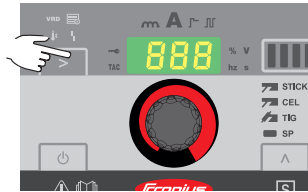




### Safety

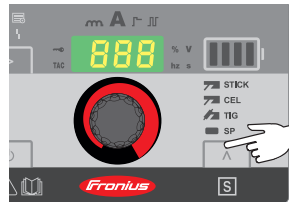
Before carrying out any work with the device, ensure that you have read and understood all the documents provided as well as those available online! This document does not describe all the functions of the device. For a complete description of the device, refer to the Operating Instructions!

## Welding Settings



### Setting values:

- ⇒ **m** Arc-force dynamic: 0 - 100 | factory setting = 20
- ⇒ **A** Welding current: 10 - 140 A (STICK), 3 - 150 A (TIG)
- ⇒ **⌋** SoftStart / HotStart function: 0 - 200% | factory setting = 130%
- ⇒ **⌋⌋** TIG pulsing (only available with TIG version)



### Available welding processes:

- ⇒ **⚡** STICK MMA welding
- ⇒ **⚡** CEL MMA welding with Cel electrode
- ⇒ **⚡** TIG TIG welding
- ⇒ **■** SP Reserved for special programs



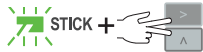
### Operating Instructions



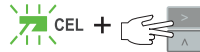
<https://manuals.fronius.com/html/4204260176>



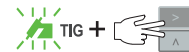
## Accessing the setup menu



Setup menu - MMA welding



Setup menu - Cel electrodes



Setup menu - TIG

## Changing welding parameters



Turn and press the adjusting dial to select and change parameters.

### Parameters for MMA Welding

<b>Ht</b>	Starting current duration: 0.1 - 1.5 seconds   0.5 seconds*
<b>ASt</b>	Anti-stick: On*/OFF
<b>Uco</b>	Break voltage: 25 - 80 V   45 V*
<b>SDF</b>	Software version
<b>tSd</b>	Automatic switch-off: 300 - 900* seconds / OFF
<b>FAC</b>	Factory setting

### Parameters for TIG welding

<b>CS</b>	Comfort Stop sensitivity: 0.3 - 2.0 V / OFF   0.5 V*
<b>Uco</b>	Break voltage: 12 - 35 V   15 V*
<b>SDF</b>	Software version
<b>tSd</b>	Automatic switch-off: 300 - 900* seconds / OFF
<b>FAC</b>	Factory setting

\*factory setting