

Artis 170, Artis 210

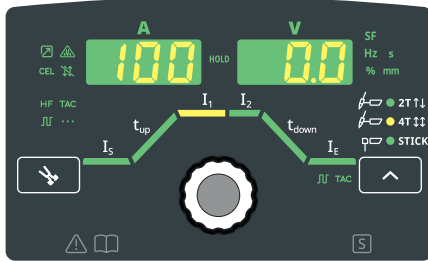
Control Panel Overview | Setting Welding Parameters



SAFETY

Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online. This document does not describe all the functions of the device. For a complete description of the device, refer to the Operating Instructions.

Control Panel Overview



To select the operating mode



2-step mode: Short weld seams



4-step mode: Longer weld seams



SMAW

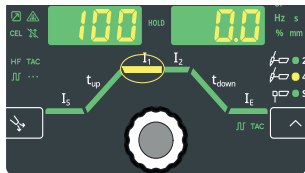


Allow shielding gas to flow out for 30 seconds

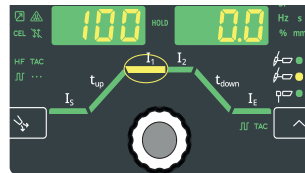
Adjustable welding parameters

- I_s Starting current
- t_{up} Up-Slope
- I_1 Main current (welding current)
- I_2 Reduced current
- t_{down} Down-Slope
- I_E Final current
- Pulses
- Tacking

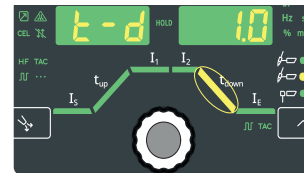
Setting the welding parameters



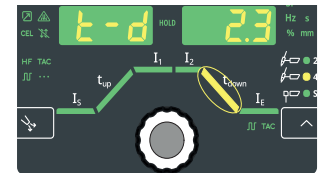
1. Press selection dial to enable parameter selection



2. Turn selection dial to select the desired parameter



3. Press selection dial to confirm the selected parameter



4. Turn selection dial to select the desired value



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Description of Setup Parameters

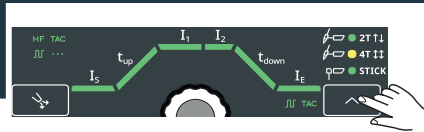


Accessing the Setup menu



1. Press and hold
2. Press

Exiting the Setup menu



Rod electrode Setup menu

- HCU** HotStart current
- Ht1** Starting current duration
- Str** Start ramp
- F-P** Pulse frequency
- ASt** Anti-stick
- CEL** CEL mode
- dYn** Dynamic correction
- UCo** Break voltage
- FAC** Reset welding system
- 2nd** Setup Menu 2nd Level

TIG Setup Menu, 1st Level

- ELd** Electrode diameter
- SPE** Spot welding time/interval welding time
- SPb** Interval pause time
- tAC** Tacking
- F-P** Pulse frequency
- dCY** Duty cycle
- I-G** Base current
- t-S** Starting current time
- t-E** Final current time
- GPp** Gas pre-flow time
- GPo** Gas post-flow time
- GPU** Gas purging
- FAC** Reset welding system
- 2nd + tIG** TIG Setup Menu, 2nd Level
- 2nd** Setup Menu 2nd Level

Setup Menu 2nd Level (TIG and SMAW)

- SAt** System active-time
- SoT** System on-time
- FUS** Fuse
- SoF** Software version
- tSd** Automatic shutdown

TIG Setup Menu, 2nd Level

- r** Welding circuit resistance
- Sst1** Slope time 1
- Sst2** Slope time 2
- tTr** Trigger mode
- IGn** HF ignition
- Ptd** Pulse TAC Display
- ItO** Ignition time out
- ArC** Arc break monitoring
- CSs** Comfort Stop sensitivity
- UCo** Break voltage
- ACS** Main current changeover

i Operating Instructions



<https://manuals.fronius.com/html/4204260516>