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BULLETIN # 174

## CDT450

### NEW SOFTWARE AND WIREFEED PCB

#### **New Display EPROM**

Some new features have been introduced with currently manufactured CDT's.

1. **'4 T' Trigger Operation.**

*Option > Gun Switch > 4 T Mode*

*Option > End Current > (select current)*

This option allows access to two separate weld current settings. The first is the normal "weld current" adjusted by the remote pendant control. The second, called "end current" is adjusted on screen.

2. **Crater Fill Operation**

*Option > Crater Fill Time > (select time)*

*Option > End Current > (select current)*

This option allows the operator to set both the filling time and filling current.

3. **Edit Pulse Height**

*Option > Pulse Height > (select current)*

Provides a range of pulse height adjustment in 10 Amp steps.

4. **Edit Voltage Trim**

*Option > Voltage > (adjust voltage trim)*

Use to centre the arc length control.

#### **SYNCHRO-PULSE**

#### **CDT 450**



#### **Controlled Drop Transfer**

These features are present in Display EPROM version:

38149/00 (default Australian)      WIA P/No CP38-3/51 and

38152/00 (default USA)              WIA P/No CP38-1/51

#### **New Wirefeed PCB**

The wirefeed PCB used in the CDT has been redesigned and simplified. It remains part number CP38-16, but is now Issue F. The new PCB has a completely new design, and a component layout is provided to identify it (Figure 1).

For Incat machines, the old Wirefeed PCB CP38-116 has been deleted and replaced by the new CP38-16 PCB.

#### **New Weld EPROM**

EPROM version 38024 for both Australia and USA.

This software includes a faster braking table and is designed to match the characteristics of the new style wirefeed PCB. It will work quite effectively with the old style wirefeed PCB.

The combination of a new style PCB with old style software should be avoided however, as it may not be possible to adjust the burnback time short enough to prevent the wire from burning back too far.

### QUALITY WELDING PRODUCTS, SYSTEMS AND SERVICES

The information provided in this sheet is accurate and reliable, however no warranty of accuracy or reliability is given and no responsibility arising in any other ways by errors or omissions is accepted. Any information involving mains or high voltage is intended for use by qualified electrical personnel only.

**Software Compatibility**

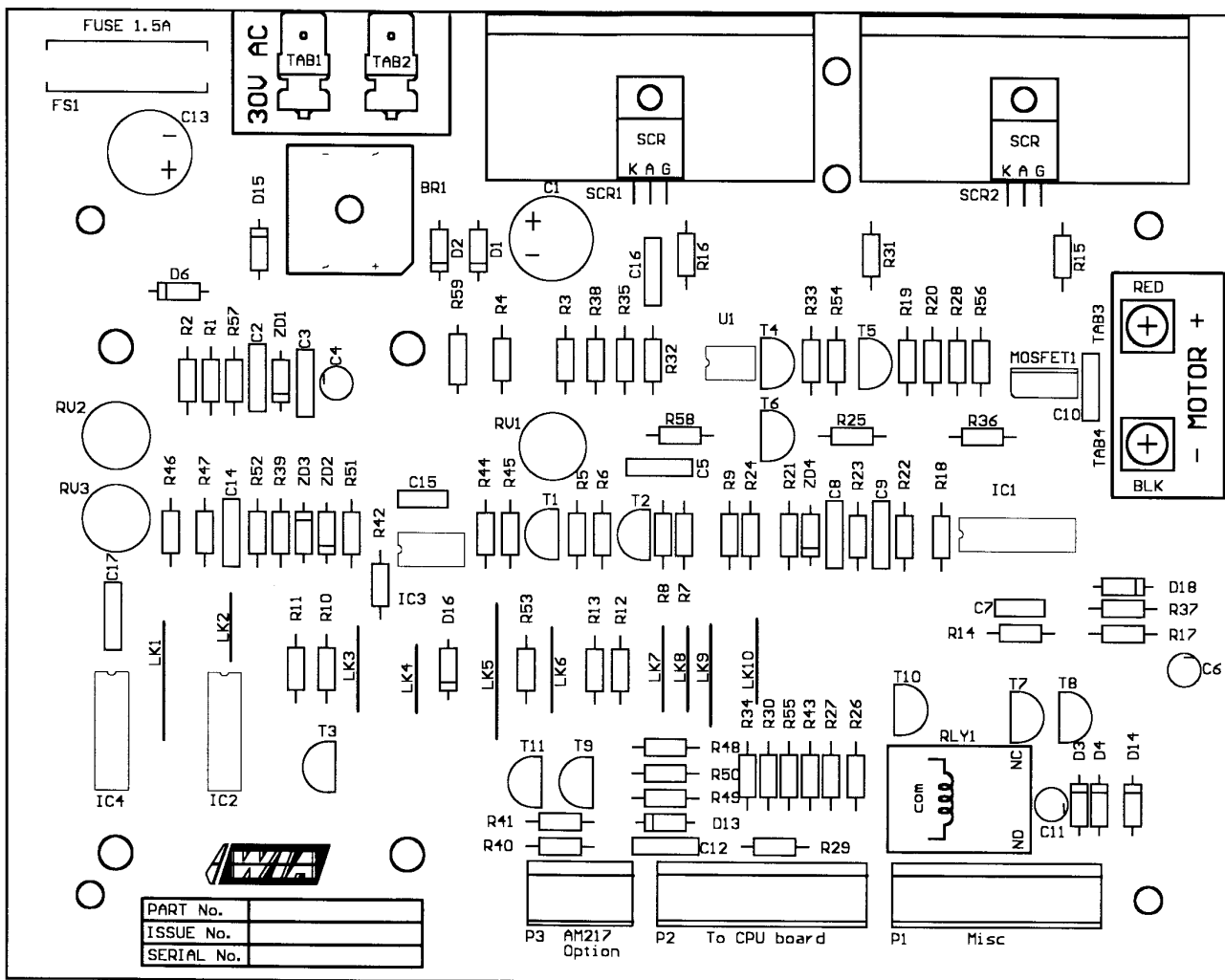
Latest version Display EPROM can only be used with latest version Weld EPROM.

**Part Numbers**

Latest Version Software (with 4T trigger & pulse height adj.)		
	EPROM Version	WIA P/No
Display EPROM	38149/00 (default Australian)	CP38-3/51
	38152/00 (default USA)	CP38-1/51
Weld EPROM	38024 (default Australian & USA)	CP38-3/50

Most Recent Version of Previous Software		
	EPROM Version	WIA P/No
Display EPROM	38146/60 (default Australian)	CP38-3/41
	38145/05 (default USA)	CP38-1/41
Weld EPROM	38021 (default Australian)	CP38-3/40
	38F21 (default USA)	CP38-1/40

Figure 1 Wirefeed Control PCB



*Hugh Stewart*

Hugh Stewart,  
 Technical Service Co-ordinator - Marketing