

TransSteel 2200

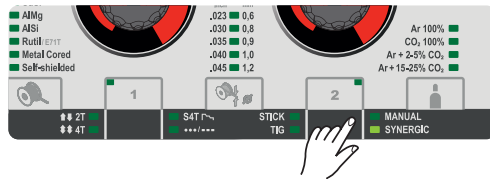
Quick Guide to Synergic Welding



Safety

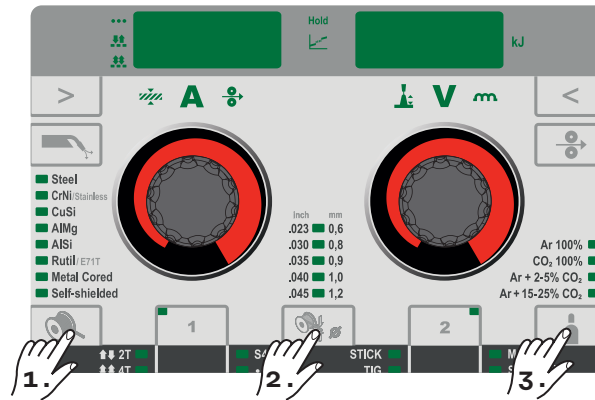
Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online. This document does not describe all the functions of the device. For a complete description of the device, refer to the Operating Instructions.

1 Set the synergic welding process

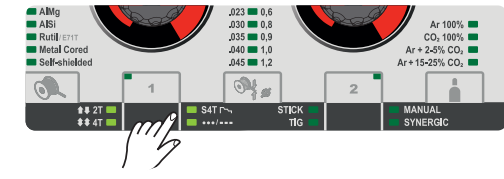


- Synergic** When setting a welding power parameter, the remaining parameters are set automatically.
- Stick** MMA welding
- TIG** TIG Welding
- Manual** The welding power parameters can be adjusted individually.

2 Set the filler metal and shielding gas

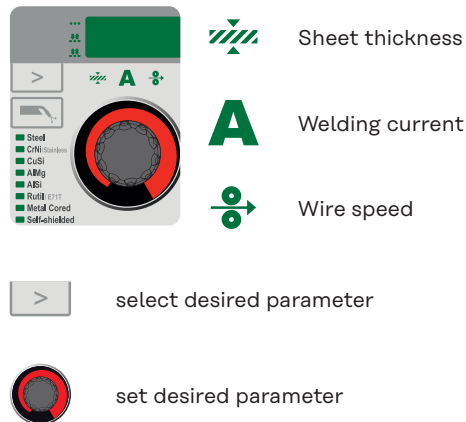


3 Set the operating mode



- 2T** 2-step mode: short weld seams, tacking work
- 4T** 4-step mode: longer weld seams, high level of comfort
- S4T** Special 4-step mode: additional settings for starting and final current
- Spot** Spot welding: for overlapping sheets / stitch welding: light-gauge sheet metal welding and air-gap bridging

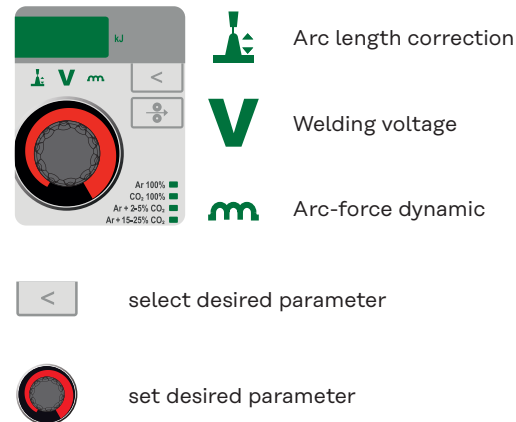
4 Set the welding power



select desired parameter

set desired parameter

5 Set the correction parameters



select desired parameter

set desired parameter

6 Optimize welding results

1. Measure the welding circuit resistance r
2. Set the mains fuse so that the device switches off before the mains fuse trips.

The description of the aforementioned measures can be found in the Operating Instructions of the power source.

i Operating Instructions



<https://manuals.fronius.com/html/4204260241>



SEt	Country-specific setting
r	Welding circuit resistance
L	Welding circuit inductivity
$E_{in}E$	Real Energy Input
FUS	Mains fuse protection
RLC	Arc length correction display

SEI Country-specific setting
 r Welding circuit resistance
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$S E t$	Country-specific setting
r	Welding circuit resistance
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$E_{in} E$	Real Energy Input
$F U S$	Mains fuse protection

SET Country-specific setting
FUS Mains fuse protection

Retrieve

Save

Delete

Available parameters:	Example of display:
Firmware version	1.00 421
Welding program configuration	3 445
Current welding program	r 2 290
Arc time in hours	654 321
Motor current for wire drive in amperes	1 Fd 00
2nd menu level (service)	2nd