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BULLETIN #221

W19, W55, W56, W60 AND W61

CREEP SPEED MALFUNCTION

When "Creep Mode" is selected, the W19, W55, W56, W60 and W61 wirefeeders use a current sensor to detect welding current, initiating an increase in the wire speed to the desired wire speed. Up until now, the current sensor employed a "U" shaped mild steel bracket which magnetically closed the contacts of a reed switch when weld current flowed through the welding cable.

There have been some cases where the "U" shaped bracket which is part of this current sensor suffered from residual magnetism and held the reed switch closed even after weld current had ceased.

The material specification for the "U" shaped bracket has been changed to ensure that the reed switch reliably opens immediately welding ceases. This bracket is bent from flat lamination steel, so its shape is quite different to that previously used. The new bracket can be identified by its different shape, and the wirefeeders it is used in are now labelled "Issue B". It has been used in wirefeeders manufactured after the following serial numbers.

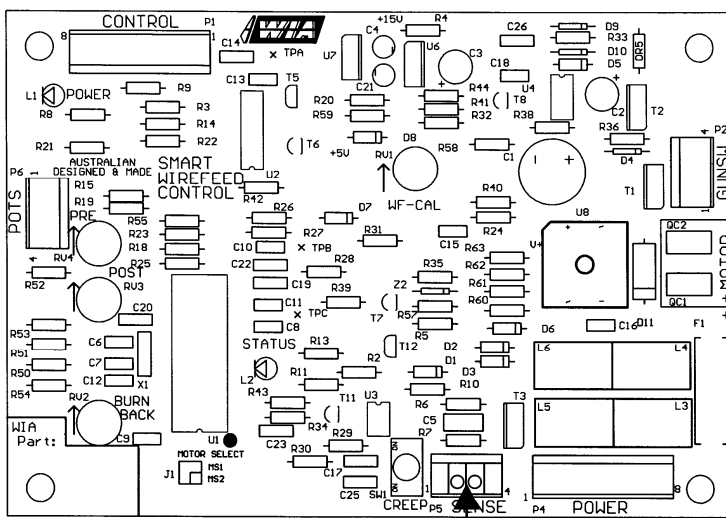
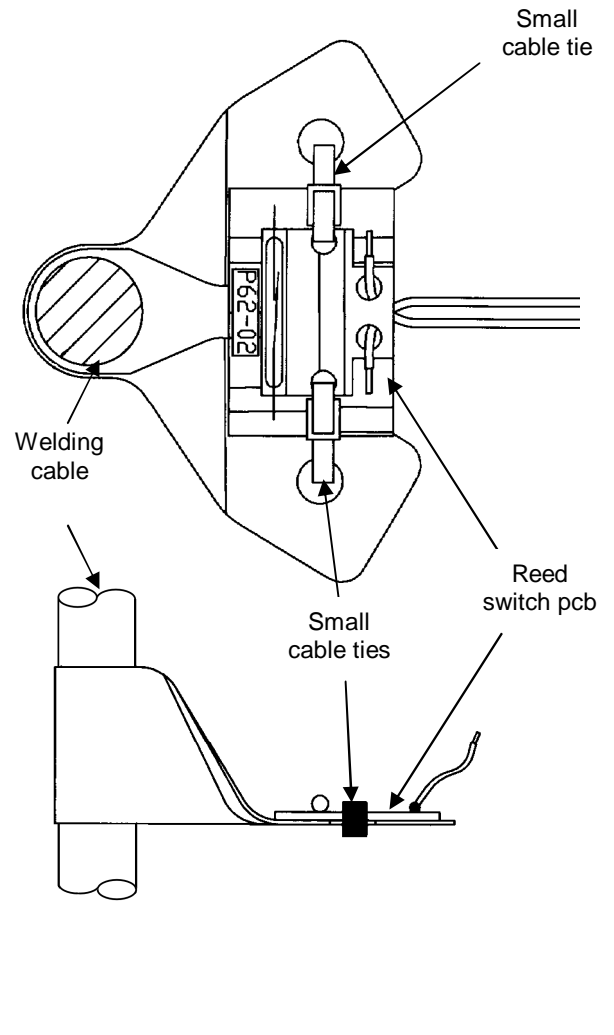
W193B1008034001, W600B1008004001 and W610B0908007001

If a customer reports that the wire speed fails to start slowly when Creep Mode is selected (on a wirefeeder before above serial numbers), it is likely that the bracket is holding in the reed switch for too long. Please contact the WIA Technical Service Coordinator for a replacement new style bracket.

To ensure reliable operation at low welding current, ensure that the reed switch pcb is placed as per the diagram when fitting an existing reed switch to the new bracket. Secure the reed switch pcb using small cable ties.

The part number for the complete current sensor assembly is **AM314**. This comes complete with a 2 pin jack ready for fitting to a W19, W60 or W61.

If using the AM314 current sensor on a W41, W55 or W56, use the 2 pin jack in the centre position as per diagram below.



2 pin jack connects to 2 centre pins

Hugh Stewart,
Technical Service Coordinator

QUALITY WELDING PRODUCTS, SYSTEMS AND SERVICES

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