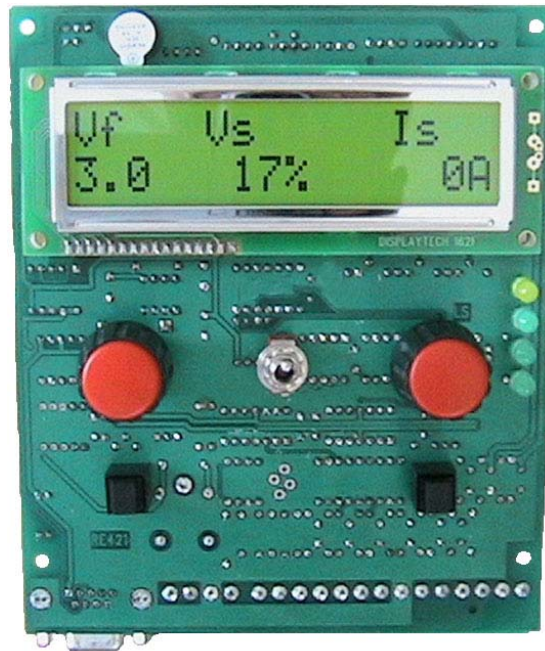


RE421

MICROPROCESSOR CONTROL BOARD FOR SYNERGIC WELDING MACHINE



VERY SIMPLE TO USE AND TO PROGRAM

The synergy curves are generated with the auto learning of 10 –20 points for each curve. The microprocessor provides the interpolation between the points.

THE CONTROL CAN BE USED IN:

ELECTROMECHANICAL (COMMUTATOR REGULATION) AND ELECTRONICAL (THYRISTORS- CHOPPER) WELDING MACHINE.

FEATURES:

- Big LCD to display the set parameters and to read voltage and current with holding value at the end of welding.
- Serial communication line that can be utilized to load program or to record the welding proceeding.
- Possibility to change +/-10% the wire speed around the set point.
- Approach speed of wire with ramping to the arc striking.
- At each turn on of the machine, the control position itself on the last curve utilized.

COMMUTATOR WELDING MACHINE

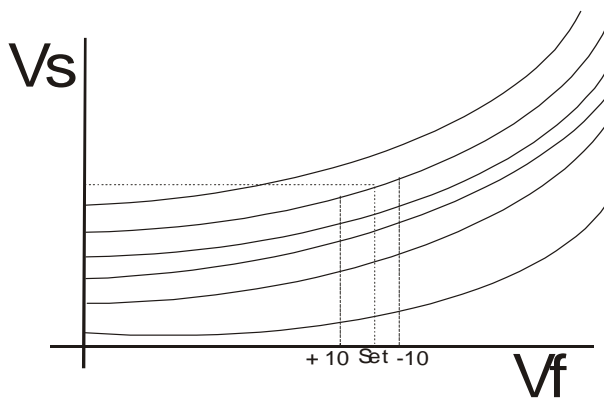
The control regulates the wire speed in function of welding voltage, following the set curve.

THYRISTORS WELDING MACHINE NORMAL OR PULSED

The control regulates the welding voltage function of wire speed, following the set curve.

The programs for pulsed mode, handle the base voltage, the peak voltage and the pulsing frequency:

$$\left[\begin{array}{l} 50 - 100 - 150 \text{ Hz} \\ 60 - 120 - 180 \text{ Hz} \end{array} \right]$$



CHOPPER WELDING MACHINE

The control regulates the welding voltage function of wire speed, following the set curve.

The programs for pulsed mode, handle the base current, the peak voltage, the frequency (0 – 500 Hz) the duty –cycle and the profile of pulsation (rectangular, trapezium, triangle or other).

