USER'S MANUAL FOR THE

PSxx4

PROGRAMMING AND ARCHIVING KIT

FOR PS 164 - PS 204 - PS 254 - PS 254-2

POWER SOURCES





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Contents

1.	USER'S RIGHTS CONVENTION	4
2.	SETTING UP THE PSXX4 KIT	5
	2.1 INSTALLING THE SOFTWARE PACKAGE	5
	2.2 DETAIL OF PSxx4 WORKING FILES	7
	2.3 CONNECTING THE MEMORY CARD READER TO THE PC	8
	2.4 USING THE MEMORY CARD READER	10
	2.5 CONFIGURING AND TESTING THE PORT USED BY THE CARD READER	11
	2.5.1 Serial port configuration	11
	2.5.2 Communication test with the reader	12
	2.6 THE PSXX4 MAIN SUREEN	13
	2.6.7 Detail of the main menu	14
		- 17
3.	CHANGING LANGUAGES AND CHOOSING UNIT	15
4.	CREATING A WELDING PROGRAM	15
	4.1 USING THE PROGRAM BANK PRE-ESTABLISHED BY POLYSOUDE	15
	4.2 Using the program editor directly	18
5.	EDITING A WELDING PROGRAM	19
	5.1 "Notebook / Welding" Тав	20
	5.1.1 Choice of welding head	21
	5.1.2 Configuring the R30 parameter	21
	5.1.3 Entering the article diameter	22
	5.1.4 Choice of power source	23
	5.1.6 Opening documentation attached to the weld	24
	5.1.7 Frasing documentation attached to the weld	26
	5.2 "PRE-GAS/ PRE-FUSING" TAB	27
	5.3 "Welding" TAB	28
	5.3.1 Adding a sector to the weld	29
	5.3.2 Inserting a sector between two sectors	30
	5.3.3 Erasing a sector	31
	5.4 "DOWN SLOPE / POST-GAS" TAB	32
	5.5 MAKING A BACKUP COPY OF THE WELDING PROGRAM	33
6.	LIAISON WITH THE MEMORY CARD READER	35
	6.1 DESCRIPTION OF THE LIAISON WINDOW	35
	6.2 WRITING PROGRAMS ON THE CARD	37
	6.3 READING THE CONTENTS OF A CARD AND RECUPERATING THE PROGRAMS	38
	δ.4 ERASING THE CARD	39



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2. SETTING UP THE PSxx4 KIT

The PSxx4 kit comprises:

- A memory card reader with connecting leads,
- A floppy disk containing the PSxx4 software package for Windows,
- This instruction sheet.

2.1 INSTALLING THE SOFTWARE PACKAGE

- Insert the floppy disk in the PC reader and launch the "Setup.exe" program in the root.
- The display below should appear once the program has been loaded. Choose the language in which you wish the installation to be done, then validate by clicking on the "OK" button.

POLYSOUDE	
Deutsch English Français Italiano Nederlands	
	X Cancel

 "Setup.exe" proposes the program installation directory by default, as shown on the screen below.

POLYSOUDE	<i>PSxx4 setup program</i> Copyright (c) 2001 - POLYSOUDE
Destination directory.	
C:\POLYSOUDE	🚰 Browse
Click on "Install" to start installation.	Install
	👖 Close

• To change directories, simply click on the "Browse" button to display a directory selection window (see following figure) and choose the new directory.

	1-Choice	of reader			
2-Choice of directory			3-Vali	dation of choic	e
Sélection du répertoire Nom de répertoire :	•			×	
F:\Program Files\PSxx4 <u>R</u> épertoires : <u>F:\</u>		<u>F</u> ichiers	: (*,*)		
 Program Files ACD Systems AvantGo Connect DAP Microsoft ActiveSy 	nc				
			; : data disk - local] OK ◀	Annuler	

Next, click on the "Install" button to finish installing the software package. At the end
of the installation, the display below appears to show that the operation was done
correctly. Validate with the mouse by clicking on the "OK" button.

	Information		×	
PÖL				ram
	i	Installation ready.	<u> </u>	DLYSOUDE
Destination c	N			
T:\MARKETIN				Browse
Installation				Install
			_	
				<u>C</u> lose
		🔀 <u>C</u> ancel	<u>✓ </u> <u>0</u> K	

• The software package is installed.



2.2 DETAIL OF PSxx4 WORKING FILES



2.3 CONNECTING THE MEMORY CARD READER TO THE PC

The memory card reader comprises a case that plugs in to the computer via two cables:

- one to supply power to the case via the PC's PS2 back plate (mouse port),
- the other ensures communication between the PC and the case, via the PC's serial port (COMx port).



To connect the reader to the PC:

- Quit Windows and disconnect the PC's power supply.
- Plug the serial port into the PC's COM1 port.
- Disconnect the mouse.
- Plug the reader power supply into the mouse port.
- Connect the mouse to the free outlet on the reader power cable.
- Re-connect the PC's power supply the reader is ready for use.

The figure below shows a correct reader connection.





2.4 USING THE MEMORY CARD READER

The memory card should be inserted into the reader slot with the chip contact side up, as shown in the figure below. Push it in until it touches the stop inside the reader.



Note:

There is no danger of the reader or card being destroyed if it is inserted the wrong way up. You will simply not be able to read or write a program until it has been replaced the right way up.



2.5 CONFIGURING AND TESTING THE PORT USED BY THE CARD READER

The "Setup.exe" installation program adds a configuration and reader test utility program to the $Windows^{\mathbb{M}}$ configuration panel (icon below).



The default configuration, used by the PSxx4 software package to communicate with the reader card, is a connection to the **COM1** port. This corresponds to the majority of PC configurations. However, if this choice is not compatible with the configuration of your PC, you can change the port number attributed to the card reader, as described in the following procedure.

2.5.1 Serial port configuration

Start up the "Smart Card Reader" utility program in the configuration panel.



2.5.2 Communication test with the reader

To check the liaison between the PC and the card reader, launch the "Test" option in the "Smart Card Reader" utility program.





2.6 THE PSxx4 MAIN SCREEN

The "Setup.exe" installation program automatically adds the shortcut enabling to launch the PSxx4 software package to the *Windows*[™] desktop (icon below).



When starting up PSxx4, the main screen is displayed.





2.6.1 Detail of the shortcut bar



2.6.2 Detail of the main menu

The main menu contains exactly the same commands as those accessible in the shortcut bar.





3. CHANGING LANGUAGES AND CHOOSING UNIT

Simply click on the corresponding shortcut button, choose a language in the list (figure below) and validate by clicking on the "OK" button.



Choose the programming units by clicking on the corresponding button.

- mm/min sector start is made in degrees (impulses)
- rotations/min (RPM) sector start is made in seconds

4. CREATING A WELDING PROGRAM

There are two ways of creating a new program:

- Using the program bank pre-established by Polysoude,
- Using the program editor directly.

4.1 Using the program bank pre-established by Polysoude

Click on the following icon in the shortcut bar to launch the search utility program.



Or, in the main menu, select "File" then "Search".





The following dialogue box is displayed on the screen. It enables you to specify:

- The material you wish to weld,
- The diameter and thickness of the article to be welded,
- A tolerance range authorized according to the values searched for, to enable to find all the welding programs that come under the defined bracket.

S	Configuration part Material Carbon steel Carbon steel Other	barameters X
Click here to launch the search	Diameter Wall thickness	16 \pm 10.8 \pm 0.1The units in the POLYSOUDE database are in mm
	X ⊆ancel	Search CP Open

Note:

The program search is done in the first instance in the Polysoude PSxx4's "**Database**" subdirectory, then in the user "**WId**" sub-directory, and then in all the directories that may have been created in the same directory structure as the first two.

The sub-directories created within these sub-directories are not scanned by the search utility program.

If no digital value is entered into the "Diameter" and "Thickness" fields, the utility program will search all the programs corresponding to the material you have entered.

If no digital value has been entered for the search tolerances, the exact value specified for the diameter and/or thickness will be searched for.

List containing the result	search
POLYSOUDE - Programming of PSxx4 Program Memory card About	
 У ∔∔ □ ⊯ ⊫ #	
	Search programs by parameters configuration net Statiless steel Carbon steel Carbon steel Carbon steel Th units in the POLYSOUDE database are in mm NSERVMATISERVEUR MARKETING MARILELSMANUE Search Click here to create a program from the one pointed to in the list

4.2 Using the program editor directly

Click on the following icon in the shortcut bar to create a new program.



Or, in the main menu, select "File" then "New".

POLYSOUDE - Programming of PSxx4					
Program Memory card	About				
Tanguage					
Search	h 🚅 🗆 🖷 🔺				
 New program					
Open					
Save					
Save as					
Print					
Exit					

Before continuing editing the program, PSxx4 will ask you to name the welding program you wish to create. For example, "TEST 16 x 0.8".

Create program	? ×	
Rechercher dans : 🔁 WLD 💌 🗲 🗈 📸		
Nom de fichier : Type : Program PSxx4 (*.WLD)	Annuler	
iter the name of the new program here	Validate the name	

Note:

The file extension is optional. PSxx4 places it automatically when saving the program.



5. EDITING A WELDING PROGRAM

The example below shows the editor using the result of the search described in paragraph 4.1.

The editor comprises four tabs that break the welding program down into logical blocks.

	Reminder name	of access	path	and	proį	gram			
			۲						1-1-1
! <u>~</u> \\58	RVMAT\SERVE	UR_MARKETIN	G\MARI	KETING		UELS\M		LVIE\PSXX4\I.	
Note pa	aa) wela cycle	Pre gas / Pretusio	on Weld	ding D	iown sli	ope / Pos	it gas		
Power	source	P5254	/	/`	_/	Ĩ	E D	ocumentation	
weidin	ig nead	/?		==i		」	\sim		
-Conf	in uration part	H3U =		_ /	Wire	e feeder			-
D	i <mark>ameter</mark>	/ 16 mm	/		Mate	rial			
V	all thickness	0,8 mm/	/		Diam	eter			
M	laterial /	Stainless steel	\neg		Batch	n no.			
Gas			/		ungstei	n			
We	l¢ing gas / [Mater	ial	TH2	%	
Bac	kpurging gas 🏻 🗍				Diam	eter		1,6 mm	
Sup	plementary gas				Elect	rode ang	le	20*	
Dia	. ceramic hozzle				Tip di	iameter		1/10	
Len	gth ceramic nozz	le /			Leng	th			
Comme	ents /	/							
									4
	V								
Four parar	program neters	tabs to ac	cess	weldi	ing				

5.1 "Notebook / Welding" Tab

This page:

- Defines the Polysoude material that will be used for the weld,
- Gives the diameter of the article to be welded,
- Documents/Comments on the general welding parameters (optional),
- Attaches files or documents from applications other than PSxx4 to the weld (optional).

V\SERVMAT\SERVEUR_MARKETING\MARKETING\MANUELS\SYLVIE\PSXX4\I							
Note pad / Weld cycle Pre gas / Prefusion Welding Down slope / Post gas							
Power source P5254							
Welding head	?	· · · · · · · · · · · · · · · · · · ·					
	R30 =	Filler wire					
Configuration part Diameter	16 mm	Material					
Wall thickness	0,8 mm	Diameter					
Material Stai	inless steel	Batch no.					
Gas		Tungsten					
Welding gas		Material	TH2%				
Backpurging gas		Diameter	1,6 mm				
Supplementary gas		Electrode angle	20*				
Dia, ceramic nozzle		Tip diameter	1/10				
Length ceramic nozzle		Length					
Comments							
			A				
			T				

Note:

The fields in blue writing correspond to minimum obligatory information needed to be able to proceed to the following tabs. Naturally, if the weld does not use filler wire, the "wire feeder" field should be empty.



🔽 \\SERVMAT\SERVEUR	_MARKETING\MARKETING\M	IANUELS\MANUE	LS\SYLVIE\PSXX4\I 💶 🗙				
Note pad / Weld cycle Pre gas / Prefusion Welding Down slope / Post gas							
Power source	P5254	•					
Welding head	MU III 25	· <					
Configuration part Diameter Wall thickness Material Sta	T5 25 T5 73 T5-TP 60 T5 2000 MU III 16 MU III 25 MU III 34	al ter no.					
Gas Welding gas	MU III 8/34 MU III 51 MU III 20/80 MU III 76		TH2%				
Backpurging gas	MU III 80 MU III 5 80 MU III 114	cer ode angle	1,6 mm				
Dia, ceramic nozzle	MU III 30/114 MU III 5 115 MU III 170	meter	1/10				
Comments	MU III 5 170 MU III 220 MU III 370	<u> </u>					
			×				

5.1.1 Choice of welding head

5.1.2 Configuring the R30 parameter

The R30 parameter is configured automatically at the correct value once the head has been chosen.

🔽 \\SERVMAT\SERVEUR	_MARKETING\MARKET	ING\MANUELS\MANUE	LS\SYLVIE\PSXX4\I 💶 🗙
Note pad / Weld cycle Pre	gas / Prefusion 🛛 Welding) Down slope / Post gas	1
Power source	P5254	-	
Welding head	MU III 25	C	Documentation
Configuration part	R30 = A028	Filler wire Wire feeder	_
Diameter	16 mm	Material	
Wall thickness	0,8 mm	Diameter	
Material Sta	ainless steel	Batch no.	
Gas		Tungsten	
Welding gas		Material	TH2%
Backpurging gas		Diameter	1,6 mm
Supplementary gas		Electrode angle	20*
Dia. ceramic nozzle		Tip diameter	1/10
Length ceramic nozzle		Length	
Comments			
			<u> </u>
			-

This field is not accessible to the user as PSxx4 manages it according to the choices made on the other program tabs, and depending on the head used.

5.1.3 Entering the article diameter

PSxx4 controls entry of the article diameter according to the welding head you choose. It is impossible to enter values outside the range authorized by the head.

When you move the mouse curser over the "Diameter" field, a help balloon is displayed to indicate the range of diameters accepted by the head. If you make an error when entering your data, an error message (figure below) is displayed when the field is validated or when you try to activate another one.



It will be impossible to change the tab in the program, or save it, until the error has been corrected.

The diameter enables PSxx4 to convert the speeds between generator units (n per thousand) and legal units (mm/min).



5.1.4 Choice of power source

1/SERVMAT\SERVEUR	_MARKETING\MARKET	ING\MANUELS\MANUE	LS\SYLVIE\PSXX4\I 💶 💌
Note pad / Weld cycle Pre	e gas / Prefusion 🛛 Welding	Down slope / Post gas	
Power source	P5164 230V 50A		
Welding head	P5164 100V-(230v) 10 P5164 100V-(230v) 50		
	P5164 230V 160A	Fandar	
Configuration part	P5164 230V 50A P5204 100V	leeuer	· · · · · · · · · · · · · · · · · · ·
Diameter	P5204 230V	a	
Wall thickness	PS204 50A PS254		
Material Sta	ainless steel	Batch no.	
Gas		Tungsten	
Welding gas		Material	TH2%
Backpurging gas		Diameter	1,6 mm
Supplementary gas		Electrode angle	20*
Dia, ceramic nozzle		Tip diameter	1/10
Length ceramic nozzle		Length	
Comments		<u> </u>	
			<u> </u>
			7

PSxx4 contains all the types of generators that comprise the xx4 family.

Remember to select the source you wish to use (sector tension and current range), since the minimum and maximum parameter values linked to the welding current vary from one type to another.

The list of current sources contains the following generators :

- PS164 100V-(230V) 100A PS164 on network tension of 100 V (Maximum current 100 A)
- PS164 100V-(230V) 50A PS164 on network tension of 100 V in 50 A range
- PS164 230V 160A PS164 on network tension of 230 V in 160 A range
- PS164 230V 50A
 PS164 on network tension of 230 V in 50 A range
- PS204 100V PS204 on network tension of 100 V (Maximum current 100 A)
- PS204 230V PS204 on network tension of 230 V (Maximum current 200 A)
- PS204 50A
 PS204 in 50 A range
- PS254 PS254 (Maximum current 250 A)

5.1.5 Attaching documentation to the weld

It is possible to link one or several files created using software package other than PSxx4 to the welding program. These documents can be word processing, spreadsheet programs, etc.

	1- Click here to c	open the file liaiso	n window	
\\SERVMAT\SER'	EUR_MARKETING\MAR	RKETING\MANUELS\MA	NUELS\SYLVIE\PSXX4\I	×
Note pad / Weld cycle	Pre gas / Prefusion We	elding 🛛 Down slope 🕻 Post	gas	
ower source	P5164 230V 50A	•		
Velding head	MU III 25	•		
	R30 = A028	Filler wire Wire feeder		
Diameter	16 mm	Material		
Wall thickness	0.8	Diameter		
Material	Stainless steel	Batch no.		
Gas	,	Tungsten	,	
Welding gas		Material	TH2%	
Backpurging gas		Diameter	, 1,6 mm	
Supplementary gas	5	Electrode	20*	
Dia, ceramic nozzla		Tip diameter	1/10	
Length ceramic no:	zzle	Length		
Comments				1
				1
umentation				
→ <u>N</u> ew program				
X ← <u>E</u> rase				
<mark>⊯ Ω</mark> pen X <u>C</u> lose				
		\		

	3- Select the fi	le you wish to use	
Ouvrir			? ×
Rechercher dans	: 🖄 Mes documents	- E 😁	∷ . ▼
Adobe Mes images My eBooks Security Etat document filtre.xls	.rtf	PRES20028DEUTSCHLAND.xls lapport.doc	
Nom de fichier :	Rapport.doc		📕 Ouvrir
Type :			Annuler
		4- Validate the	



5.1.6 Opening documentation attached to the weld



5.1.7 Erasing documentation attached to the weld



5.2 "Pre-gas/ Pre-fusing" tab

This page proposes the parameters to be fixed before starting welding, up to the beginning of the first sector.

🔽 \\SERVMAT\SERV	EUR_MARKETING\MAR	RKETING\MANUELS\MANUELS	\SYLVIE\PSXX4\I
Note pad / Weld cycle	Pre gas / Prefusion We	elding 🛛 Down slope / Post gas 📄	
Gas Pre-gas time	T10 3 s	Rotation Mode © Straight	C Pulsed
Current Current Straight	C Pulsed	Direction of rotation Forward	C Backward
Prefusion current	T21 30,0 A	Filler wire Mode © Straight	C Pulsed
		Start	T40 0 s

The buttons for choosing the mode of functioning for rotation, filler wire and the parameters linked to the wire are greyed over when they cannot be selected.

Indeed, if the weld does not need filler wire, then choosing smooth or pulsed wire and temporising before starting do not apply here; PSxx4 thus makes them inactive.

Similarly, the choice of pulsed rotation in smooth current is illogical.



5.3 "Welding" tab

This page proposes the parameters linked to the current, head rotation and filler wire that can vary according to the sectors of the weld.

🔽 \\SERVMAT\SERVEUF	R_MARKETING\M	IARKETIN	G\MANUE	LS/MA	ANUELS	5\SYLVIE\I	PSXX4\I	
Note pad / Weld cycle Pro	e gas / Prefusion	Welding	Down slope	e / Post	gas			
S1 0 D S2 720 D								
						G	Ŵ	
Peak current	I	22 32 A	۱					
Time peak current	т	22 50	ms					
Base current	1	23 7 A						
Time base current	т	23 100	ms					
Welding speed	v	32 296 1	7	98,20	mm/mi	in		
Base welding speed	v	33 296 1	7	98,20	mm/mi	in		
Wire speed	v	42 0 */	·	0,00 m	m/min	1		
Base wire speed	v	43 0 */	·	0,00 m	m/min	1		
					4	1		
	0				0			
	Speed in n (n per thou	usand)	e units		Spe	eea in le	egai units	

For parameters linked to a speed, the conversion of one unit system to another is automatic when the value has been validated with the "Enter" key.

As in the previous tab, the parameters that do not apply to the weld due to the axes used and their chosen mode of functioning are greyed out and are not accessible to the user.



5.3.1 Adding a sector to the weld

"Sectors" sym	bol		Z- validate the sector in
Note pad / Weld cycle S1 0 D S2 720 D	MARKETING MARKETIN A aas / Prefusion Welding Dow	MANUELS MANUELS SYLVIE P	
Peak current	122 32 4		
Time neak current	T22 52 A	_	
Base current	Warning		×
Time base current	י 🚹	Do you want to insert a s	sector 2 ?
Welding speed	N		
Base welding speed	N N		
Wire speed	· · ·		
Base wire speed	ν.	<mark>≭</mark> №	Yes
ting a No. 2 sector		4- Programming t	the sector
ting a No. 2 sector		4- Programming t startup value	the sector
ting a No. 2 sector		4- Programming t startup value	the sector
ting a No. 2 sector	RKETING\MARKETING\M.	4- Programming t startup value	the sector
ting a No. 2 sector	RKETING\MARKETING\M. Prefusion Welding Down	4- Programming t startup value	the sector
ting a No. 2 sector	RKETING\MARKETING\MA Prefusion Welding Down	4- Programming t startup value	the sector
ting a No. 2 sector \\SERVMAT\SERVEUR_MAI hte pad / Weld cyfle Pre gas / 1 0 D S2 180 D S3 1 Begin sector	RKETING\MARKETING\M. Prefusion Welding Down 720 D N 180 D	4- Programming t startup value	the sector
ting a No. 2 sector SERVMAT SERVEUR_MA SERVMAT SERVEUR_MA SERVMAT SERVEUR_MA 1 0D S2 180D S3 3 3 egin sector Peak current	RKETING\MARKETING\M Prefusion Welding Down 720 D N 180 D 122 32.0 A	4- Programming t startup value	the sector
ting a No. 2 sector \\SERVMAT\SERVEUR_MAI te pad / Weld cyle Pre gas / 1 0D S2 180D S3 3 Begin sector Peak current Time peak current	RKETING\MARKETING\M Prefusion Welding Down 720 D N 180 D 122 32,0 A T 22 50 ms	4- Programming t startup value	the sector
ting a No. 2 sector SERVMAT SERVEUR_MAI Sepad / Weld of the Pregas / 1 0D S2 180D S3 1 Begin sector Peak current Time peak current Base current	RKETING\MARKETING\MA Prefusion Welding Down 720 D N 180 D 122 32.0 A T22 50 ms 123 7.0 A	4- Programming t startup value	the sector
ting a No. 2 sector SERVMAT SERVEUR_MAI ate pad / Weld of te Pre gas / 1 0 D S2 180 D S3 1 Begin sector Peak current Time peak current Base current Time base current	N 180 D 122 32.0 Å T22 50 ms 123 7.0 A T23 100 ms	4- Programming t startup value	the sector
ting a No. 2 sector	RKETING\MARKETING\MARKETING\MARKETING\MARKETING\MARKETING\MARKETING\MARKETING\MA Prefusion Welding Down 720 D N 180 D 122 32,0 Å T22 50 ms 123 7,0 Å T23 100 ms V32 296 */. */.	4- Programming t startup value	the sector
ting a No. 2 sector	RKETING\MARKETING\MARKETING\MARKETING\MARKETING\MARKETING\MARKETING\MARKETING\MA Prefusion Welding Down 720 D N 180 D 122 32,0 Å T22 50 ms 123 7,0 Å T23 100 ms V32 296 */ V33 296 */	 4- Programming t startup value ANUELS\MANUELS\SYLVIE\I a slope / Post gas 98,20 mm/min 98,20 mm/min 	the sector
ting a No. 2 sector	RKETING\MARKETING\MA Prefusion Welding Down 720 D N 180 D 122 32.0 Å T22 50 ms 123 7.0 Å T23 100 ms V32 296 *7 V32 0 *7	 4- Programming to startup value ANUELS\MANUELS\SYLVIE\ ANUELS\MANUELS\MANUELS\SYLVIE\ ANUELS\MANUELS\SYLVIE\ ANUELS\MANUELS\MANUELS\SYLVIE\ ANUELS\MANUELS\SYLVIE\ 	the sector
ting a No. 2 sector	RKETING\MARKETING\M Prefusion Welding Down 720 D N 180 D 122 32,0 Å T22 50 ms 123 7,0 Å T23 100 ms V32 296 */ V33 296 */ V42 0 */ V42 0 */	 4- Programming t startup value ANUELS\SYLVIE\ ANUELS\SYLVIE\ Post gas 98,20 mm/min 98,20 mm/min 0,00 mm/min 0,00 mm/min 	the sector

3-



5.3.2 Inserting a sector between two sectors

1- Activate the sector to	2- Click on the	
precede the new one	« Sectors » symbol	3- Validate the sector insertion
Note pad / Weld cycle S1 0	EUR_MARKETING\MARKETING\MARK Pre gas / Prefusion Welding Down slo 0 S3 720 D	JELS\MANUELS\SYLVIE\PSXX4\L
Peak current	122 32,0 A	
Time peak current	Warning	
Base current		
Time base current Welding speed Base welding speed	1 <u>1</u>	Do you want to insert a sector 2 ?
Wire speed	N	
Base wire speed	N	<u> </u>
4- Insert a new shift the old on	No. 2 sector and	5- Program the sector startup value
Vote pad / Wel	\ FERVEUR_MARKETING\MARKETING\MA	NUELS\/ 1ANUELS\SYLVIE\PSXX4\I
S1 0D S Begin sector	2 90 D S3 180 D S4 720 D N 90 D	
Peak current	122 32 0 A	
Time peak cu	rrent T 22 50 ms	
Base current	123 7,0 A	
Time base cu	rent T23 100 ms	
Welding spee	d v32 296 */	98,20 mm/min
Base welding	speed V33 296 */	98,20 mm/min
Wire speed	V42 0 */	0,00 mm/min
Base wire spe	ed V43 0 */	0,00 mm/min

5.3.3 Erasing a sector



4- Erase the sector and acti	vate the previous s	sector	
Note pad / Weld cycle Pre gas / Pre S1 0.D S2 90.D S3 720	TING\MARKETING\MAN Ifusion Welding Down sk	UELS\MANUELS\SYLVII	E\PSXX4\I 💶 🗅
Begin sector	N 720 D		
Peak current	122 34 A		
Time peak current	T22 50 ms		
Base current	123 8 A		
Time base current	T23 100 ms		
Welding speed	V32 482 */	160,00 mm/min	
Base welding speed	V33 482 */	160,00 mm/min	
Wire speed	V42 0 */	0,00 mm/min	
Base wire speed	V43 0 */	0,00 mm/min	

5.4 "Down slope / Post-gas" tab

This page deals with the parameters linked to weld down slope and the actions that should be undertaken after the arc has been cut off.

Filler wire		7
Stop wire	N40 370 D	
Retract wire	T41 0,0 s	
Current		
Start down slope	N20 900 D	
Down slope time	T25 10 s	
Gas		7
Time after arc stops	T11 30 s	
Ticket		
Print ticket		
Parameters sp	ecific to welding heads in the	TS/TP series if one
Parameters sp them is used f SERVMAT\SERVEUR_MAFKET a pad / Weld cycle Pre gas / Pref	ecific to welding heads in the or welding TING\MARKETING\MANUELS\MANUELS fusion Welding Down slope / Post gas	TS/TP series if one
Parameters sp them is used f SERVMAT\SERVEUR_MAFKET e pad / Weld cycle Pre gas Pref ller wire	ecific to welding heads in the for welding TING\MARKETING\MANUELS\MANUELS fusion Welding Down slope / Post gas N40 370 D	TS/TP series if one
Parameters sp them is used f SERVMAT\SERVEUR_MAFKET a pad / Weld cycle Pre gas Pref ller wire Stop wire Retract wire	ecific to welding heads in the for welding TING\MARKETING\MANUELS\MANUELS fusion Welding Down slope / Post gas N40 370 D T41 0.0 s	TS/TP series if one
Parameters sp them is used f SERVMAT\SERVEUR_MAFKET a pad / Weld cycle Pre gas / Pref ller wire itop wire tetract wire	ecific to welding heads in the for welding TING\MARKETING\MANUELS\MANUELS fusion Welding Down slope / Post gas N40 370 D T41 0,0 s	TS/TP series if one
Parameters sp them is used f SERVMAT\SERVEUR_MAFKET a pad / Weld cycle Pre gas / Pref ller wire itop wire tetract wire urrent itart down slope	ecific to welding heads in the for welding TING\MARKETING\MANUELS\MANUELS fusion Welding Down slope / Post gas N40 370 D T41 0.0 s N20 900 D	TS/TP series if one
Parameters sp them is used f SERVMAT\SERVEUR_MAFKET a pad / Weld cycle Pre gas a pad / Weld cycle Pre gas Berwire Stop wire Retract wire Start down slope Down slope time	ecific to welding heads in the for welding TING\MARKETING\MANUELS\MANUELS fusion Welding Down slope / Post gas N40 370 D T41 0,0 s N20 900 D T25 10 s	TS/TP series if one
Parameters sp them is used f SERVMAT\SERVEUR_MAKE a pad / Weld cycle Pre gas Pref ller wire Stop wire Retract wire urrent Start down slope Down slope time	ecific to welding heads in the for welding TING\MARKETING\MANUELS\MANUELS fusion Welding Down slope / Post gas N40 370 D T41 0.0 s N20 900 D T25 10 s	TS/TP series if one
Parameters sp them is used f SERVMAT\SERVEUR_MAFKET a pad / Weld cycle Pre gas Pref iller wire Stop wire Retract wire Start down slope Down slope time as Time after arc stops	ecific to welding heads in the for welding TING\MARKETING\MANUELS\MANUELS fusion Welding Down slope / Post gas N40 370 D T41 0.0 s N20 900 D T25 10 s T11 30 s	TS/TP series if one
Parameters sp them is used f SERVMAT\SERVEUR_MAF a pad / Weld cycle Pre gas Pref ller wire Stop wire Retract wire Start down slope Down slope time as Time after arc stops icket	ecific to welding heads in the for welding TING\MARKETING\MANUELS\MANUELS fusion Welding Down slope / Post gas N40 370 D T41 0,0 s N20 900 D T25 10 s T11 30 s	TS/TP series if one
Parameters sp them is used f SERVMAT\SERVEUR_MAKE a pad / Weld cycle Pre gas Pref iller wire stop wire Retract wire urrent start down slope Down slope time as "ime after arc stops cket Print ticket	ecific to welding heads in the for welding TING\MARKETING\MANUELS\MANUELS fusion Welding Down slope / Post gas N40 370 D T41 0.0 s N20 900 D T25 10 s T11 30 s	TS/TP series if one
Parameters sp them is used f SERVMAT\SERVEUR_MAFKET e pad / Weld cycle Pre gas Pref iller wire Stop wire Retract wire urrent Start down slope Down slope time as Fime after arc stops icket Print ticket otation TS/TP	ecific to welding heads in the for welding TING\MARKETING\MANUELS\MANUELS fusion Welding Down slope / Post gas N40 370 D T41 0.0 s N20 900 D T25 10 s T11 30 s	TS/TP series if one

5.5 Making a backup copy of the welding program

Click on this button to save the program modifications	Click on this button to save a copy of the program under another name and/or in another sub-directory
POLYSOUDE - Programming of P5xx4 Program Memory card About	
Gas Pre-gas time T10 3 s Current Current Current Current © Straight C Pulsed	ETING\MANUELS\SYLVIE\PSXX4\I ng Down slope / Post gas Mode Straight Pulsed Direction of rotation Forward Backward
Prefusion current 121 30,0 A Prefusion time T21 2.0 s	Filler wire Mode Straight C Pulsed



Note:

If you are making the first backup of a program that has just been created using a copy from the Polysoude program bank, PSxx4 will ask you to save the program under another name and in a different directory to the program bank one.

The following figure shows the window that corresponds to the "Save under" command.

Defa the	ault sub-directory program	for saving		
	Save as			<u>?</u> ×
	Enregistrer dans :	🔄 WLD	- 🖬 📩 🗢 🔽	
	Nom de fichier :	POLYSOUDE	/PS> X4/DATABASE/12X.LD	Enregistrer
	Туре :	Program PSxx	(4 (*.V/LD)	Annuler
		Give a n eventually it does not the top	ew name to the program, and erase the name from the directory if correspond to the one displayed at	

6. Liaison with the memory card reader

Click on the icon below in the shortcut bar when you want to launch a program reading / writing operation from / to the memory card.



This icon opens the window below.

□ c: [system disk] □	
	12 13 14 15 16

6.1 Description of the liaison window

The left side of the window displays the list of programs contained in the PC. Above the list, a directory structure displays the directory where the displayed programs are stored. This directory structure enables you to change directories by simply clicking on the mouse. Finally, there is a selection list above the directory structure to enable you to change readers or disks.

The right side of the window displays the commands relative to the card reader, as well as the list of programs it contains. The list is updated only after a read command.

Between the two sides, we find buttons enabling to transfer the programs from one list to the other, depending on the operation to be implemented (reading or writing).



6.2 Writing programs on the card



Note: Selection of several programs in the list to be written on the card

With *Windows*[™], it is possible to make selections in a list (*) of several elements by keeping the "Ctrl" key pressed down and clicking the desired element with the mouse. This "Ctrl-click" combination enables alternately, at each click, to select / de-select a particular element in the list without modifying the status (selected / de-selected) of the other elements.

(*) Only for lists enabling multiple selection.



6.3 Reading the contents of a card and recuperating the programs





6.4 Erasing the card



2- Validate confirmation to erase

1

r		
Confirmation		×
Efface Etes-vi	ment de la carte pus sûr de vouloir l'effacer ?	×
	X Non	ui

