

OPERATION & MAINTANANCE MANUAL

MODEL – INMIG 500 IDL

Inverter Based MIG/MAG Welding Machines



WARPP ENGINEERS PVT.LTD.

Survey No. 36, House No. 15/3, Unique Industrial Estate
Dhumal Nagar Vasai (East) Dist. Palghar (Maharashtra) INDIA
PIN -401208

Tel: 8551817744 / 8551819944 / 8551817868 - 69 / 8551812002

Customer Care Tel: 8080808734

Email: service@warpp.co.in

Website: www.warpp.co.in

PREFACE

Thanks for purchasing our product and looking forward to your precious advice for the improvement of our product. We will dedicate to produce the best products and offer the best services.

The machine has been carefully inspected both mechanically and electrically before it left the factory. The machine should be initially inspected upon receipt, if any damage which may have occurred in transit inform “**WARPP ENGINEERS PVT.LTD.** OR It’s Dealer immediately. Check for the accessories supplied against those listed in packing slip.

Caution: Before attempting to connect the equipment to any Power source, read instructions carefully.

In case of any defect or deficiency, contact “**WARPP ENGINEERS PVT.LTD.**” or its authorized Agent. Make sure to quote model number and serial number of the equipment in all correspondence.

The design of this equipment is subject to continuous development and improvements, consequently “**WARPP ENGINEERS PVT.LTD.**” reserves the right to incorporate minor changes from the information contained in this manual.

INDEX

- 1. Safety Precautions**
- 2. Product Description & Features**
- 3. Working Condition & Environment Required**
- 4. Technical Specification**
- 5. Working Principle**
- 6. Installation**
- 7. Controls**
- 8. Parameters & its operational meaning**
- 9. How to operate the machine**
- 10. Do's & Don'ts**
- 11. Trouble Shooting**
- 12. Wiring Diagram**
- 13. Maintenance**
- 14. Spare Part List**

1. Safety Precaution

General safety precaution:

- Please strictly comply with rules defined in this manual to avoid unexpected accidents.
- How to connect to power supply, select working area and use pressure gas, please comply with proper rules
- Not allow non-operator to enter working area.
- Machine's installation, inspection, maintenance, and manipulation must be completed by authorized person.
- Don't use welding machine for unrelated purposes (Such as recharging, heating or plate cutting, etc.)
- Must take safe precaution in case machine falling when it is put on the uneven ground

Avoid being electric shocked and burnt:

- Never touch the hot electrical units.
- Please instruct the authorized electrician to ground the machine frame by using Proper-sized copper wire.
- Please instruct the authorized electrician to connect the welder to power supply by using proper- sized, well-insulated copper wire.
- When operating in the damp, space limited area, must ensure well-insulated between body and work piece
- When operating in the high-rising location, must ensure safety by using safe net.
- Please power off the input voltage while no longer using.

Avoid breathing in hazardous welding fume or gas:

- Please use specified ventilation to prevent being gas poisoned and asphyxiated
- Especially in the container where oxygen is depleted easily

⚠️ Avoid being harmed by arc flash, hot spatter and slag:

- Arc rays can injure your eyes and make your eyes feel uncomfortable.
- Hot spatter and slag can burn your skin. Please wear proper welding helmet, leather gloves, long- sleeved suit, cap, apron and boot before welding.

⚠️ Preventing from fire, explosion, and container break accidents:

- Don't put flammable material in the working area. Hot spatter and hot weld can easily start a fire.
- Cable must be connected the work piece firmly to ensure good conductivity in case causing fire by resistance heat.
- Don't weld in the flammable gas or weld container which contains flammable material, otherwise it can cause explode.
- Don't weld encapsulated container, otherwise it can cause break.
- Ensuring a fire extinguisher at hand in case fire break out.

⚠️ Avoid being hurt by moving parts:

- Never let the finger, hair, and cloth near the rotary cooling fan and wire feeder rollers.
- When feeding wire, don't let the bottom of gun near your eyes, face and body, to prevent being harmed by wire.

⚠️ Avoid gas bottle falling or gas regulator breaking:

- Gas bottle must be firmly fixed on the ground, else if injure will exerts on.
- Never place bottle under high temperature or straight sun light.
- Never let your face near gas outlet while turning on the gas valve to prevent from being hurt by pressure gas.
- Customer should use the gas regulator provided by our company, and comply with the proper instruction.

⚠️ Avoid being hurt by welding machine while in transport:

- When moving the welding machine by fork-lift truck or crane,

nobody can be allowed for standing downright the route of the moving welder, in case being hurt by the falling welding machine.

- The ropes or wires which used for hanging up the welding machine must be strong enough to withstand corresponding tension strength. The rope or wire inclination hanging on the tackle must be no more than 30°

2. Product Description & Features

The **INMIG 500IDL** series is inverter **GMAW** welders are high-quality performers that can be used for all-purpose, semi-automatic CO₂ gas shield welding with solid or flux-cored wire (0.8 -1.6mm) for welding mild steel and low alloy steel work pieces. Inverter technology can ensure fairly good stability of output voltage when fluctuation occurs in input primary voltage or arc length changes.

Features:

- ❖ Digital Software controller-based design.
- ❖ Ability to save welding parameters like voltage, current, rpm of wire feeder motor, speed of wire feeder, wire thickness, gas used and track welding data with reports generated.
- ❖ Protection from accidental and welding beyond set parameters.
- ❖ Multiple welder and operator profiles to set.
- ❖ User-friendly screen for better readability and settings.
- ❖ Less spatter, high deposit efficiency.
- ❖ Less weld distortion, good weld formation.
- ❖ Adjustable crater voltage & crater current facility available on front panel
- ❖ High success rate of arc-starting due to stronger pulse strike
- ❖ Reducing molten ball while stopping arc.
- ❖ Stable wire feeding due to consistent output of power circuit.
- ❖ Energy-saving, low expense and flexible to various input primary Quality.

3. Working Condition and Environment Required

- ❖ Please note that this equipment to be installed in a clean place free from dirt, moisture.
- ❖ Avoid direct exposure to sunlight.
- ❖ Care should be taken to see that it is not exposed to rain.
- ❖ Whenever the machine to be used at a site make sure proper shade is provided for the machine
- ❖ Do not keep the machine near oven, furnace where temperature may be higher and it can affect the performance of the machine
- ❖ Always keep the machines at least with a gap of 300 mm around the machine as it is required for free circulation of air.
- ❖ Keep the machine in a flat position and if it is placed in an inclined position then the degree of inclination shall not be more than 15 degrees.
- ❖ This machine can operate in the temperature range of 0 ~ 50 degree centigrade. When used over 40 degree centigrade the duty cycle of the machine may be lower than what is mentioned in the catalogue
- ❖ Always connect the machine to the electric supply through a preferably D type MCB of suitable capacity
- ❖ Use cables with proper cross section based on the input power requirement of the machine (Please refer to technical specification page for input power of the machine)
- ❖ When long cables are used you need to select higher cross-sectional area of conductors to avoid voltage drop during the usage.

Selection guide for type of MCB

MCB Type	Tripping Current	Application
B Type	3 to 5 times the rated current	Purely resistive load like lighting and general-purpose outlets
C Type	5 to 10 times the rated current	Moderate inductive load like air conditioners, residential / commercial pumps
D Type	10 to 20 times the rated current	Heavy inductive loads like heavy induction motor and welding machines

Selection of cable size for input supply

Please note that the cable size required for input supply depends on following.

1. Whether the machine is single phase or three phases
2. Input KVA of the machine.
3. Distance from electrical supply point.

First calculate the current the machine will draw based on the input KVA given (refer to technical specification page for this)

If the machine is a single-phase machine then each KVA would require around 4.6 Amps of current. That if input KVA of the machine is 5 KVA, then it would draw 23 Amps at full load

If the machine is a three-phase machine then each KVA would require around 1.4 Amps of current. That if the input KVA of the machine is 5 KVA, then it would draw around 7 amps of current at full load

Cable capacity for copper cable can be taken as 6Amps/Sq. mm when cable length is less than 10 meters. That means 1 sq. mm cable can carry a current of 6 Amps of current

Now you have input current of the machine based on its input KVA.

You can calculate the conductor size by this formula

Input current / capacity of conductor

Example

From the above for a single-phase machine of 5 KVA you would need $23/6=3.8$ Sq. mm cable. (You can choose 4 sq. mm cable)

From the above for a three-phase machine of 5 KVA you would need $7/6=1.16$ Sq. mm cable. (You can choose 1.5 sq. mm core cable for each phase)

Note:

When the length of the cable is short the required cross section for input cable will come down

Below table will help you in selecting the right size of welding cable based on the length and current to be used

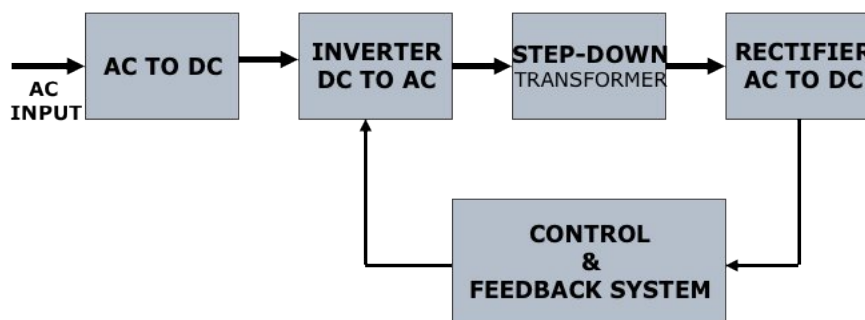
Welding Cable selection chart					
Welding Current in Amps	Recommended Cable size (Sq. mm) based on length (inMtrs)				
	1 ~ 15 Mtrs	15 ~ 30 Mtrs	30 ~ 45 Mtrs	45 ~ 60 Mtrs	60 ~ 75 Mtrs
100	16	25	25	35	50
150	16	25	35	50	50
200	35	35	50	50	70
300	50	50	70	70	95
400	70	70	70	95	120
600	95	95	95		
Table given is just for reference and the actual result may vary depending on the quality of conductor Multiple cables can be used where every single cable of that capacity is not available					

4. TECHNICAL SPECIFICATIONS

PARAMETERS		INMIG 500 IDL
Rated input voltage		Three-phase supply 415VAC 50Hz
Rated input capacity		25 KVA
GMAW	Output Current	60 - 500
	Output Voltage	15 – 50 V
Duty cycle @ 100%		400A
Duty cycle @ 100%		500A
Rated current		500A
Suitable welding wire's diameter		Solid: 0.8mm,1.2mm ,1.6mm
		Flux-cored: 1.2mm / 1.6mm
Dimension (LxWxH) in mm		700X 325X 540
Weight		50 Kg.
Class of Insulation		'H'
Class of protection		IP23
Cooling of Machine		Air Cooled

5. WORKING PRINCIPLE

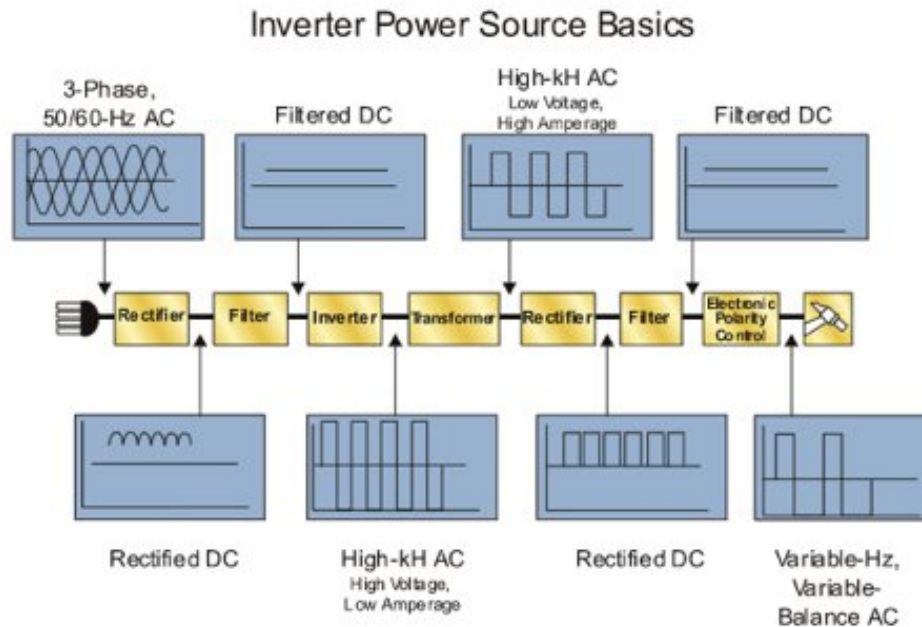
Block Diagram



These power sources are used for various types of welding, and they are based on IGBT inverter Technology. In these types of machines input supply is first converted into DC by a rectifier circuit. The rectified voltage is then filtered and fed to an inverter section. This section will convert the DC to high frequency AC. In this case it is 20 K Hz AC. This AC voltage is fed to a specially designed high frequency transformer which steps down the voltage to acceptable welding voltage and increases the current to the required level. The output of the transformer is fed to a high frequency rectifier circuit which converts this AC to DC for various welding applications.

In the case of machines having capability to deliver both AC & DC outputs for welding, this DC is fed to one more inverter circuit OR electronic polarity control circuit which converts this into low frequency AC output for Aluminum TIG application. In this case controls are provided for adjusting the AC frequency, AC balance along with other regular controls.

Block diagram with waveforms at different stages is given below for reference:



Different types of power sources are available for welding and most commonly used are as under

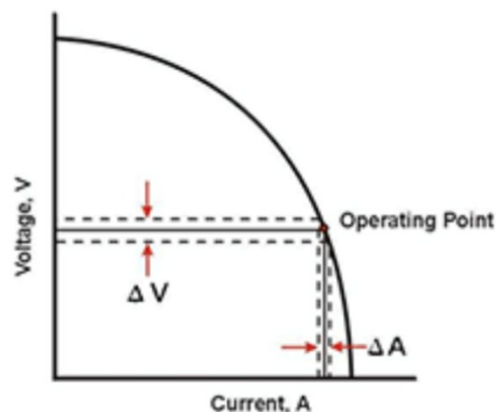
- ❖ Constant current (CC) power source
- ❖ Constant Voltage (CV) power source
- ❖ CC/CV power source

Please refer to the below chart for process-wise recommended power source types

Process	Power source type
SMAW	CC
GTAW	CC
GMAW /FCAW	CV
SAW	CV is commonly used and sometimes CC is used
Plasma Cutting	CC

Constant Current (CC) type power source

Constant current characteristics are also called as drooping characteristics. Typical V/I curve of such power source is shown below. Here the current remains stable even if the arc length varies. When there is change in arc length, change in the voltage is more when compared to change in current and hence they are called constant current type power source



Relationship between the voltage and current for different process in CC type power source is as under

SMAW:

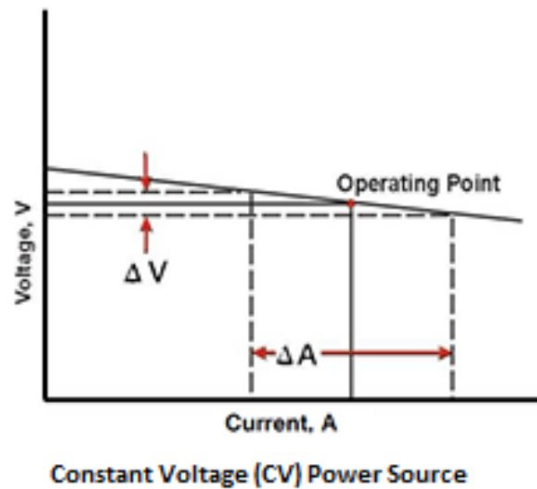
$$V = I * 0.4 + 20$$

GTAW:

$$V = I * 0.4 + 10$$

Constant Voltage (CV) type power source

Constant voltage characteristics are also called as Flat characteristics. Typical V/I curve of such power source is shown below. Here the voltage remains stable even if the arc length varies. When there is change in arc length, change in the current is more when compared to change in voltage and hence they are called constant voltage type power source



Relationship between the voltage and current for different process in CV type power source is as under

$$\text{GMAW: } V = I * 0.5 + 14 \quad \text{FCAW: } V = I * 0.5 + 17$$

Note:

Some power sources have both CC and CV characteristics. The explanation given above is general and the capability of the machines depends on the model number of the machine purchased by you.

6. INSTALLATION

Installation:

- ❖ Place the welding machine in the room where there is no straight sunlight, no rain, less dust, low humidity, and temperature range of 0° - 50°C.
- ❖ The gradient of ground must not be more than 15°
- ❖ Ensure no wind at the welding position, or use screen to block the wind.
- ❖ The distance between welder and wall must be more than 300 mm.
- ❖ Connect the 3 phase Input supply to the machine. Supply voltage must be in the range of 400 V +_ 10% as mentioned in the technical specification of this manual.
- ❖ Power supply:
 - The size of fuse and breaker in the table are for reference:

Product type		INMIG 500 IDL
Power supply		3 Phase AC 400 V
Power capacity		25 KVA
Input Protection	Fuse	40A
Input Protection	Breaker	50A
Min Cable Size	Input side	6mm ²
	Output side	70mm ²

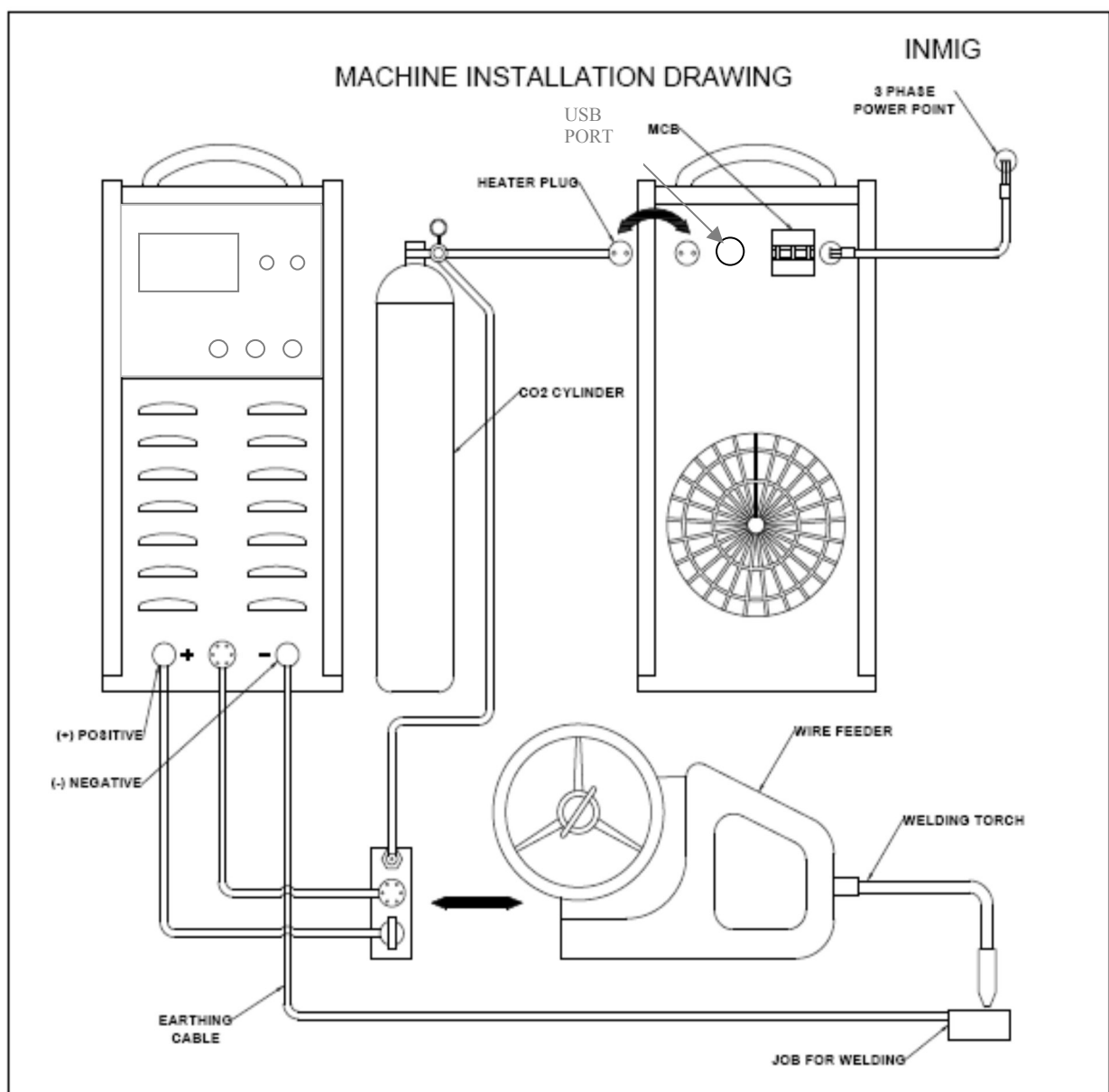
CONNECTION FOR GMAW WELDING

- ❖ Connect the +Ve cable of wire feeder to the positive terminal of machine & -Ve terminal to the job to be welded.
- ❖ Ensure firmly connection of gas hose to the gas cylinder.
- ❖ Adjust every knob, and switches on the front panel to proper position in line with selected mode.
- ❖ Connect 6 pin remote connector of the wire feeder to the power source.

CONNECTION OF GAS CYLINDER

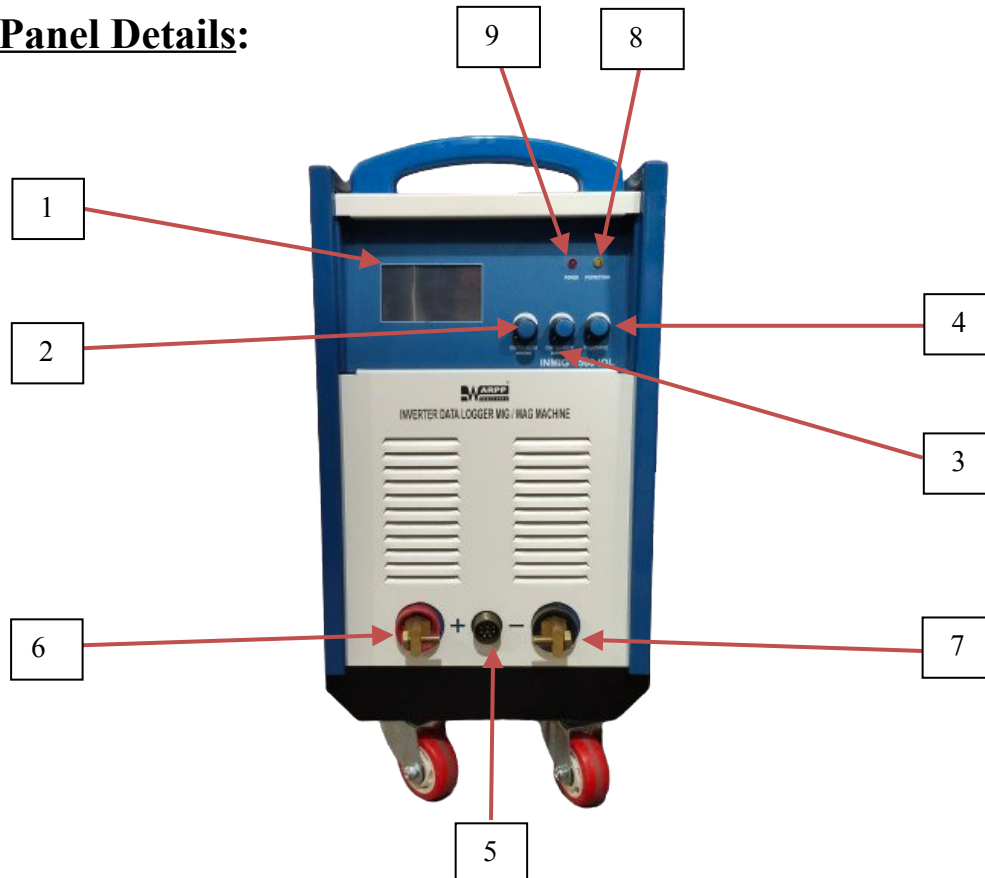
1. Install the gas regulator to the gas cylinder. Connect the gas heater to the heater's power source socket on the back panel of the machine. Connect the gas hose of the wire feeder to the gas output connector of the gas heater.

Installation & Commissioning Diagram INMIG 400I Series



7. Controls

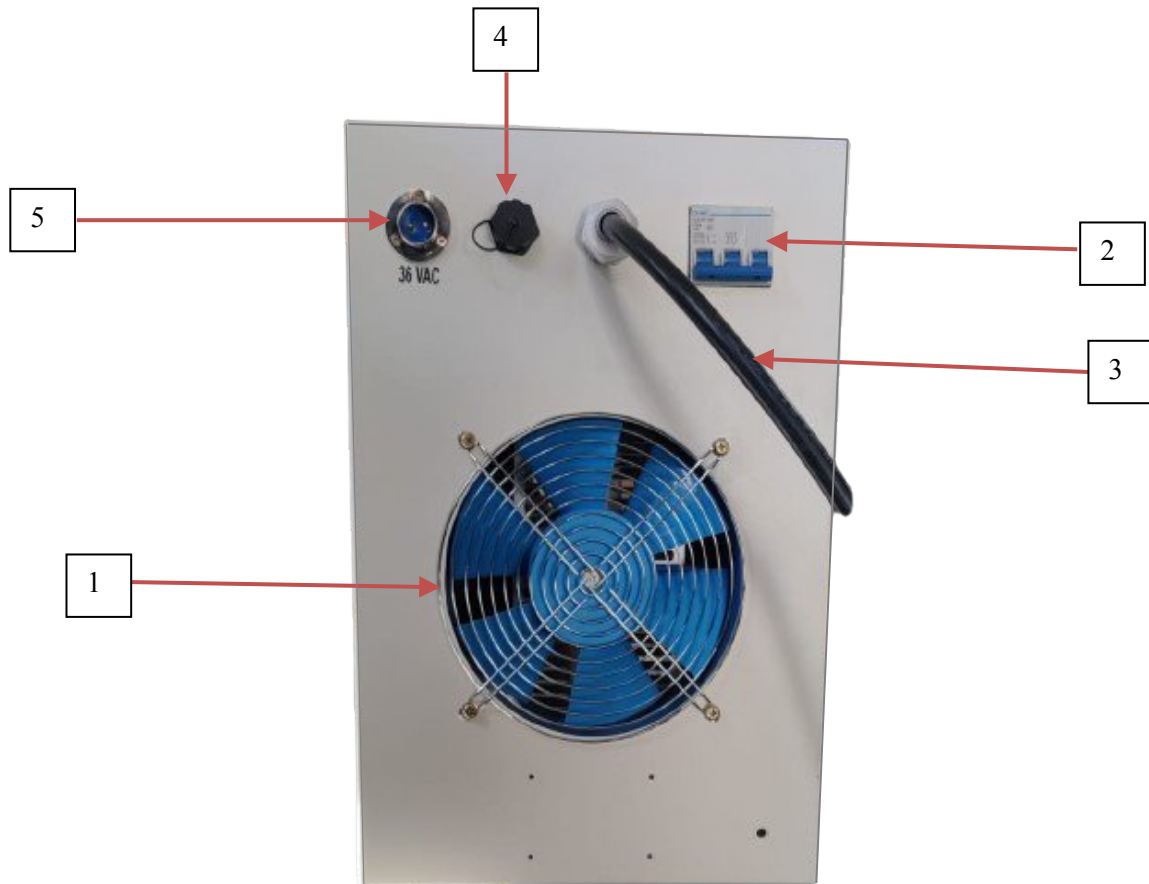
Front Panel Details:



1. **DIGITAL DISPLAY:** - Set and observe welding data.
2. **CRATER FILLER VOLTAGE:** - This pot has been provided to set the crater voltage. At the end point of welding crater is created. This crater can be filled by increasing this pot.
3. **CRATER FILLER CURRENT:** - This pot has been provided to set the crater current. At the end point of welding crater is created. This crater can be filled by increasing this pot.
4. **INDUCTANCE:** - The inductance pot is used to vary the output inductance of the welding machine to improve the quality of the welding.
5. **10 Pin Connector:** This connector is connected to control cable which is supplying the control voltage to wire feeder.
6. **+Ve TERMINAL** : This is +ve supply terminal of the power source, which can be connected to wire feeder.
7. **-Ve TERMINAL** : This is -Ve supply terminal of the power source, which can be connected to the job to be weld.
8. **Protection LED:** - with turn on an machine is a protection mode.

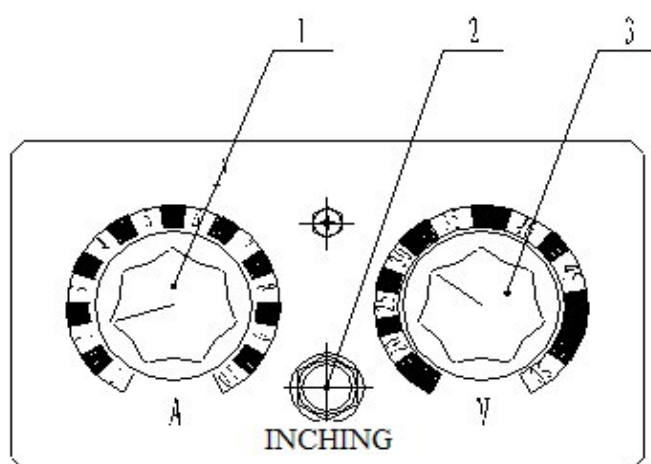
9. **Power LED:** - This LED will indicate if machine is power or not.

BACK PANEL



1. **Cooling Fan:** It is provided to cool the machine while welding.
2. **MCB:** This is provided to switch on or switch off the machine.
3. **Input Cable:** This is provided to give the input supply to the machine.
4. **USB port:** - We can attach a USB drive to this port for data transfer.
5. **Supply for preheater:** - 2 pin connector for gas cylinder preheater supply.

WIRE FEEDER CONTROL PANEL: -



1.

1. Current Control knob: - To Adjust welding current.
2. Inching Button: - Used for quick wire feeding.
3. Voltage Control knob: - To adjust the welding voltage

(The user should choose the power cables, switches, fuses and power switches as specified in table)

Specification	INMIG 500 IDL
Switch capacity (A)	32
Fuse capacity (A)	25
Section surface of power supply cables (mm ²)	4
Section surface of grounding cables mm ²)	35

- **Connections of the power supply cable and the grounding cable. Methods and requirements**

Make sure that the power supply panel is off before connecting. Do not connect with wet hands. Do not place anything on the power supply cable. Make sure all the connections are proper. Connect the green-yellow wire of the three-phase input cable to the grounding wire on the switch board properly.

Connections of GMAW (Gas Metal Welding)

Please make sure the power switch is cut off before connecting.

Connect the welding cable of wire feeder to '+Ve' output that of the welding power source.

Connect the Earthling cable to '-Ve' output of the welding power source & other end to job.

Connect the 10-pin connector of wire feeder to the front panel &, then tighten the ring nut.

Connect the MIG torch to the wire feeder connector properly.

Connect the gas preheater to the gas cylinder & then gas regulator with flow meter.

Connect the gas pre heater's supply socket to the heater's power source socket on the back panel of the machine. Connect the gas hose of the wire feeder to the gas output connector of the gas heater.

Put the wire spool of required size in the wire feeder.

8. Parameters & its Operational meaning

Welding operation without crater function (operate with welding torch's switch synchronously)

Operation:

Press the welding torch's switch to start welding and release it to stop welding. It is called **2T** mode. In **4T** mode, press & release the torch switch to start welding & press & release to stop welding. To get the proper welding, voltage & current to be settled precisely. When welding is finishing, release the welding torch switch, wire feeding stops immediately, and become back burn state, the welding voltage will decrease and becomes back burn voltage. When welding current becomes zero, arc quenches, gas sending stops, and the welding finished.

Instruction to use long output cable

The connection cable on this series of machine is allowed to be lengthened between power source and wire feeder, but the below points to be followed. The resistance of cable will increase with length, and also increase of the cable's voltage drop. Moreover, the cross-section area of the cable effect the voltage drops; When lengthening the cable, get the cable with higher cross section area; when lengthening cable, place the cable straight don't make it in coil form. Welding operation with crater function

1. Features & instruction:

The main features of the data logger machine is to record welding data and generate reports accordingly. This welding machine has the ability to fill up the hollows when ending weld, which can be propitious to connect the start-point and end-point of the welding seam continuously.

2. Crater ON function:

Normally there is a small depressing at the end of the weld when welding is done at higher currents. The depression is called crater, the arc crater is caused because of the arc force and solidification of metal in all direction. To minimize the crater the machine has crater fill function.

Normally crater fill voltage and current set at 60 to 70 % of the welding voltage and current. When crater is set on the welding voltage and current will automatically switch to lower voltage and current (crater voltage and current) at the end of the welding. To guaranteed better arc striking every time the wire feeding is normally done at lower speed. When the torch trigger is pressed irrespective of the current (wire speed) set, wire will be fed slowly and it switches over to the set speed once the arc is struck.

What is burn-back time?

After welding, wire feeder is not stop even if the welding torch switch is released because of inertia. So, there will be some more wire drive out from the torch, thus the wire will stick to the work piece, or it will cause difficulty in arc striking next time. In order to avoid this, it is necessary to deal with welding machine operation, so that after releasing the welding torch switch, the output voltage will still exist for a short time to burn the wire. This process time is burn-back time. This time varies because of differences in welding conditions, the resistance of welding feeding tube and the length of output cable.

Welding Chart for Parameters setting:

Table - 1

		Thickness (mm)	Length (mm)	Wire diameter (mm)	Welding current (A)	Welding voltage (V)	Welding speed (cm/Min)	Stick out (mm)	Gas flow (L/ Min)
T type welding	Slow speed	1.0	2.5~3	0.8	70~80	17~18	50~60	10	10~15
		1.2	3~3.5	1.0	85~90	18~19	50~60	10	10~15
		1.6	3~3.5	1.0,1.2	100~110	18~19.5	50~60	10	10~15
		2.0	3~3.5	1.0,1.2	115~125	19.5~20	50~60	10	10~15
		2.3	3~3.5	1.0,1.2	130~140	19.5~21	50~60	10	10~15
		3.2	3.5~4	1.0,1.2	150~170	21~22	45~50	15	15~20
		4.5	4.5~5	1.0,1.2	180~200	23~24	40~45	15	15~20
		6	5~5.5	1.2	230~260	25~27	40~45	20	15~20
		8, 9	6~7	1.2,1.6	270~380	29~35	40~45	25	20~25
		12	7~8	1.2,1.6	300~380	32~35	35~40	25	20~25
	High speed	1.0	2~2.5	0.8	140	19~20	150	10	15
		1.2	3	0.8	140	19~20	110	10	15
		1.6	3	1.0, 1.2	180	22~23	110	10	15~20
		2.0	3.5	1.2	210	24	110	15	20
		2.3	3.5	1.2	230	25	100	20	25
		3.2	3.5	1.2	260	27	100	20	25
		4.5	4.5	1.2	280	30	80	20	25
		6	5.5	1.2	300	33	70	25	25
Put up weld (thin plate)	Slow speed	0.8		0.8	60~70	16~17	40~45	10	10~15
		1.2		0.8	80~90	18~19	45~50	10	10~15
		1.6		0.8	90~100	19~20	45~50	10	10~15
		2.3		0.8	100~130	20~21	45~50	10	10~15
				1.0,1.2	120~150	20~21	45~50	10	10~15
	Slow speed	3.2		1.0,1.2	150~180	20~22	35~45	10~15	10~15
		4.5		1.2	200~250	24~26	40~50	10~15	10~15
		2.3~3.2		1.2	220	24	150	15	25
					300	26	250	15	25
	High								
Corner weld	Slow speed	1.6		0.8	65~75	16~17	40~45	10	10~15
		2.3		0.8	80~100	19~20	40~45	10	10~15
		3.2		1.0, 1.2	130~150	20~22	35~40	15	10~15
		4.5		1.0, 1.2	150~180	21~23	30~35	15	10~15

Table - 2

		Thickness (mm)	Wire diameter (mm)	Root gap G (mm)	Weldi ng curren t (A)	Weldin g voltage (V)	Welding speed (cm/Min)	Wire out (mm)	Gas flux (L/Min)	
I type butt welding	Slow speed	0.8		0.8	0	60~70	16~16.5	50~60	10	10
		1.0		0.8	0	75~85	17~17.5	50~60	10	10~15
		1.2		0.8	0	80~90	17~18	50~60	10	10~15
		1.6		0.8	0	95~105	18~19	45~50	10	10~15
		2.0		1,1.2	0~0.5	110~120	19~19.5	45~50	10	10~15
		2.3		1,1.2	0.5~1	120~130	19.5~20	45~50	10	10~15
		3.2		1,1.2	1~1.2	140~150	20~21	45~50	10 15	~ 10~15
		4.5		1,1.2	1~1.5	170~185	22~23	40~50	15	15
		6	Face	1.2	1.2 ~ 1.5	230~260	24~26	40~50	15	15~20
			Inside	1.2	1.2 ~ 1.5	230~260	24~26	40~50	15	15~20
		9	Face	1.2	1.2 ~ 1.5	320~340	32~34	40~50	15	15~20
			Inside	1.2	1.2 ~ 1.5	320~340	32~34	40~50	15	15~20
	High speed	0.8		0.8	0	89	16.5	120	10	15
		1.0		0.8	0	100	17	120	10	15
		1.2		0.8	0	110	18	120	10	15
		1.6		1,1.2	0	160	19	120	10	15
		2.0		1,1.2	0	180	20	80	15	15
		2.3		1,1.2	0	200	22	100	15	20
		3.2		1.2	0	240	25	100	15	20

9. How to operate the machine

- ❖ Switch on the main switch for input supply provided for the machine.
- ❖ Switch on the MCB of the machine provided on the rear side of the machine.
- ❖ Take out the wire from the torch after pressing the inching switch provided on the wire feeder.
- ❖ Set the output voltage & current as per required wire size from panel of wire feeder.
- ❖ Set the gas flow 10-15 LPM on the flow meter of gas cylinder.
- ❖ Now start welding by pressing the torch. Adjust the welding current & voltage as per requirement.
- ❖ When welding is over, Switch off the machine.
- ❖ Switch off the main switch & gas cylinder.

1. When we turn on supply machine is in protection mode.

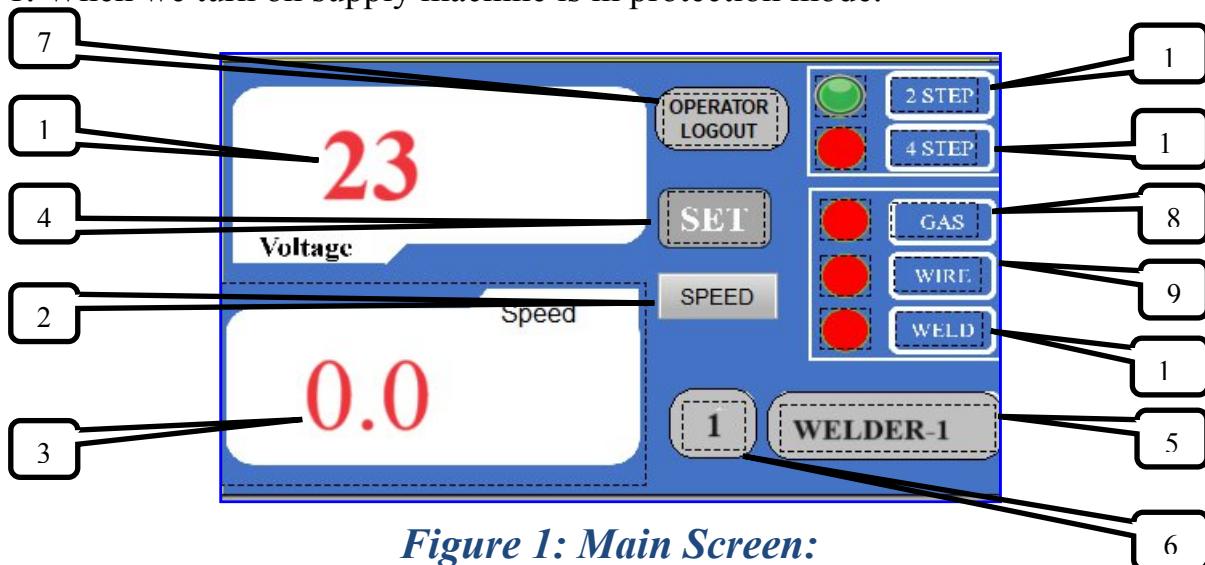


Figure 1: Main Screen:

1. Voltage Display:

This will give actual voltage reading that machine is giving.

2. SPEED / CURRENT BUTTON:

This is Toggle button to display either wire feeder speed or actual current flowing through job when welding is in progress.

3. SPEED/ CURRENT DISPLAY:

This will give actual current when welding is in progress. Regular current reading is 3 times lesser than actual current that is going to flow to job at welding time.

4. SET:

This is button to select operator or admin profile. Refer to screen2 for details.

5. OPERATOR:

This is a display to show operator selected. If this display is blanks, it means no operator is selected. For details refer to screen2.

6. ADMIN:

This is a display to show admin profile selected. If this display is blank, it means no admin profile is selected. For details refer to screen2.

7. OPERATOR LOGOUT:

This button will logout operator (i.e. welder) and machine will enter in protection mode.

8. GAS:

This button is for gas test. Indicator next to it shows it's state. Green colour shows ON state and red colour shows OFF state.

9. Wire:

This button is for wire test from feeder.

10. WELD:

This button is for welding. This button should be always GREEN for welding. If it's off we cannot do welding even if we have all desired parameters.

11. 2 STEP:

This is trigger mode of a wire feeder. If this button indicator is GREEN, then we have to keep trigger of torch pressed till we complete welding.

12. 4 STEP:

This is trigger mode of a wire feeder. If this button indicator is GREEN, then we have to press trigger of torch once and leave it and again press it to stop welding

When we press SET button in main screen we enter into another screen as

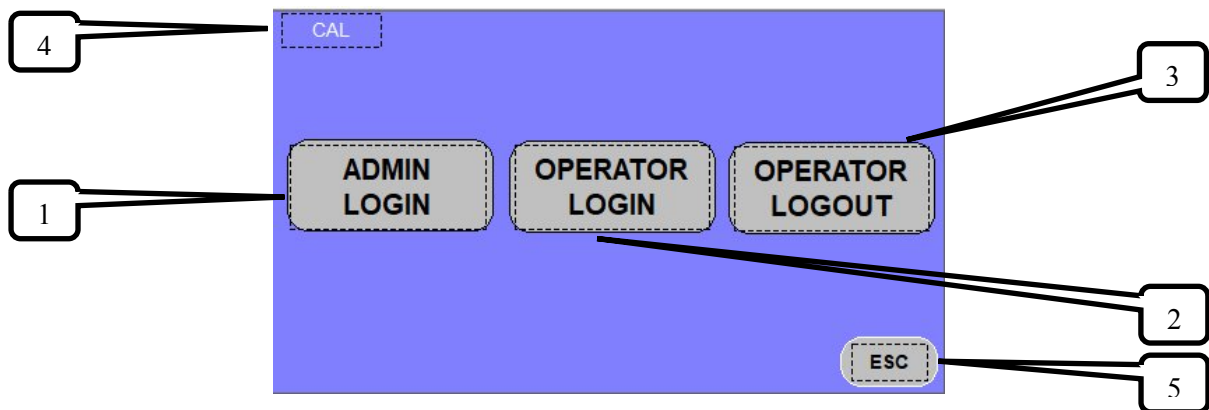
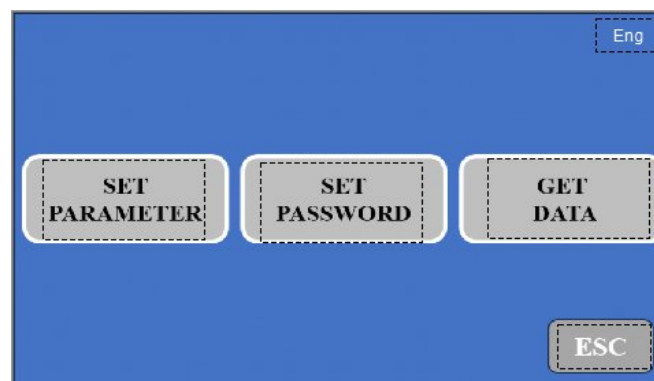


Figure 2: Screen 2

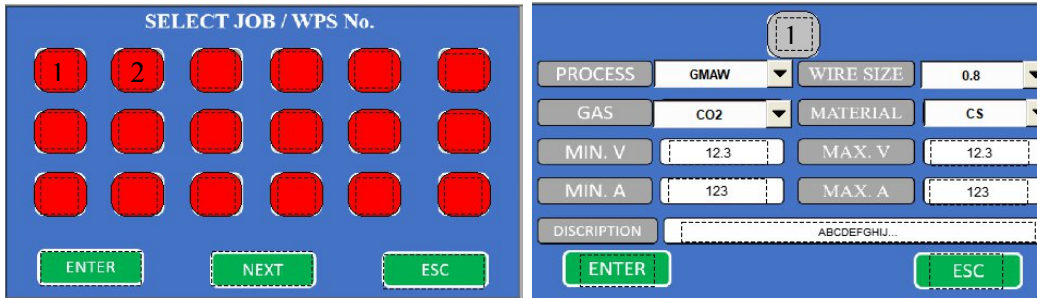
shown below:

2.1) ADMIN LOGIN



2.1.1) SET PARAMETER

We can set welding parameters and mention job description here.



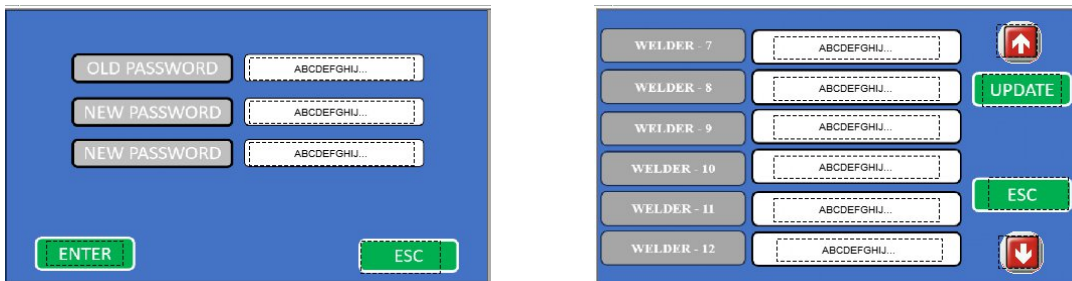
We can set welding parameters operator has to work on with the help of this screen.

Process, Wire size, gas and material can be selected from the drop-down list but minimum voltage, minimum current, maximum voltage, maximum current should be chosen as per job requirement. If during welding current and/or voltage exceed these limits then machine will enter into protection mode till those parameters come within limit. We can add description of our own choice according to job.

2.1.2) SET PASSWORD

We can set/change password for both admin and operators here.

Default admin password is **ADMIN** and default operator password will be W1 for welder 1, W2 for welder 2, and like that W30 for welder 30.



2.1.3) GET DATA

We can view data logged here. We can also transfer data from plc to USB.

To clear data long press DATA CLEAR button till data is cleared from screen.

2.1.4) Eng

This is

No.	TIME	DATE	Current	Voltage
1	hh:mm:ss	dd/mm/yy	####	#####

engineering

CAL

ENGINEERING SETTING

ESC

ROLLER DIA

123.4

BATCH NO.

123456

SAMPLE TIME

12.3

OVERSHOOT

123

DENSITY

GMAW-CS

123.45

FCAW-CS

123.45

GMAW-SS

123.45

FCAW-SS

123.45

GMAW-AI

123.45

OTHER-1

123.45

GMAW-CuAl

123.45

OTHER-2

123.45

setting screen.

Roller DIA: This setting should be kept as it is as set up by warpp engg.

Sample Time: This is interval at which we need our data to be saved. Sampling time can be set from 0.1 to 5 seconds.

BATCH NO: This is machine specific number.

OVERSHOOT: This number indicates when machine will enter in protection mode. i.e. if this is set 1 and during welding current and/or voltage exceeds limits set in admin profile then machine will enter into protection mode. If it is 2 then machine will enter into protection mode after current or voltage exceed its limits twice during welding.

2.2: OPERATOR LOG IN

We can select operator for welding here. Protection LED turns off and machine enter in ready state for welding once we select operator.

WELDER-1	WELDER-2	WELDER-3
WELDER-4	WELDER-5	WELDER-6
WELDER-7	WELDER-8	WELDER-9
WELDER-10	WELDER-11	WELDER-12
WELDER-13	WELDER-14	WELDER-15
ENTER	NEXT	ESC

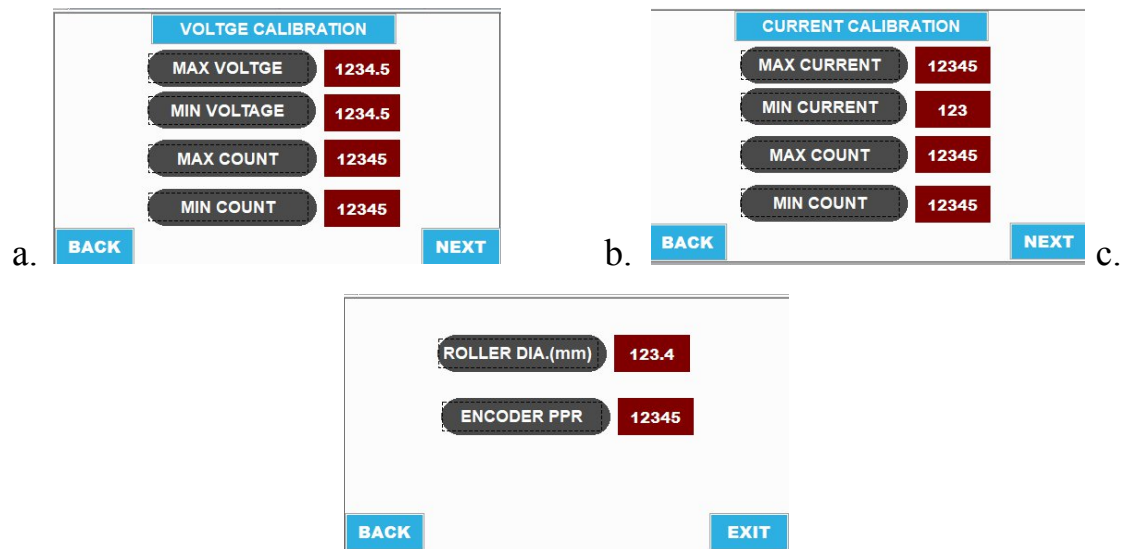
We can create more operator profiles as per requirement.

2.3 : OPERATOR LOG OUT:

This will logout operator (i.e. WELDER) if operator has done his job. Machine will be in protection mode if operator has already logged out.

3. CAL:

This is used for HMI calibration. We can set machine maximum and minimum limits in these parameters. Roller diameter should be same as actual roller diameter of wire feeder. Encoder PPR should be same as mentioned in machine manual. **These settings must be done by warpp engineer only.**



4. ESC: This button will switch display to main menu.

10. DO'S & Don'ts

Do's	Don'ts
------	--------

Clean the machine with compressed air @ $< 3 \text{ Kg/Cm}^2$	Don't keep any foreign material or plate on the top cover of the machine
Use proper polarity & current	Never use the higher current than recommended
Use proper welding cable size	Never use long cable if not required
Use proper welding angle	Never use long arc
Make firm connection of welding cable	Never use the joint of cable unless proper technique is used to join the cable
Keep the machine in proper shade to protect it from rain & direct sun light	Don't keep the machine in open ground or site

11. Trouble Shooting

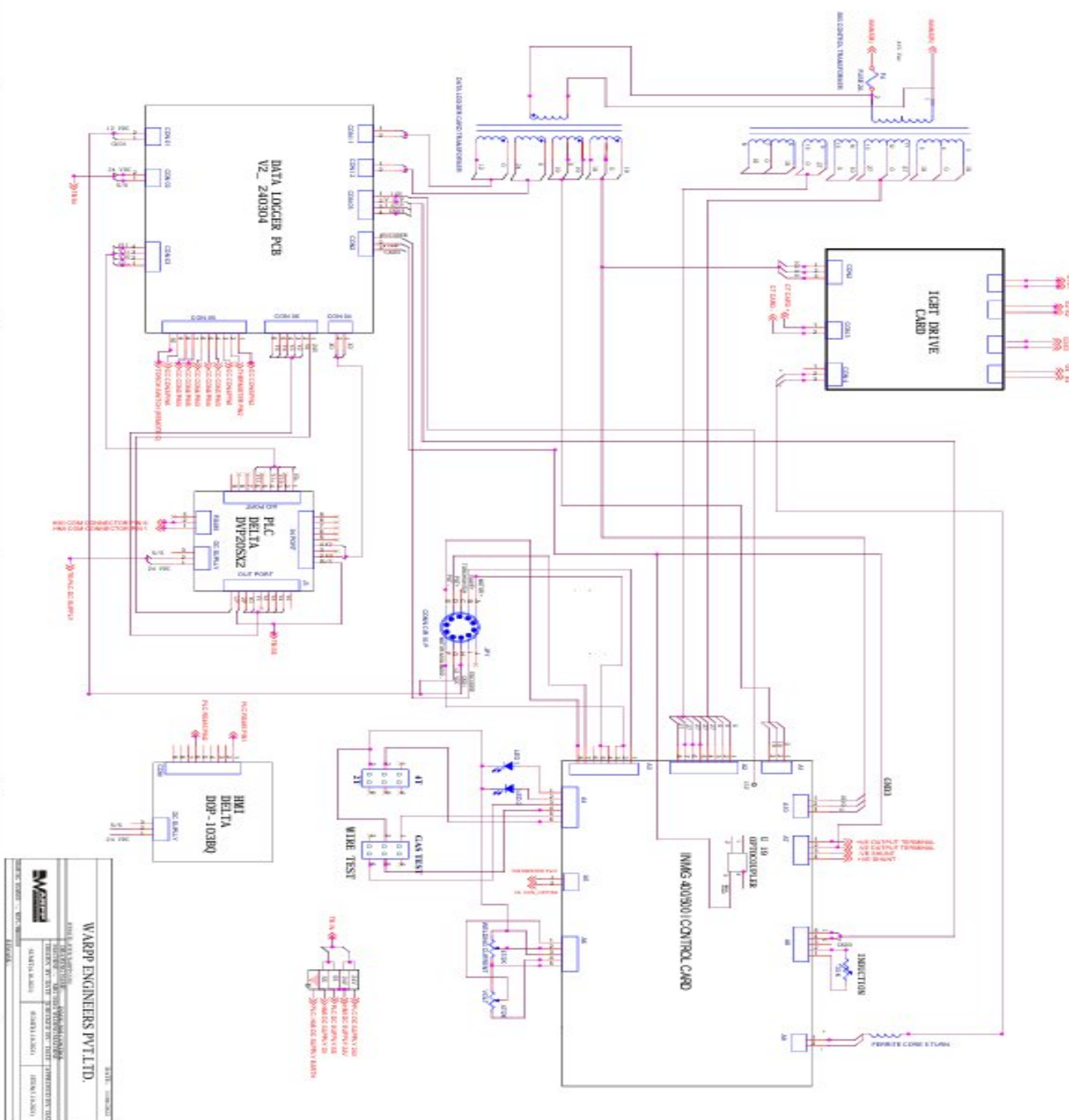
Common troubles and trouble shooting

Troubles	Probable Reasons	Remedy
----------	------------------	--------

❖ After Turn on power, the indicator led doesn't light, the digital meter doesn't light, Digital display dose not turn on.	❖ Phase missing ❖ MCB faulty	❖ Check & rectify ❖ Check & replace
❖ There is no output voltage and there is noise inner the Machine	❖ The output diode of the main circuit is faulty	❖ Check and replace the faulty fast recovery diode
❖ Welding wire feeder works, but there is no wire feeding or the feeding isn't stable.	❖ Wire press wheel is not pressed tightly ❖ The type of wire feeding slot doesn't match the welding wire ❖ The tip is jammed because of the spatters ❖ The wire feeding roller is damaged ❖ The wire feeding tube of the welding torch is jammed	❖ Press tightly ❖ Replace wire feeder Roller ❖ Clean the spatters in the tip ❖ Change wire feeding roller ❖ Check & rectify
❖ The feeder doesn't work after pressing down the torch switch & there is no open circuit voltage	❖ The control cable of the wire feeder is broken ❖ Torch switch is faulty gun switch ❖ The PCB is broken	❖ Replace the control cable ❖ Check control wire of the welding torch switch ❖ Repair or replace the PCB
❖ Porosity in the welding	❖ CO2 gas is not pure ❖ The gas flow is not h ; ❖ There is rust or oil in the welding seam ; ❖ The wind is strong when welding ; ❖ The path of CO2 is jammed or air	❖ Use pure CO2 gas ❖ Adjust the gas flow ❖ Clean the welding seam ; ❖ The precaution against wind should be adopted ; ❖ Check the path;
	❖ Valve doesn't work ❖ The nozzle is distorted	❖ Check the voltage 24VDC of the valve winding ❖ Replace the nozzle
❖ Current /voltage is out of control	❖ Control cable of wire feeder is broken ❖ Current /voltage adjust potentiometer is damaged ❖ The PCB is faulty	❖ Replace the control cable ; ❖ Replace the potentiometer ; ❖ Repair or replace the PCB ;

❖ Wire feeding starts without pressing down the welding torch switch	❖ The wire connecting welding gun is short circuit ; ❖ Control cable of the wire feeder has short circuit ; ❖ The manual button of wire feeding is damaged ;	❖ Repair or change welding gun ; ❖ Repair or change control cable ; ❖ Change the manual button of wire feeding ;
❖ The current isn't stable, and there is too much spatter	❖ Welding current or voltage is not proper ❖ The quality of wire is poor ❖ Problems in the shielding gas ❖ Tip of the torch not proper as per wire size	❖ Adjust the welding current & voltage ❖ Change wire ❖ Replace the cylinder ❖ Replace tip
❖ Gas heater frosts	❖ The input power fuses of the heater (2A) is burnt ❖ The cable of heater is faulty. ❖ Heater faulty	❖ Replace the fuse with the same rating ❖ Check & replace ❖ Check & replace

12. Circuit Diagram



13. Maintenance

In principle, Machine's maintenance and repair should be completed by us or our authorized distributors. Customers can also solve the problems

instructed by us or our authorized distributors.

1. Periodic inspection and maintenance:

- Remove dust from power resource with compressed air by our authorized maintainer every 3- 4 months. Check if the bolt is loose.
- Check frequently if control cables are worn out, adjusting knobs are loose, and components of panel are damaged.
- Check output cable periodically, if jointers are loose or plugs are distorted, and then please repair it in time, otherwise the sockets will burn out.

Warning:

Don't open up side panel of the machine uninstructed, the max voltage inside the machine is 600VDC, which is very dangerous. Take safe precautions to prevent from being electric shock while maintenance.

14. Spare Parts List

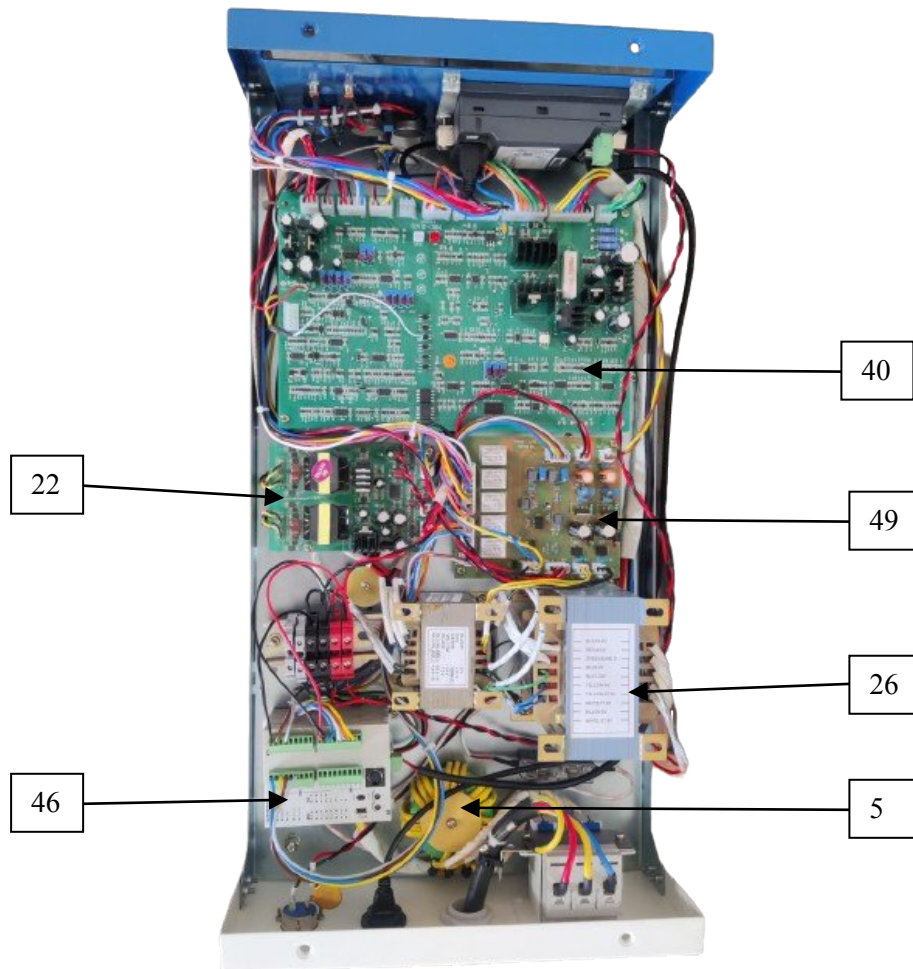
Sr no	Description	Part Code
	Model	INMIG 500 IDL
1	Heat Sink S.A For Inmig 500 IDL	SA00433
2	Middle Panel S.A For Inmig 500 IDL	SA00434

3	BOTTOM PANEL S.A For COMBO / MIG - 500	SA00018
4	INMIG 500 IDL Front Control Panel With Wire Harnessing	SA00419
5	Shunt Filter for CO2 MIG/Combo	SA00186
6	Out Put Connector Euro Type With Strip (Black)	SA00040
7	Out Put Connector Euro Type With Strip (Red)	SA00039
8	Cable Gland-Pg21	SP00597
9	Fan 200FZY7-D (420V	SP01321
10	Fuse-2Amp	SP01499
11	Handle For Inarc-400I	SP01624
12	Allen Bolt- 8 X 20 Mm	SP00227
13	Lug Snap On Tabs Size-2.5 Mm2(Cat No-181789)	SP02106
14	Lug Ring Type Copper-10 X 6 Mm (7120)	SP02102
15	Corrugated Box:-Inmig-500 ,Size: 30*1/2"(I.D) X 15*3/4"(I.D) X 25*1/2" , 7 Ply, One Side Open	PM00017
16	E.P.S. Fabrication Box Size-650X340X130-2Nos, 400X300X20-3Nos & 375X65X50-4Nos	PM00027
17	Shunt-500A/75Mv	SP03486
18	MCB NB1-63H63A	SP02468
19	Lug Copper Ring Tongue Terminal Ends- 70 Sq Mm X M 10 (319-17) (Make -Dowel/JainsoN)	SP02097
20	Power Plug- 2 Pin (F) Steel Type	SP02853
21	Power Plug- 2 Pin (M) Steel Type	SP02854
22	Hard Switching Drive Card	SP04916
23	Welding Machine Body Set For Inmig-500 IDL	SP07474
24	Fuse Holder-Hy F15,250V,15Amp	SP01497
25	Flexible Wire:-6.0 Sq.Mm X 4.0 Core Black Ins."A" Class As Per Is 694:1990	SP01454
26	Control Transformer Type 15 No-1.5) Input 415 Volt With Shield Out-Put 1) 19-0-19 Vot (350 M.A) 2) 19-0-19 Volt (350 M.A) 3) 12 Volt(0.350M.A) 4) 24 Volt(0.700 M.A)	SP07467
27	Control Transformer NBC-500 II.3.5-1(BIG)	SP00925
28	Wheel Rubber Size - 100 X 37.5 Mm Bore Size-16Mm	SP04045
29	Wheel Excel 12 inch Length 16 Mm Round Pipe X C/C Hole-258 Mm	SP04051
30	Welding Copper Cable:-70 Sq. Mm / Hofr,	SP04017
31	Ferrite Core-T2206 Coated (Grade Cf-197)	SP01351
32	FG EPOXY WASHER31MMOD*3MM	SP04134

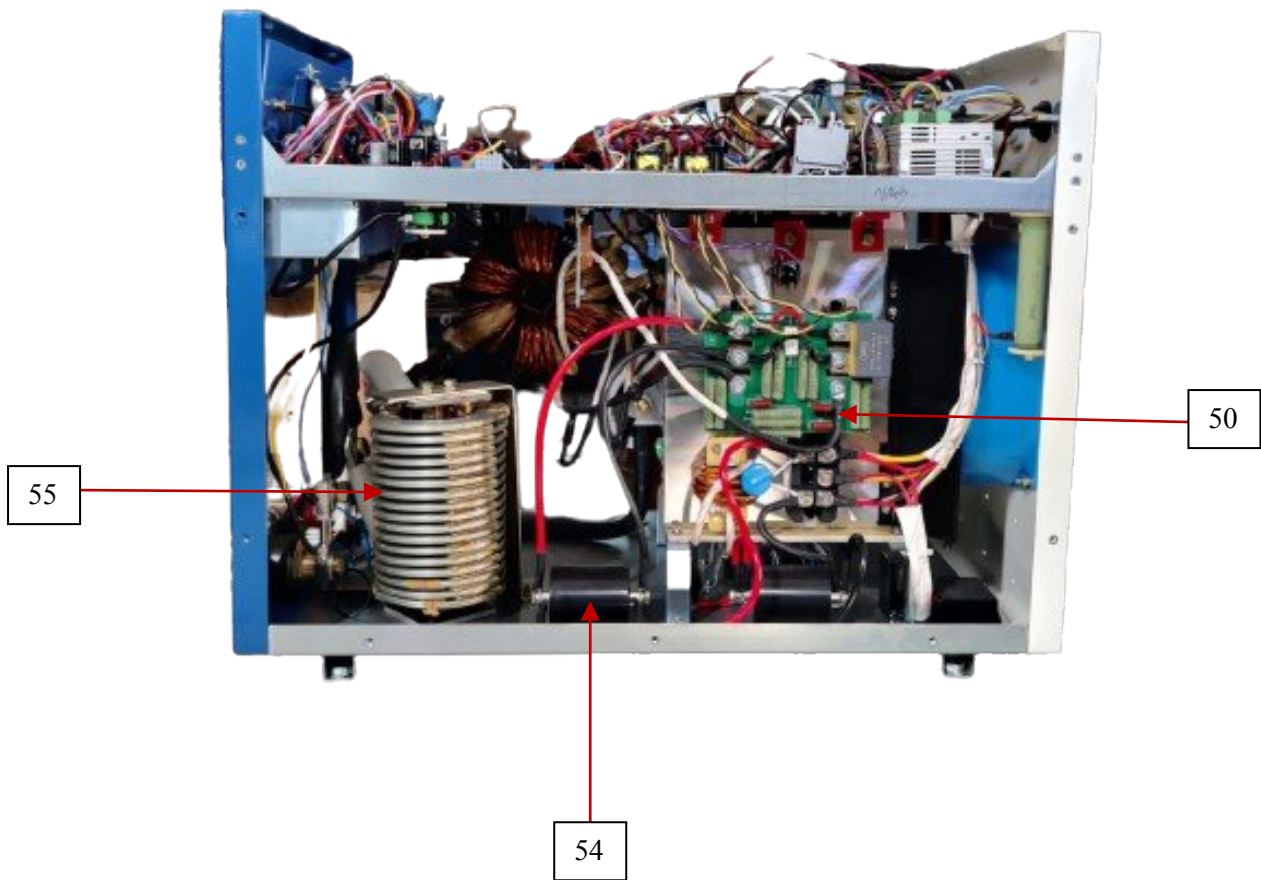
	HOLE-4.2MM(FOR SHUNT FILTER)	
33	INPUT LINE FILTER CHOKE FOR COMBO-502 I/ INMIG-500 I	SA00027
34	F.G.Washer-3X46Mm	SP01313
35	Resistor Aluminium Hsg 200E50W	SP03127
36	Flexible Wire:-0.5 Sq.Mm X 2Core Black Ins."A" Class As Per Is 694:1990	SP01398
37	FG EPOXY WASHER31MMOD*6.2 Hole MM(FOR Fan Wire wonds Resistor)	SP08364
38	Resistor-300E/50 W,Fix	SP08365
39	Hex Bolt-6 X 120Mm	SP08319
40	Main Pcb For Inmig-400I	SP02412
41	Lug Copper Ring Tongue Terminal Ends- 4.6 Sqmm X 6 Mm (7017)	SP02095
42	Gp 6-300 Ptc (Resettable fuse)	SP04374
43	JJ CARD FOR INMIG-400I	SA00031
44	Power Plug Metal Type:-10 Pin (M) Ms 3102R 18-1P	SP02861
45	Power Plug Metal Type:-10 Pin (F) Ms 3106F 18-1S	SP02860
46	DVP20SX211T [8/6 DI/DO + 4/2 AI/AO MAIN UNIT PLC	SP07113
47	DOP-103BQ [4.3" COLOUR HMI	SP07114
48	YU Series USB 2.0 Female-Male Data Connector	SP07561
49	Data logger Pcb-V2-240304	SA00430
50	Snubber Card For Inarc 400 Ih New / INARC-400 IS	SP03572
51	Terminal Red Kut-6	SP03770
52	Terminal Black Kut-6	SP03766
53	Elemex-Kut4	SP01281
54	Dc Capacitor 20Mfd-1400Vdc	SP01065
55	Out Put Choke (17 Turn) For Intig-630I/Inarc-630Ii	SP02651
56	IGBT	SP01867
57	Snubber PCB for output frm	SA00042
58	50Mfd/500vac-cbb65S	SP00130

SPARE PARTS LIST IN DETAILS:

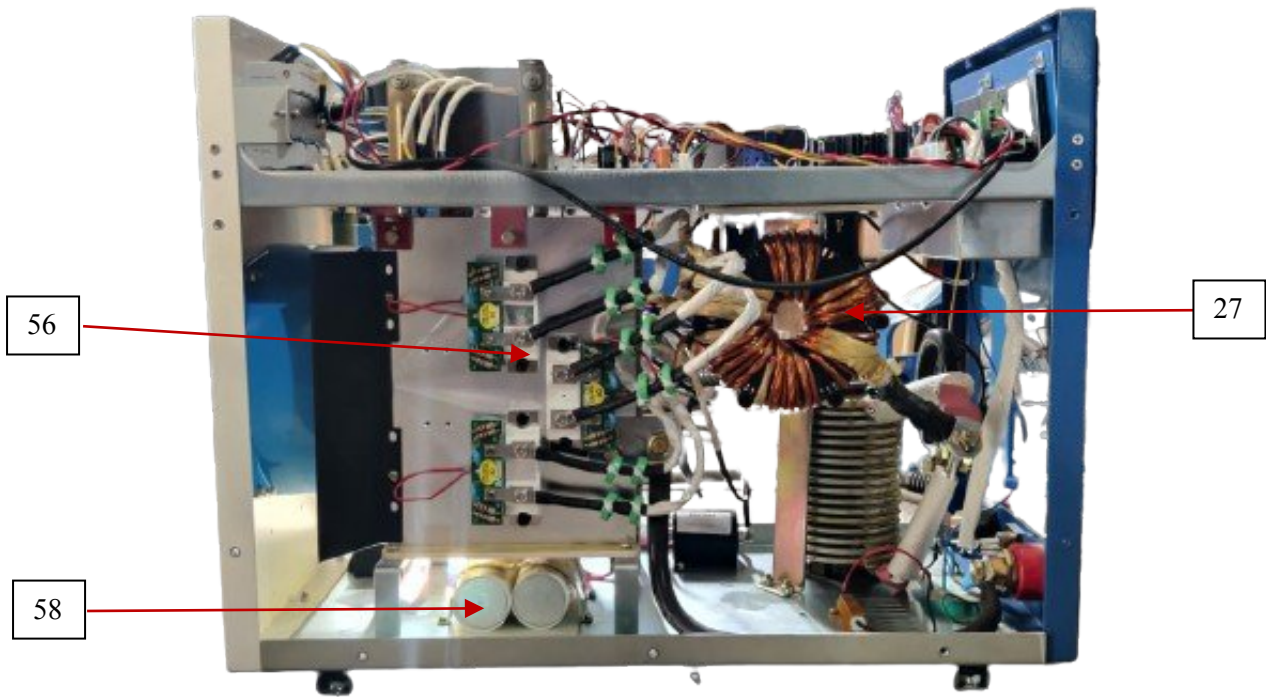
TOP VIEW



RIGHT VIEW



LEFT VIEW



...END...