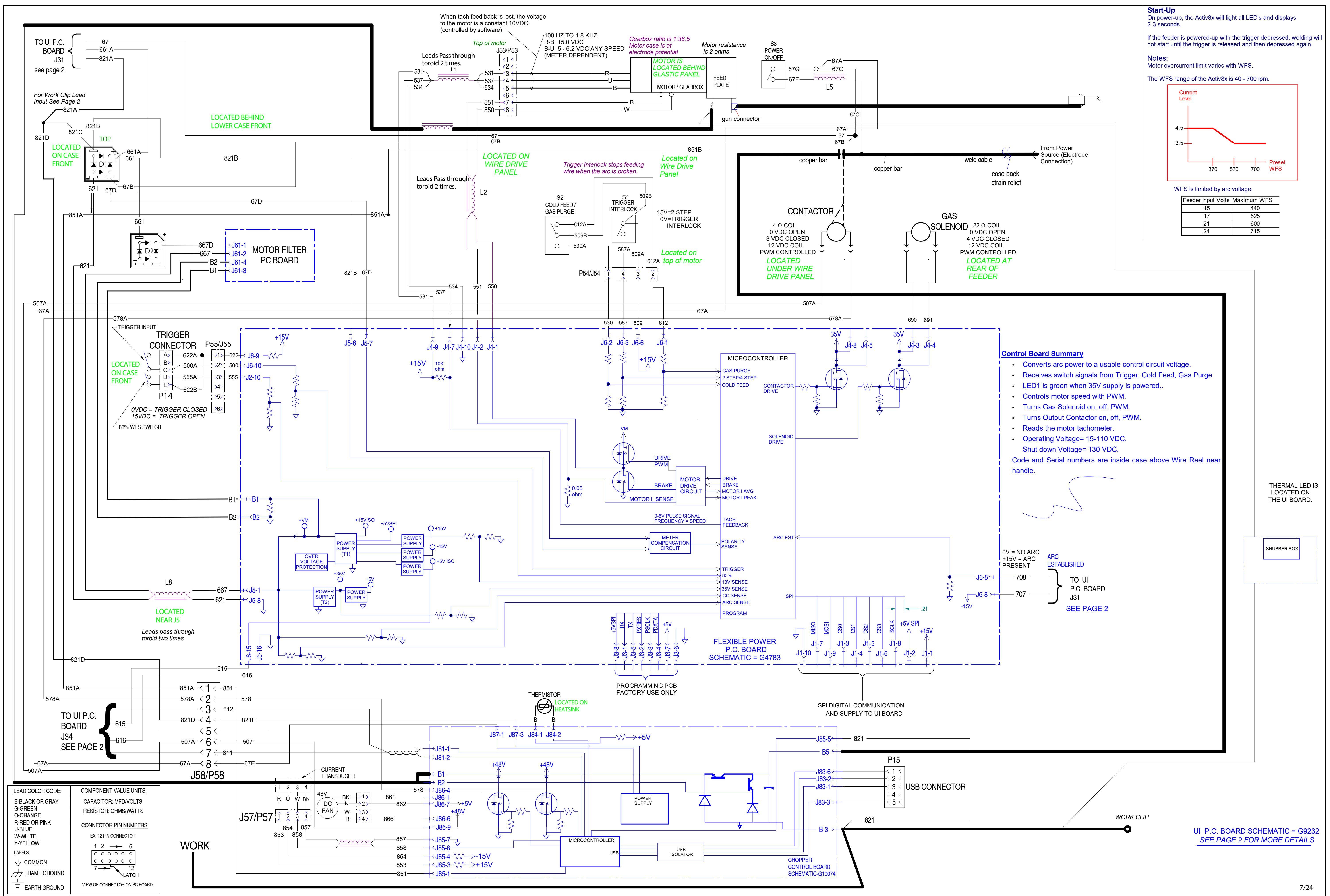
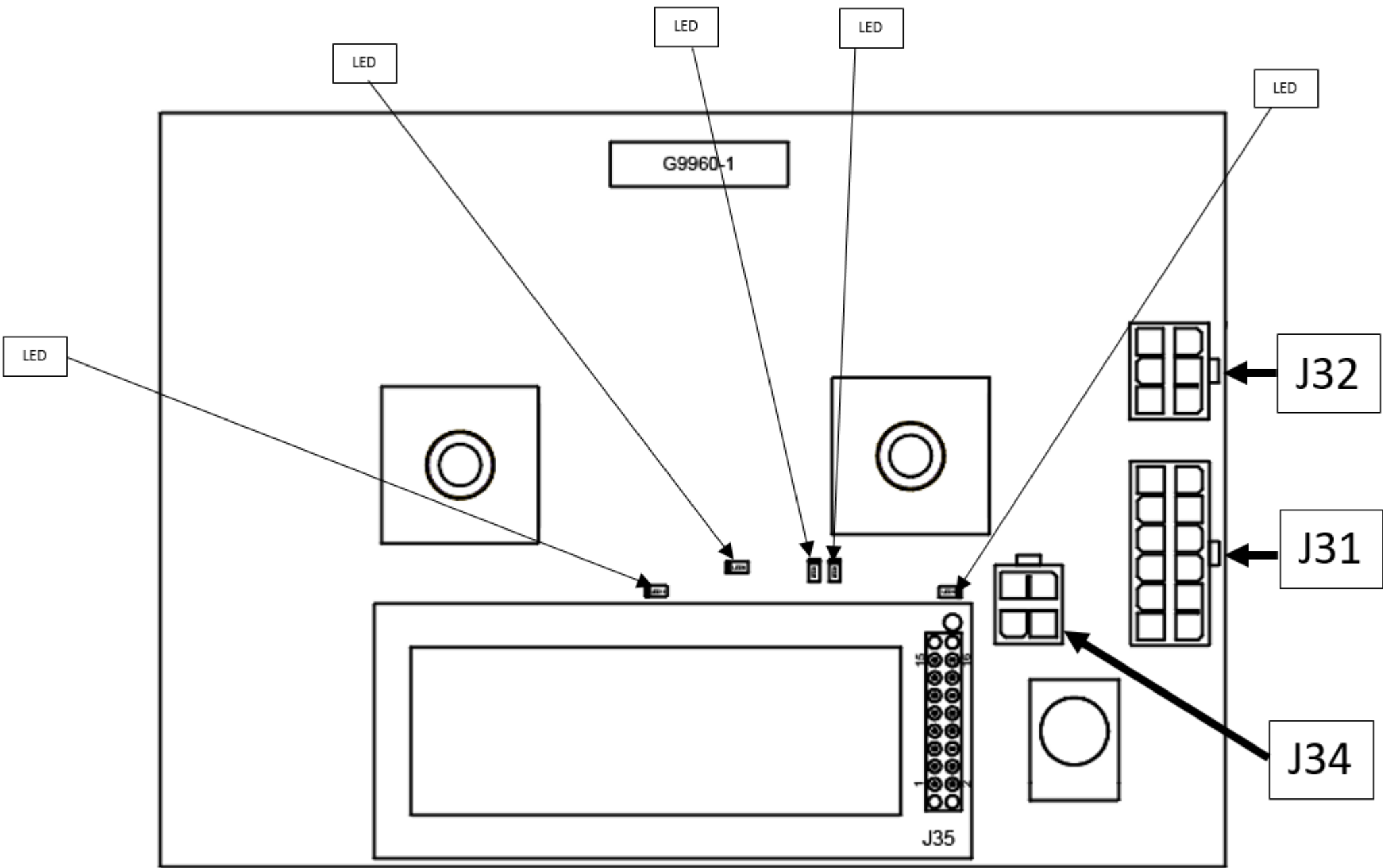
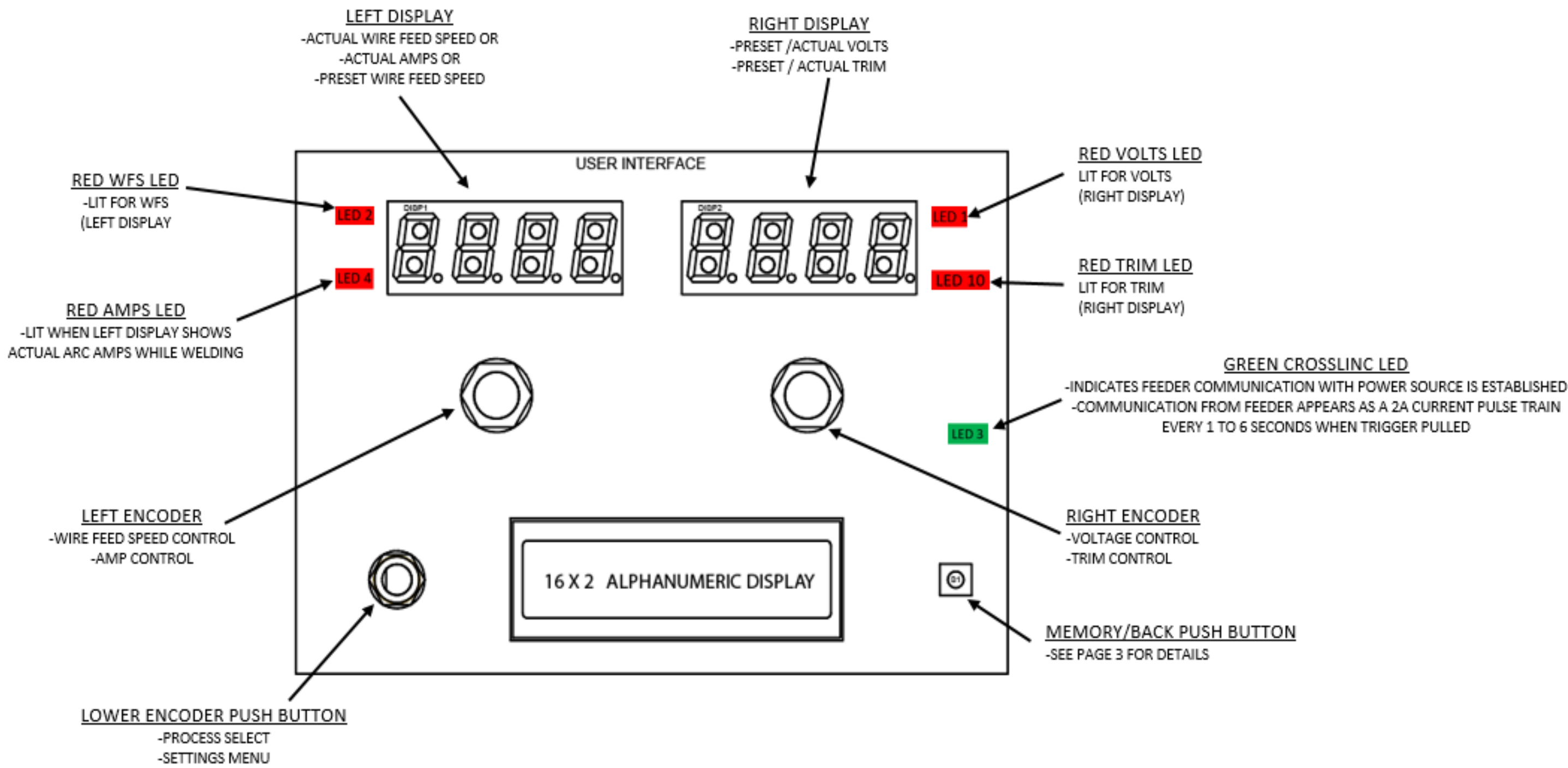


ACTIV8X PIPE MACHINE SCHEMATIC G10089 REV: B

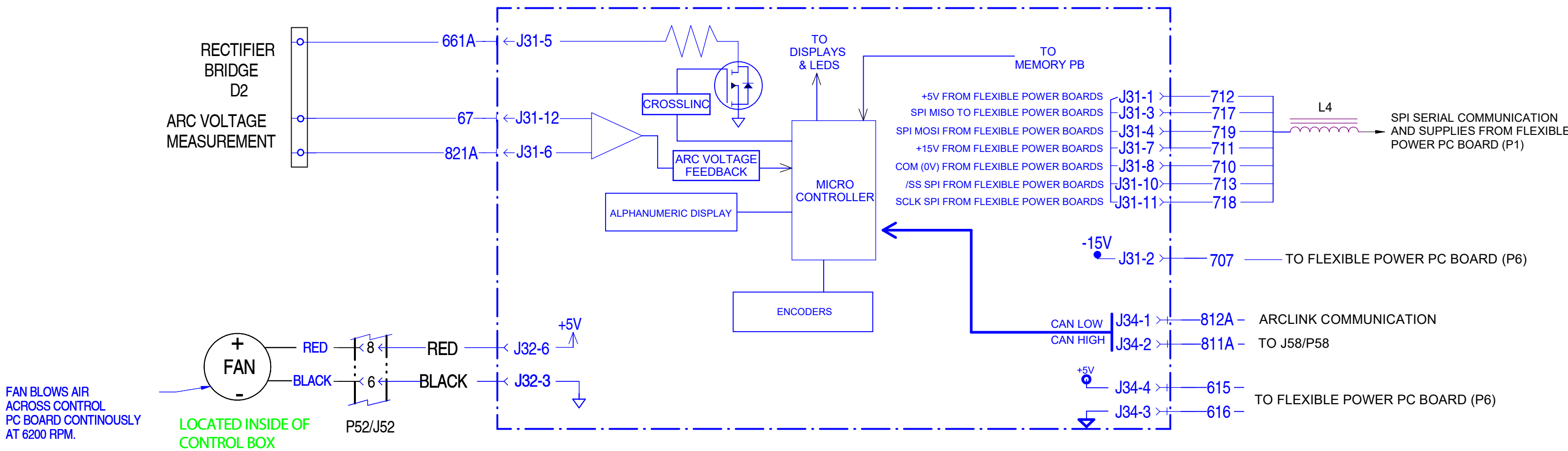


UI P. C. BOARD CIRCUITRY

SCHEMATIC = G9959-1C2



CIRCUITRY





SETTINGS MENU

ERROR CODES

- The setup menu can be accessed using the bottom encoder pushbutton that is to the left of the alphanumeric display.
- To enter the menu system, press and hold the left pushbutton for at least ½ second.
- Rotating the bottom encoder knob will select other “Settings Menu” items.
- A press of the right push button exists the settings menu.

• “Setting Menu” item will be:

- Arc Control (factory default =0)
- Run In Speed (% of weld speed setting) (factory default = AUTO/OFF)
- Preflow Time (factory Default = AUTO/OFF)
- Postflow Time (factory default = AUTO/OFF)
- Burnback Time (factory default = AUTO/OFF)
- Start Settings (factory default = AUTO/OFF)
- Crater Settings (factory default = AUTO/OFF)
- Setup Menu

SETUP MENU

- When “Enter Setup Menu” is shown and blinking, pressing the bottom encoder push button will enter the setup menu.
- A press of the right push button exits the setup menu and returns to the top of the settings menu.

• “Setup Menu” item will be:

- Metric / Imperial wire feed speed units display setting (factory default = Imperial)
- Arc current or actual wire feed speed display during welding (factory default = actual arc current)
- Gun Trigger selection of memories (factory default = enabled)
- High Limits Settings (If password is enabled, a password is required to change) (factory default = no limits)
- Low Limits Settings (If password is enabled, a password is required to change) (factory default = no limits)
- Arc Control Limits Settings (If password is enabled, a password is required to change) (factory default = -10.0 to +10.0)
- Trim display setting as unitless trim or in volts (factory default = trim)
- True Energy display enable setting (factory default = Off)
- Process Selection Lockout (If password is enabled, a password is required to change) (factory default = not lockout)
- Memory Save Enable (If password is enabled, a password is required to change) (factory default = save enabled)

ADVANCED SETUP MENU

- The Advanced Setup menu can be entered by pressing the bottom encoder push button and the bottom right “memory” push button simultaneously for 5 seconds when not in the menu system or welding.
- A press of the right push button exits the advanced setup menu.

• The “Advanced Setup” items will be:

- Wire Feed Speed Calibration (If password is enabled, a password is required to change) (factory default = 1.00)
- Password Setting / Enable (If password is enabled, a password is required to change) (factory default = password disabled)
- Software Versions
- Factory Reset
- View True Energy Logs
- Arc Time Display Enable
- Test Modes Enable
- System Test

Error Code	Fault	Display
Text29	DSP DAC ISR is close to time limit	DSP DAC Load Hi
31	primary overcurrent	Primary Overl
32	cap bank “a” over voltage	Capacitor UnderV
33	cap bank “b” over voltage	Capacitor UnderV
34	cap bank “a” over voltage	Capacitor OverV
35	cap bank “b” over voltage	Capacitor OverV
36	thermostat tripped	Weld Therm Err
37	soft start failed	Soft Start Fault
38	momentary ac dropout	Input Dropout
42	power down 42	Power Down Fault
43	cap delta voltage	Cap DeltaV Error
44	DSP detects ‘332 dropped HB	DSP Fault
45	Output voltage high	Output V High
47	misc hw 2 fault	Misc HW Fault 2
48	misc hw 3 fault	Misc HW Fault 3
49	single phase error	Single phase Err
52	DSP ADC ISR is close to time limit	DSP ADC Load Hi
53	Voltage sense loss	V Sense Loss
54	Secondary overcurrent	Secondary Overl
55	lost communication w/DSP	Lost Comm Fault
56	error communication w/chopper	Chop Comm Fault
57	FGEN misc error	Func Gen Error
58	primary input power board not ready	Input Pwr Fault
63	WC slave fault	Slave Fault
71	secondary overpower	Secondary OverP
92	water shutdown	Remote Shutdown

UI/Wire Drive

Error Code	Fault	Display Text
6	User interface couldn’t map in system (also indicates input polarity wrong)	Mapping Error
82	wire drive overcurrent fault	Motor Overl
83	Indicates a CrossLinc therma fault as shutdown 1	CrossLinc Therm
86	G4784 board input voltage too high or too low	Input V Hi/Low
155	SPI communication error to/from G4784 board	WD Comm Error
213	control board is offline	Control Offline
263	The UI tried to select a non-existent weld mode	No Weld Modes
714	Indicates a input voltage error from the chopper board	Check