

**ISUM** N° 8695-8915  
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## Instructions for Safety Use and Maintenance

WELDRY MW2: W 000 120 430  
WELDRY MW4: W 000 120 431  
WELDRY MW6: W 000 120 454



### 1. GENERAL INFORMATION

This instruction for safety, use and maintenance manual is an integral and essential part of the product and is supplied together with the oven. It is suggested to read carefully this manual and observe any stated indication in order to use the equipment correctly. Please take care of this manual for any further consultation.

#### Typographic convention



Danger signal which indicates to observe carefully the instructions for avoiding possible damages to the equipment or accident.



Danger signal which indicated to pay attention as hot surfaces are present.

This manual wants to be an instructions and maintenance guide for **Holding Ovens for MMA electrodes model WELDRY MW2 - MW4 - MW6**, which are designed for WELDLINE - Air Liquide Welding: 13 rue d'Épluches - Saint Ouen l'Aumône - 95315 CERGY PONTOISE France

- It must be used and read by the operators, maintenance employees and by the staff and purchaser for what it concerns spare parts.
- It must be located with care in a known place, protected by dirty and humidity and it must be always available for consultation by the operators.
- Read it and give to read carefully to all the operators in all parts before proceeding to install, to use, or for maintenance or dismantling of the oven and/or equipment.
- Check always that the operator has understood very well how to proceed for use and the safety symbols fitted on the oven.
- Do not damage or remove the labels or the name-plate fitted on the oven.
- It is possible to prevent accidents if the given instructions are respected.
- Before connecting the oven be sure that the name-plate data correspond to the electrical distribution system ones.
- Do not expose the oven to the inclemency of the weather or install in high humidity environments, which are bathrooms, etc.
- In case of emergency, that is fire starting, anomalous noise, overheating, etc. disconnect immediately the system electrical connection.

When this manual has been completely damaged, it is possible to ask for a copy directly to WELDLINE - Air Liquide Welding: 13 rue d'Épluches - Saint Ouen l'Aumône - 95315 CERGY PONTOISE France, giving the following references:

- Type of oven and Model
- Serial Number
- Supplier/Reseller
- Name and address of the User
- Correct address where to deliver the copy of the manual.

In case the portable oven is given to someone else, please inform us of the change in order to communicate to the new owner the up-to-date information.

This manual respects the state of the art at the moment of sale and it could not be considered inadequate if it is reviewed due to improvements.

The producer is not obliged to up-to-date the manual and/or the oven of the users if, in the meantime, due to the evolution of the technology, he has modified and/or improved the equipment and/or the manual.

### 2. SPECIFICATIONS

#### 2.1. General specifications

The holding ovens are mainly used for keeping the treatment of welding electrodes to avoid hydrogen inclusion into the welding puddle after the drying cycle and before the welding process.

Three basic models are available: **WELDRY MW2 – MW4 – MW6** (see Table 1).

Table 1 – Available versions

Model description	Max. keeping temperature	Heating elements	Load Capacity	Power	IP Protection Grade
WELDRY MW2	300 °C	1 x 2,7 kW	3000 electrodes*	230 V AC single-phase	44
WELDRY MW4	300 °C	1 x 2,7 kW	6000 electrodes*	230 V AC single-phase	44
WELDRY MW6	300 °C	3 x 1,5 kW	9000 electrodes*	380 V AC three-phase	44

\* 3,25 mm diam.

The oven has an external structure made of sheet steel painted with epoxy powder coating to withstand heavy working conditions as humidity, corrosion and salty atmosphere. The inner chamber is made of stainless steel (inox).

On the top of the oven a control box is located with the main switch, the thermoregulators and the signal pilot lamps. On the back of the oven there is the power supply plug.

#### 2.2 Electrical connections – Consumption

WELDRY MW2: 1 heating element - Total nominal power: 2,7 kW

WELDRY MW4: 1 heating element - Total nominal power: 2,7 kW

WELDRY MW6: 3 heating elements - Total nominal power: 4,5 kW

The holding ovens are provided with IEC plug and socket suitable for the power supply type.

#### 2.3. Weight and dimensions:

	WELDRY MW2	WELDRY MW4	WELDRY MW6
External size (mm)	830 x 690 x 760	830 x 690 x 1400	820 x 690 x 1310
Internal size (mm)	720 x 510 x 350	720 x 510 x 620	720 x 510 x 890
Oven weight (kg)	90	123	152
Packaging size (mm)	850 x 710 x 780	850 x 710 x 1420	840 x 710 x 1330
Weight for transport (kg)	95	135	160

### 3. ASSEMBLING INSTRUCTIONS

The oven is packaged in heavy duty cardboard packaging for shipment. The oven is equipped with eyebolts so that it can be handled by a lifting device.

Connect the oven electrical cable to the power supply in accordance with all local and national electrical and safety standards; The working voltage and power rating are listed on a label located on the oven.

The oven is now ready for use.

### 4. OPERATING INSTRUCTIONS

After checking the power supply connections to the oven, act on the general switch and check that power is on (white pilot light).

After a self-control phase of about 5 seconds, the thermo regulators are on and start doing the ON/OFF symmetrical adjustment with 5 °C hysteresis according to the temperatures and times set up in advance.

Oven-environment 120 °C with safety control on the heating elements at 470 °C.

Should a different program be required, act in the following way:

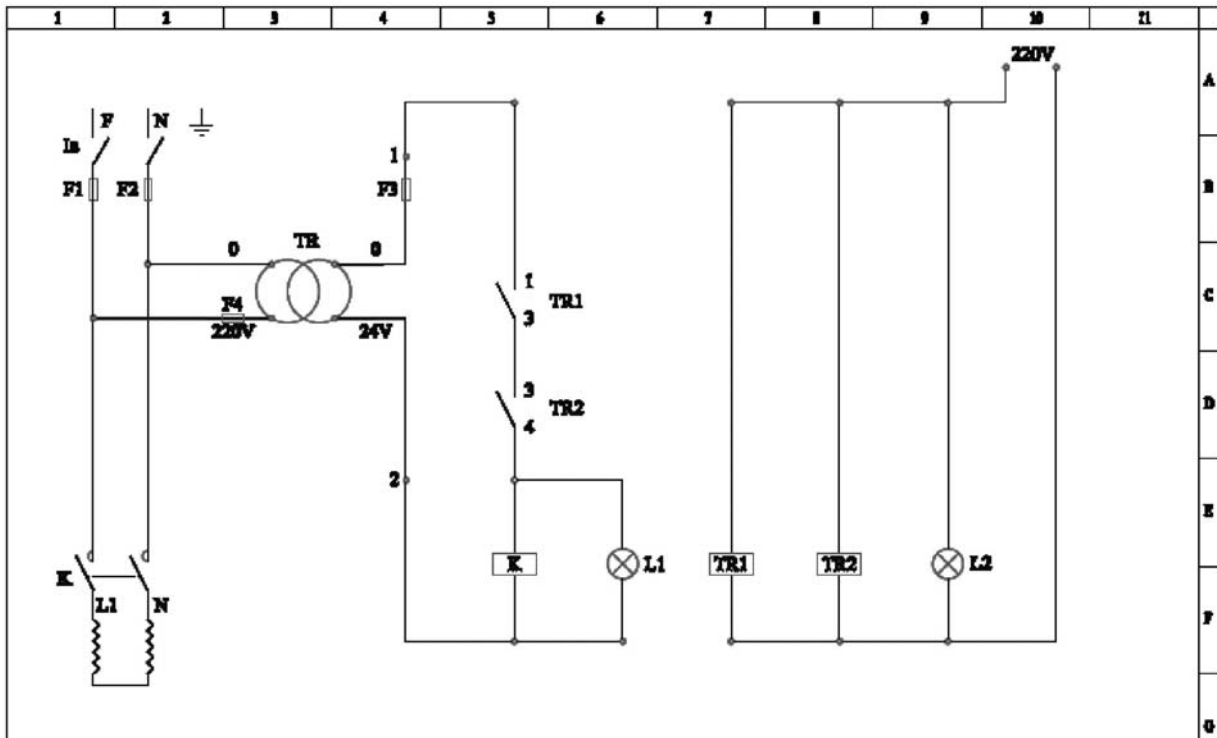
#### 1) Thermo regulator for the heating elements control and safety (°C heating element):

Press and release the key **[L1]**: the L1 led starts lightening, 1SP is displayed for one second, then the value linked to the setpoint appears; press **◀** or **▶** to change the value; by pressing **↵** the new value and the return to normal mode can be saved; the same happens after 10 seconds the keyboard is inactive; press **[T/O]** to return to normal mode without saving any value.

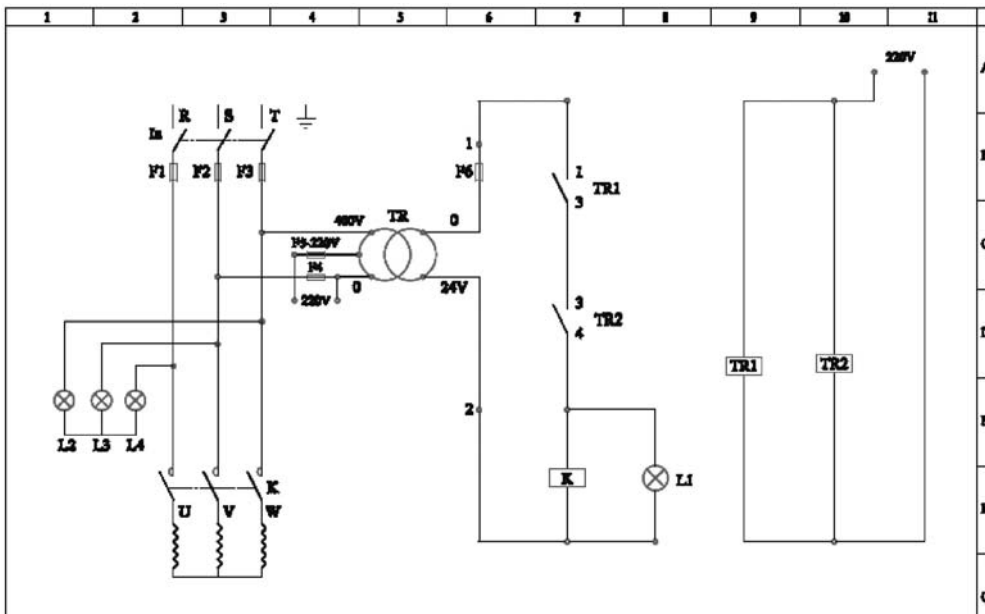
#### 2) Thermo regulator for air (°C oven-environment): adjustment as above.



### WIRING DIAGRAMS



DRAWING RELEVANT TO KEEPING OVEN WELDRY WM 2 and WELDRY WM4 (WITH .2 THERMO REGULATORS)



DRAWING RELEVANT TO HOLDING OVEN WELDRY WM6 (WITH.2 THERMO REGULATORS)

**Caption of the drawing:**

Keeping oven for electrodes

Ia	Main switch. Sectioner 3x16 / 3x25 / 3x32 A
Ib	Fan ventilation system switch
Ic	Door micro-switch
Tr2	Heating element thermoregulator
Tr1	Oven air thermoregulator
L1	Heating element "ON" signal - green
L2/13/14	Electric connection signal - white

K	Heating elements remote control switch
K1	Fan ventilation remote control switch
M	Fan motor 380 V. 0,25 KW
R1-R2-R3	Heating elements 230V. 1500 W x F3-F6-F9-FM2 / 2750 W x FM-FM1 / 1300 W x F100-F200-F400
TR	Transformer 220-380/24 V - 380/220 V 50 VA

F1-F2-F3	Fuses 16-20-25-32 A
F4-F5	Fuses 2 A
F6	Fuses 6 A
Rt	Fan motor thermal relay
Vf	Equipment cooling fans x F200-F400
Lt	Thermic presence signal - red
S	Selector - A - B -