



INTIG 402 PULSE OPERATING MANUAL.

Warpp Engineers Pvt Ltd.

Source of Reliable welding and cutting equipment.

Unit no 36/15 Unique Industrial Estate,

Dhumal Nagar, Waliv,

Vasai East, Palghar 401208.

TEL: 08551819944, 8551817869, 851817744.

E mail: sales@warpp.co.in

Website: www.warpp.co.in

1. SAFETY

Welding is dangerous, and may cause damage to you and others, so take good protection when welding. For details, please refer to the operator safety guidelines in conformity with the accident prevention requirements of the manufacturer.

Professional training is needed before operating the machine.

- Use labor protection welding supplies authorized by national security supervision department. The operator must be qualified personnel with a valid "metal welding (OFC) operations" operation certificate. Cut off power before maintenance or repair.



Electric shock—may lead to serious injury or even death.

- Install earth device according to the application criteria.
- Never touch the live parts when skin bare or wearing wet gloves/clothes. Make sure that you are insulated from the ground and work piece. Make sure that your working position is safe.



Smoke & gas—may be harmful to health.

- Keep the head away from smoke and gas to avoid inhalation of exhaust gas from welding. Keep the working environment in good ventilation with exhaust or ventilation equipment when welding.



Arc radiation—may damage eyes or burn skin.

- Wear suitable welding masks and protective clothing to protect your eyes and body. Use suitable masks or screens to protect spectators from harm.



Improper operation may cause fire or explosion.

- Welding sparks may result in a fire, so please make sure no combustible materials nearby and pay attention to fire hazard.
- Have a fire extinguisher nearby, and have a trained person to use it. Airtight container welding is forbidden



Hot work piece may cause severe scalding.



- Do not contact hot work piece with bare hands.
- Cooling is needed during continuous use of the welding torch.

Magnetic fields affect cardiac pacemaker.

- Pacemaker users should be away from the welding spot before medical consultation.



Moving parts may lead to personal injury.

- Keep yourself away from moving parts such as fan.
- All doors, panels, covers and other protective devices should be closed during operation.

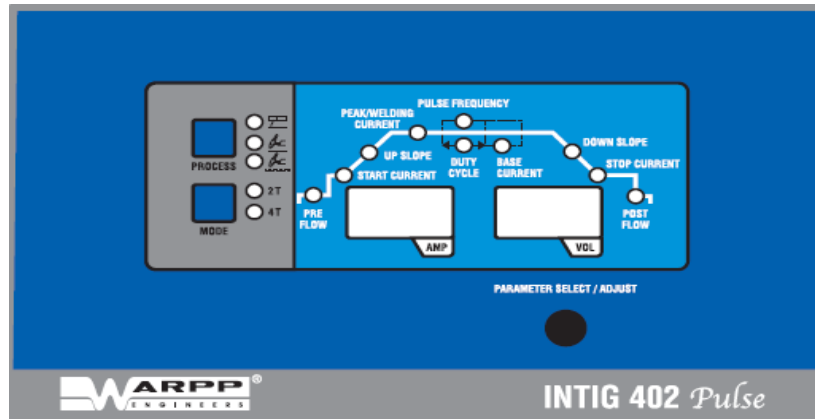


Please seek professional help when encountering machine failure.

- Consult the relevant contents of this manual if you encounter any difficulties in installation and operation.
- Contact the service center of your supplier to seek professional help if you still can not fully understand after reading the manual or still can not solve the problem according to the manual.



(FRONT PANEL DESCRIPTION):



PARAMETER SETTING FOR INTIG 402 PULSE

DESCRIPITON OF INDICATION AND SWITCH :



:This LED indicates the welding is in the MMA or SMAW mode .



:This LED indicates the welding is in the TIG mode .



:This LED indicates the welding is in the PULSE mode .



:This LED indicates the welding is in the 2 Trackmode. (Applicable only in TIG Mode).



:This LED indicates the welding is in the 4 Track mode .
(Applicable only in TIG Mode)



PREFLOW :This LED indicates the preflow time before the GAS.



START CURRENT : This LED indicates the Start Current or Hand Arc welding current state output.



UPSLOPE :This LED indicates the time taken for machine to reach it welding current from its start current.



PEAK CURRENT :This LED indicates the Welding current during welding & arc welding normal output state.



PULSE FREQUENCY :This LED indicates the operating frequency of PULSE output (applicable in PULSE MODE).



DUTY CYCLE :This LED indicates the ON / OFF TIME OF pulse frequency output.



BASE CURRENT :This LED indicates the base current during off time of pulse output (Applicable in PULSE MODE).



DOWN SLOPE :This LED indicates the time taken for machine to reach its Arc current from its welding current.



STOP CURRENT : This LED indicated the current value before the are welding quenching.



POST FLOW :This LED indicates the continues flow timing after welding.



PROCESS :This SWITCH is used for selection of MMA , TIG Or PULSE WELDING.



MODE :This SWITCH is used for selection of 2 Tray Or 4 Tray welding.



VOLT/AMP :This is digital display for voltage and current display.

DURING WELDING

STEP -1 DISPLAY SETTING:

- Connect holder and earth clamp at output,take a **5 mm rod** in holder and do welding. Set output **current 50A to 400A** with the help with help of rotary switch.Same procedure apply to **4 mm&3.15mm rod**.

STEP -2 HF TESTING:

- Put SMAW / TIG switch in TIG mode and press the torch switch, HF spark will be generated on the HF spark plug.

STEP -3 GAS TESTING:

- Put the switch in TIG mode solenoid valve will turn ON.Now press the torch switch and release it.Valve will turn off.

STEP -4 DOWN SLOPE TESTING:

- Arc force / down slope pot should be maximum and in 4step mode.When torch switch is pass and released for to stop the welding,current will slowly decreases to minimum and then welding will stop after 5sec.



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