

QUICK GUIDE



MULTI STATION VAS 821001



SAFETY

Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online. This document only describes the most important functions of the device. For a complete description of the device, refer to the Operating Instructions.

1 Set the filler metal and shielding gas

- Open the material selection

- Turn and press to enable the desired settings

2 Set the welding process

- Press to select the desired welding process

2 Set the operating mode

- Press to select the desired mode

4 Set the welding power

- Sheet thickness
- Welding current
- Wire speed
- Special function F1

- select desired parameter

- set desired parameter

5 Adjust the parameters for correction

- Arc length correction
- Welding voltage
- Pulse/dynamic correction
- Special function F1

- select desired parameter

- set desired parameter

Text display:

- Activate / deactivate = press left adjusting dial
- Scroll through full text = turn left adjusting dial

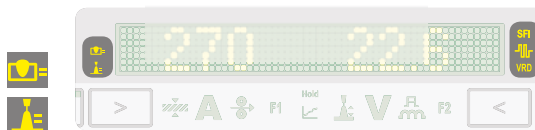
Abbreviation Full text

ALS 0.0 + = Start arclenath

Status indicators:

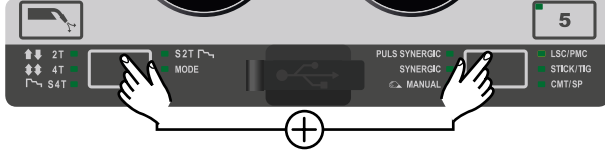
(light up when the respective function is active)

- Arc length stabilizer
- Penetration stabilizer



- SFI Spatter Free Ignition
- SynchroPulse
- VRD Voltage Reduction Device

Entering/exiting the Setup menu



Process parameters

I-S	Starting current (135)
AI-S	Start arc length correction (0)
t-S	Starting current time (off)
SL1	Slope 1 (1.0)
SL2	Slope 2 (1.0)
I-E	Final current (50)
AI-E	End arc length correction (0.0)
t-E	Final current time (off)
SFI	SFI ignition (off)
SFI-HS	SFI HotStart (off)
W-r	Wire retract (0.0)
IgC	Ignition current (manual), (450)
W-r (man.)	Wire retract (manual), (0.0)

Gas Setup

Gpr	Gas pre-flow (0.1)
GPo	Gas post-flow (0.5)

Process control

PSt	Penetration stabilizer (0.0)
AISt	Arc length stabilizer (0.0)

Components

C-C	Cooling unit operating mode (auto)
C-t	Filter time flow sensor (10)
Fdi	Feeder inching speed (10.0)
ito	Ignition timeout (off)

STICK

I-S	Starting current (150)
Hti	Starting current time (0.5)
Eln	Characteristic (I-constant)
Ast	Anti-stick (on)
Uco	Break voltage (90.0)

TIG

Uco	Break voltage (14.0)
CSS	Comfort-Stop sensitivity (0.8)

SynchroPulse

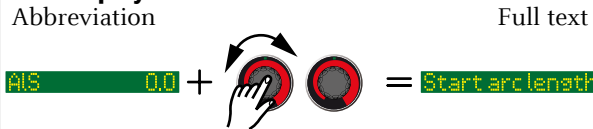
Syn-Puls	SynchroPulse (off)
vd	Wire speed (5.0)
dFd	Delta wire feed (2.0)
F	Frequency (3.0)
DC	Duty cycle (50)
AI-h	Arc correction high (0.0)
AI-l	Arc correction low (0.0)

(Values/entries in brackets show the factory setting)

Activating/deactivating the key lock



Text display



Process Mix

vd	Wire speed (1.5)
AIC	Arc length correction (0.0)
PDC	Pulse/dynamic correction (0.0)
Hptc	Upper power time correction (0)
Lptc	Lower power time correction (0.0)
Lpc	Lower power correction (0.0)

R/L-check / alignment

Aligning welding circuit resistance
welding circuit inductivity

Settings

Display	Units
Ein.	Standards
Norm	Display brightness setting
UIBS	User-defined parameters for F1 and F2
F1/F2 Param.	Favourite key
Favorit	System data
IP	

System

CLS	Housing lighting setup
FAC	Restore factory settings
Web-PW reset	Reset website password
Information:	IM-V. / SWV / IP
Operating mode setup:	S4T / ijob

Language

cs, de, en, etc.

Favourite

The Favourite key can be assigned the Setup parameter or Setup folder that is currently selected.

Retrieve:		1x			150
Save:					★
Delete:					★x

EasyJobs

The EasyJob keys allow up to 5 operating points to be saved. Specifically, the current welding-relevant settings are saved.

Retrieve:		1x			17.5 620
Save:					Job1✓
Delete:					Job1x

F1 / F2 special function parameters

Retrieve:					150
Save:					F1✓
Delete:					F1x
Use the key for F2!					

QUICK GUIDE TO SYNERGIC WELDING



PART
2

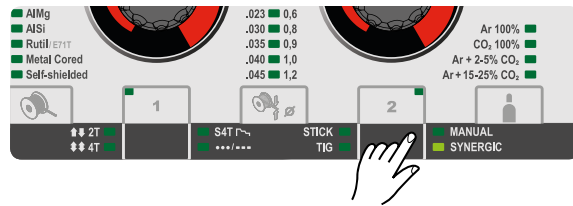
MULTI STATION VAS 821001



SAFETY

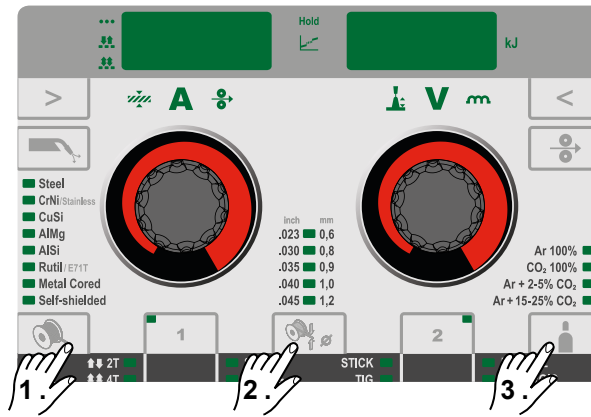
Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online. This document does not describe all the functions of the device. For a complete description of the device, refer to the Operating Instructions.

1 Set the synergic welding process

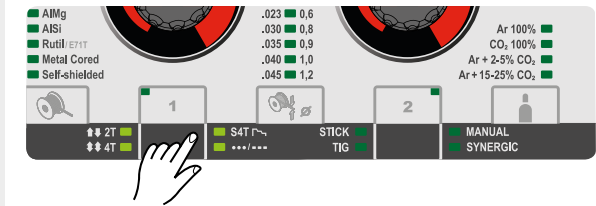


- SYNERGIC** When setting a welding power parameter, the remaining parameters are set automatically
- STICK** MMA welding
- TIG** TIG welding
- MANUAL** The welding power parameters can be adjusted individually

2 Set the filler metal and shielding gas

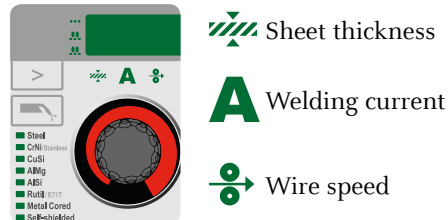


3 Set the operating mode



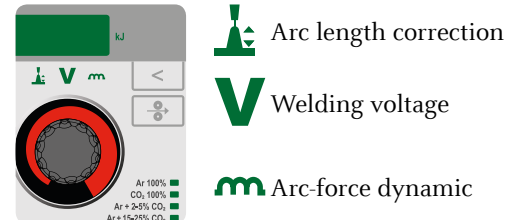
- 2T** 2-step mode: short weld seams, tacking work
- 4T** 4-step mode: longer weld seams, high level of comfort
- S4T** Special 4-step mode: additional settings for starting and final current
- Spot welding**: for overlapping sheets / stitch welding: light-gauge sheet welding and air-gap bridging

4 Set the welding power



- > select desired parameter
- set desired parameter

5 Adjust the parameters for correction



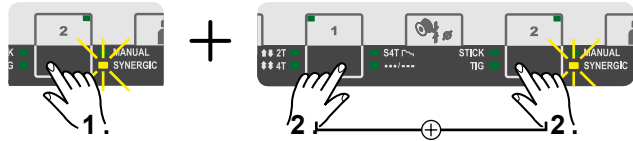
- < select desired parameter
- set desired parameter

6 Optimise 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

MIG/MAG Synergic Setup menu



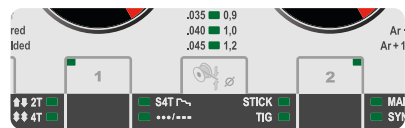
Level 1 Setup menu

- 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* Feeder inching speed
- I t o* Length of wire that is fed before the safety cut-outs trips
- S P t* Spot welding time / interval welding time
- S P b* Interval pause time
- I n t* Operating mode for stitch welding
- F A C* Restore factory setup

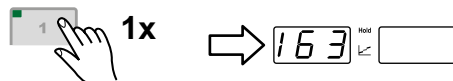
2nd Level 2 Setup menu

- 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
- A L C* Arc length correction display

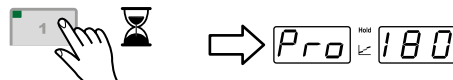
EasyJobs



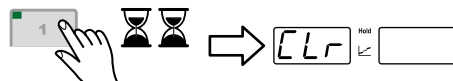
Retrieve:



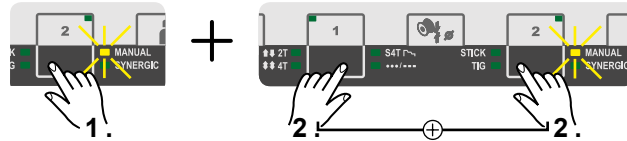
Save:



Delete:



MIG/MAG Manual Setup menu



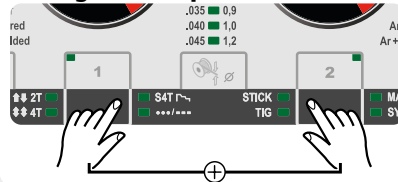
Level 1 Setup menu

- G P r* Gas pre-flow time
- G P o* Gas post-flow time
- F d* Feeder inching speed
- I t o* Ignition current
- I t o* Length of wire that is fed before the safety cut-out trips
- S P t* Spot welding time / interval welding time
- S P b* Interval pause time
- I n t* Operating mode for stitch welding
- F A C* Restore factory setup

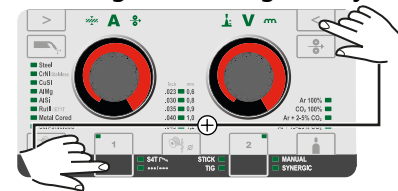
2nd Level 2 Setup menu

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

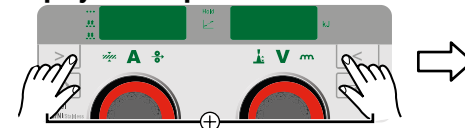
Exiting the Setup menu



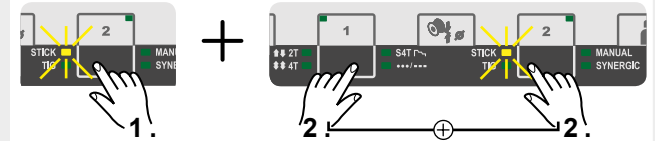
Activating/deactivating the key lock



Display service parameters



MMA Setup menu



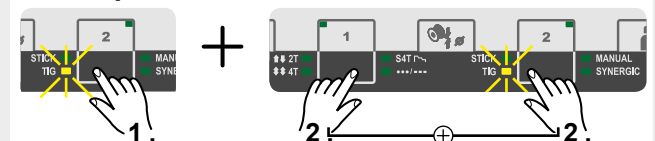
Level 1 Setup menu

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

2nd Level 2 Setup menu

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

TIG Setup menu



Level 1 Setup menu

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

2nd Level 2 Setup menu

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

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 ampere	I Fd	00
2nd menu level (Service)	2nd	