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PROGRAM EDITOR SETUP
NO. P95577003

Thank you for the trust you have expressed by purchasing this equipment, which will give you full satisfaction if you follow its instructions for use and maintenance.

Its design, component specifications and workmanship comply with applicable European directives.

Please refer to the enclosed CE declaration to identify the directives applicable to it.

The manufacturer shall not be liable if the product is used in association with items not recommended by the manufacturer.

For your safety, below is a non-limitative list of recommendations or requirements, many of which appear in the labour code.

Lastly, please inform your supplier of any error you may find in this instruction manual.

LINCOLN ®
ELECTRIC

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A - DESCRIPTION

> ⚠ **Program Editor Setup** is intended for the following installations:
> - **NERTAMATIC 450 Plus**
> - **LINC-MASTER**

This editor is used for:

- reading a program file,
- editing a program file,
- importing a modified program file into the installation via USB.
- exporting a program file in Excel format to allow printing and archival.

The application can manage a certain number of additional pieces of information (name, material, thickness, MDO settings, hot wire, movement) in the Installation program structure. Such information makes the program export to Excel more meaningful. These last data are only provided for information and are not managed directly and numerically by the installation.

B - INSTALLING THE SOFTWARE

Start the **Linc-Master Program Editor Setup** program and follow the stages.

> ⚠️ **NB:** The software is compatible with Windows Seven (with the installation of .Net framework 4.6); Windows 10. Export requires an Excel 2007 version as a minimum.
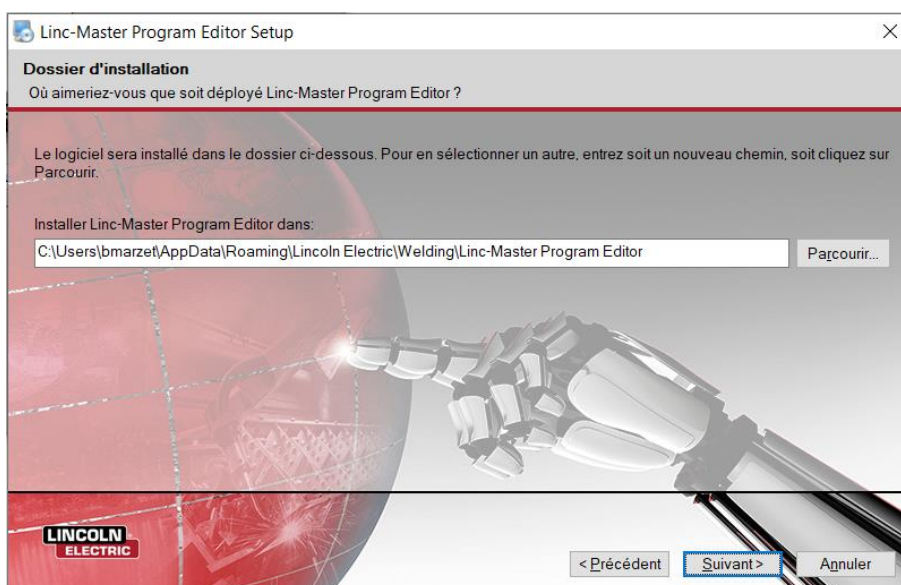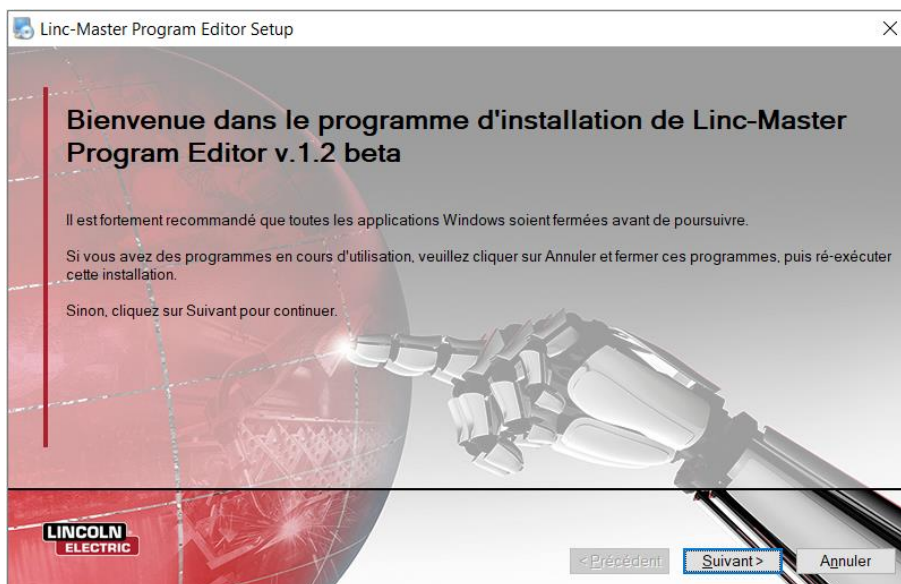
The installation folder is in "C:\Program Files\..." by default (installation for all users). If the user does not have the required administrator rights, then the installation folder will automatically change to one that is specific to the current user.
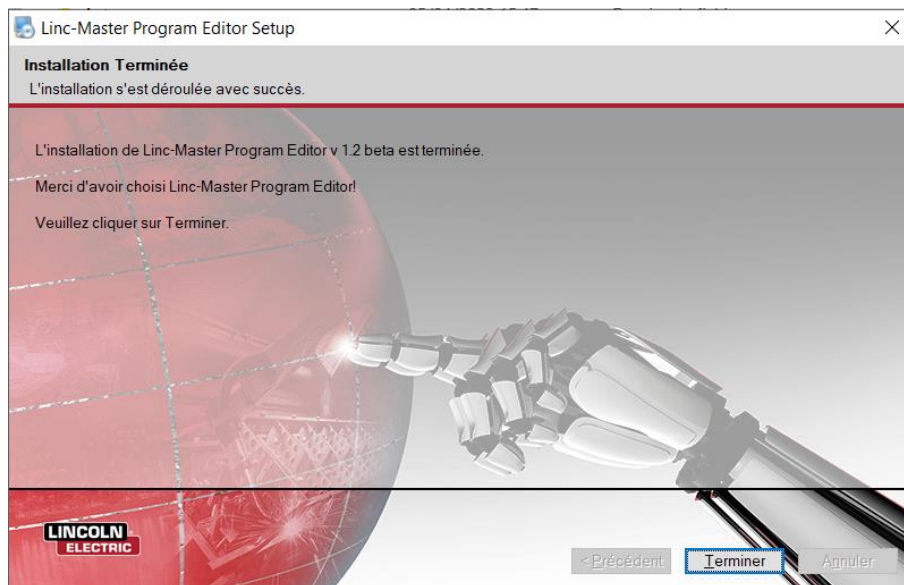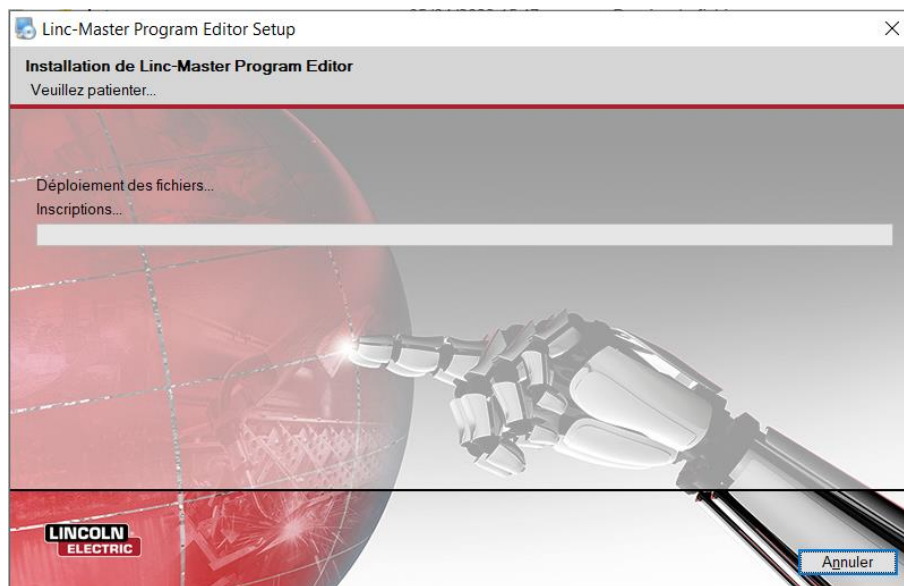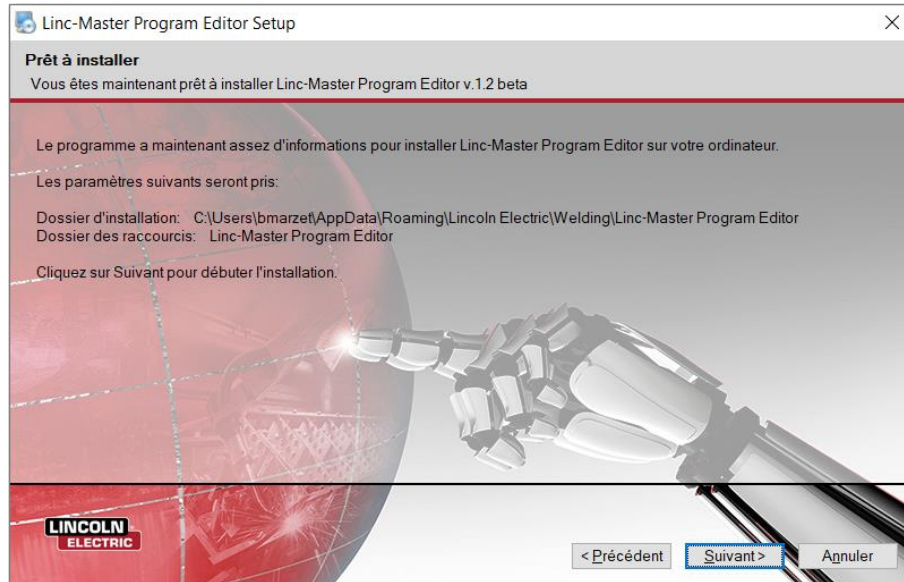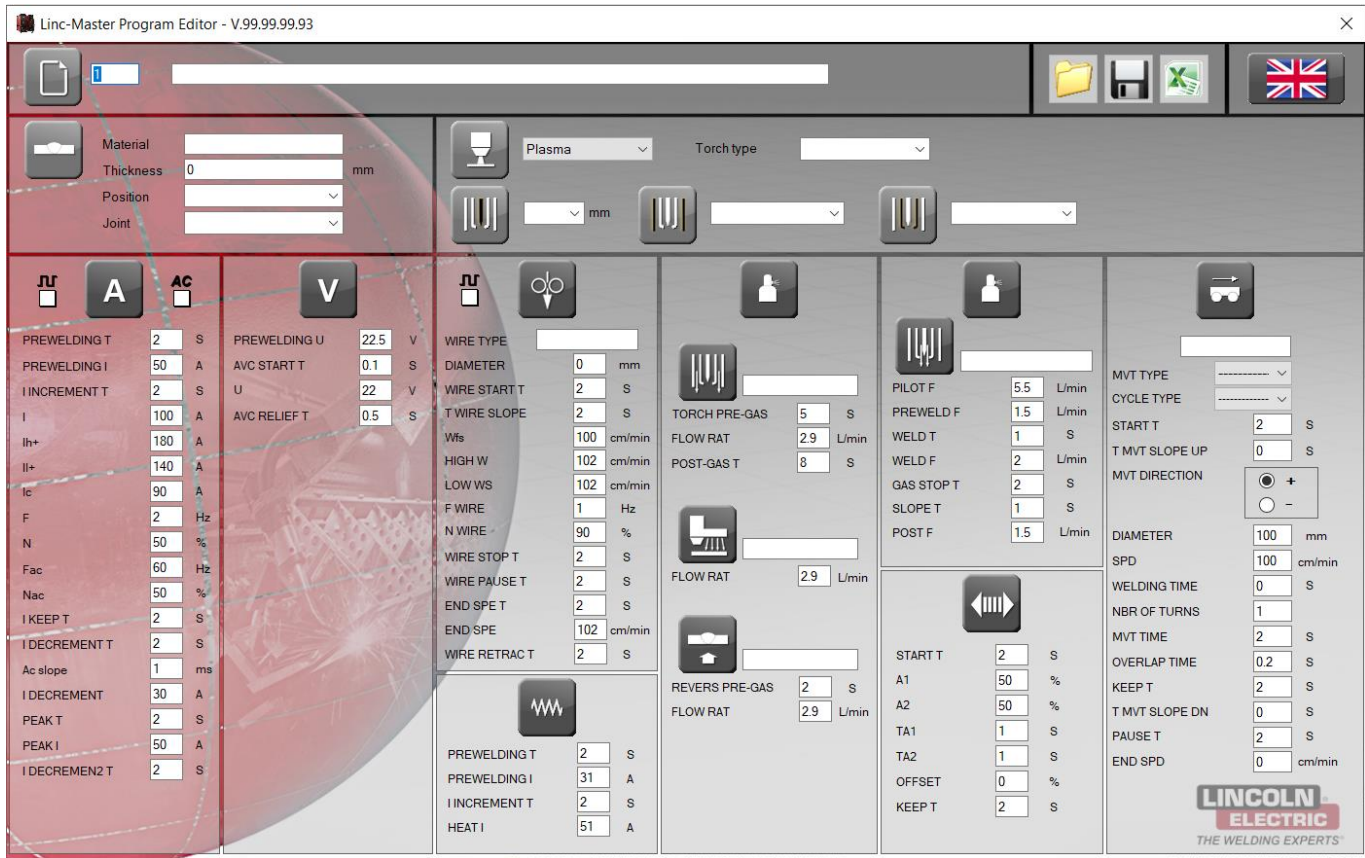
C - STARTING SCREEN

Start the program installed earlier that is located here:
Start
→ All programs
→ Linc-Master Program Editor
→ Linc-Master Program Editor

MAIN FEATURES

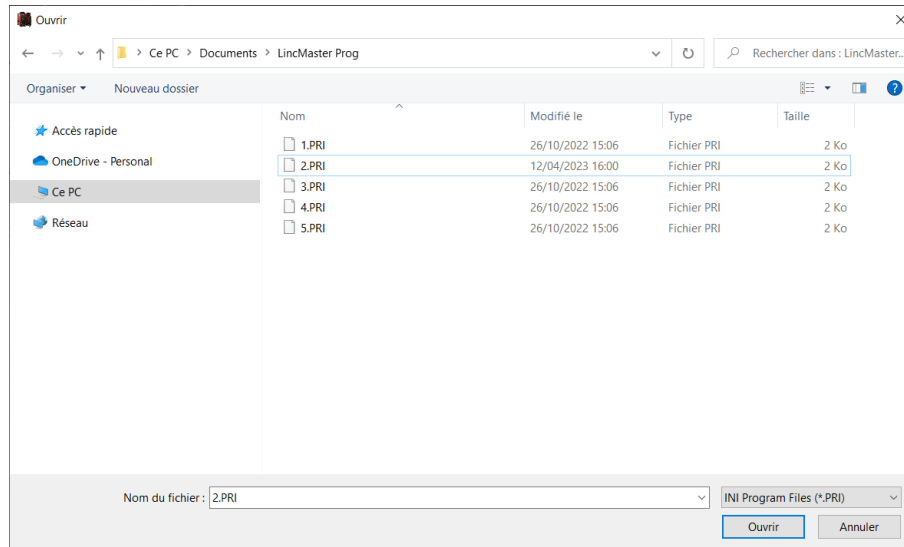|		
		Open program
		Save current program
		Export current program to Excel file
		Change application language

D - EDITING A PROGRAM

1 - SELECTING THE PROGRAM

You must first retrieve the programs from your installation via a USB drive.

Click the button to open the standard Windows file selection window.

Select the program file from your installation and click Open to display the program settings.

2 - DEFINING EDITING ZONES

GENERAL INFORMATION

1	The program number is initialised from the name of the file. Give the program a name.
2	Enter the material and grade, and its thickness. Enter the weld position and the type of seam.

3	Enter the type of process :
	- Plasma
	- Plasma*
	- TIG
	- BP TIG
	- DF TIG
	Enter the characteristics of the welding torch:
	- Type of torch
	    • **SP7**
	    • **MEC4**
	
	- Electrode diameter
	
	- Type of tip
	
	- Type of nozzle
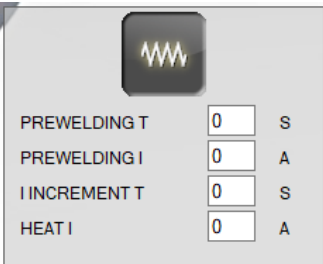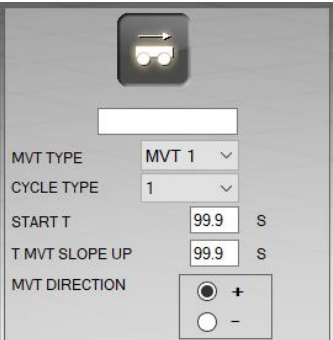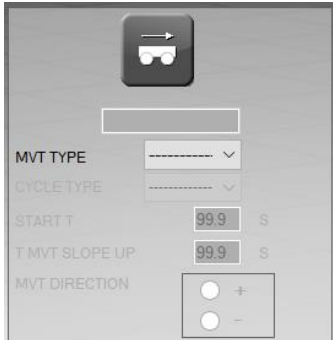
BASIC FUNCTIONS

A	Power source current settings. <u>Options:</u> ☐ Check this box to programme pulsed welding current. **AC** ☐ Check this box to programme alternating welding current.
	Annular gas settings
	Gas setting, PLASMA or TIG double flux

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3 - OPTIONAL FUNCTIONS

V	Arc voltage regulation settings
	Wire feed settings. Options: ⊓⊔ ☐ Check this box to define the pulsed wire.
∿∿	Hot wire settings
	Auxiliary gas settings
	Backing gas settings
◀IIII▶	MDO (Magnetic Deviation Oscillation) settings
	Movement settings

Click the picture at the top of the area to select/deselect a function.

Function selected	**Function deselected**
Button on: Active edit fields	Button off: all the fields are greyed
∿∿ PREWELDING T 0 S PREWELDING I 0 A I INCREMENT T 0 S HEAT I 0 A	∿∿ PREWELDING T 0 S PREWELDING I 0 A I INCREMENT T 0 S HEAT I 0 A
Particular case: definition of a movement	
Select MVT 1 or MVT 2 from the list	Select ----------- from the list

MVT TYPE   MVT 1 ∨
CYCLE TYPE   1 ∨
START T   99.9   S
T MVT SLOPE UP   99.9   S
MVT DIRECTION   ⦿ +
   ○ –
	MVT TYPE ----------- ∨
	CYCLE TYPE ----------- ∨
	START T 99.9 S
	T MVT SLOPE UP 99.9 S
	MVT DIRECTION ○ +
	   ○ –

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E - SAVING A PROGRAM

1 - SAVE CURRENT PROGRAM

Click the button to save the program being edited. The message below is displayed if saving succeeds.
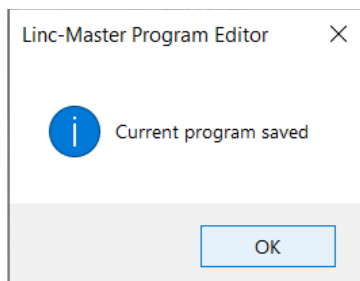
2 - SAVE AS

To save the current program under another program name, just modify the program number (1 to 99)

and then click the button .

The application will detect the change in number and display the following message.
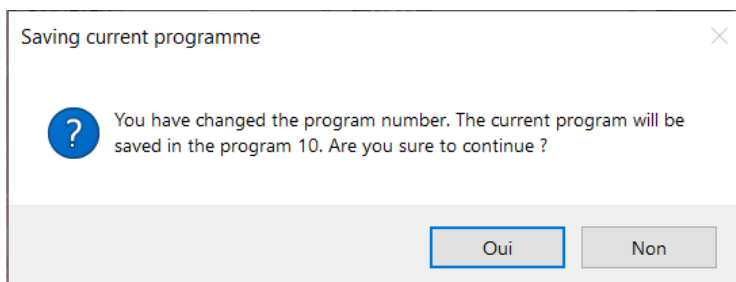
When you click **Yes**, the program will be saved under another number (see previous paragraph) and become the current program.

F - EXPORTING A PROGRAM

Click the button to export 1 to 5 programs in an Excel file.

A program selection screen will display all the program files present in the directory of the current program, which is itself selected by default.

	Program selection check boxes
	Click the arrows to modify the order of display of the programs in the Excel file.
	Click this button to export the selected programs to an Excel file (extension **XLSX**). The standard Windows **Save as** window will be opened. Select a directory and a name for the file and click **Save**. The file is then exported and the message "Export completed" is displayed if export is successful

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1 - EXPORT FILE FORMAT

WELDING PROGRAM EDITION		LINCOLN ELECTRIC
LINC-MASTER	Customer :	Date :
	Project :	Rev :
		Page(s) : 1 / 1

Piece

Material	
Thickness	0.0
Position	
Joint	

Consumables

Wire Type	
Wire Ø (mm)	0.0
Plasma Gas	
Annular Gas	
Trailer Gas	
Backing Gas	

Process TIG

Torch

Torch Type	
Electrode Ø (mm)	
Shielding Nozzle	
Plasma Nozzle	

Program parameters

Program number	10
Program Name	

Current Pulsed DC

PREWELDING T (s)	5.0
PREWELDING I (A)	50
I INCREMENT T (s)	2.0
I (A)	
I (A)	80
II (A)	50
Ic (A)	
F (Hz)	2.0
N (%)	30
Fac (Hz)	
Nac (%)	
I KEEP T (s)	0.1
I DECREMENT T (s)	2.0
Ac slope (ms)	
I DECREMENT (A)	
PEAK T (s)	
PEAK I (A)	
I DECREMEN2 T (s)	

Voltage

PREWELDING U (V)	
AVC START T (s)	
U (V)	
AVC RELIEF T (s)	

Wire -

WIRE START T (s)	0.1
T WIRE SLOPE (s)	0.1
Wfs (cm/min)	80
HIGH W (cm/min)	
LOW WS (cm/min)	
F WIRE (Hz)	
N WIRE (%)	
WIRE STOP T (s)	0.1
WIRE PAUSE T (s)	
END SPE T (s)	
END SPE (cm/min)	
WIRE RETRAC T (s)	0.1

Hot Wire

PREWELDING T (s)	0.0
PREWELDING I (A)	0
I INCREMENT T (s)	0.0
HEAT I (A)	0

Annular Gas

TORCH PRE-GAS (s)	2.0
FLOW RAT (l/min)	0.0
POST-GAS T (s)	5.0

Trailer Gas

FLOW RAT (l/min)	

Backing Gas

REVERS PRE-GAS (s)	
FLOW RAT (l/min)	

Plasma Gas

PILOT F (l/min)	
PREWELD F (l/min)	
WELD T (s)	
WELD F (l/min)	
GAS STOP T (s)	
SLOPE T (s)	
POST F (l/min)	

Magnetic Deviation

START T (s)	
L AMPLI (%)	
R AMPLI (%)	
L PAUSE T (s)	
R PAUSE T (s)	
OFFSET (%)	
KEEP T (s)	

Principal Movement

MVT TYPE	MVT 1
CYCLE TYPE	1
MVT START T (s)	99.9
T MVT SLOPE UP (s)	99.9
MVT DIRECTION	+
DIAMETER (mm)	
SPD (cm/min)	1000
WELDING TIME (s)	
NBR OF TURNS	
MVT TIME (s)	
OVERLAP TIME (s)	
MVT STOP T (s)	0.1
T MVT SLOPE DN (s)	0.0
MVT RESTART T (s)	2.0
END SPD (cm/min)	1000

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G - CHANGING THE LANGUAGE

Left click to change the current language of the software to the next language in the list. Right click to go back to the previous language. The flag of the current language is then displayed inside the button.

French	English	German	Neerlandais	Italian	Spanish	Portuguese	Polish

PERSONAL NOTES