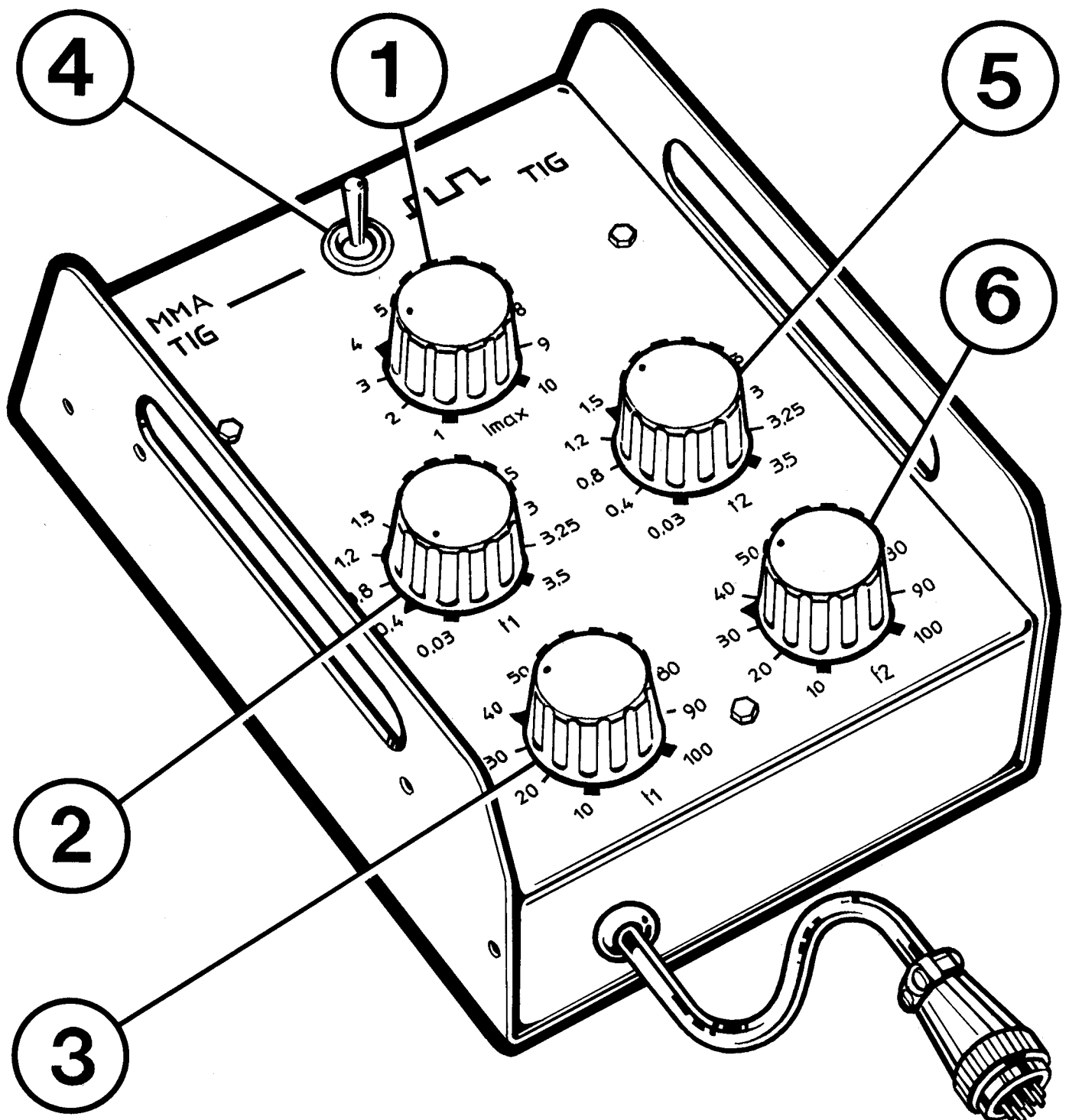


**MANUALE DI ISTRUZIONE PER DISPOSITIVO DI PULSAZIONE**  
**INSTRUCTION MANUAL FOR PULSING DEVICE**  
**BETRIEBSANLEITUNG FÜR PULSIERUNGVORRICHTUNG**  
**MODE D'EMPLOI POUR DISPOSITIF A IMPULSIONS**  
**MANUAL DE UTILISACIÓN DEL DISPOSITIVO DE PULSACIÓN**



This device has been developed for weld with pulsing arc following the T.I.G. procedure and it can be also used as a remote control for continuous TIG weld and with coated electrodes. The pin connected to the outgoing cable of the device should be connected to the connector provided for remote controls.

## CURRENT PULSING

The pulsing current offers the following advantages:

- easier welding of small thicknesses
- easier control of the weld arc
- fewer difficulties with plates of different thicknesses
- fewer possibilities that hot flaws occur
- fewer faulty welded pieces

This device is especially used for stainless steel and nickel alloys.

## FUNCTIONS DESCRIPTION

### 1 Knob adjusting the weld current ( $I_{max}$ )

It sets the maximum power while welding. When the potentiometer is at the maximum level, the current value will correspond to that indicated in the features plate.

### 2 Knob adjusting time ( $t_1$ )

It adjusts the time of the peak current. It varies time from 0.03 sec. to 3.5 sec.

### 3 Knob adjusting peak current ( $I_1$ )

This is a percentage of the  $I_{max}$  current set by knob (1). When this knob is on the highest position (100%)  $I_1$  current is equal to  $I_{max}$  one.

### 4 Weld selector

On position (MMA/TIG) a current without pulsing is obtained. Its value is the one set by knob (1)  $I_{max}$ . All other adjustments are excluded. On position (TIG) a pulsed current is obtained. Its rate times are  $t_1$  and  $t_2$  and the weld currents are those set by  $I_1$  and  $I_2$ .

### 5 Knob adjusting time ( $t_2$ )

It adjusts the time of the basic current. It varies time from 0.03 to 3.5 sec.

### 6 Knob adjusting the basic current ( $I_2$ )

This is a percentage of the value of the current set by knob (1) i.e.  $I_{max}$ .

## INSTALLATION

Once the pulsing control support has been connected to the upper part of the housing, put the device on it.

Connect the pin to the connector provided for remote controls and select the type of weld.

### Pulsed T.I.G. weld

Selector switch (4) is turned to right, generator starting selector switch is turned to TIG, knob (1) is turned to the highest position (clockwise). Set  $I_1$ ,  $I_2$ ,  $t_1$ ,  $t_2$ .

Theoretically, the peak current  $I_1$  should be 4 times as high as the basic current  $I_2$ .

In order to achieve good results position the peak current  $I_1$  to the highest possible level and set the duration time of this current ( $t_1$ ) as short as possible so as not to lose the arc control.

The basic minimal current ( $I_2$ ) should be chosen for welding. The duration time ( $t_2$ ) should make the cast metal to be cooled without cratering.

The weld speed is then determined by time  $t_2$  that is of course the longest time.

If it is noted while welding that currents ( $I_1 - I_2$ ) are not suitable whereas the weld speed is good, simply turn knob (1)  $I_{max}$  clockwise or counter-clockwise to increase or decrease both weld currents, respectively without losing the pulsing rate.

### Continuous weld (MMA/TIG)

Selector switch (4) is turned to the left. Generator starting selector switch is turned to TIG or electrode. In this position only knob (1) of current  $I_{max}$  works.

To decentralize this accessory demand for extension art.1326.