



OWNERS MANUAL

WelderModel =FW-DC

Amps = 300+400

KW = 10

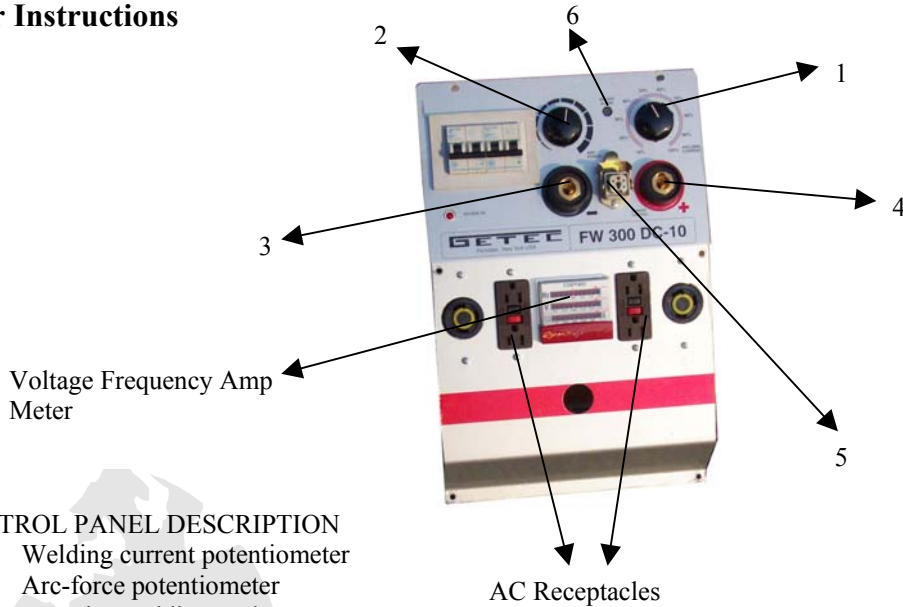
Phase = 1

RPM = 3600

AC Volt = 120/240

Style = 2 Bearing

User Instructions



CONTROL PANEL DESCRIPTION

- 1 Welding current potentiometer
- 2 Arc-force potentiometer
- 3 Negative welding socket
- 4 Positive welding socket
- 5 Remote control socket
- 6 Welding overload alarm

HOW TO USE THE GENERATOR

The machine will operate as a generator even while it is being used as a welder. However it is best to avoid using the maximum welding current together with heavy generator loads.

HOW TO USE THE WELDER

Plug the ground cable into socket 3 (4 for reverse polarity welding).

Attach the ground cable to the piece being welded.

Plug the electrode holder cable into the other socket.

Set the welding current on potentiometer

1.

Weld.

For some types of electrodes, (e.g. cellulose-based) potentiometer 2 (arc-force) has to be adjusted to obtain a good quality weld.

If, when working with high currents (i.e. over 200A), the overload cut-out trips (pilot light 6 comes on), wait a few minutes for it to reset automatically.

Anti-stick function: if the electrode should stick the machine trips automatically cutting out the welding current after 2-3 seconds to save ruining the electrode.

INSTRUCTIONS FOR WELDING

WELDING CABLES

The welding cables must be of the minimum length necessary, they must be kept close together and run along the ground. Do not use cables on which the insulation is spoiled or which have an insufficient section.

EQUIPOTENTIAL CONNECTION AND EARTHING

Follow the national requirements for the for the equipotential connection of metal components in the vicinity of welding system and for earthing them if necessary.

PREPARING THE PARTS

The preparation varies depending on the type f join, the thickness, the position and the accessibility of the parts. In general, the edges to be welder must be prepared by cleaning off any paint, rust or other contaminating substances. For flat welding up to a thickness of 10-12mm, the V preparation is normally used; while for greater thickness it is preferable to use the X preparation with upside-down rewelding or the U preparation without rewelding.

CHOOSING THE ELECTRODE

The welders in the FW series are suitable for welding any type of electrodes (rutile, basic, and cellulose). The electrode diameter depends on the thickness of the material, the position of the part and the type of join. Larger diameters of course require greater currents and involve a greater amount of heat in welding. When making a weld in position it is convenient to use smaller diameters and several passes to reduce the flow of the weld pool.

CHOOSING THE CURRENT

The range of the welding current is recommended by the electrode manufacturer and is indicated on the electrode container.

WELDING

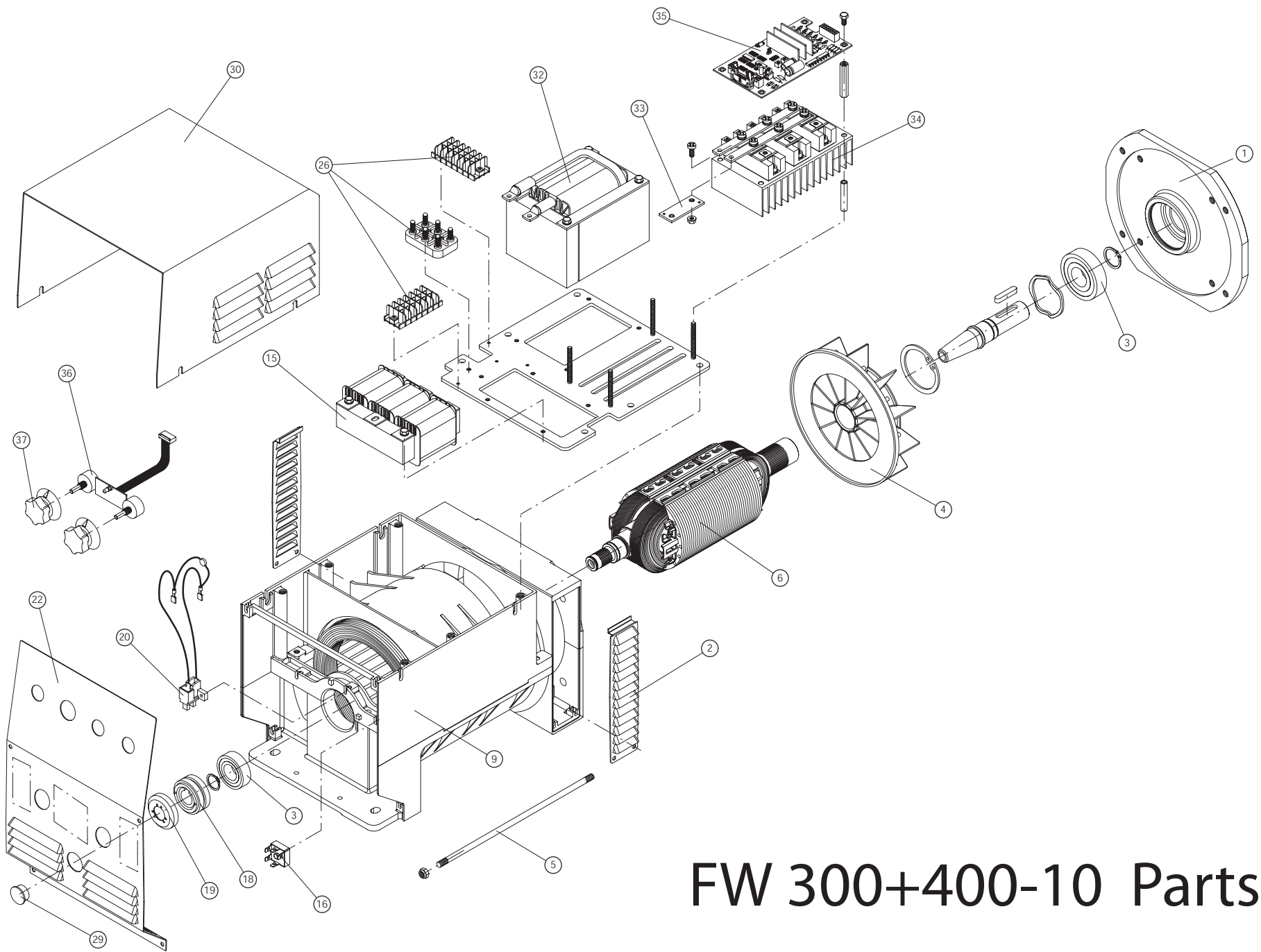
The arc is struck by rubbing the tip of the electrode on the part connected to the earth cable and then drawing back the electrode to the normal welding distance. If the movement is too fast, the arc goes out; if it is too slow, the electrode sticks and you must pull sideways to free it.

Welding consists of depositing drops of molten electrode metal on the part. As it burns, the electrode coating provides the protective gas for the weld pool.

Welding may be carried out with different techniques, the choice of which depends on various factors.

In general, the electrode is kept tilted and is shifted by making oscillating movements between the two edges that are to be joined so as to avoid an excessive build-up of weld material in the center of the weld.

At the end of each pass, it is necessary to remove the slag with a hammer and/or a brush,



FW 300+400-10 Parts

FW300+400 Parts List

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Item #	GETEC #	Description	Price
1	601049	Front Flange	
2	601050	Front Guard IP23	
2a	601051	Front Guard IP21	
3	601052	Bearing Type 6306 2RS1 C3	
3a	601053	Bearing Type 6206 2RS1 C3	
4	601054	Fan with Ø 37 hole	
4a	601055	Fan with Ø 42 hole	
5	601056	Stay Rod	
6	601057	Rotor	
9	601058	Stator	
12	601059	Spring Washer Ø72	
15	601060	Compound	
16	601061	Field Rectifier Bridge	
17	601062	EMC Filter	
18	601063	Slip Ring (51X22X08)	
19	601064	Slip Ring (Ø51)	
20	601065	Brush Holder & Brushes	
22	601066	FW Blind Panel	
22a	601067	FW Panel	
24	601068	Disk Joint	
25	601069	Flange SAE 4	
25a	601070	Flange SAE 5	
26	601071	Base 6 M6 pins	
26a	601072	Term. Block 6 double fast-ons	
29	601073	Tap for Rear Guard	
30	601074	FW Top Cover	

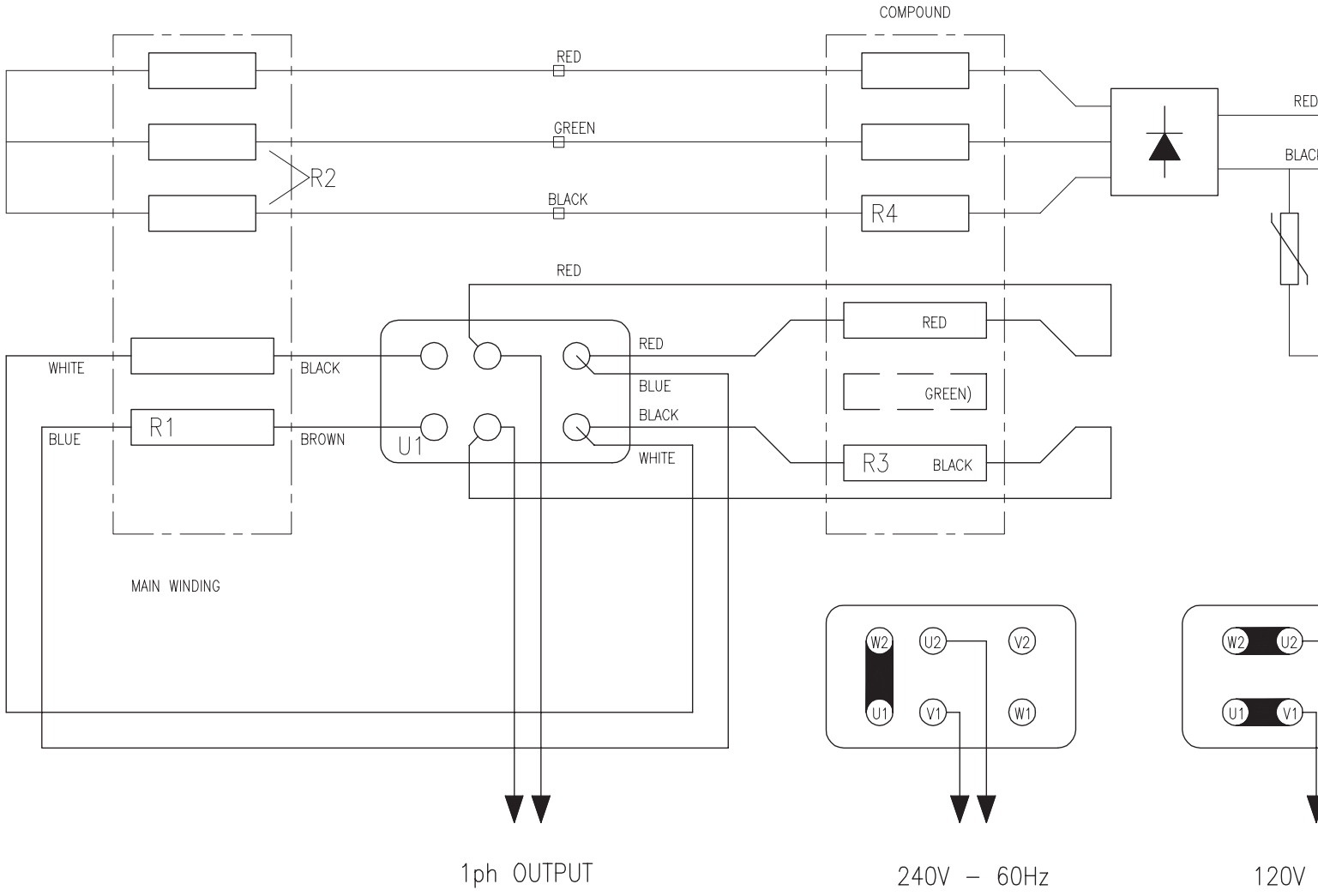
FW300+400 Parts List

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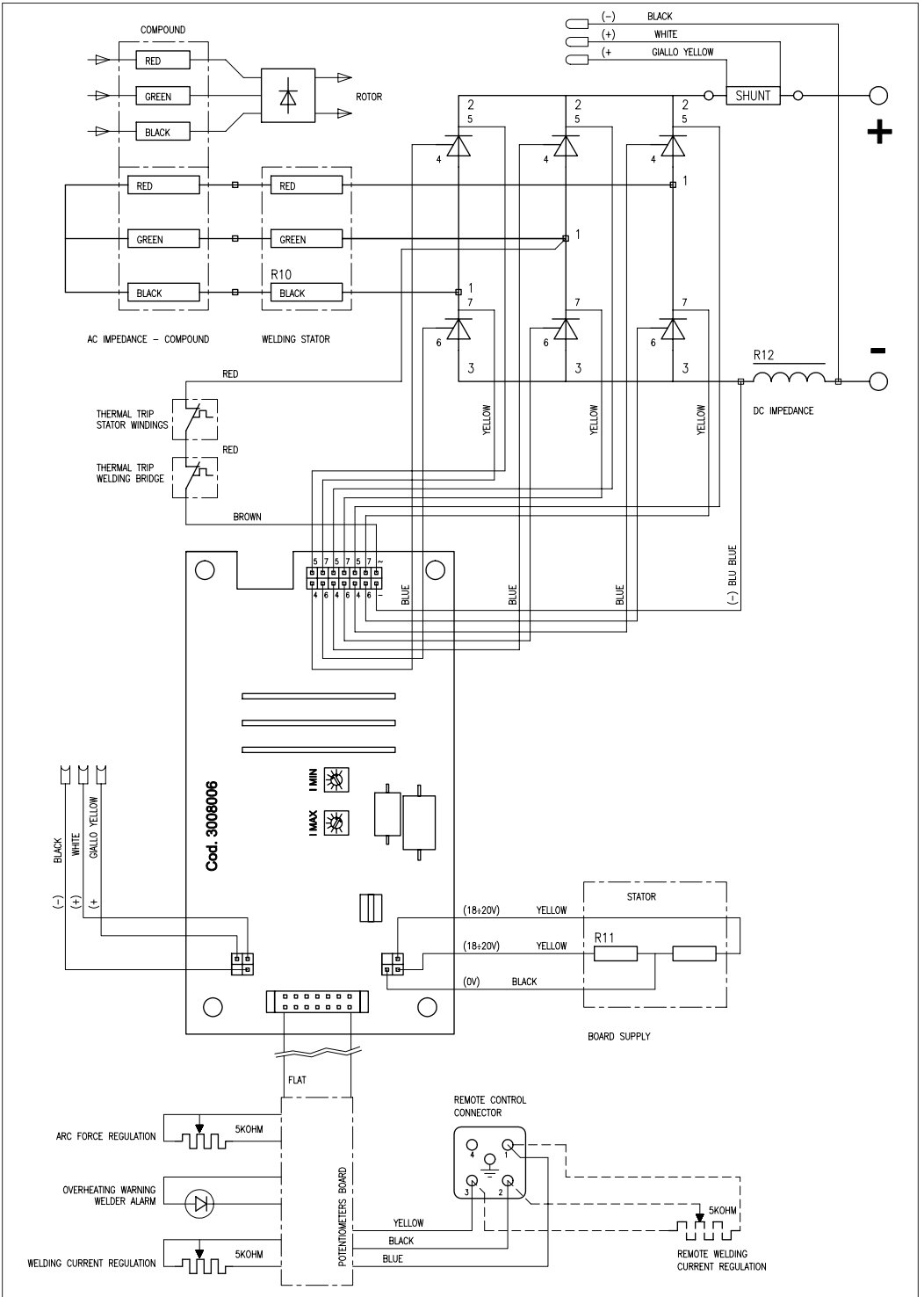
Item #	GETEC #	Description	Price
31	601075	Kit: from J609B c.35 to B34	
32	601076	FW Welding Impedance	
33	601077	Shunt 300A 75mV	
34	601078	Welding Bridge	
35	601079	FW PCB	
36	601080	Potentiometer PCB	
36a	601081	FW Pot. PCB (400mm cable)	
37	601082	Potentiometer Knob	
37	601083	Female 400A Welding Terminal	
37a	601084	Male 400A Welding Terminal	

1 PH

AUXILIARY WIND.



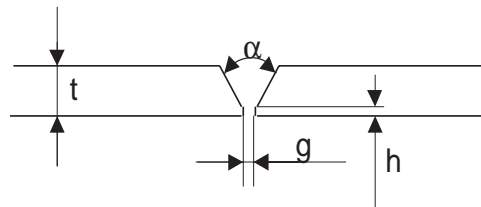
Wiring diagrams



Minimum section of the welding cables		
Max welding current	Cable length	
	5-10m	10-20m
130A	25mm ²	35mm ²
220A	35mm ²	50mm ²
300A	50mm ²	70mm ²

Tab.1

t mm	a °	h mm	g mm
0-3	0	0	0
3-6	0	0	0-t/2
6-12	60-120	0-1.5	0-2



Tab.2

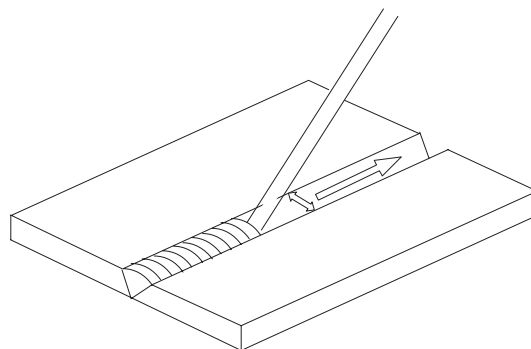


Fig.1