

**Service Notice Number:** 201504003-4

**Date:** April 13, 2015

**To:** Domestic and International Lincoln Service Departments, District Sales Offices  
Domestic and International Lincoln Electric Automation Divisions  
Domestic and International Distributors, Lincoln Authorized Service Facilities, End Users  
Cleveland Quality Assurance, Marketing, Engineering, Manufacturing

**Immediate Action Required – Potential Machine Fire Hazard  
On 115V Auxiliary Power PC Board**

**Product(s) Covered:**

Power Wave R350 code 11745 (product number K3022-1)  
Serial Numbers U1130904879 through U1141107806

Power Wave S350 products that meet ALL of the following three requirements:

- 1) Product code number is 11783, 11589, 11694, 11753, 11782, or 11625
- 2) Auxiliary Power Kit K2829-1 is installed
- 3) Auxiliary Power PC Board is one of the following models: G6571-1C5 or G6571-2D3

9SG6571-1 or 9SG6571-2 replacement PC board models G6571-1C5 or G6571-2D3  
installed in either a Power Wave R350 or Power Wave S350.

\*See Figure 1 below for the board location within the machine. Model number is printed  
on the side of the board.

**Notice Description:**

**Symptoms:**

It has come to our attention that under certain conditions there is a chance for board failure,  
possibly causing machine fire. The above listed machines MUST have the G6571-1C5 or G6571-  
2D3 115V Auxiliary Power PC Board replaced with a G6571-3 board.

**Required Action:**

The G6571-1C5 or G6571-2D3 115V auxiliary power PC board needs to be replaced as soon as possible (using the Replacement Procedure below) with a G6571-3 PC board. A Lincoln Authorized Service Facility should be contacted for the replacement or disconnecting the 115V auxiliary PC board, which will allow use of the machine until a new G6571-3 is installed. With this board disconnected the machine will maintain full functionality except that it will not have 115 VAC auxiliary power. If the 115V auxiliary power PC board is not disconnected, the input power should be removed from the machine to prevent potential damage / hazard.

**If you sold or repaired an affected Power Wave R350 or S350, please direct this service notice to the owners of those units.**

**PC Board Disconnect Procedure:**

To temporarily disable the G6571-1C5 or G6571-2D3 115V auxiliary power PC board perform the following procedure:

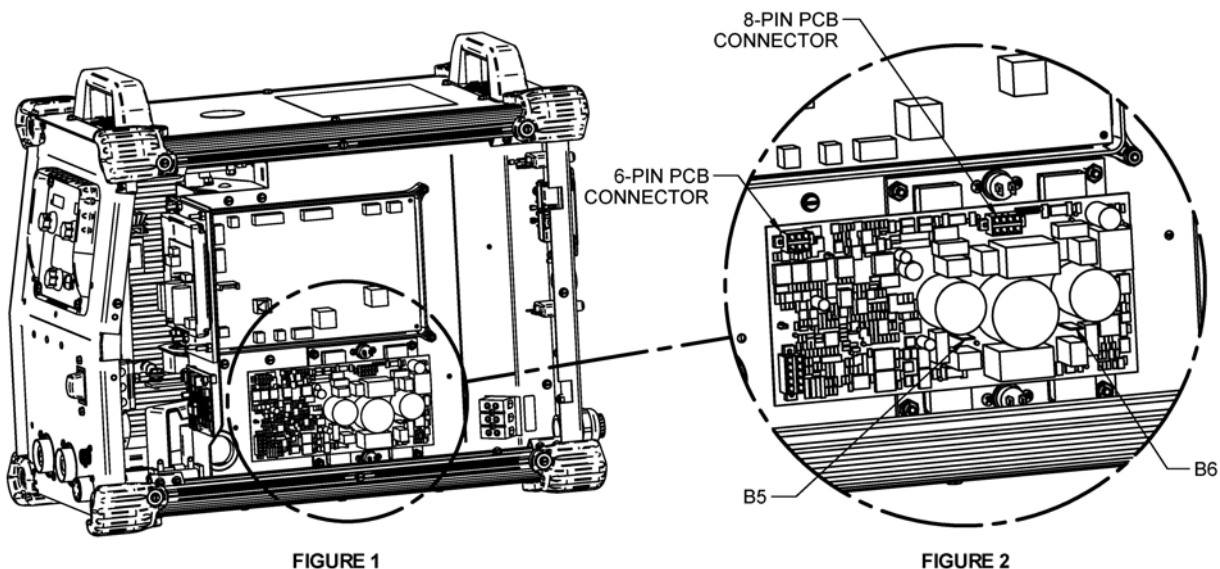
1. Turn off input power to the power source at the disconnect switch or fuse box before working on the power source.
2. Remove the right case side of the power source by removing the 2 top corner caps and the screws fastening the side to the power source using a 5/16" nut driver.
3. Disconnect the 6 pin connector from J62 on the 115V PCB. (See FIG 2)
4. Disconnect the 2 female quick connect terminals (leads #317 and #318) from B5 and B6 on the 115V PCB assembly. Tape the ends of the female quick connect terminals separately with electrical tape to operate the machine waiting for the replacement 115V PCB assembly.
5. Re-install the right case side of the power source using the screws and corner caps removed in Step 2. Reconnect the input power to the power source afterwards.

**PC Board Replacement Procedure:**

To replace the G6571-1C5 or G6571-2D3 115V PC board with the updated G6571-3 PC board, perform the following procedure:

1. Turn off input power to the power source at the disconnect switch or fuse box before working on the power source.

2. Remove the right case side of the power source by removing the 2 top corner caps and the screws fastening the side to the power source using a 5/16" nut driver.
3. Disconnect the 6 pin connector from J62 on the 115V PCB. (See FIG 2)
4. Disconnect the 8 pin Molex plug (J63) from the G6571-1C5 or G6571-2D3 PC board. (See FIG 2)
5. Disconnect the 2 female quick connect terminals (leads #317 and #318) from B5 and B6 on the 115V PCB assembly.
6. Using a 3/8 in nut driver, remove the 4 nuts securing the PC Board to the 4 mounting studs.
7. Carefully remove the G6571-1C5 or G6571-2D3 PC Board from the machine.
8. Install the updated G6571-3 PC Board into the machine and secure with the 4 nuts previously removed in step number 6.
9. Replace the 8 pin (J63) and the 6 pin (J62) Molex plugs previously removed in steps 3 and 4 from above.
10. Next, replace the quick connect terminals (leads #317 and #318) to B5 and B6.
11. Using the 5/16 nut driver and the screws and washers previously removed, re-install the right case side of the power source. Reconnect the input power to the power source afterwards.



Lincoln Electric will supply the G6571-3 at no charge and pay the Lincoln Authorized Service Facility for 1 hour of labor to install. Please reference service notice 201504003-4 in the warranty claim. If you have any questions regarding this notice, please contact us at 1-888-935-3877.

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