

Service Notice N°: ESN0072 Rev. 00
Date: 02NOV2018

Elimination of unexpected WFS increase to the maximum value or decrease to the minimum value

Product	K Number	Code Number	Serial Numbers
POWERTEC i250C STD	K14157-1	50430	P1181005475 and below
POWERTEC i250C ADV	K14157-2	50431	P1181005475 and below
POWERTEC i320C STD	K14158-1	50432	P1181005475 and below
POWERTEC i320C ADV	K14158-2	50433	P1181005475 and below



WARNING

Be sure that only qualified individuals perform all installation, operation, maintenance and repair procedures. Lincoln Electric is not responsible for damages caused by improper installation, improper care or abnormal operation.

Before opening or disassembling any parts of the product, the power must be turned OFF and the product must be disconnected from the input power source. Only Lincoln trained service technicians are authorized to perform these modifications.

Explanation of the Problem

Symptom: The WFS (Wire Feed Speed) goes to the maximum or minimum value when trigger of gun or cold inch is switched on and there is no possibility to regulate WFS on the control panel.

Cause: The microprocessor reset of Y042 board is not done properly after switching machine on and some of processor registers take unpredictable values.

Verification of the Problem

All PTi250C/i320C machines with serial numbers prior to those listed above are susceptible to this problem. Machine that will be modified will have the Y042 control board (indexes: R-6042-080-1, R-6042-080-2, R-6042-082-1, R-6042-082-2) with P0097-03 or P0097-02 program version.

Correction of the Problem

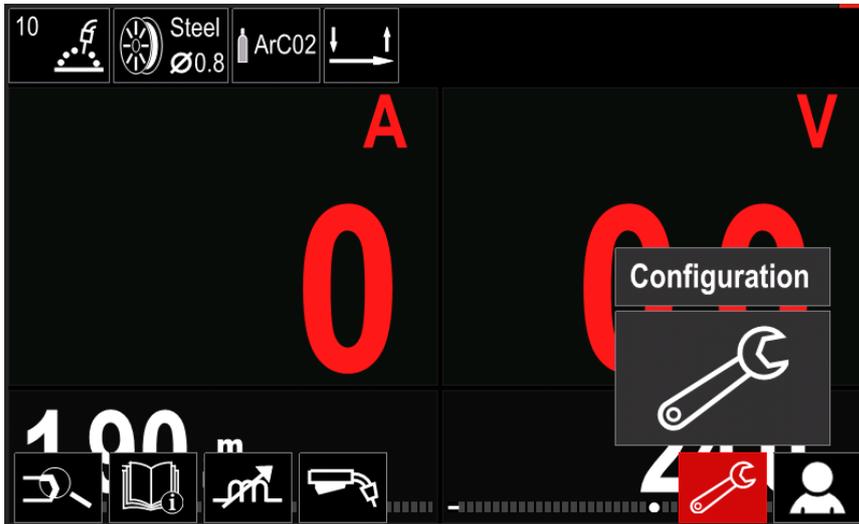
The elimination of this problem can be achieved by machine software update to the newest version. In that case the P0097 program will get "04" revision or higher.

It can be made in two different ways for Advanced and Standard machine version:

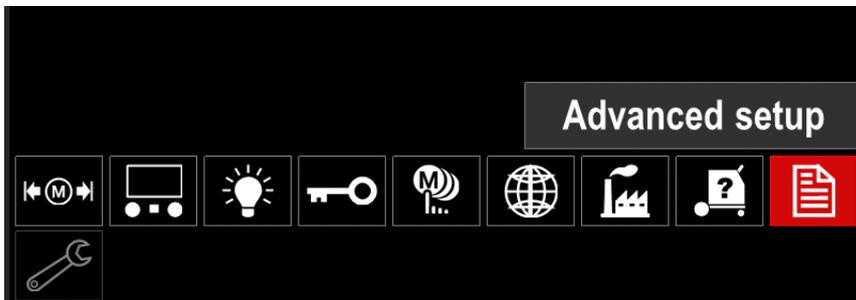
1. Advanced: using memory stick (pendrive),
2. Standard: using laptop.

ADVANCED version

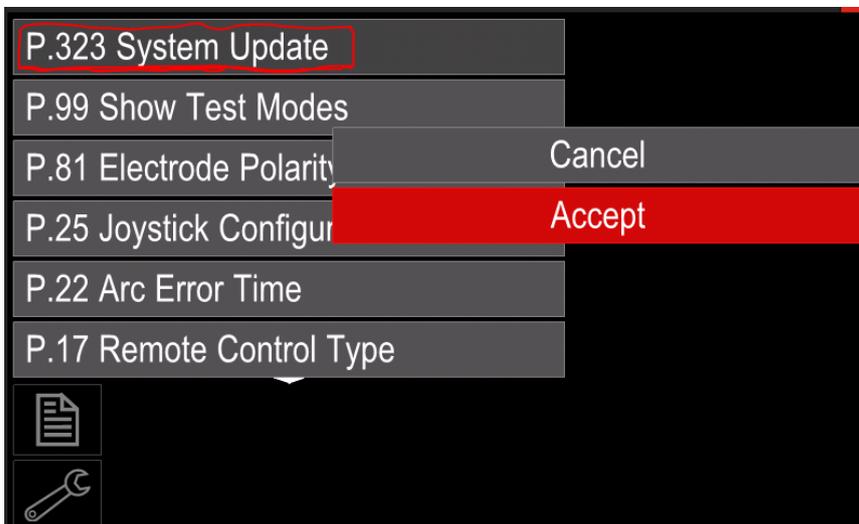
1. Gain the correct files from Services (or use P0097-04.zip file and unpack it) and upload them to the root directory of a USB memory stick. Preferably to have empty and formatted pendrive.
2. Insert the pendrive into the USB socket of the machine.
3. Switch machine on.
4. Enter the **Configuration** menu (key icon).



5. Enter the **Advanced setup** menu (card icon).



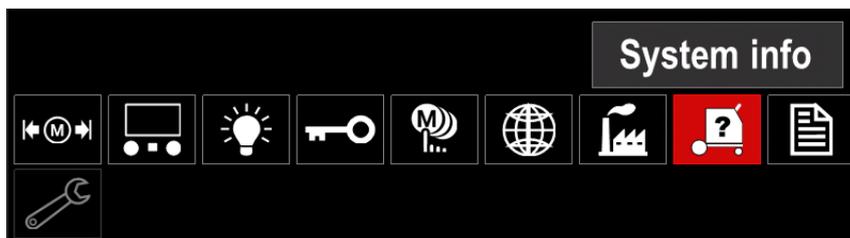
6. Select **P.323 System Update** parameter and **Accept**



7. Confirm the update - choose **YES**. The screen will show the progress of the update.

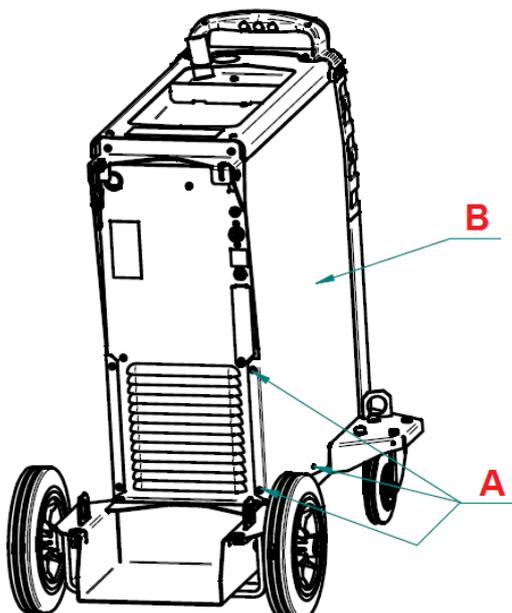


8. After uploading the device will reset itself and this is the end of update. You can also check the upgraded software version in the **System Info** menu – highlight the **Wire Drive** description, the **P0097-04** number (or higher) should appear.

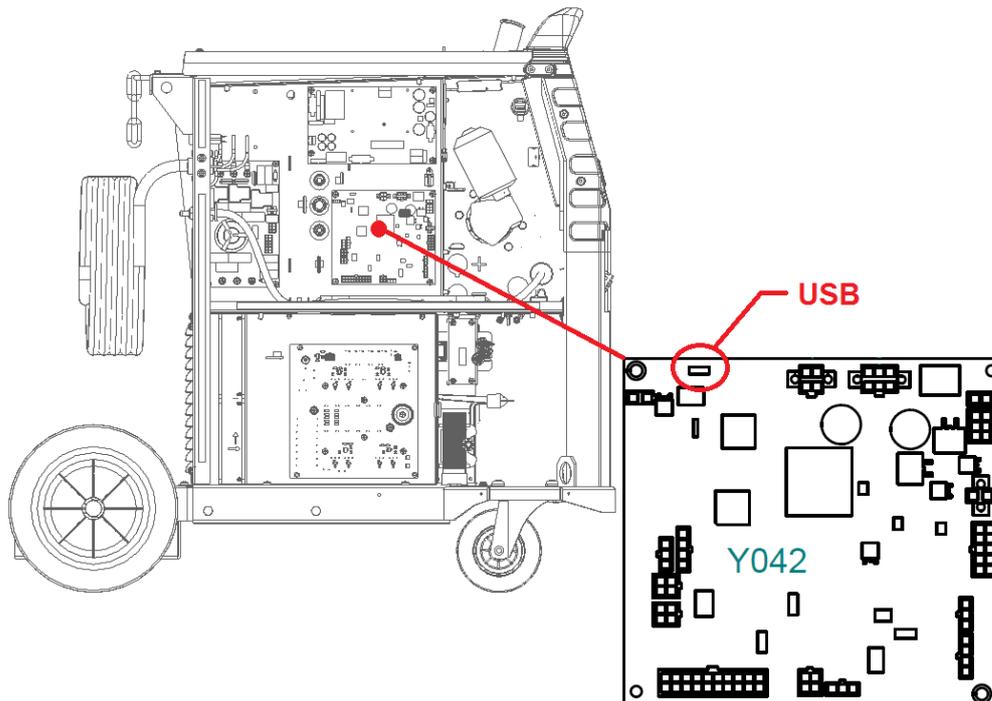


STANDARD version

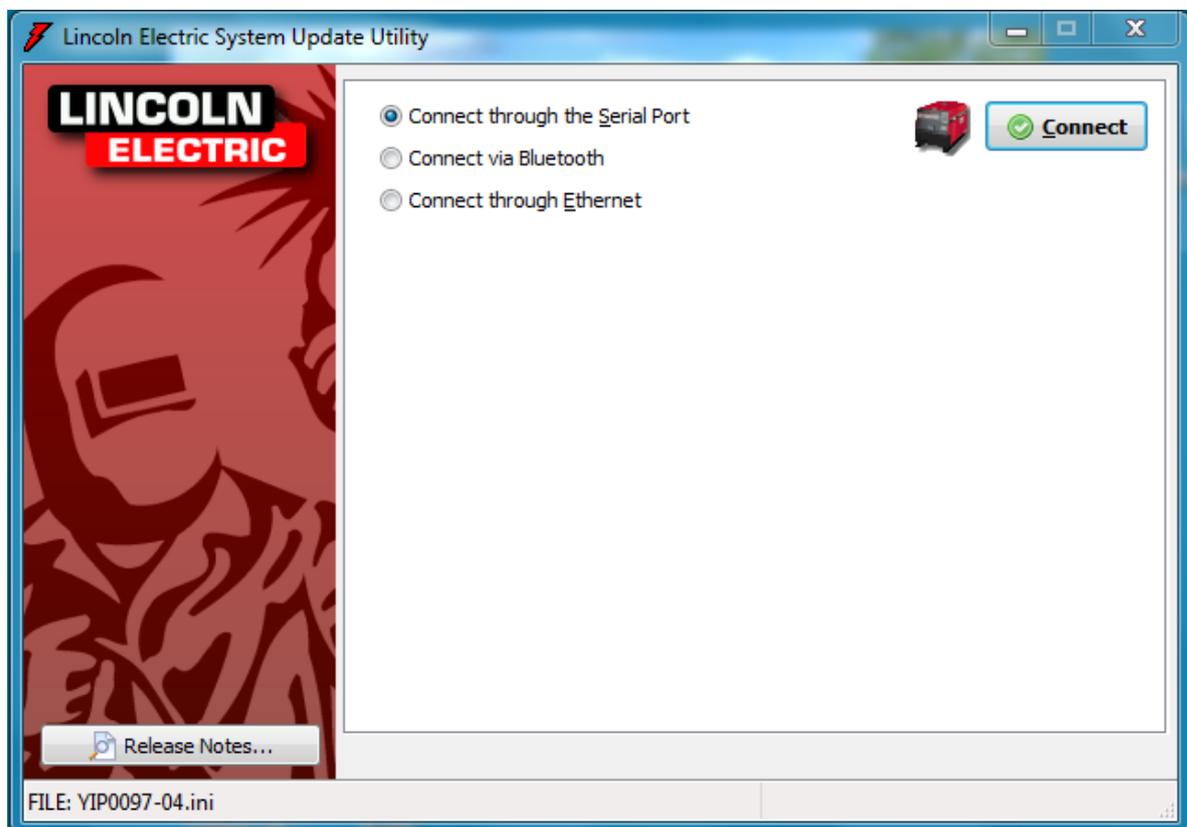
1. Gain the correct files from Services (or use P0097-04.zip file and unpack it) and upload them to the laptop to the separate directory.
Warning: Use laptop with Windows 10 operating system.
2. Unscrew 3 bolts (A) and disassemble side panel (B)



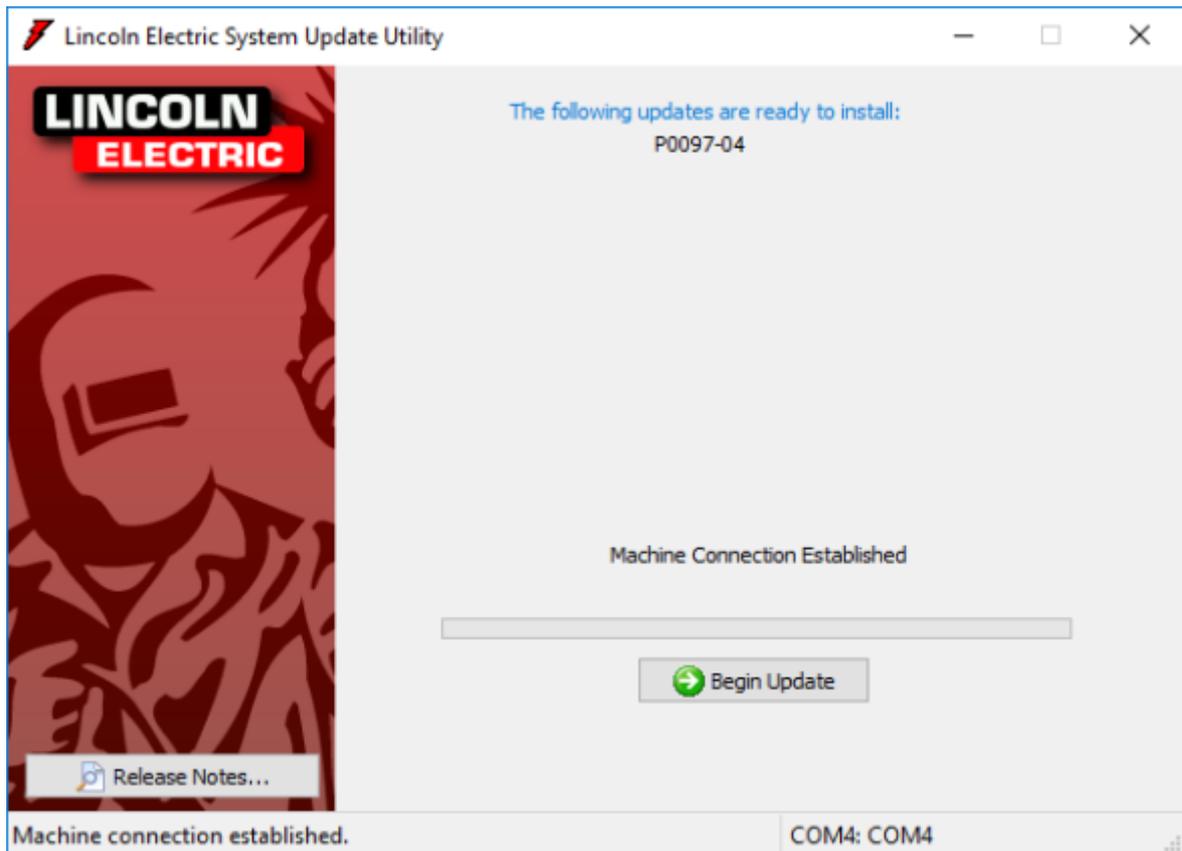
3. Connect the Y047 board to the laptop through the USB cable (micro-A type).



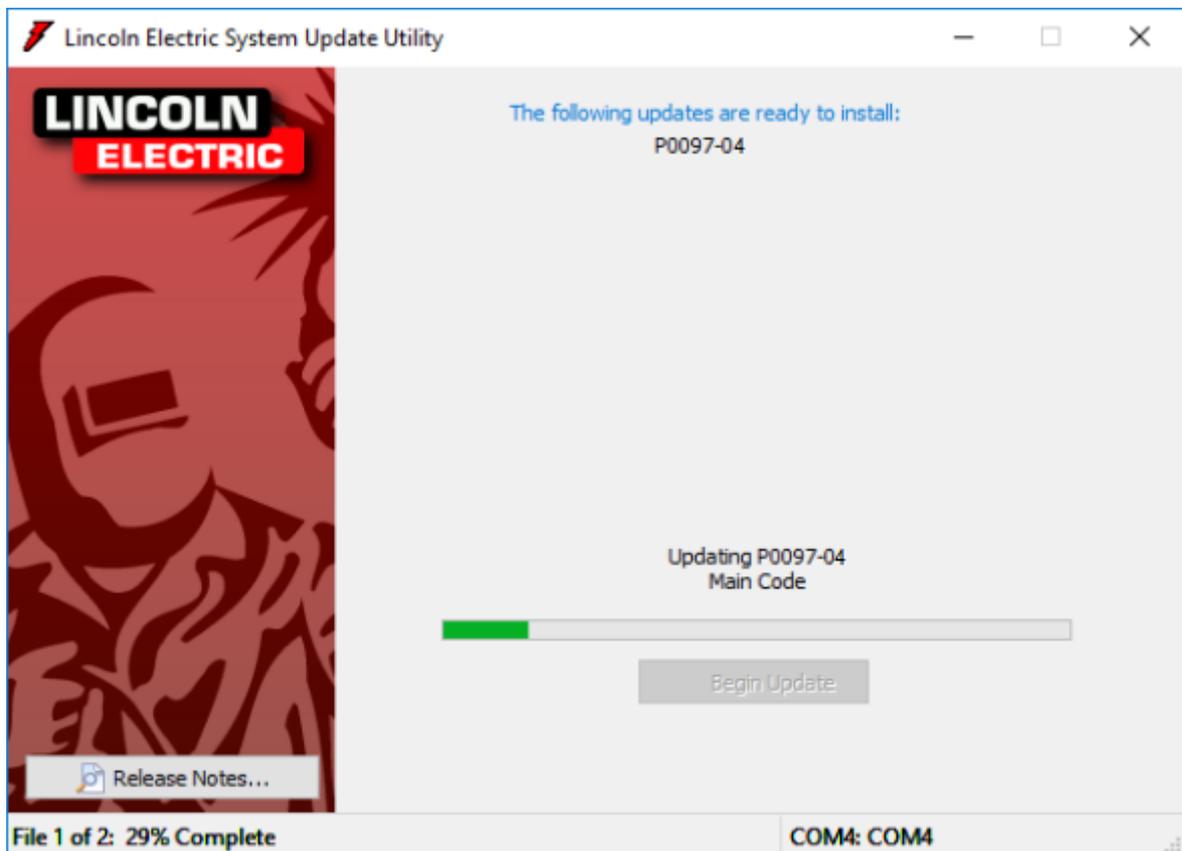
4. Switch the machine on.
5. Run **SystemUpdate.exe** program on the laptop. Set connection through the serial port - push **Connect** button.



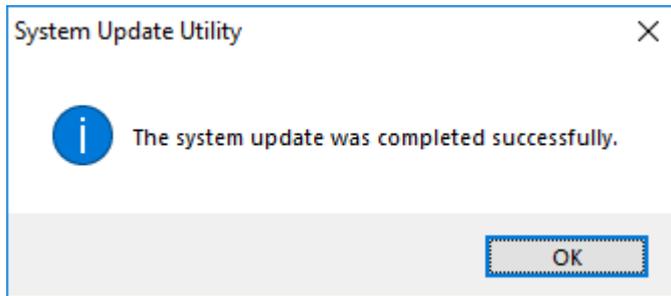
6. Push the **Begin Update** button.



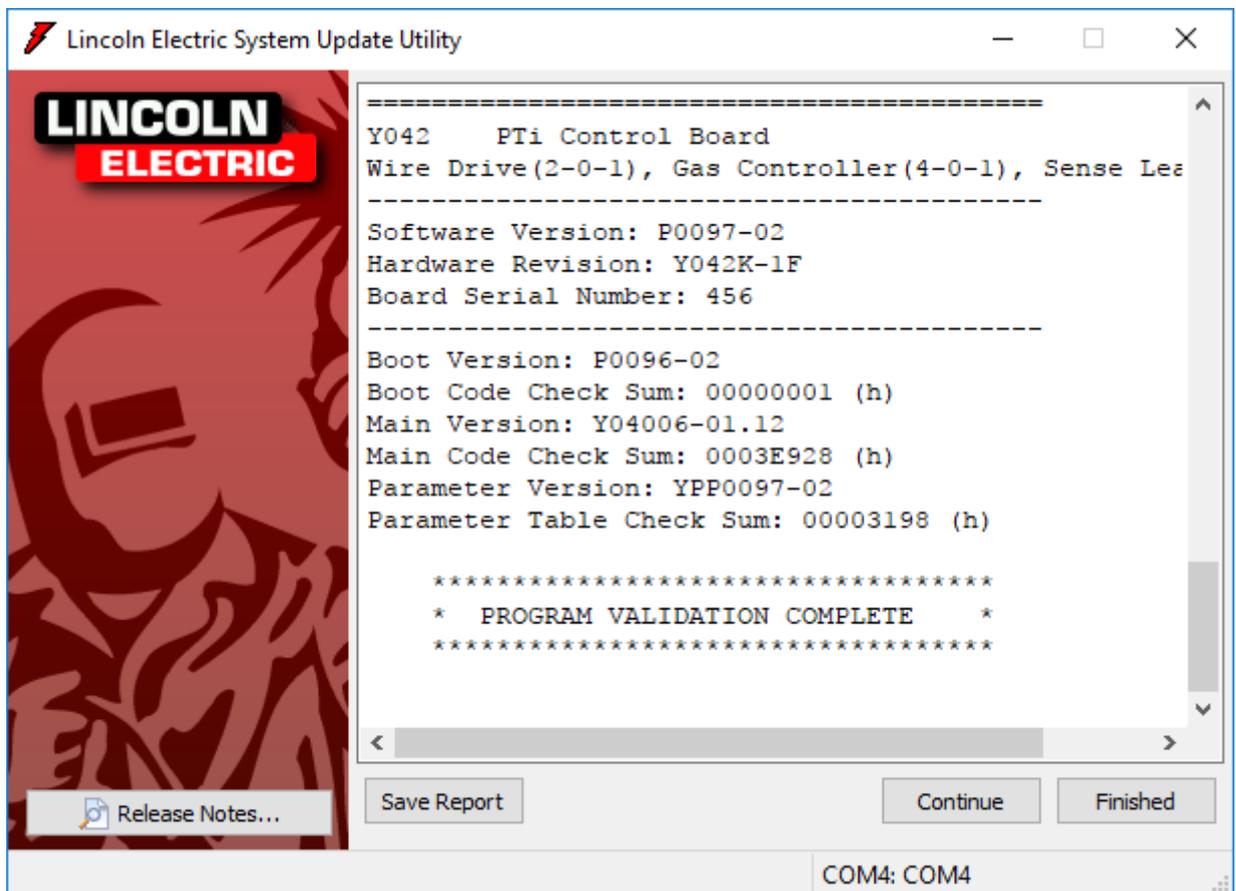
7. Update is running.



8. When finished, push **OK**.



9. A short report appears (the content of picture below may differ from the actual one). Push **Finished** button.



10. Switch machine off and disconnect laptop.

11. Mount side panel and screw down 3 bolts. This is the end of update.