The equipment must only be used in line with its designated purpose and by trained or expert personnel!
- Do not improperly modify or convert the equipment!

3.1 Applications

Arc welding machine for MMA DC welding with TIG DC welding with lift arc (touch starting) as secondary process.

3.1.1 Demagnetize function (degaussing)

The degaussing of ferromagnetic workpieces in welding technology is intended to reduce arc deflection, arc instability, uneven droplet detachment, spatter and irregular flank connections.

3.2 Documents which also apply

3.2.1 Warranty

For more information refer to the "Warranty registration" brochure supplied and our information regarding warranty, maintenance and testing at www.ewm-group.com!

3.2.2 Declaration of Conformity

CE This product corresponds in its design and construction to the EU directives listed in the declaration. The product comes with a relevant declaration of conformity in the original.
The manufacturer recommends carrying out the safety inspection according to national and international standards and guidelines every 12 months (from commissioning).

3.2.3 Welding in environments with increased electrical hazards

S Power sources with this marking can be used for welding in an environment with increased electrical hazard (e.g. boilers). For this purpose, appropriate national or international regulations must be followed. The power source must not be placed in the danger zone!

3.2.4 Calibration/Validation

An original certificate is enclosed with the product. The manufacturer recommends calibration / validation at intervals of 12 months (from commissioning).

3.2.5 Part of the complete documentation

These operating instructions are part of the complete documentation and valid only in combination with the "Safety instructions"!

Read and observe the documents for all system components!

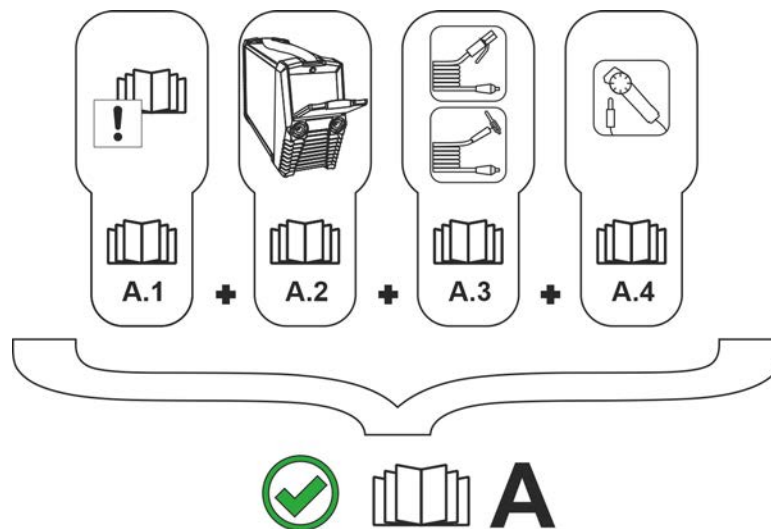


Figure 3-1

Item	Documentation
A.1	Safety instructions
A.2	Power source
A.3	Welding torch / Electrode holder
A.4	Remote control
A	Complete documentation

4 Machine description – quick overview

4.1 Front view

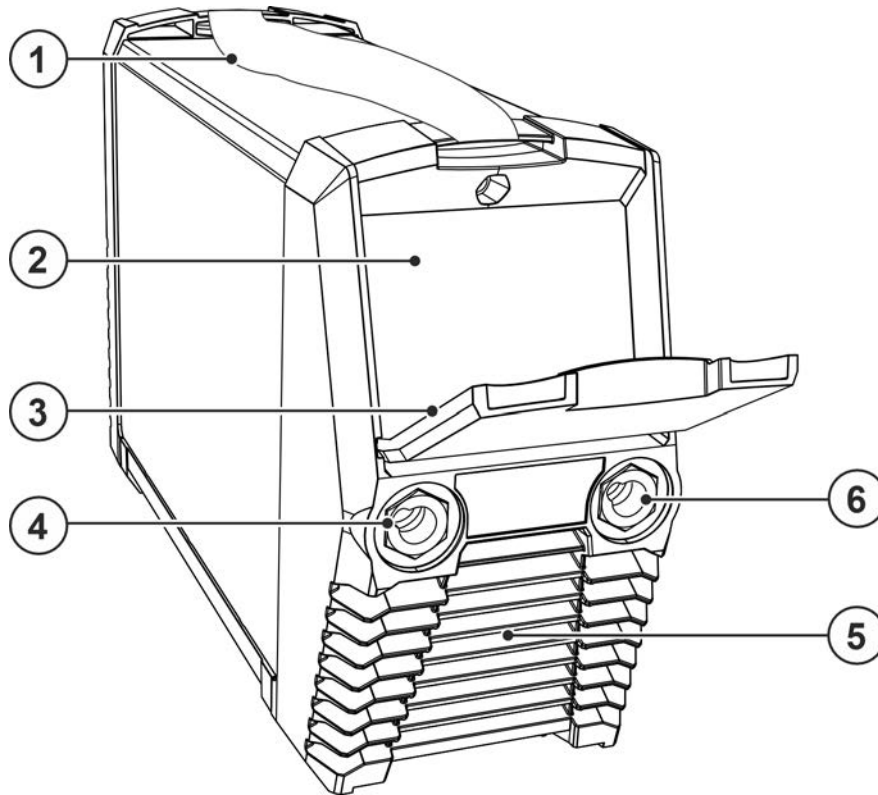


Figure 4-1

Item	Symbol	Description
1		Carrying strap > see 5.1.4.1 chapter
2		Machine control > see 4.3 chapter
3		Protective cap
4	+	Connection socket, "+" welding current <ul style="list-style-type: none"> • MMA: Electrode holder or workpiece lead connection • TIG: Connection for workpiece lead
5		Cooling air outlet
6	—	Connection socket, "-" welding current <ul style="list-style-type: none"> • MMA: Connection of electrode holder or workpiece lead • TIG: Connection of TIG welding torch

4.2 Rear view

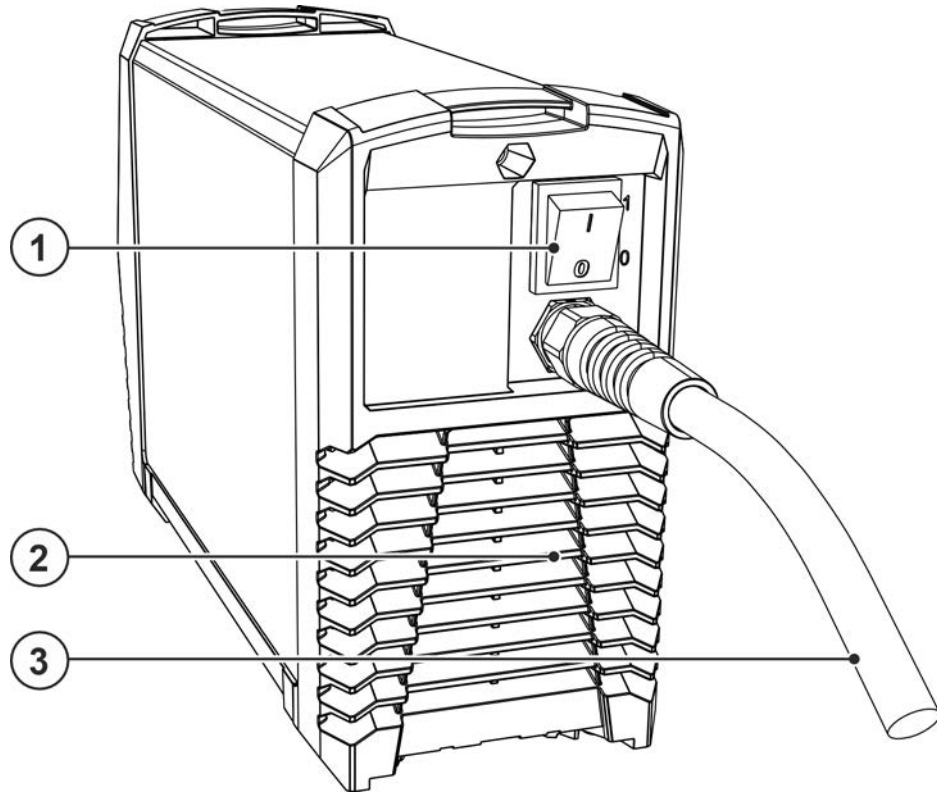



Figure 4-2

Item	Symbol	Description
1		Main Switch Switching the machine on or off.
2		Cooling air inlet
3		Mains connection cable > see 5.1.7 chapter

4.3 Machine control – Operating elements

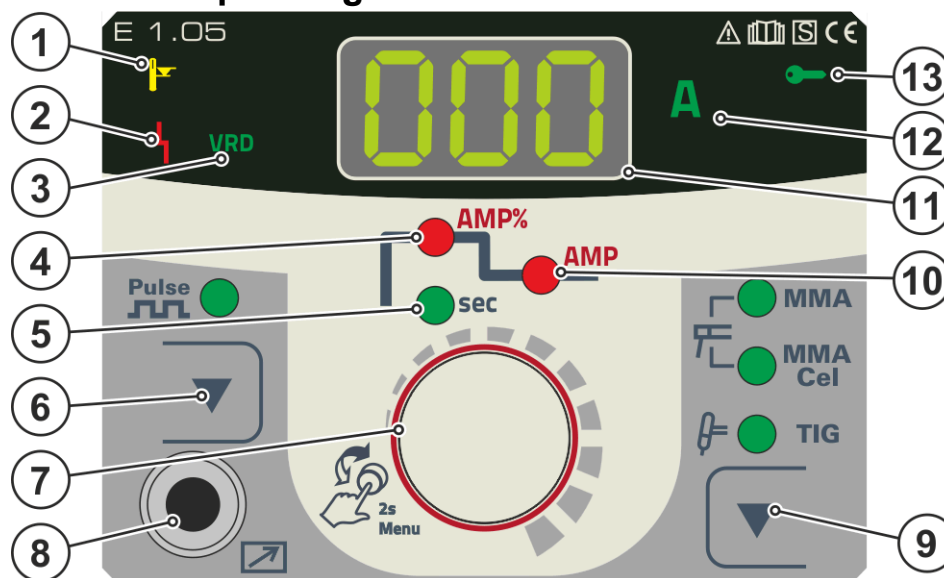


Figure 4-3

Item	Symbol	Description
1		Excess temperature signal light In case of excess temperature, temperature monitors de-activate the power unit, and the excess temperature control lamp comes on. Once the machine has cooled down, welding can continue without any further measures.
2		Collective interference signal light For error messages, > see 7 chapter
3	VRD	Voltage reduction device (VRD) signal light > see 5.9 chapter
4	AMP%	Hotstart current signal light
5	sec	Hotstart time signal light
6		Pulsed welding/power-saving mode push-button MMA ---- pulse welding > see 5.3.6 chapter TIG ----- pulse welding > see 5.4.7 chapter Press for 2 s to put the machine into power-saving mode. To reactivate, activate one of the operating elements > see 5.8 chapter.
7		Control button Central control button to be pressed or turned > see 5.2 chapter.
8		3-pole connection socket Remote control control cable
9		Pushbutton welding process / degaussing (activgauss) > see 5.5 chapter MMA-- MMA welding > see 5.3 chapter MMA Cel ----- MMA welding (Cel characteristics) TIG ----- TIG welding > see 5.4 chapter
10	AMP	Main current signal light I _{min} to I _{max} (1 A increments)
11		Welding data display (3-digit) Displays the welding parameters and the corresponding values > see 5.2.1 chapter
12	A	“Welding current unit” signal light Illuminates when welding currents are displayed.
13		Access control active signal light Signal light is on when access control is active on the machine control > see 5.10 chapter.

5 Design and function

WARNING



Risk of injury from electrical voltage!

Contact with live parts, e.g. power connections, can be fatal!

- Observe the safety information on the first pages of the operating instructions!
- Commissioning must be carried out by persons who are specifically trained in handling power sources!
- Connect connection or power cables while the machine is switched off!

Read and observe the documentation to all system and accessory components!

5.1 Transport and installation

WARNING



Risk of accident due to improper transport of machines that must not be lifted!

Do not lift or suspend the machine! The machine can drop and cause injuries! The handles, straps or brackets are suitable for transport by hand only!

- The machine must not be suspended or lifted using a crane.

5.1.1 Machine cooling



Insufficient ventilation results in a reduction in performance and equipment damage.

- **Observe the ambient conditions!**
- **Keep the cooling air inlet and outlet clear!**
- **Observe the minimum distance of 0.5 m from obstacles!**

5.1.2 Workpiece lead, general

CAUTION



Risk of burning due to incorrect welding current connection!

If the welding current plugs (machine connections) are not locked or if the workpiece connection is contaminated (paint, corrosion), these connections and leads can heat up and cause burns when touched!

- Check welding current connections on a daily basis and lock by turning to the right when necessary.
- Clean workpiece connection thoroughly and secure properly. Do not use structural parts of the workpiece as welding current return lead!

5.1.3 Ambient conditions

- The machine must not be operated in the open air and must only be set up and operated on a suitable, stable and level base!**
- The operator must ensure that the ground is non-slip and level, and provide sufficient lighting for the place of work.
 - Safe operation of the machine must be guaranteed at all times.

- Equipment damage due to contamination!**
Unusually high amounts of dust, acids, corrosive gases or substances can damage the machine (observe maintenance intervals > see 6.2 chapter).
- Avoid large amounts of smoke, steam, oily fumes, grinding dust and corrosive ambient air!

In operation

Temperature range of the ambient air:

- -25 °C to +40 °C (-13 °F to 104 °F)

Relative humidity:

- up to 50 % at 40 °C (104 °F)
- up to 90 % at 20 °C (68 °F)

Transport and storage

Storage in a closed room, temperature range of the ambient air:

- -30 °C to +70 °C (-22 °F to 158 °F)

Relative humidity

- up to 90 % at 20 °C (68 °F)

5.1.4 Transport belt

5.1.4.1 Adjusting the length of the carrying strap

To demonstrate adjustment, lengthening the strap is shown in the figure. To shorten, the strap's loops must be inched in the opposite direction.

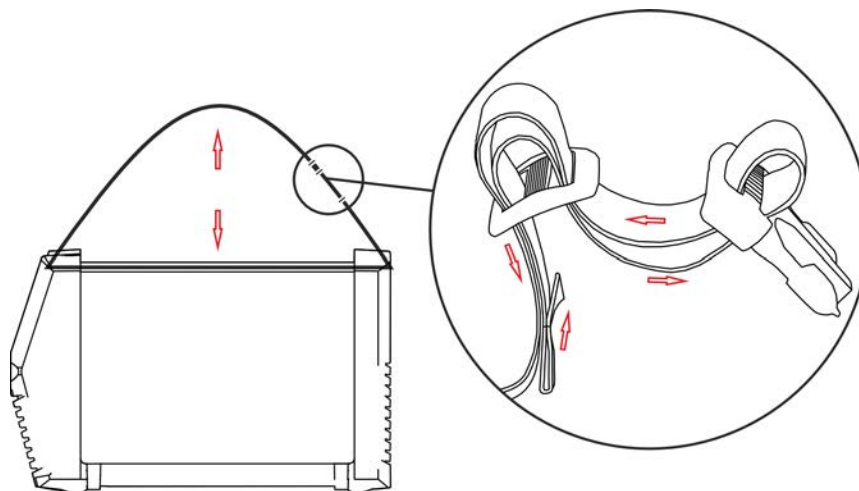


Figure 5-1

5.1.5 Notes on the installation of welding current leads

- Use an individual welding lead to the workpiece for each welding machine!

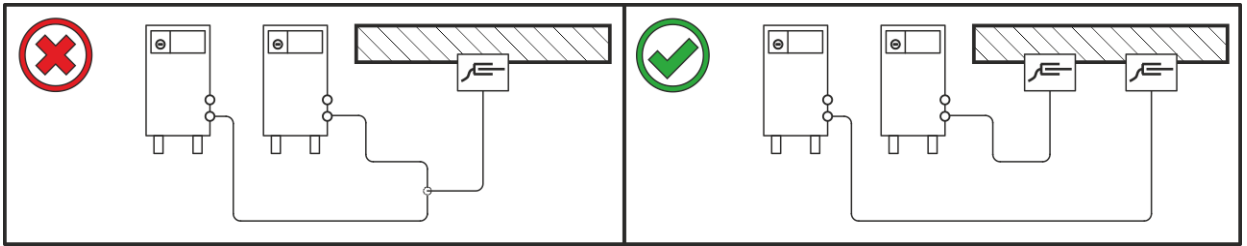


Figure 5-2

- Fully unroll welding current leads, torch hose packages and intermediate hose packages. Avoid loops!
- Always keep leads as short as possible!

Lay any excess cable lengths in meanders.

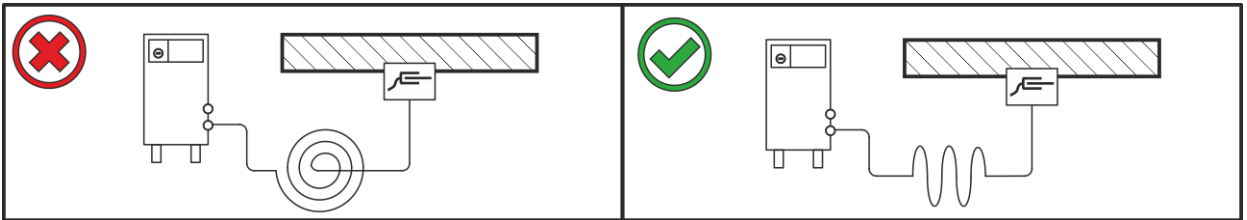


Figure 5-3

5.1.6 Stray welding currents

⚠ WARNING



Risk of injury due to stray welding currents!

Stray welding currents can destroy protective earth conductors, damage machines and electronic devices and cause overheating of components, leading to fire.

- Check that all welding current connections are firmly secured and electrical connections are in perfect condition.
- Set up, attach or suspend all conductive power source components such as casing, transport vehicles and crane frames so they are insulated.
- Do not place any other electronic devices such as drills or angle grinders on the power source, transport vehicle or crane frames unless they are insulated.
- Always put welding torches and electrode holders on an insulated surface when they are not in use.

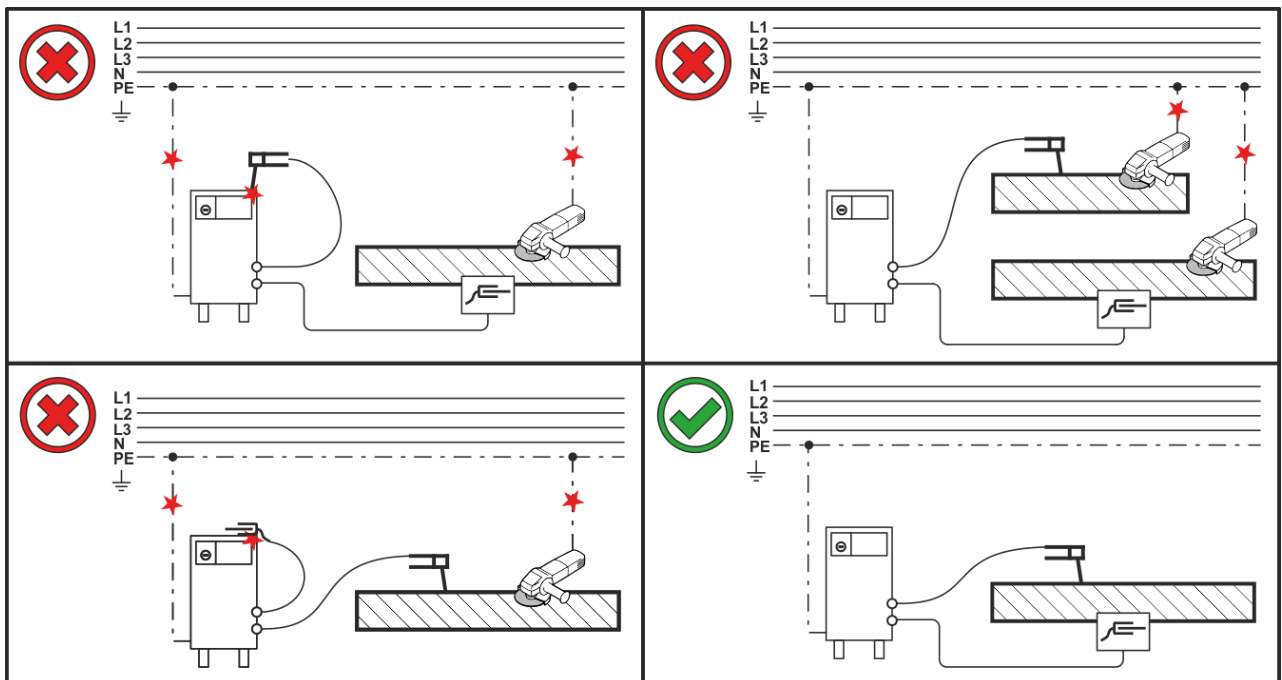


Figure 5-4

5.1.7 Mains connection

⚠ DANGER



Hazards caused by improper mains connection!

An improper mains connection can cause injuries or damage property!

- The connection (mains plug or cable), the repair or voltage adjustment of the device must be carried out by a qualified electrician in accordance with the respective local laws or national regulations!
- The mains voltage indicated on the rating plate must match the supply voltage.
- Only operate machine using a socket that has correctly fitted protective earth.
- Mains plug, socket and lead must be checked by a qualified electrician on a regular basis!
- When operating the generator, always ensure it is earthed as stipulated in the operating instructions. The network created must be suitable for operating machines according to protection class I.

5.1.7.1 Mains configuration



The machine may only be connected to a one-phase system with two conductors and an earthed neutral conductor.

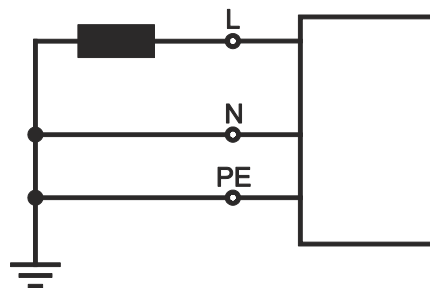


Figure 5-5

Legend

Item	Designation	Colour code
L	Outer conductor	brown
N	Neutral conductor	blue
PE	Protective conductor	green-yellow

- Insert mains plug of the switched-off machine into the appropriate socket.

5.2 Operating the machine control

5.2.1 Machine display

The machine control switches to the main screen after it has been turned on or a setting has been completed. This means that the previously selected settings (indicated by signal lights where applicable) have been applied and the current nominal value (A) is displayed in the welding data display.

5.2.2 Welding power setting

The welding power is set using the control button. You can also adjust the parameters in the operation sequence or settings in the different machine menus.

5.2.3 Welding parameter setting in the operation sequence

During the operation sequence you can set a welding parameter by briefly pressing the control button (navigate the parameters) and then turning the button (set the parameter).

5.2.4 Setting advanced welding parameters (Expert menu)

The Expert menu contains functions and parameters which cannot be set directly in the machine control or which do not need to be set on a regular basis. The number and display of these parameters depends on the previously selected welding procedure or the functions.

5.2.5 Changing basic settings (machine configuration menu)

The basic welding system functions can be adjusted in the machine configuration menu. Only experienced users should change the settings > see 5.11 chapter.

5.3 MMA welding

5.3.1 Connecting the electrode holder and workpiece lead

⚠ CAUTION



Risk of crushing and burns!

When changing stick electrodes there is a risk of crushing and burns!

- Wear appropriate and dry protective gloves.
- Use an insulated pair of tongs to remove the used stick electrode or to move welded workpieces.

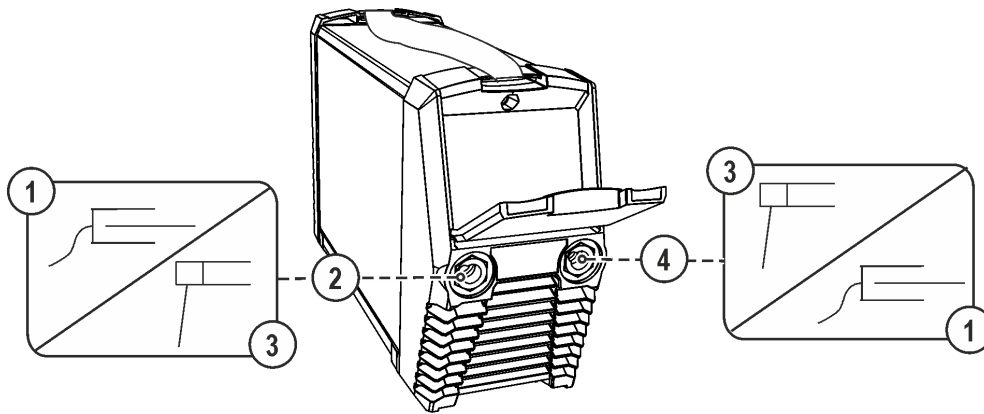


Figure 5-6

Item	Symbol	Description
1		Workpiece
2		Connection socket for "+" welding current Electrode holder or workpiece lead connection
3		Electrode holder
4		Connection socket, "-" welding current Workpiece lead or electrode holder connection

- Insert the electrode holder plug and workpiece lead into the welding current socket depending on application and lock in place by turning to the right. The corresponding polarity will be based on the information of the electrode manufacturer on the electrode packaging.

5.3.2 Welding task selection

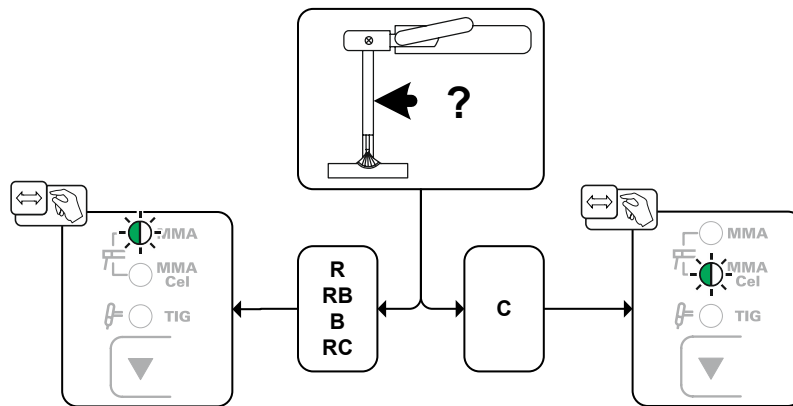


Figure 5-7

Type	Electrode type
R	Rutile
RB	Rutile-basic
B	Basic
RC	Rutile cellulose
C	Cellulose

5.3.3 Arcforce

During the welding process, arcforce prevents the electrode sticking in the weld pool with increases in current. This makes it easier to weld large-drop melting electrode types at low current strengths with a short arc in particular.

For parameter setting, > see 5.3.7 chapter.

5.3.4 Hotstart

The function hot start ensures a secure igniting of the arc and a sufficient heating to the still cold parent metal at the beginning of the welding process. The ignition takes place here with increased current (hot start current) over a certain time (hot start time).

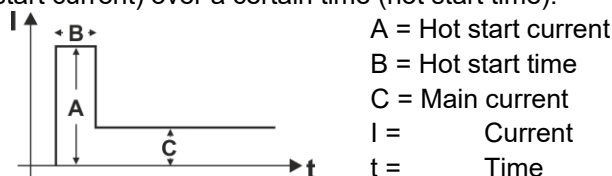


Figure 5-8

Setting

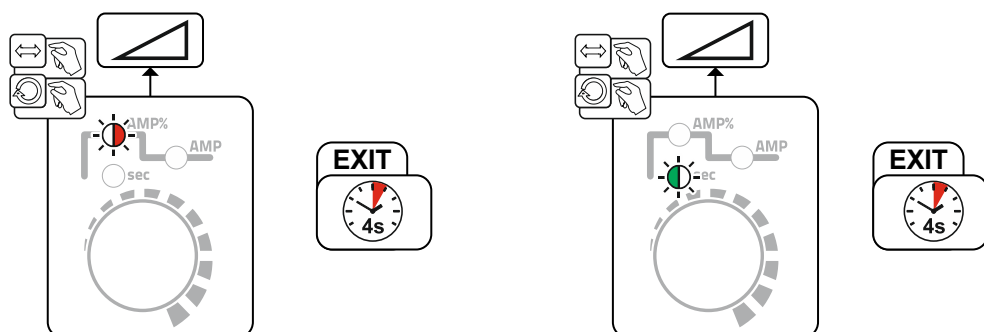
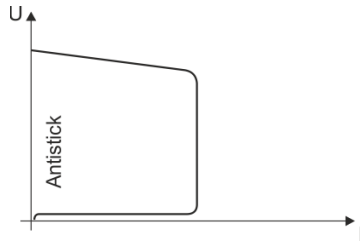


Figure 5-9

5.3.5 Antistick



The Antistick feature prevents the electrode from annealing.

Should the electrode stick despite the Arcforce feature, the machine automatically switches to the minimum current within approx. one second. This prevents the electrode from annealing. Check the welding current setting and correct for the welding task in hand.

Figure 5-10

5.3.6 Average value pulse welding

Average value pulse welding means that two currents are switched periodically, a current average value (AMP), a pulse current (Ipuls), a balance (\overline{bRL}) and a frequency (\overline{FrE}) having been defined first. The predefined ampere current average value is decisive, the pulse current (Ipuls) is defined by the \overline{IPL} parameter as a percentage of the current average value (AMP). The pulse pause current (IPP) requires no setting. This value is calculated by the machine control, so that the welding current average value (AMP) is maintained at all times.

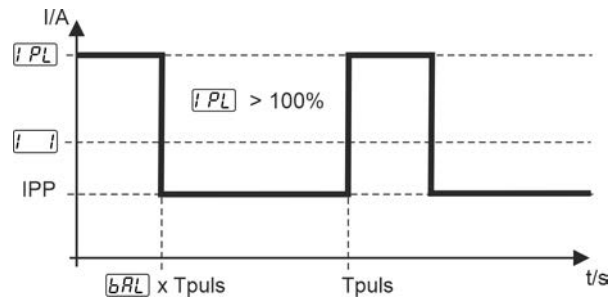


Figure 5-11

AMP = Main current; e.g. 100 A

Ipuls = Pulse current = \overline{IPL} x AMP; e.g. 140% x 100 A = 140 A

IPP = Pulse pause current

Tpuls = Duration of one pulse cycle = $1/\overline{FrE}$; e.g. 1/1 Hz = 1 s

\overline{bRL} = Balance

Selection

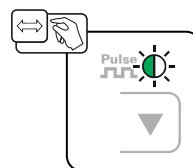


Figure 5-12

For parameter setting, > see 5.3.7 chapter.

5.3.7 Expert menu (MMA)

The Expert menu has adjustable parameters stored that don't require regular setting. The number of parameters shown may be limited, e.g. if a function is deactivated.

The setting ranges for the parameter values are summarised in the Parameter overview section > see 11.1 chapter.

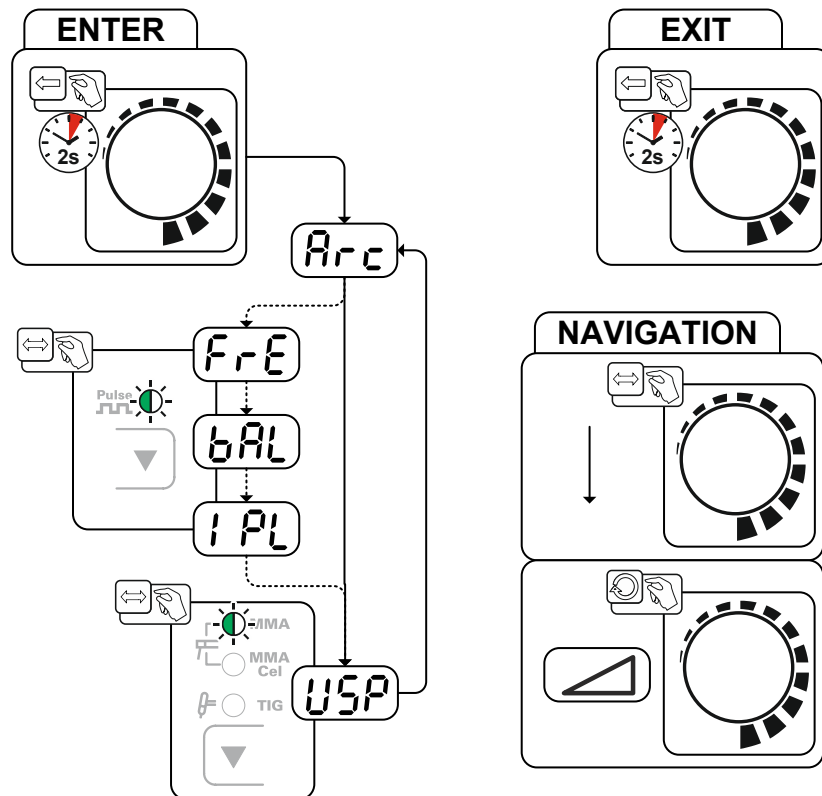


Figure 5-13

Display	Setting/selection
	Arcforce correction <ul style="list-style-type: none"> • Increase value > harder arc • Decrease value > softer arc
	Pulse frequency
	Pulse balance
	Pulse current > see 5.3.6 chapter
	Arc length restriction > see 5.7 chapter ----- Function switched on ----- Function switched off

5.4 TIG welding

5.4.1 Connecting a TIG welding torch with rotating gas valve

Prepare welding torch according to the welding task in hand (see operating instructions for the torch).

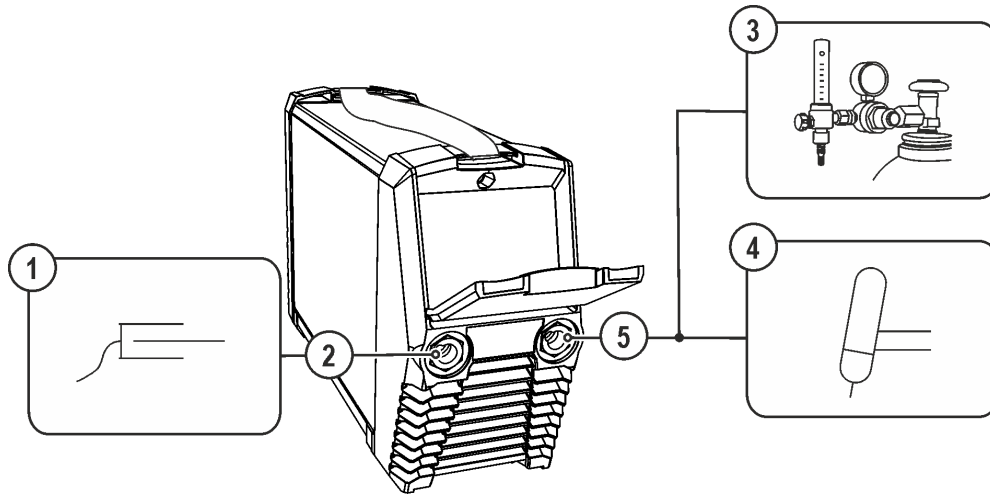


Figure 5-14

Item	Symbol	Description
1		Workpiece
2		Connection socket for "+" welding current Workpiece lead connection
3		Output side of the pressure regulator
4		Welding torch
5		Connection socket, "-" welding current Welding current lead connection for TIG welding torch

- Insert the welding current plug on the welding torch into the welding current connection socket and lock by turning to the right.
- Insert the cable plug on the work piece lead into the "+" welding current connection socket and lock by turning to the right.
- Screw the shielding gas hose of the welding torch to the pressure regulator outlet.

5.4.2 Shielding gas supply (shielding gas cylinder for welding machine)

⚠ WARNING

Risk of injury due to improper handling of shielding gas cylinders! Improper handling and insufficient securing of shielding gas cylinders can cause serious injuries!

- Place shielding gas cylinder into the designated holder and secure with fastening elements (chain/belt)!
- Attach the fastening elements within the upper half of the shielding gas cylinder!
- The fastening elements must tightly enclose the shielding gas cylinder!



An unhindered shielding gas supply from the shielding gas cylinder to the welding torch is a fundamental requirement for optimum welding results. In addition, a blocked shielding gas supply may result in the welding torch being destroyed.

- All shielding gas connections must be gas tight.

5.4.3 Pressure regulator connection

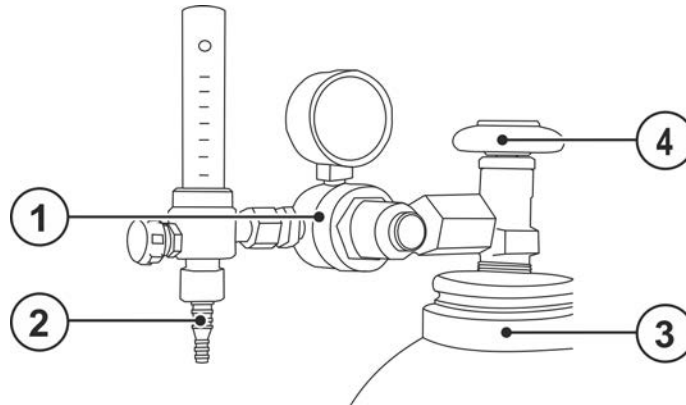


Figure 5-15

Item	Symbol	Description
1		Pressure regulator
2		Output side of the pressure regulator
3		Shielding gas cylinder
4		Cylinder valve

- Before connecting the pressure regulator to the gas cylinder, open the cylinder valve briefly to blow out any dirt.
- Tighten the pressure regulator screw connection on the gas bottle valve to be gas-tight.
- Screw the gas hose connection to the outlet side of the pressure regulator gas-tight.

5.4.4 Welding task selection

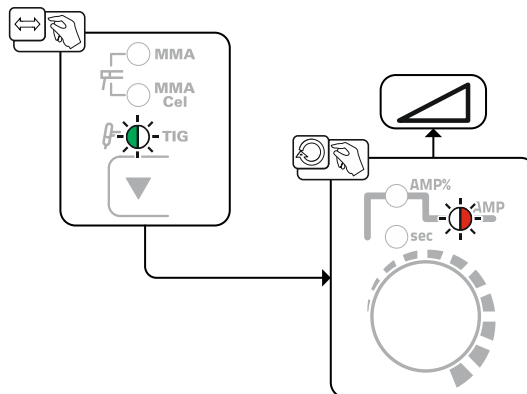


Figure 5-16

5.4.5 Gas test – setting the shielding gas volume

If the rotary gas valve is open, the shielding gas flows permanently from the welding torch (no adjustment with a separate gas valve). The rotary valve must be opened before each welding procedure and closed after each welding procedure.

If the shielding gas setting is too low or too high, this can introduce air to the weld pool and may cause pores to form. Adjust the shielding gas quantity to suit the welding task!

Rule of thumb for the gas flow rate:

Diameter of gas nozzle in mm corresponds to gas flow in l/min.

Example: 7mm gas nozzle corresponds to 7l/min gas flow.

- Slowly open the gas cylinder valve.
- Set the relevant gas quantity for the application on the pressure regulator.

5.4.6 Arc ignition

5.4.6.1 Liftarc

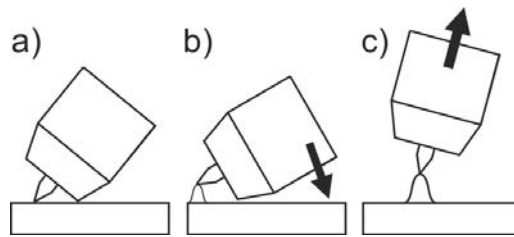


Figure 5-17

The arc ignites through contact with the workpiece:

- Carefully place the torch gas nozzle and tungsten electrode tip against the workpiece (lift arc current flows independent of the set main current)
- Angle the torch above the torch gas nozzle until the distance between electrode tip and workpiece is approx. 2–3 mm (arc ignites, current increases to the set main current).
- Lift the torch off and bring into normal position.

Complete the welding task: Remove the torch from the workpiece so that the arc extinguishes > see 5.7 chapter.

5.4.7 Average value pulse welding

Average value pulse welding means that two currents are switched periodically, a current average value (AMP), a pulse current (I_{puls}), a balance (\overline{bRL}) and a frequency (\overline{FrE}) having been defined first. The predefined ampere current average value is decisive, the pulse current (I_{puls}) is defined by the \overline{iPL} parameter as a percentage of the current average value (AMP). The pulse pause current (IPP) requires no setting. This value is calculated by the machine control, so that the welding current average value (AMP) is maintained at all times.

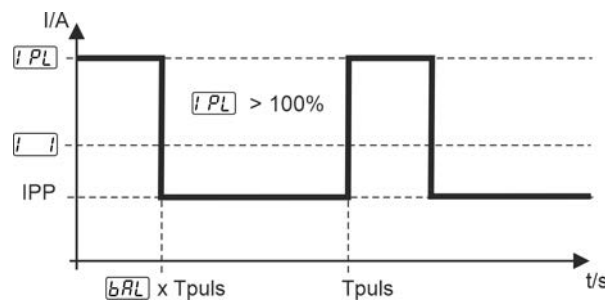


Figure 5-18

AMP = Main current; e.g. 100 A

I_{puls} = Pulse current = $\overline{iPL} \times \text{AMP}$; e.g. 140% x 100 A = 140 A

IPP = Pulse pause current

T_{puls} = Duration of one pulse cycle = $1/\overline{FrE}$; e.g. 1/1 Hz = 1 s

\overline{bRL} = Balance

For parameter setting, > see 5.4.8 chapter.

Selection

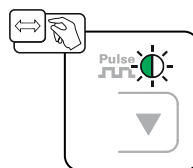


Figure 5-19

5.4.8 Expert menu (TIG)

The Expert menu has adjustable parameters stored that don't require regular setting. The number of parameters shown may be limited, e.g. if a function is deactivated.

The setting ranges for the parameter values are summarised in the Parameter overview section > see 11.1 chapter.

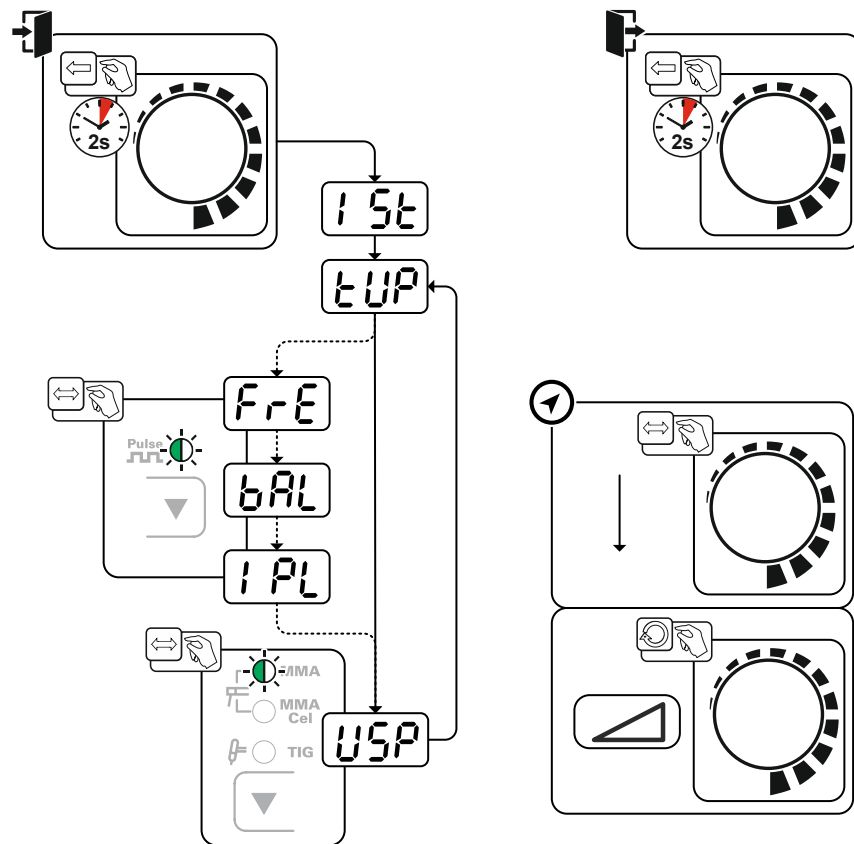


Figure 5-20

Display	Setting/selection
15t	Start current (as percentage, dependent on main current)
tUP	Upslope time to main current
FrE	Pulse frequency
bAL	Pulse balance
I PL	Pulse current > see 5.4.7 chapter
USP	Arc length restriction > see 5.7 chapter <input type="checkbox"/> on ----- Function switched on <input type="checkbox"/> off ----- Function switched off

5.5 Degaussing

⚠ CAUTION



Movement forces due to electromagnetic fields!

Electromagnetic fields may exert movement forces on unsecured metal objects! This may result in injury for example by tools that are set in motion uncontrolled, etc.

- Remove metal objects lying around from the working area or secure against movement.

5.5.1 Description of procedure

With the process activgauss, an adjustable direct current is used to generate an opposing magnetic field. The opposing magnetic field is applied during the welding process and counteracts the magnetism present in the workpiece. This reduces arc deflection (arc instability), irregular droplet detachment, spatter and irregular flank connections.

When using the activgauss method, only the magnetic fields in which the opposing field is identical are compensated. The magnetic field along the welding joint is usually not constant. This means that in practical use the field around the welding start should be compensated. The welder begins to weld. If the arc becomes unsteady, the magnetic flux density must be measured and re-compensated until the pipe root has been completely welded. Experience has shown that this process must be carried out 3 to 4 times over the circumference. As the root welding progresses, the existing magnetic field decreases to 0.

Degaussing the workpiece successfully and demonstrably requires the measuring of the magnetic flux density in millitesla (mT). This requires a field strength or magnetic flux density meter.

5.5.2 Notes on laying power cables

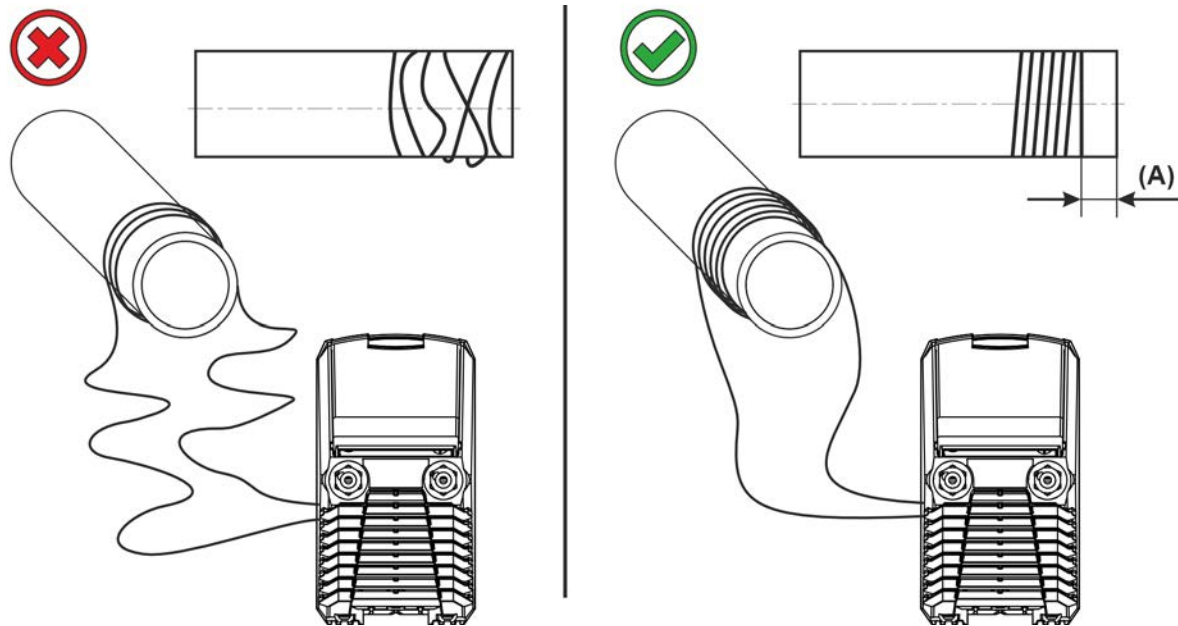


Figure 5-21

- Lay power cables close together around the component.
- The greater the distance to the welding-relevant area (A), the greater the number of turns you must select. Using the activgauss method, it is possible to increase the degaussing current as an alternative or in addition.

Large or long workpieces



Figure 5-22

- Lay power cables tightly around the component.
- Lay power cables up to the welding-relevant area, such as the sidewall of the joint.

If the space required by the power lines is too large, the turns can also be placed on top of each other. This has no significant influence on the degaussing process.

As the distance between the individual turns (B) increases, the current must be corrected upwards to achieve the desired result.

5.5.3 Generating an opposing magnetic field during welding (activgauss)

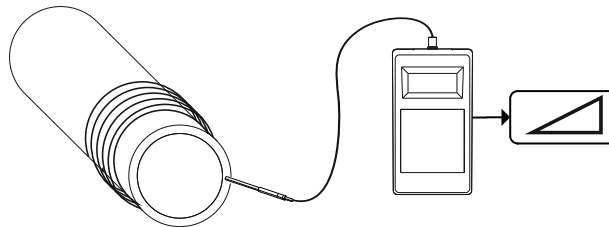


Figure 5-23

- Measure the magnetic flux density.

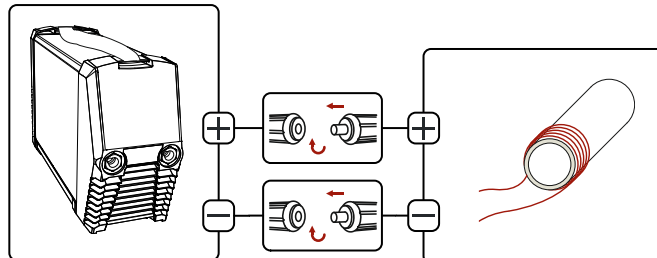


Figure 5-24

- Lay power cables tightly around component > see 5.5.2 chapter.
- Connect power cables to the power source (the polarity is freely selectable).

The process must be activated before use. The subsequent restarting of the power source switches back to the last active welding procedure.

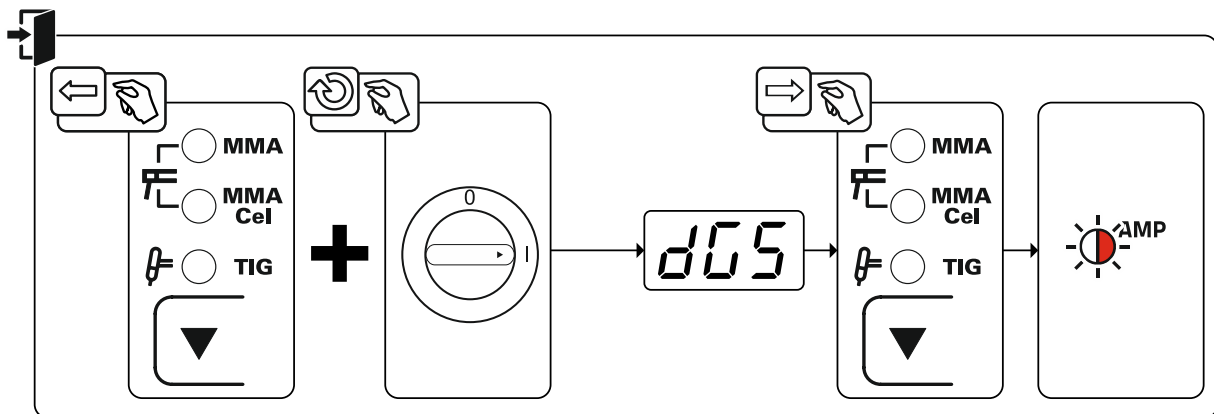


Figure 5-25

Display	Setting/selection
	Degaussing is activated.

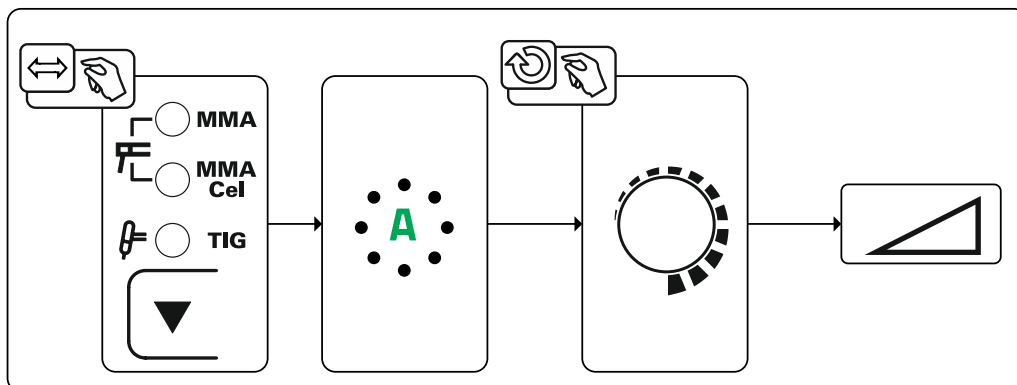


Figure 5-26

- Press the welding procedure/ degaussing pushbutton.
- The signal light "A" flashes.
- Check the magnetic field on the workpiece with the magnetic field meter.
- Increase the current with the rotary transducer until the magnetic field in the component decreases towards "0".

If the field strength increases in the workpiece:

- Switch off activgauss.
- Change polarity by switching cables.
- Switch on activgauss.
- Increase the current with the rotary transducer until the magnetic field in the workpiece decreases towards "0".

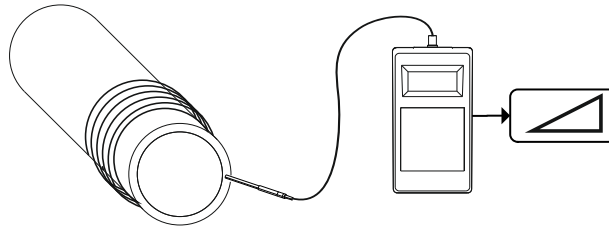


Figure 5-27

- Measure the magnetic flux density.
- Compare the measured magnetic flux density with the table “Guide values for residual flux density” > see 11.2 chapter for the corresponding welding process.

If the residual field strength is too high, the process of degaussing can be repeated as often as desired (increase the number of turns if necessary).

5.5.3.1 Automatic cut-out

The demagnetization process is stopped within 5 seconds if no current flow can be established. The display shows the message $b r E$ (interruption). Check all circuit connections and repeat the process.

5.5.4 Decommissioning

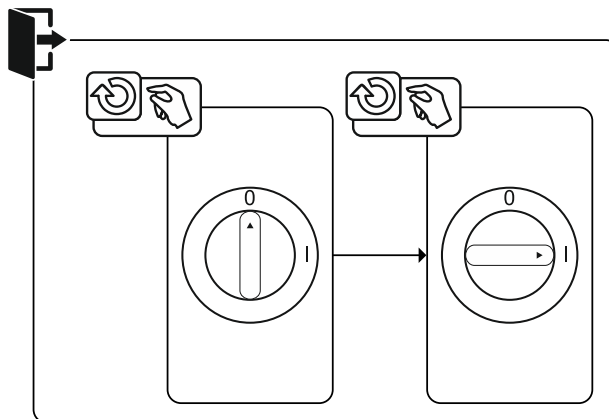


Figure 5-28

- Switch off machine at the main switch.
- Remove all connections.

5.6 Remote control

Remote controls are used for the remote operation of various machine functions. The 2-pin remote control connection is installed on the device controller > see 4.3 chapter.

5.7 Arc length restriction (USP)

The arc length restriction USP function stops the welding process when an excessive arc voltage is detected (unusually high gap between electrode and workpiece). This function can be adjusted in the corresponding Expert menu, depending on the process:

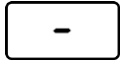
MMA welding > see 5.3.7 chapter

TIG welding > see 5.4.8 chapter

The arc length restriction cannot be used for cel characteristics (if available).

5.8 Power-saving mode (Standby)

You can activate the power-saving mode by either pressing the push-button > see 4.3 chapter for a prolonged time or by setting a parameter in the machine configuration menu (time-controlled power-saving mode \overline{SbR}) > see 5.11 chapter.



When power-saving mode is activated, the machine displays show the horizontal digit in the centre of the display only.

Pressing any operating element (e.g. turning a rotary knob) deactivates power-saving mode and the machine is ready for welding again.

5.9 Voltage reducing device

Only machine variants with the (VRD/SVRD/AUS/RU) code are equipped with a voltage reduction device (VRD). The VRD is used for increased safety, especially in hazardous environments such as shipbuilding, pipe construction or mining.

A VRD is mandatory in some countries and required by many on-site safety instructions for power sources.

The VRD > see 4.3 chapter signal light is illuminated when the voltage reduction device is operating without fault and the output voltage is reduced to a value specified in the relevant standard (see technical data > see 8 chapter).

5.10 Access control

The control can be locked to secure some basic parameters against unauthorised or unintentional adjustment of machine settings. The access block operates as follows:

- The parameters and their settings in the machine configuration menu, Expert menu and operation sequence can only be viewed but not changed.
- Welding procedure cannot be changed.

The parameters for the access block are configured in the machine configuration menu > see 5.11 chapter.

Enabling the access block

- Assign the access code for the access block: Select parameter \overline{cod} and select a number code (000–999).
- Enable the access block: Set parameter \overline{LoE} to access block enabled \overline{on} .

The access block activation is indicated by the "Access block active" signal light > see 4.3 chapter.

Disabling the access block

- Enter the access code for the access block: Select parameter \overline{cod} and enter the previously selected number code (000–999).
- Disable the access block: Set parameter \overline{LoE} to access block disabled \overline{off} . The only way to disable the access block is to enter the previously selected number code.

5.11 Machine configuration menu

Basic machine settings are defined in the machine configuration menu.

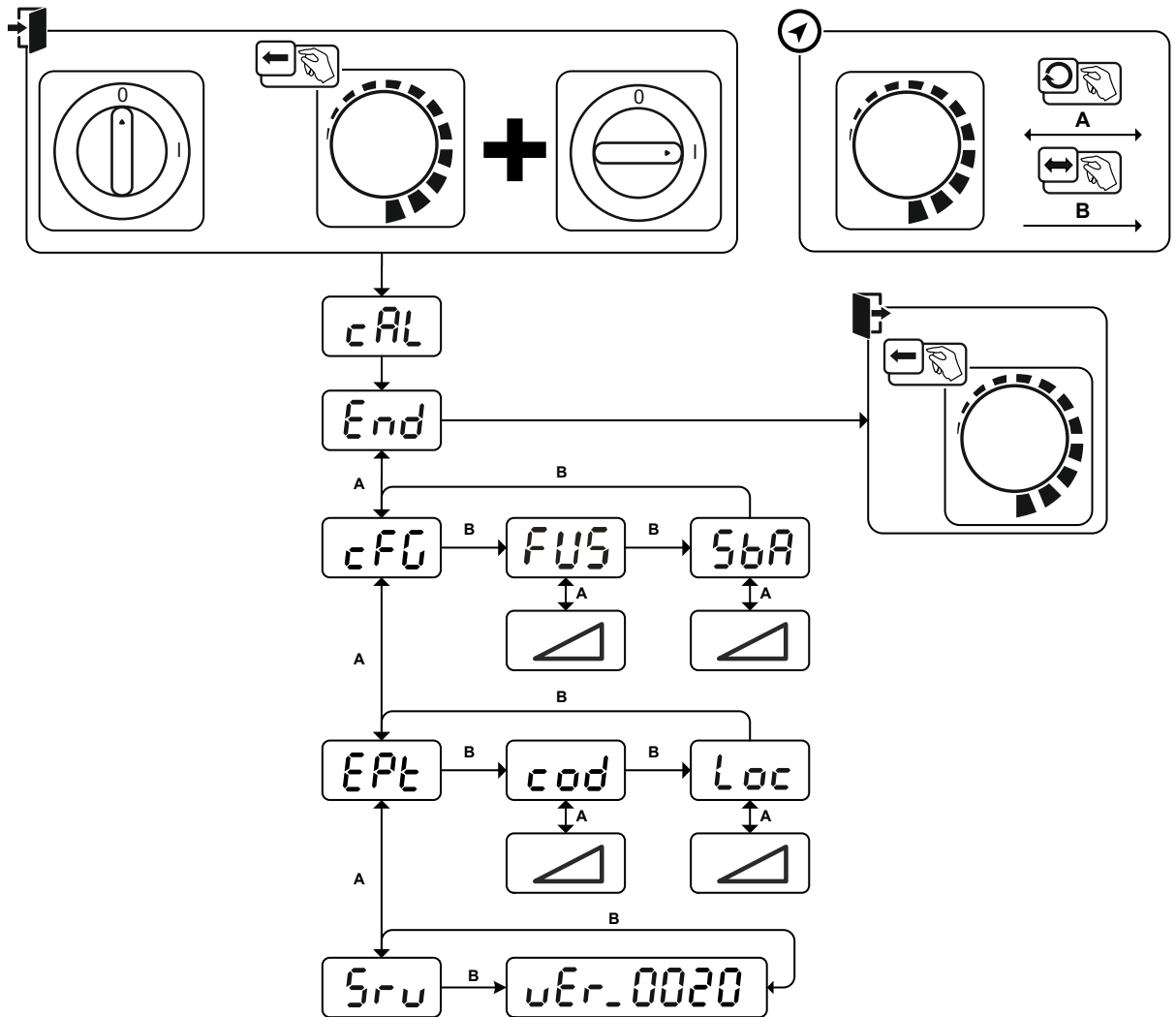
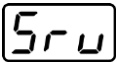
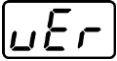


Figure 5-29

Display	Setting/selection
	Calibration The machine will be calibrated for approx 2 seconds each time it is switched on.
	Exit the menu Exit
	Machine configuration Settings for machine functions and parameter display
	Dynamic power adjustment > see 7.4 chapter
	Time-based power-saving mode > see 5.8 chapter Time to activation of the power-saving mode in case of inactivity. Setting = disabled or numerical value 5-60 min..
	Expert menu
	Access control – access code Setting: 000 to 999 (000 ex works)
	Access control > see 5.10 chapter ----- Function enabled ----- Function disabled (ex works)

Display	Setting/selection
	Service menu Any changes to the service menu should be agreed with the authorised service personnel.
	Software version of the machine control Version display

6 Maintenance, care and disposal

6.1 General

DANGER



Risk of injury due to electrical voltage after switching off!

Working on an open machine can lead to fatal injuries!

Capacitors are loaded with electrical voltage during operation. Voltage remains present for up to four minutes after the mains plug is removed.

1. Switch off machine.
2. Remove the mains plug.
3. Wait for at last 4 minutes until the capacitors have discharged!

WARNING



Improper maintenance, testing and repairs!

Maintenance, testing and repair of the machine may only be carried out by skilled and qualified personnel (authorised service personnel). A competent person is someone who, based on training, knowledge and experience, can recognize the hazards and possible consequential damage that may occur when testing power sources and can take the necessary safety precautions.

- Follow the maintenance instructions > see 6.2 chapter.
- If any of the test requirements below are not met, the unit must not be put back into operation until it has been repaired and tested again.

Repair and maintenance work may only be performed by qualified authorised personnel; otherwise the right to claim under warranty is void. In all service matters, always consult the dealer who supplied the machine. Return deliveries of defective equipment subject to warranty may only be made through your dealer. When replacing parts, use only original spare parts. When ordering spare parts, please quote the machine type, serial number and item number of the machine, as well as the type designation and item number of the spare part.

Under the specified ambient conditions and normal working conditions this machine is essentially maintenance-free and requires just a minimum of care.

Contamination of the machine may impair service life and duty cycle. The cleaning intervals depend on the ambient conditions and the resulting contamination of the machine. The minimum interval is every six months.

6.1.1 Cleaning

- Clean the outer surfaces with a moist cloth (no aggressive cleaning agents).
- Purge the machine venting channel and cooling fins (if present) with oil- and water-free compressed air. Compressed air may overspeed and destroy the machine fans. Never direct the compressed air directly at the machine fans. Mechanically block the fans, if required.
- Check the coolant for contaminants and replace, if necessary.

6.1.2 Dirt filter

When using a dirt filter, the cooling air throughput is reduced and the duty cycle of the machine is reduced as a result. The duty cycle decreases with the increasing contamination of the filter. The dirt filter must be removed at regular intervals and cleaned by blowing out with compressed air (depending on the level of soiling).

6.2 Maintenance work, intervals

6.2.1 Daily maintenance tasks

Visual inspection

- Mains supply lead and its strain relief
- Gas cylinder securing elements
- Check hose package and power connections for exterior damage and replace or have repaired by specialist staff as necessary!
- Gas tubes and their switching equipment (solenoid valve)
- Check that all connections and wearing parts are hand-tight and tighten if necessary.
- Check correct mounting of the wire spool.
- Wheels and their securing elements
- Transport elements (strap, lifting lugs, handle)
- Other, general condition

Functional test

- Operating, message, safety and adjustment devices (Functional test)
- Welding current cables (check that they are fitted correctly and secured)
- Gas tubes and their switching equipment (solenoid valve)
- Gas cylinder securing elements
- Check correct mounting of the wire spool.
- Check that all screw and plug connections and replaceable parts are secured correctly, tighten if necessary.
- Remove any spatter.
- Clean the wire feed rollers on a regular basis (depending on the degree of soiling).

6.2.2 Monthly maintenance tasks

Visual inspection

- Casing damage (front, rear and side walls)
- Wheels and their securing elements
- Transport elements (strap, lifting lugs, handle)
- Check coolant tubes and their connections for impurities

Functional test

- Selector switches, command devices, emergency stop devices, voltage reducing devices, message and control lamps
- Check wire guide elements (wire feed roll holder, wire feed nipple, wire guide tube) for tight fit. Recommendation for replacing the wire feed roll holder (eFeed) after 2000 hours of operation, see replacement parts).
- Check coolant tubes and their connections for impurities
- Check and clean the welding torch. Deposits in the torch can cause short circuits and have a negative impact on the welding result, ultimately causing damage to the torch.

6.2.3 Annual test (inspection and testing during operation)

A periodic test according to IEC 60974-4 "Periodic inspection and test" has to be carried out. In addition to the regulations on testing given here, the relevant local laws and regulations must also be observed. For more information refer to the "Warranty registration" brochure supplied and our information regarding warranty, maintenance and testing at www.ewm-group.com!

6.3 Disposing of equipment



Proper disposal!

The machine contains valuable raw materials, which should be recycled, and electronic components, which must be disposed of.

- **Do not dispose of in household waste!**
- **Observe the local regulations regarding disposal!**
- According to European provisions (Directive 2012/19/EU on Waste of Electrical and Electronic Equipment), used electric and electronic equipment may no longer be placed in unsorted municipal waste. It must be collected separately. The symbol depicting a waste container on wheels indicates that the equipment must be collected separately.
This machine has to be disposed of, or recycled, in accordance with the waste separation systems in use.

According to German law (law governing the distribution, taking back and environmentally correct disposal of electrical and electronic equipment (ElektroG)), used machines are to be placed in a collection system separate from unsorted municipal waste. The public waste management utilities (communities) have created collection points at which used equipment from private households can be disposed of free of charge.

The deletion of personal data is the responsibility of the end user.

Lamps, batteries or accumulators must be removed and disposed of separately before disposing of the device. The type of battery or accumulator and its composition is marked on the top (type CR2032 or SR44). The following EWM products may contain batteries or accumulators:

- **Welding helmets**
Batteries or accumulators are easy to remove from the LED cassette.
- **Device controls**
Batteries or accumulators are located on the back of these in corresponding sockets on the circuit board and are easy to remove. The controls can be removed using standard tools.

Information on returning used equipment or collections can be obtained from the respective municipal administration office. Devices can also be returned to EWM sales partners across Europe.


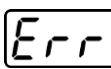
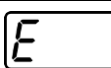
Further information on the topic of the disposal of electrical and electronic equipment can be found on our website at: <https://www.ewm-group.com/de/nachhaltigkeit.html>.

7 Rectifying faults

All products are subject to rigorous production checks and final checks. If, despite this, something fails to work at any time, please check the product using the following flowchart. If none of the fault rectification procedures described leads to the correct functioning of the product, please inform your authorised dealer.

7.1 Error messages (power source)

Depending on the options of the machine display, a fault is shown as follows:

Display type - machine control	Display
Graphic display	
two 7-segment displays	
one 7-segment display	

The possible cause of the fault is signalled by a corresponding fault number (see table). In the case of an error, the power unit shuts down.

The possible error numbers displayed depend on the machine series and version!

- Document machine errors and inform service staff as necessary.
- If multiple errors occur, these are displayed in succession.

Error message	Possible cause	Remedy
E 0	Start signal set in the event of errors	Do not press the torch trigger or the foot-operated remote control
E 4	Temperature error	Allow the machine to cool down
E 5	Mains overvoltage	Switch off the machine and check the mains voltage
E 6	Mains undervoltage	
E 7	Electronics error	Switch the machine off and on again. If the error persists, notify service department
E 9	Secondary overvoltage	
E12	Voltage reduction error (VRD)	
E13	Electronics error	
E14	Alignment error in current recording	Switch off the machine, place the electrode holder in an insulated position and switch the machine back on. If the error persists, notify service department
E15	Error in one of the electronics supply voltages	Switch the machine off and on again. If the error persists, notify service department
E23	Temperature error	Allow the machine to cool down
E32	Electronics error	Switch the machine off and on again. If the error persists, notify service department
E33	Alignment error in voltage recording	Switch off the machine, place the electrode holder in an insulated position and switch the machine back on. If the error persists, notify service department
E34	Electronics error	Switch the machine off and on again. If the error persists, notify service department
E37	Temperature error	Allow the machine to cool down

Error message	Possible cause	Remedy
E40	Motor fault	Check wire feed mechanism, switch the machine off and on again, inform the service department if the fault persists.
E51	Earth fault (PE error)	Connection between welding wire and machine casing
E55	Failure of a mains phase	Switch off the machine and check the mains voltage
E58	Short circuit in welding circuit	Switch off the machine and check welding current leads for correct installation, e.g. by placing the electrode holder in an insulated position; detach current lead from degaussing.

7.2 Checklist for rectifying faults

The correct machine equipment for the material and process gas in use is a fundamental requirement for perfect operation!

Legend	Symbol	Description
	↗	Fault/Cause
	✘	Remedy

Excess temperature signal light illuminates

- ↗ Excess temperature, welding machine
- ✘ Allow the machine to cool down whilst still switched on

Functional errors

- ↗ All machine control signal lights are illuminated after switching on
- ↗ No machine control signal light is illuminated after switching on
- ↗ No welding power
 - ✘ Phase failure > check mains connection (fuses)
- ↗ Connection problems
 - ✘ Make control lead connections and check that they are fitted correctly.
- ↗ Loose welding current connections
 - ✘ Tighten power connections on the torch and/or on the workpiece
 - ✘ Tighten contact tip correctly

7.3 Software version of the machine control

The query of the software versions only serves to inform the authorised service staff. It is available in the machine configuration menu > see 5.11 chapter.

7.4 Dynamic power adjustment

This requires use of the appropriate mains fuse.

Observe mains fuse specification > see 8 chapter!

This function enables aligning the machine to the mains connection fusing to avoid continuous tripping of the mains fuse. The maximum power input of the machine is limited by an exemplary value for the existing mains fuse (several levels available).

You can predefine this value in the machine configuration menu > see 5.11 chapter using parameter \boxed{FUS} . The selected value will be shown on the machine display \boxed{ERL} for two seconds after the machine has been switched on.

The function automatically adjusts the welding power to an uncritical level for the mains fuse.



When using a 20-A mains fuse, a suitable mains plug has to be installed by a qualified electrician.

7.5 Resetting welding parameters to the factory settings

All customised welding parameters that are stored will be replaced by the factory settings.

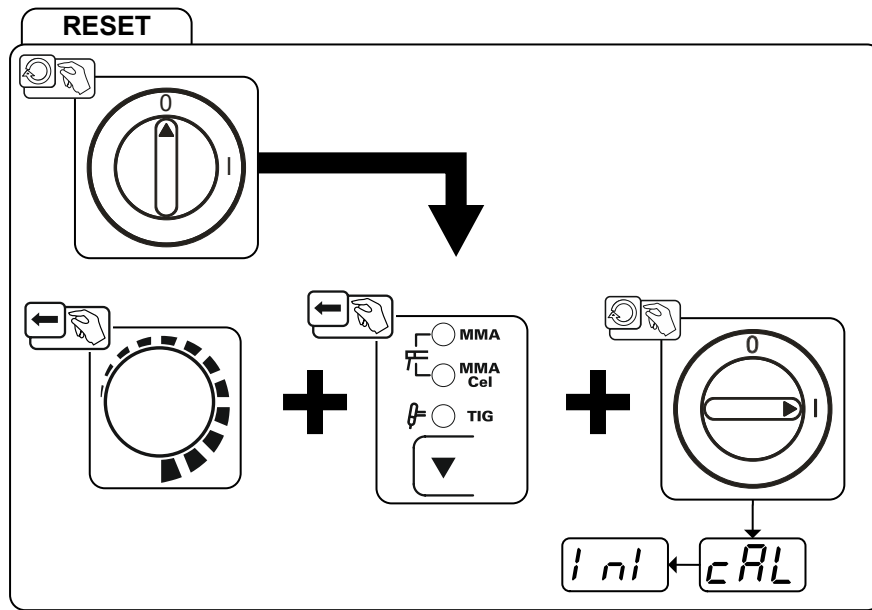






Figure 7-1

Display	Setting/selection
	Calibration The machine will be calibrated for approx 2 seconds each time it is switched on.
	Initialising Keep the push-button pressed until is shown on the display.

8 Technical data

Performance specifications and guarantee only in connection with original spare and replacement parts!

8.1 Pico 160 cel puls

	MMA	TIG
Welding current (I_2)	5 A to 150 A	5 A to 160 A
Welding voltage according to standard (U_2)	20,2 V to 26,0 V	10,2 V to 16,4 V
Duty cycle DC at 40° C ^[1]		
30 %	150 A	160 A
60 %	120 A	
100 %	110 A	
Mains voltage (Tolerance) / Frequency	1 x 230 V (-40 % to +15 %) / 50/60 Hz	
mains fuse ^[2]	1 x 20 A	
Continuous primary current (100 %)	1 x 20 A	1 x 11 A
Open circuit voltage (U_0)	94 V	
Open circuit voltage (U_r) VRD AUS	33 V	12 V
Open circuit voltage (U_r) VRD RU	12 V	12 V
max. Connected load (S_1)	7,3 kVA	4,9 kVA
Generator rating (Rec.)	9,9 kVA	6,6 kVA
Maximum mains impedance (@PCC)	xxx mOhm ^[3]	
Cos ϕ / efficiency	0,99 / 83 %	
Protection class / Overvoltage category	I / III	
Contamination level	3	
Insulation class / protection classification	H / IP 23	
Residual current circuit breaker	Type B (recommended)	
Noise level ^[4]	<70 dB(A)	
Ambient temperature	-25 °C to +40 °C	
Machine cooling / Torch cooling	Fan (AF) / gas	
Mains connection cable	H07RN-F3G2,5	
Workpiece lead	16 mm ²	
EMC class	A	
Test mark	 /  /  / 	
Standards used	See declaration of conformity (appliance documents)	
Dimensions (l x b x h)	370 x 129 x 236 mm / 14.6 x 5.1 x 9.3 inch	
Weight	4,9 kg / 10.8 lb	

^[1] Load cycle: 10 min. (60 % DC \triangleq 6 min. welding, 4 min. pause)

^[2] Safety fuses are recommended DIAZED xxA gG. When using automatic cutouts, the "C" trigger characteristic must be used.

^[3] This welding equipment does not comply with IEC 61000-3-12. When connecting a welding machine to a public low-voltage supply system, the manufacturer or operator has to consult the electricity utilities to make sure the welding machine may be connected.

^[4] Noise level during idle mode and operation under standard load according to IEC 60974- 1 at the maximum operating point.

9 Accessories

9.1 Electrode holder

Type	Designation	Item no.
EH 16mm ² Ø13 mm 170A/60% 4m	Electrode holder with cable	094-005800-00000

9.2 Workpiece lead

Type	Designation	Item no.
WK16mm ² 170A/60% 4m/K	Workpiece lead	094-005801-00000

9.3 Welding torch

Type	Designation	Item no.
TIG 26 GDV 4m	TIG welding torch, rotary gas valve, gas-cooled, de-central	094-511621-00100
TIG 26 GDV 8m	TIG welding torch, rotary gas valve, gas-cooled, de-central	094-511621-00108

9.3.1 Shielding gas supply (shielding gas cylinder for welding machine)

Type	Designation	Item no.
Proreg Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-008488-10015
Proreg Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-008488-10030
Mod. 842 Ar/CO2 230bar 15l	Pressure regulator with manometer	394-002910-00015
GH 2X1/4" 2M	Gas hose	094-000010-00001
GH 2x1/4" 3m	Gas hose	094-000010-00003
GH 2X1/4" 5m	Gas hose	094-000010-00005
GH 2X1/4" 10 m	Gas hose	094-000010-00011
GH 2X1/4" 15m	Gas hose	094-000010-00015

9.4 Options

Type	Designation	Item no.
ON Filter Pico160	Air inlet dirt filter, retrofit option	092-003206-00000
ON Handle Pico 160	Grip, retrofit option	092-003205-00000
ON TG	Carrying strap	092-004310-00000

9.5 Remote controls and accessories

Type	Designation	Item no.
RG13	Remote control	090-008113-00000

9.6 General accessories

Type	Designation	Item no.
SKGS 16A 250V CEE7/7, DIN 49440/441	Protective contact plug, solid rubber	094-001756-00000
ADAP CEE16/SCHUKO	Earth contact coupling/CEE16A plug	092-000812-00000

9.7 Degaussing

Type	Designation	Item no.
Set LC 35 mm ²	Set: Two 5-metre load cables (35 mm ²) and one 20-metre load cable (35 mm ²) for degaussing	092-002921-00000

10 Service documents

WARNING



No improper repairs and modifications!

To prevent injuries and damage to the machine, only competent personnel (authorised service personnel) are allowed to repair or modify the machine.

Unauthorised manipulations will invalidate the warranty!

- Instruct competent personnel (authorised service personnel) to repair the machine.

10.1 Spare and replacement parts

Spare parts can be obtained from the relevant authorised dealer.

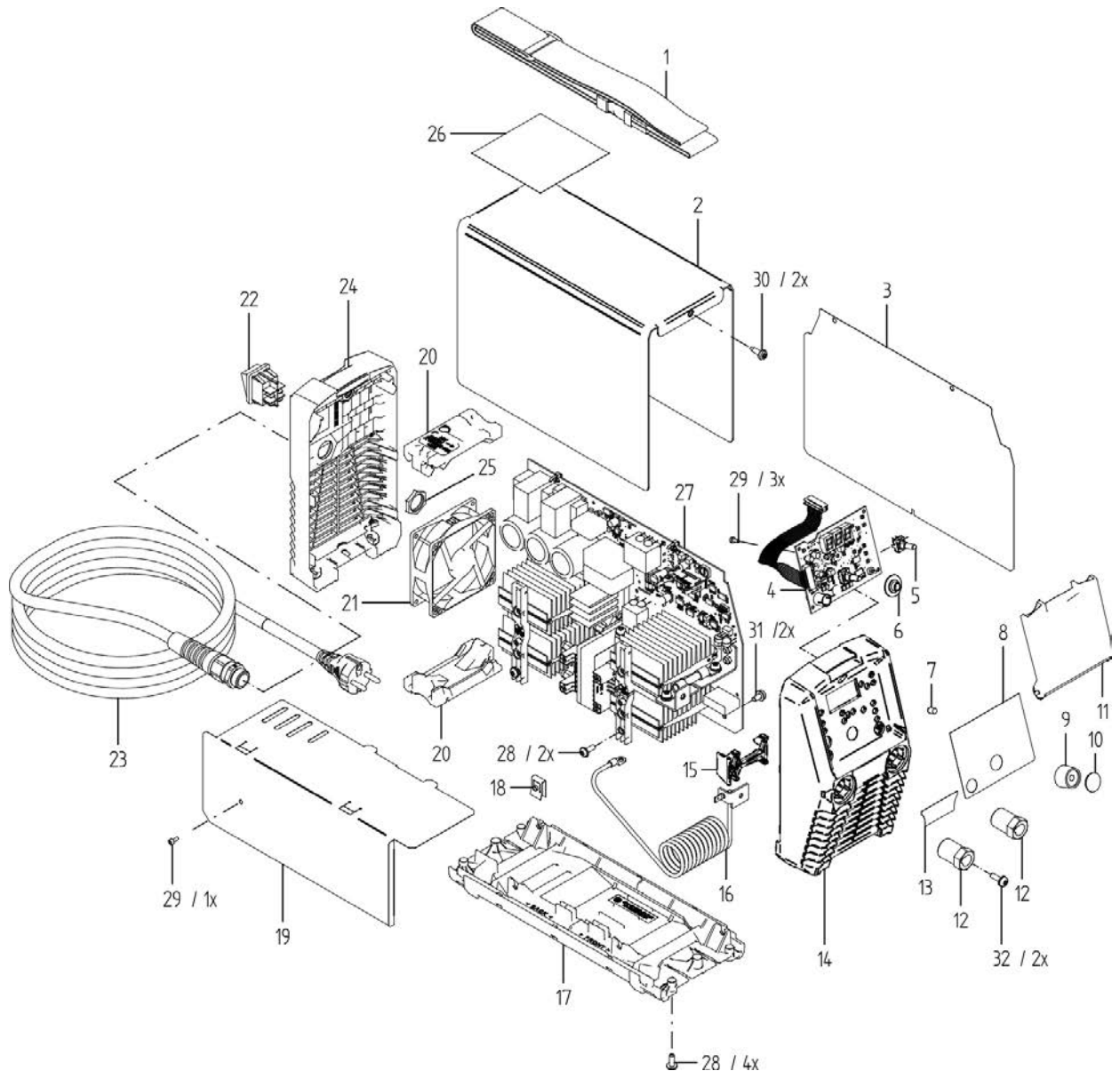


Figure 10-1

Item	Order number	Designation	Type
1	094-015236-E0501	Carrying strap	TG3-E
2	094-021818-E0501	Casing panel	BH276,5X201,5X124,2
3	094-021826-00000	Insulating paper	IP
4	040-001090-E0000	Operating panel and rotary transducer assembly	E160
5	044-004185-10015	Rotary transducer	30POS/1,5NCM
6	094-019308-00000	Plastic insulation for the rotary transducer	KID/D23X7,3
7	094-021994-00000	Light guide	LL8X6
8	094-021794-00502	Adhesive film	KLF-E 1.05
9	074-000315-00000	Rotary knob	KNOB 23MM
10	094-015043-00001	Rotary knob cover	KNOB COVER 23MM
11	094-021514-00000	Cover cap	KKS
12	094-021511-00001	Welding current socket	EB/35-50QMM
13	094-021795-00502	Adhesive film	LOGO/PLUS/MINUS
14	094-021477-00001	Casing, front section	KFG
15	094-022172-00002	Spacer	KA57,3X33,5X17,5
16	092-003193-00002	Choke	WD
17	094-021509-00000	Casing, lower section	KBG
18	094-014311-00000	Sheet metal nut	M5/21X15X6
19	094-021508-00000	Insulating paper	IPL
20	094-015248-00001	Foam, fan support	S95X48X23
21	092-019418-00000	Fan	92X92X32
22	094-008045-10000	Mains switch	WS 250V/20A 2POLE
23	092-003003-00001	Mains cable	3X2.5QMM/3.5M SCHUKO
23a	094-020188-00032	Mains cable - Pico 160 VRD (AUS)	1PHASIG/2.5 3.5M BOC
24	094-021478-00000	Casing, back panel	KRG
25	094-019537-00000	Screw nut	M20x1,5
26	094-021796-00500	Adhesive film	processes PICO CEL PULS
27	040-001084-E0000	PCB inverter circuit board	HB160
27a	040-001424-E0000	PCB inverter circuit board - Pico 160 VRD (AUS)	HB160 VRD
28	094-012942-00000	Screw	M5X14/DELTA-PT-SCHRAUBE
29	094-010089-00000	Screw, Torx	M3X8-DG-SCHRAUBE
30	094-015135-00000	Screw	M5X16/KOMBITORX PLUS T25
31	094-021833-00000	Screw	M5X10/DIN6900-5 Z9/8.8/VERZ.
32	094-022122-00000	Clamping screw	M5X16/DIN6900-5 Z9/8.8/VERZ.

10.2 Circuit diagram

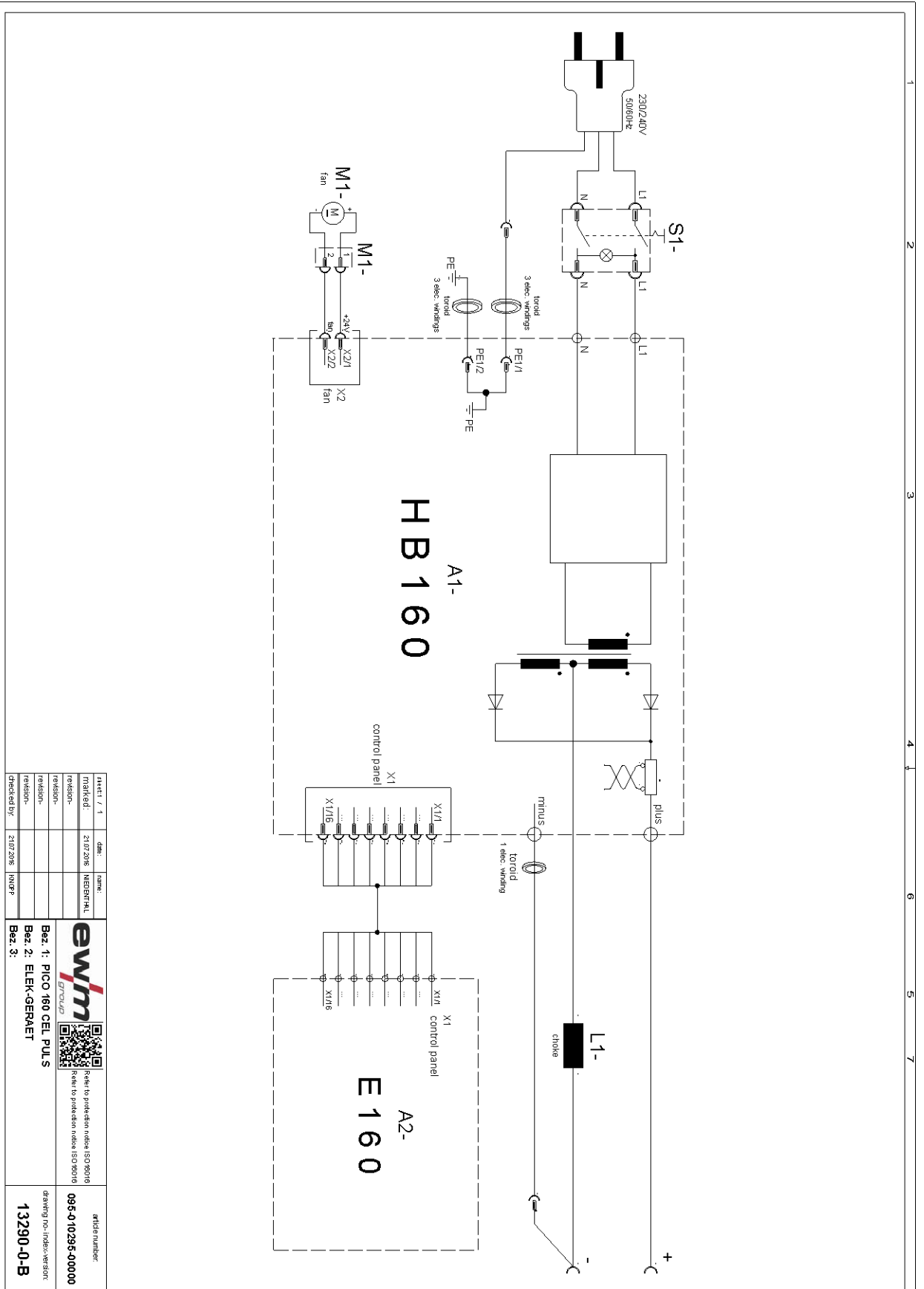























Figure 10-2

marked	date	name	article number
21.07.2016	21.07.2016	INDEPENDENT	095-010295-00000
revision-			Refer to protection index (SPD) 061016
revision-			Refer to protection index (SPD) 061016
revision-			
checked by:	21.07.2016	INDEP	13290-0-B

11 Appendix

11.1 Parameter overview – setting ranges

Welding data display (3-digit)	Parameters/function	Setting range			
		Standard (ex works)	Min.	Max.	Unit
MMA (MMA)					
	Main current (AMP)	100	5 - 150	A	
	Hot start current (AMP%)	120	50 - 200	%	
	Hot start time (sec)	0,5	0,1 - 20,0	s	
	Arcforce correction	0	-10 - 10		
	Pulse frequency	1,2	0,2 - 500	Hz	
	Pulse balance	30	1 - 99	%	
	Pulse current	142	1 - 200	%	
	Arc length restriction	off	off - on		
TIG (TIG)					
	Main current AMP	100	5 - 160	A	
	Start current	20	1 - 200	%	
	Up-slope time	1,0	0,0 - 20,0	s	
	Pulse frequency	2,8	0,2 - 2000	Hz	
	Pulse balance	50	1 - 99	%	
	Pulse current	140	1 - 200	%	
	Arc length restriction	on	off - on		
Basic parameters (independent of procedure)					
	Calibration				
	Exit menu				
	Machine configuration				
	Dynamic power adjustment	16	10 - 20	A	
	Time-based power-saving mode	off	5 - 60	min.	
	Expert menu				
	Access control – access code	000	000 - 999		
	Access control	off	off - on		
	Service menu				
	Power-saving mode active				

11.2 Guide values of magnetic flux density, weldability

TIG welding		GMAW welding	
Magnetic flux density	Weldability	Magnetic flux density	Weldability
<0.5 mT	very good	<3 mT	very good
0.5-1 mT	good	3-4 mT	good
1-2 mT	possible	4-6 mT	possible
2-5 mT	poor	6-8 mT	poor
>5 mT	unsuitable	>8 mT	unsuitable

11.3 Searching for a dealer

Sales & service partners
www.ewm-group.com/en/specialist-dealers



"More than 400 EWM sales partners worldwide"