

TransSteel 2200

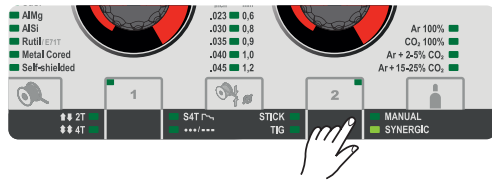
Quick Guide to Synergic Welding



Safety

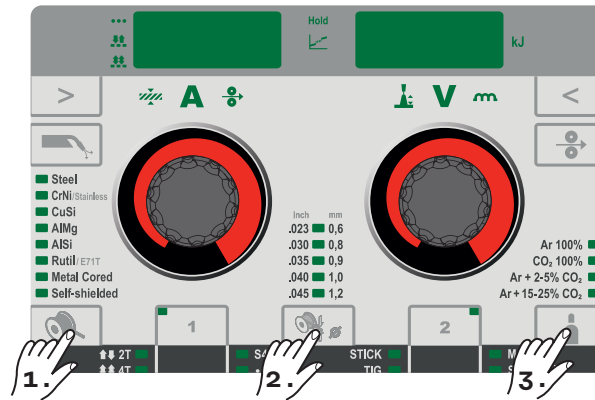
Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online. This document does not describe all the functions of the device. For a complete description of the device, refer to the Operating Instructions.

1 Set the synergic welding process

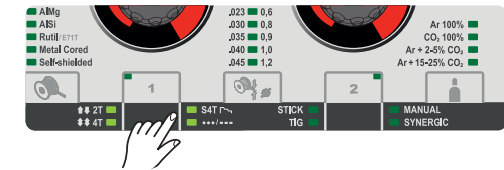


- Synergic** When setting a welding power parameter, the remaining parameters are set automatically.
- Stick** MMA welding
- TIG** TIG Welding
- Manual** The welding power parameters can be adjusted individually.

2 Set the filler metal and shielding gas

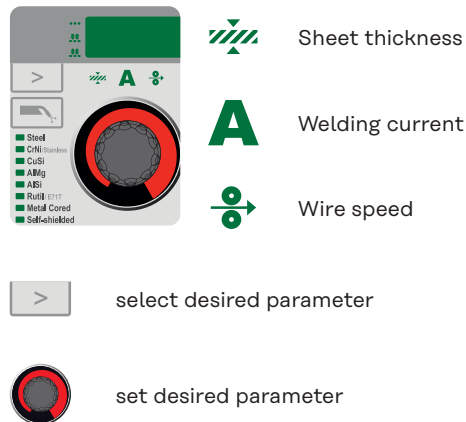


3 Set the operating mode



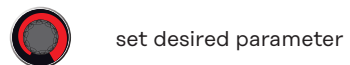
- 2T** 2-step mode: short weld seams, tacking work
- 4T** 4-step mode: longer weld seams, high level of comfort
- S4T** Special 4-step mode: additional settings for starting and final current
- Spot welding** for overlapping sheets / stitch welding: light-gauge sheet metal welding and air-gap bridging

4 Set the welding power



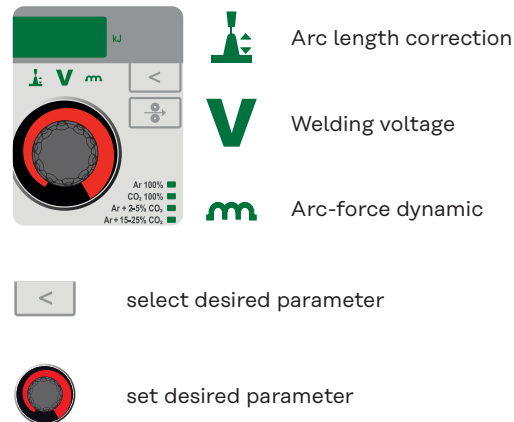
- Sheet thickness
- Welding current
- Wire speed

> select desired parameter



set desired parameter

5 Set the correction parameters



- Arc length correction
- Welding voltage
- Arc-force dynamic

< select desired parameter



set desired parameter

6 Optimize welding results

- Measure the welding circuit resistance r
- 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



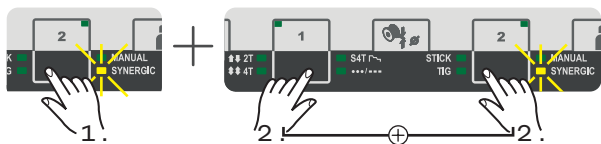
<https://manuals.fronius.com/html/4204260241>



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MIG/MAG Synergic Setup Menu



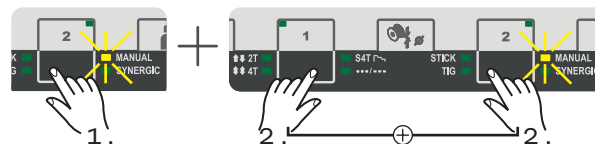
Setup Menu 1st Level

- G P r* Gas pre-flow time
- G P o* Gas post-flow time
- S L* 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)
- F d ,* Wire threading speed
- l t o* Length of wire that is fed before the safety cut-out trips
- S P t* Spot welding time/stitch welding time
- S P b* Interval pause time
- I n t* Operating mode for stitch welding
- F R C* Restore factory setup

Setup Menu 2nd Level

- S E t* Country-specific setting
- r* Welding circuit resistance
- L* Welding circuit inductivity
- E n E* Real Energy Input
- F U S* Mains fuse protection
- R L C* Arc length correction display

MIG/MAG Manual Setup Menu



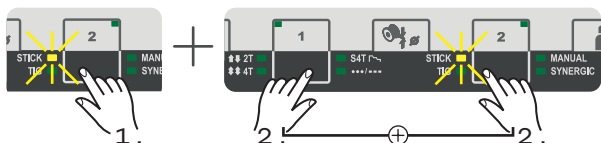
Setup Menu 1st Level

- G P r* Gas pre-flow time
- G P o* Gas post-flow time
- F d ,* Wire threading speed
- l t o* Length of wire that is fed before the safety cut-out trips
- S P t* Spot welding time/stitch welding time
- S P b* Interval pause time
- I n t* Operating mode for stitch welding
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Setup Menu 2nd Level

- S E t* Country-specific setting
- r* Welding circuit resistance
- L* Welding circuit inductivity
- E n E* Real Energy Input
- F U S* Mains fuse protection

MMA Setup Menu



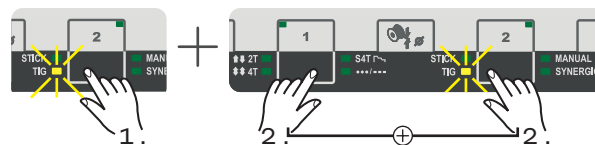
Setup Menu 1st Level

- H C U* HotStart current
- H t ,* HotStart time
- A S t* Anti-Stick
- F R C* Restore factory setup

Setup Menu 2nd Level

- S E t* Country-specific setting
- r* Welding circuit resistance
- L* Welding circuit inductivity
- F U S* Mains fuse protection

TIG Setup Menu



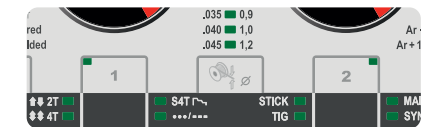
Setup Menu 1st Level

- F - P* Pulse frequency
- t U P* UpSlope
- t d o* DownSlope
- I - S* Starting current
- I - 2* Reduced current
- I - E* Final current
- G P o* Gas post-flow time
- t R C* Tacking
- F R C* Restore factory setup

Setup Menu 2nd Level

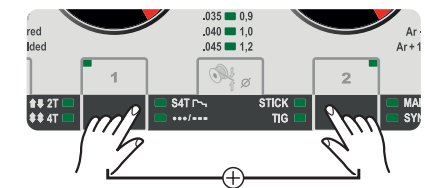
- S E t* Country-specific setting
- F U S* Mains fuse protection

EasyJobs

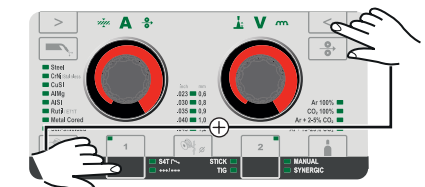


- Retrieve 1x 163
- Save 1 Pro 180
- Delete 1 CLR

Exiting the Setup Menu



Activating/Deactivating the Key Lock



Displaying Service Parameters



Available parameters:

- 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 Fd 00
- 2nd menu level (service) 2nd

Example of display: