

EASY 400 PLUS

Total control of the welding process

ALWAYS BY YOUR SIDE

The EASY 400 PLUS control panel is removable. This allows on the manual welding the operator to move the panel next to the welding area for a faster set-up of the parameters. For the welding automations, remote control panel is suitable to set the parameters far from the peripherals. EASY 400 PLUS gives a total control of the welding process.

AUXILIARY CONTROL CONNECTOR

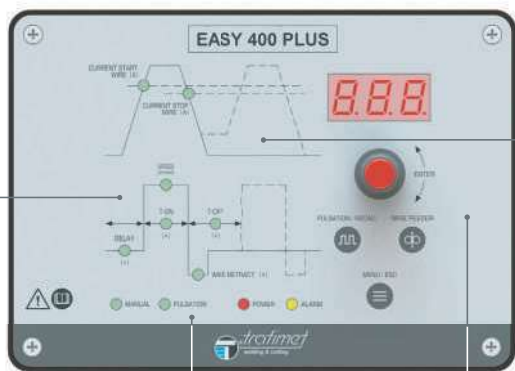
A connector is available on the front panel of EASY 400 PLUS for interfacing with the automation plants, through the possibility to manage the torch signals; START/STOP welding arc, FORWARD/BACKWARD, Wire speed UP/DOWN.

It is possible to use the same input to connect an auxiliary START/STOP WIRE command, released from the current thresholds; this allows you to control the wire output independently, for example by connecting to a control desk.



USER FRIENDLY

With EASY 400 PLUS, the operator can save up to 16 welding jobs, to easily recall the previously used welding programs. The setting of the parameters is simple, fast and intuitive, thanks to the new digital graphic panel.



CURRENT START WIRE

Wire start threshold from 15 to 460A.

The wire comes out only when the set START current threshold is exceeded (or via the auxiliary command). The wire starts to be fed with a soft start speed and with an acceleration ramp it gradually moves to the set nominal speed.

CURRENT STOP WIRE

Wire stop threshold from 15 to 460A.

Under the STOP threshold the wire will stop and go into the wire retract phase.

SPEED

Wire speed from 0 to 8 m/min.

T-ON

Pulsation ON time, from 0,3 to 25 sec is the wire feeding time.

T-OFF

Pulsation OFF time, from 0,3 to 25 sec is the time while the wire does not advance.

DELAY

Wire output delay time from 0 to 25 sec. The wire will start feeding after this time. The time is counted from the moment the current has surpassed the START threshold.

WIRE RETRACT

Wire retract time from 0 to 2,5 sec. After the current goes under the current STOP threshold the wire will retract for the set time at the maximum speed (8 m/sec) and then stop.

MANUAL

OFF = automatic wire feeding.
ON = manual wire feeding.

PULSATION

ON = independent pulsation activated.

POWER

ON = power presence.

ALARM

ON = alarms presence.

PULSATION / RECALL

Pulsation activation: activation of the asynchronous (independent) pulsations of the wire.

WIRE FEEDER

Wire loading/feeding if pressed continuously.
Wire retraction if pressed intermittently.

MENU / ESC

Access to user menu where you can save/load the welding programs and set parameters.

ENTER

Knob selector and data confirm.

Special settings:

- soft start speed, from 10% to 100% of the nominal speed,
- acceleration ramp, from OFF to 2 seconds,
- manual wire exit command,
- password setting,
- special settings for automation systems



DISPLAY