

27 May 2005

BULLETIN # 195

WELDMATIC 255, CP112

IRREGULAR OPERATION OF SCR MODULE (VIBRATION)

There have been some infrequent reports of problems while welding with our current model Weldmatic 255.

Symptoms that can occur are:

- vibration of the panels
- greater than normal primary current draw (in some cases severe enough to slow the fan)
- irregular welding characteristic from one welding run to the next

The symptoms may be more severe when particular combinations of coarse and fine voltage settings are selected.

The problem is caused when the SCR's used to energise the welding transformer are turned on incorrectly. In the past, this has been cured by swapping either the SCR module or the SCR Control pcb with another one which has slightly different characteristics. However this is not guaranteed to be 100% effective. We have identified the component used on the SCR Control pcb that is the root cause of the problem and have found a new specification component that will effectively cure the fault, whichever SCR module is used.

All new SCR Control pcb's (part number PWA001) will be upgraded to this specification, and will be identified as Issue B.

This modified pcb will now be fitted to all new machines, starting with serial number C1122D0605026001.

The 480 volt version of the CP112, and the CP107 (earlier model 255S) are not affected as they use a different electronic switch.

If you find a machine which exhibits these symptoms, please contact us for a replacement SCR Control pcb.

Hugh Stewart,
Technical Service Coordinator

QUALITY WELDING PRODUCTS, SYSTEMS AND SERVICES

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