MIGATRONIC AUTOMIG II Welding System Instruction Manual

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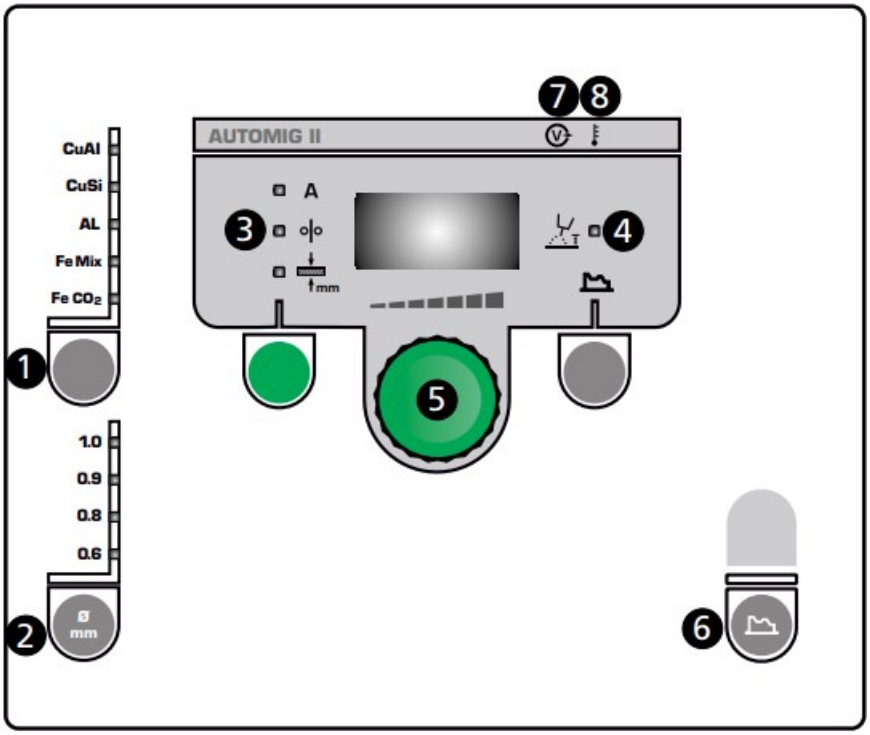
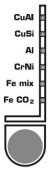
control panel



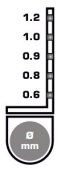
Contents

Selection of material type



Press the  -key pad until the indicator for the required material is switched on

Selection of wire dimension



Press the  -key pad until the indicator for the required diameter is switched on. Not all wire dimensions can be used for all materials.

Reset to factory settings: Factory settings for the selected wire dimension will be reloaded when pressing the key

pad until the indicator gives a short flash.

Current/wire feed speed/material thickness

A When the machine is not welding, the set current/ wire feed speed/material

dimension is displayed. During welding the measured current is displayed.

mm Material thickness:

The function helps adjusting the current according to material thickness (in mm). When selecting material thickness an automatically setting of current is calculated. Thereafter, the current can be further adjusted.

The material thickness function can be seen as a good starting point in the selection of correct current and voltage. A trimming of these parameters will be required in almost every welding task in order to obtain the most optimum result.

Arc length

If necessary, the arc length can be adjusted by trimming the voltage. The measured voltage is shown during welding. Press the -key pad and adjust from -9,9 to +9,9.

Control knob

This knob is used for adjusting welding current, wire feed speed, material thickness, arc length or secondary parameters. Inching speed is adjustable during wire inching. Max. wire feed speed is 18.0 m/min.

Setting of secondary parameters

Press the keypad until the requested parameter is displayed. Turn the control knob up and down until the requested value is displayed. Press the key for arc length or current/wire feed speed/material thickness briefly to return to normal display

Arc adjust:
Arc-adjust (electronic choke) makes it possible to adjust the speed of reaction to short-circuits. Arc-adjust can be set in steps from -5.0 to +5.0

Gas pre-flow:

Gas pre-flow ensures that the arc is fully protected from atmosphere before an arc is established. Gas pre-flow time is the time from activating the torch trigger until the wire feed starts. The gas pre-flow time can be set between 0.0 sec. and 10.0 secs.

Soft start:

Soft start improves the ignition characteristics. Here speed with which the wire shall start is set. The speed is set between 1.5- 18.0 m/min. The soft start function is disengaged when displaying – – – .

Hot-start time:

Hotstart is a function which help creating the right temperature in the weld pool at the beginning of the welding. Hot-start time determines the time in which welding in hot-start takes place. The time can be set between 0 and 10 secs.

Slope-down:

The time of the current slope-down is set. By activating the trigger, the slope down begins in order to make a crater filling. The current reduces from the adjusted current to stop amp

Burn back:

The burn back function prevents the welding wire sticking to the workpiece at the end of a weld. Burn back can be adjusted between 1 and 30.

Gas post-flow:

Gas post-flow time ensures protection of the molten pool after welding and cools off the torch. The gas post-flow time is the time from which the arc extinguishes to the gas flow being disconnected. The time can be set between 0.0 and 10.0 secs.


Stop amp:
Stop amp is adjustable between 0-100% of the set welding current.


Remote control:
Choose between internal and external adjustment.

0 = internal
1 = torch control

When the machine is switched off, the adjusted parameters are saved internally in the machine. Simultaneously, the number of the most recently used program is saved so that the machine will start up in this.

Please note: Automig2 i DUO saves the number of the most recently used program separately for each wire feed unit.

Welding voltage indicator


The welding voltage indicator is illuminated for reasons of safety and in order to show if there is voltage at the electrode or torch.

Temperature fault


The indicator is switched on, when the power source is overheated.

For tack welding,
we recommend the following settings

- 2 Gas pre-flow = 0.2 s*
- 4 Hot-start time = 0.10 s
- 5 Slope-down = 0.0 s
- 7 Gas post-flow = 3.0 s*

* Gas pre-flow and gas post-flow are reducable for faster tack welding. This may result in lack of gas shielding.

Documents / Resources

	**MIGATRONIC AUTOMIG II Welding System** [pdf] Instruction Manual AUTOMIG II Welding System, AUTOMIG II, Welding System, System

References

- All-guides – Innovative Search Service of Online Manuals
- ltd.no
- Migatronic - Welding Machines and Equipment