

1 CC • Arc Force (Dig) /
CV • Inductance

Use CC/CV Switch (see Figure 4-4) to select weld amperage (CC) or voltage (CV). If CC position is selected, adjust Arc Force (Dig). If CV, adjust Inductance.

Numbers around control are for reference only.

CC • Arc Force (Dig)

For SMAW (Stick Electrode) welding, use control to help start an arc or make vertical or overhead welds (control increases short-circuit amperage, as shown in Figure 2-1).

When set at 0, short-circuit amperage is the same as normal welding amperage.

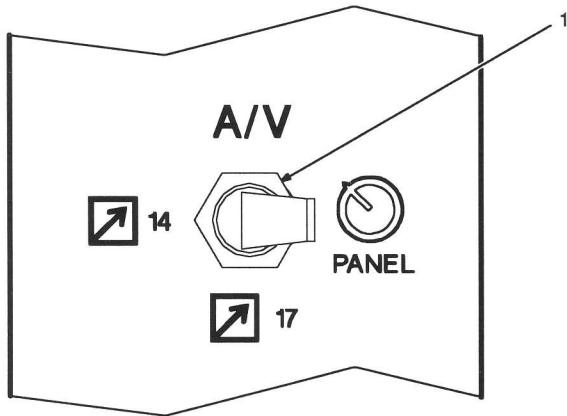
When setting increases, short-circuit amperage increases to help arc starting and decrease electrode sticking to workpiece.

Set at 0 for GTAW and GMAW-P welding.

CV • Inductance

Use this control to change weld output inductance for GMAW and FCAW. Inductance determines the "wetness" of the weld puddle. When setting increases, wetness increases.

Figure 4-6. Arc Force (Dig)/Inductance Control



1 Amperage/Voltage Control Switch

Use switch to select way of controlling amperage and voltage adjustment.

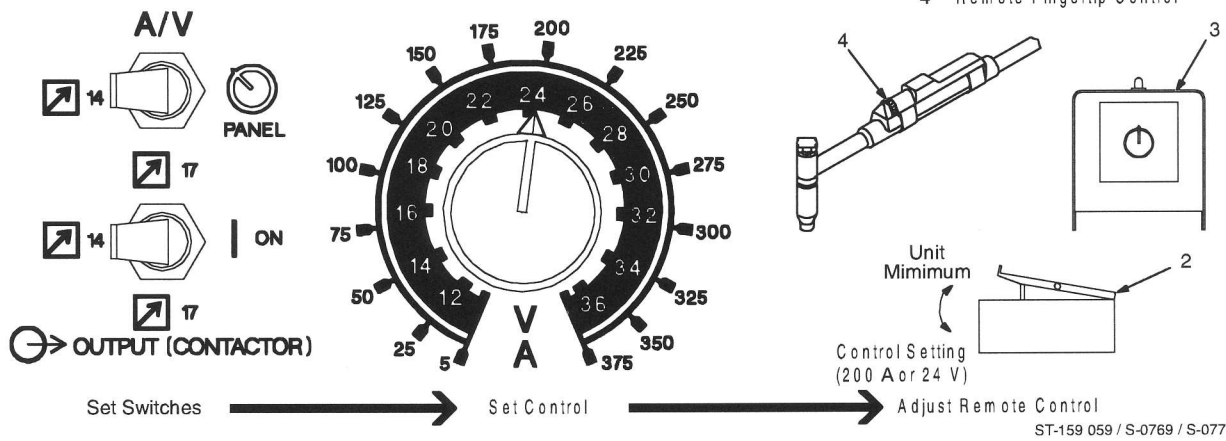
For front panel control, place switch in Panel position.

For remote control, place switch in Remote 14 or Remote 17 position (see Sections 3-5 and 3-6).

Remote control at Remote 17 receptacle adjusts percent of front panel setting if socket K is used. If socket A is used, remote control adjusts the full range of the welding power source output, regardless of front panel control setting.

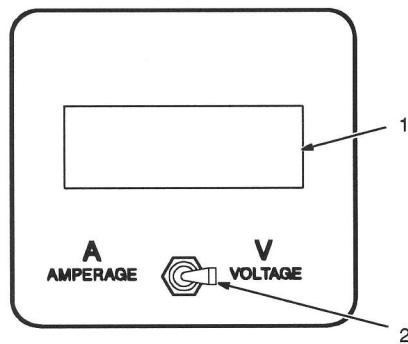
Remote control at Remote 14 is percent of front panel control. See Example below.

EXAMPLE Of Combination Remote Amperage/Voltage Control



- 2 Remote Foot Control
- 3 Remote Hand Control
- 4 Remote Fingertip Control

Figure 4-8. Amperage/Voltage Control Switch



1 Amperage/Voltage Meter

Use meter to read amperage and voltage output. The preset value is displayed when not welding. The actual value is displayed while welding and is held for 15 seconds after welding stops (see Section 9-4).

See table for the values displayed for A/V and CC/CV switch settings.

2 Meter Switch

Use switch to select amperage or voltage display.

Switch Positions		Meter Display	
A/V	CC/CV	When Not Welding	When Welding
A	CC	Preset Amps	Actual Amps
A	CV	Preset Volts	Actual Amps
V	CC	Preset Amps	Actual Volts
V	CV	Preset Volts	Actual Volts

Figure 4-9. Amperage/Voltage Meter And Switch

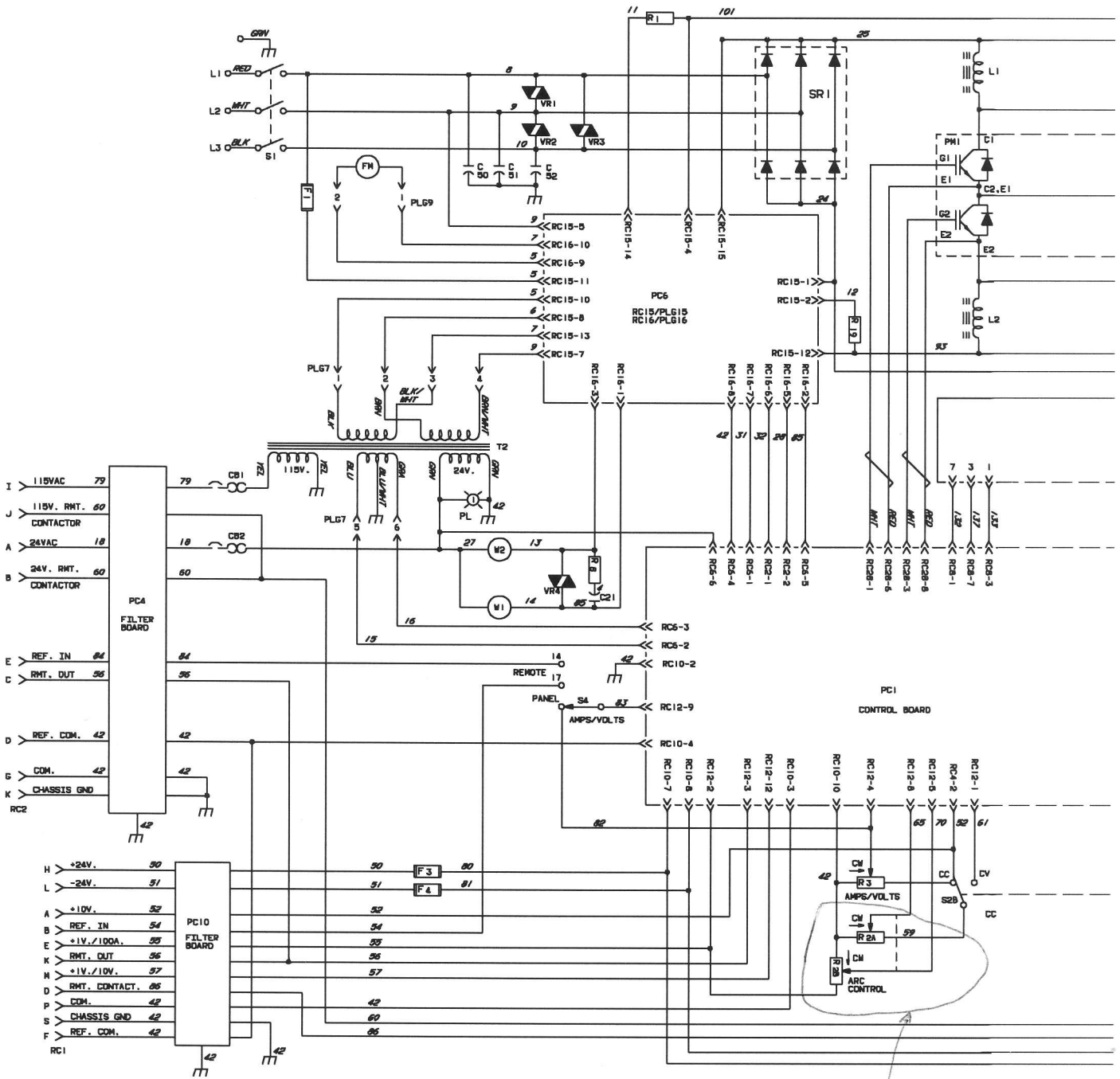


Figure 11-1. Circuit Diagram For 230/460 Volt Models Without PC1 Upgrade Kit
153 391 Installed

