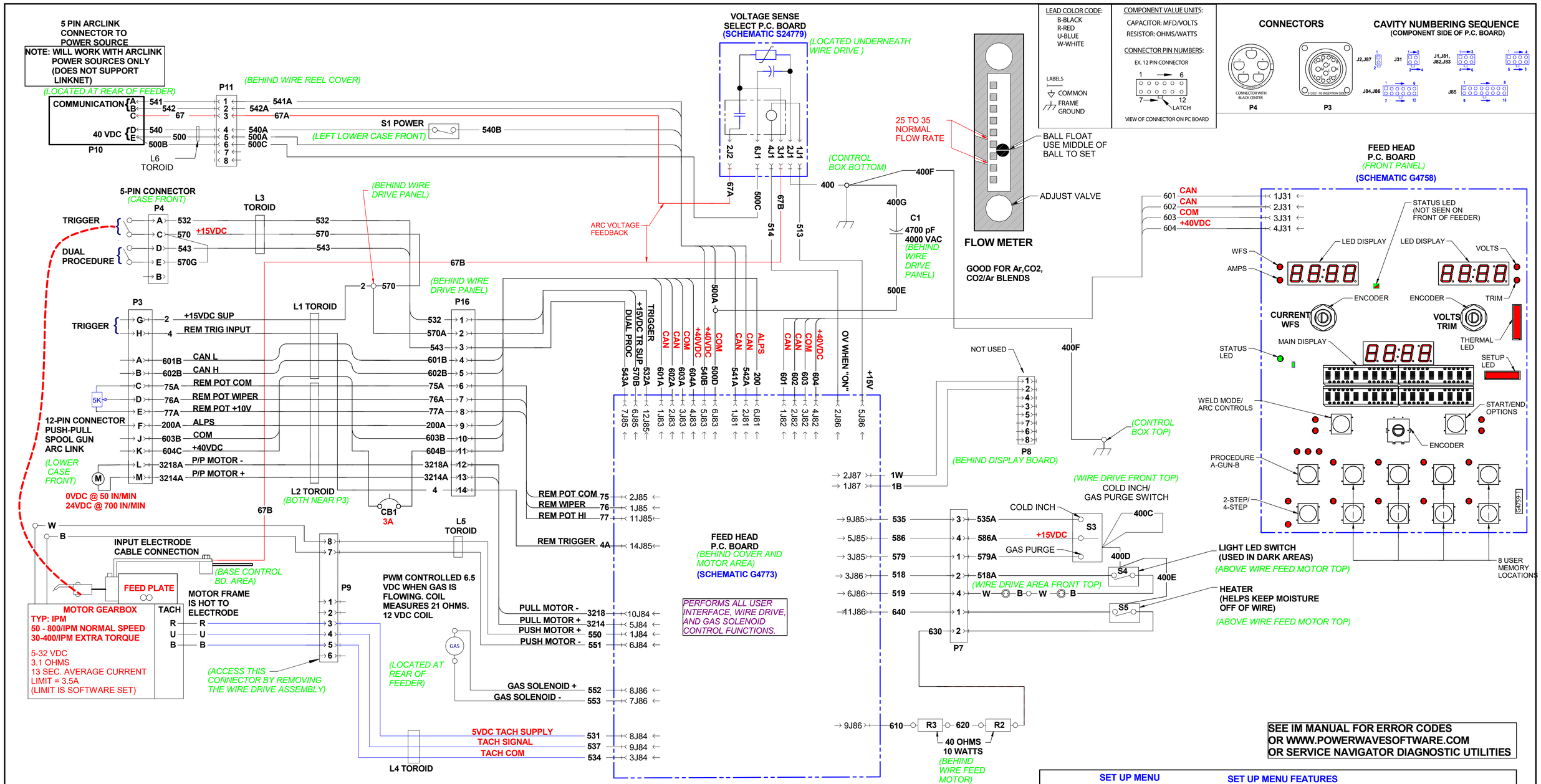
POWER FEED 25M NNS MACHINE SCHEMATIC G5638-4 REV: A



SEE IM MANUAL FOR ERROR CODES OR WWW.POWERWAVESOFTWARE.COM OR SERVICE NAVIGATOR DIAGNOSTIC UTILITIES

WELD MODES MAY VARY BASED UPON POWER SOURCE AND SOFTWARE

GENERAL

	GMAW	STD. CV	5
CV	GMAW	POWER MODE	40
	FCAW	STD. CV	6
	STICK	SOFT (7018)	1
	STICK	CRISP (6010)	2
CC	TIG	TOUCH START	3
	GOUGE	---	9

STEEL

		0.030	0.035	0.045	0.052
GMAW	CO2	---	10	20	24
GMAW	Ar (MIX)	94	11	21	25
PULSE (CRISP)	Ar (MIX)	95	12	22	26
PULSE (SOFT)	Ar (MIX)	---	14	19	28
STT (NO TAIL OUT)	CO2 Ar/CO2	109	109	125	125
STTII	CO2 Ar/CO2	110	110	126	126

STAINLESS

		0.030	0.035	0.045
GMAW	Ar (MIX)	61	31	41
GMAW	Ar/He/CO2	63	33	43
PULSE	Ar/CO2	66	36	46
PULSE	Ar/O2	62	32	42
PULSE	Ar/He/CO2	---	34	44
STT	Ar/He/CO2	109	109	125
STTII	Ar/He/CO2	110	110	126

ALUMINUM

			0.035	3/64	1/16
	GMAW	Ar	148	71	73
4043	PULSE	Ar	149	72	74
	PULSE ON PULSE	Ar	98	99	100
	GMAW	**Ar**	**151**	**75**	**77**
5356	**PULSE**	**Ar**	**152**	**76**	**78**
	PULSE ON PULSE	**Ar**	**101**	**102**	**103**

METAL CORE

		0.045	0.052	1/16
GMAW	Ar/CO2	81	83	85
PULSE	Ar/CO2	82	84	86

SERIAL NUMBER AND CODE NUMBER LOCATED BELOW WIRE FEED DRIVE ROLL AREA OR TOP INSIDE.

SET UP MENU

To access, press the right and left push buttons on the UI Panel simultaneously

Setup feature numbers may vary between software versions. Must read small display to find your specific feature you want. These P numbers listed are for reference.

P500 and above are accessible with Weld Manager Software

SEE IM MANUAL FOR MORE DETAILS

SET UP MENU FEATURES

P.0 = On/Off enter exit set up mode
P1 = WFS English/metric
P2 = Left display amps/wfs
P3 = Display Options
P4 = Trigger memory recall
P5 = Trigger procedure change
P6 = Stall factor
P7 = Push pull gun offset
P8 = New TIG solenoid feature
P9 = Crater Delay
P14 = Reset Consumable Weight
P16 = Push-Pull Gun Knob Behavior
P17 = Remote Control Type
P18 = Wire Drive Gear Ratio
P20 = Display Trim as Volts
P22 = Arc Start/Loss Error Time
P28 = Display Workpoint as Amps
P80 = Sense From Studs
P81 = Electrode Polarity
P82 = Voltage Sense Display
P99 = Show test modes 200 and 201
P100 = View diagnostics
P101 = View Event Logs
P102 = View Fatal Logs
P103 = View Software Version
P104 = View Hardware Version
P105 = View Welding Software
P106 = View Ethernet IP Address
P107 = View Power Source Protocol
P350 = User Interface Group Select
P501 = Encoder Lockout
P502 = Memory Change Lockout
P503 = Memory Button Disable
P504 = Mode Select Panel Lock
P505 = Setup Menu Lock
P506 = Set User Interface Passcode
P509 = User Interface Master Lockout