

13<sup>th</sup> Mar 2012

BULLETIN # 234C

## GENERAL

### FITTING W64 WIREFEEDER TO OLDER MODEL WELDMATIC

The W64 wirefeeder used on our current range of Weldmatic product has a 3 pin plug to connect to the power source. If a customer wishes to use a W64 with a **recent model** Weldmatic power source (see list below) there are 2 recommended solutions that are available:

1. Purchase a W64 wirefeeder (part number WFL013) ready to connect to Weldmatic (less than 18 years old). The WFL013 comes complete with 10 metre, connecting cable consisting of 50mm<sup>2</sup> welding cable, gas hose complete with 5/8" UNF nut and tail, and 4 pin plug ready to connect to the 4 pin socket on a Weldmatic power source.
2. Purchase AM346 adaptor to allow a W64 wirefeeder with 3 pin plug to connect to 4 pin socket on Weldmatic.

Either of these options is sufficient to allow connection to Weldmatic models (external wirefeeder style): CP43, CP44, CP113, CP114, CP117, CP120, CP125, CP126, CP127 or CP130. **No modification of the power source is required.**

#### **Fitting a W64 Wirefeeder to Older Model Weldmatics**

For a CP33-02 Fabricator power source later than serial number 33104.XX, manufactured May 1993, a modification of the wiring inside the power source is required for the W64 to operate correctly.

For older CP33 Fabricators, and other Weldmatic models that have a 4 pin socket on the front, some modification of the electrical wiring on the power source is required, **plus** the addition of a relay to switch on the 110 volt ac contactor coil. The relay would need to have a 30 volt ac coil, and with contacts suitable for switching 110volt ac. Models that are suitable for this modification are:

CP4, CP6, CP15, CP18, CP32, CP33.

For old Weldmatic models which have a 6 pin socket on the front panel, a 4 pin socket, p/no CP15-0/14 (SOCKET 4PIN FEMALE CHASIS MOUNT) can be fitted. The 110 volt wire connected to pin F on the 6 pin socket will need to be disconnected and removed or safely isolated.

Another solution would be to replace the contactor in the power source with one utilising a 30 volt coil and change the wiring so that the relay coil is powered by 32 vac. For an older series Fabricator, CP33, contactor part number E0048 would be suitable.

The following pages show how to modify various models so that either a W64 or an older Weldmatic wirefeeder may be used, as well as the wiring diagram for W64 connected to 4 pin plug as in WFL013..

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Technical Service Coordinator

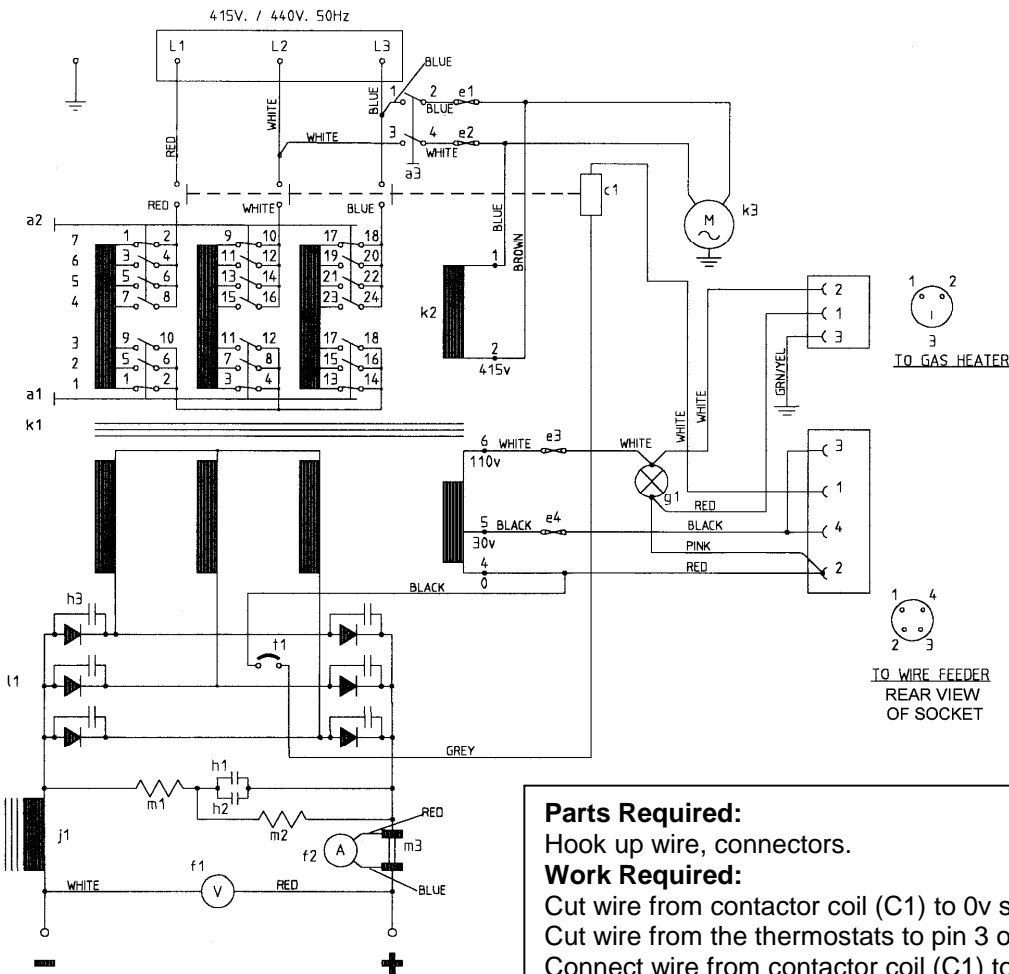
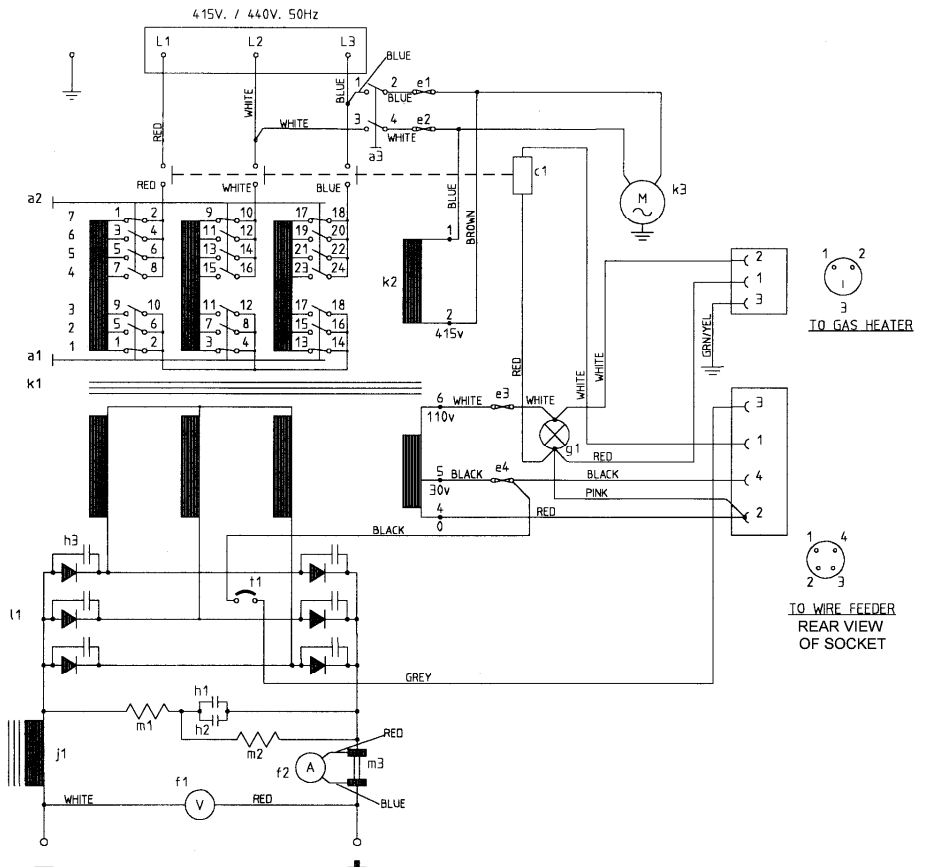
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### QUALITY WELDING PRODUCTS, SYSTEMS AND SERVICES

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.



Unmodified  
CP33 Circuit (with 32 vac  
contactor coil), from  
serial number 33104.xx



CP33 Circuit (with 32 vac  
contactor coil), modified  
to suit W64, 3 wire  
wirefeeder (with 4 pin  
plug fitted) as well as  
older, 4 wire wirefeeders

**Parts Required:**

Hook up wire, connectors.

**Work Required:**

Cut wire from contactor coil (C1) to 0v supply (at Power Light G1).

Cut wire from the thermostats to pin 3 on 4 pin socket.

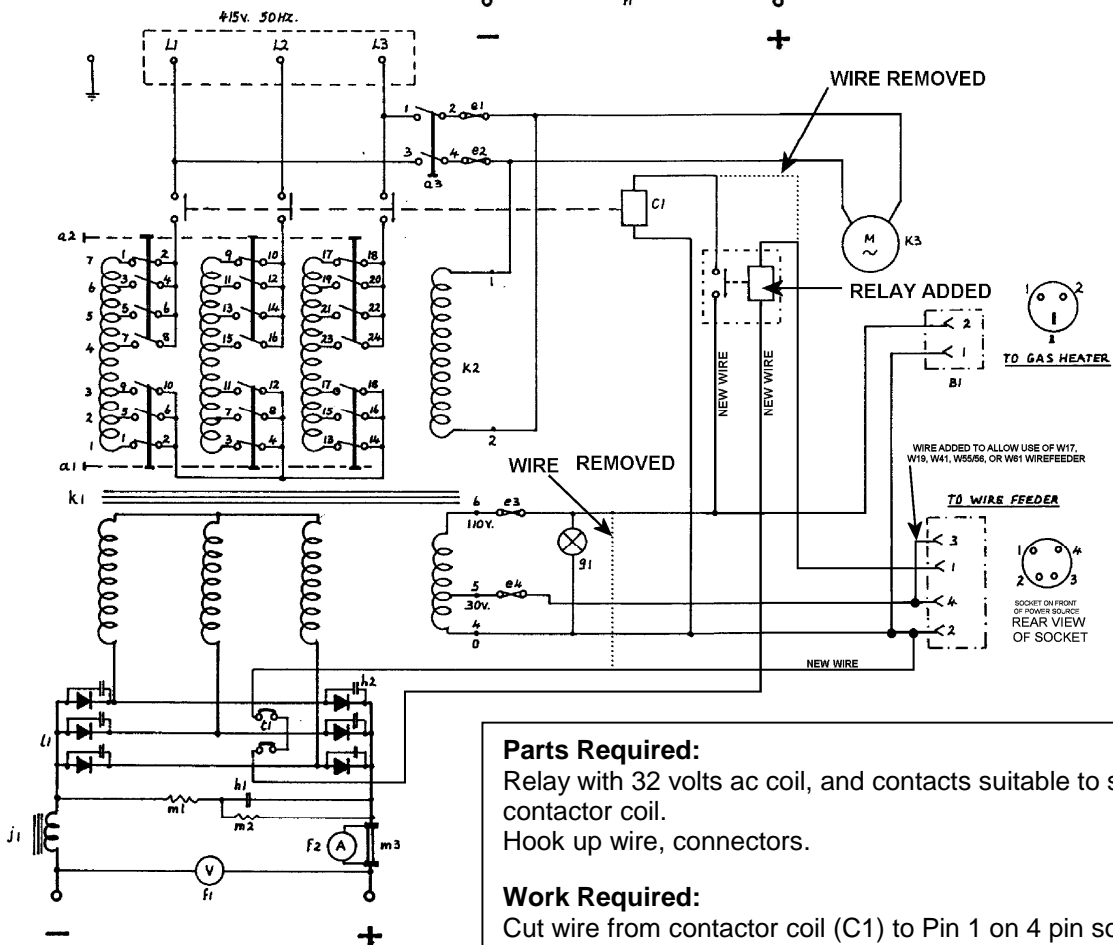
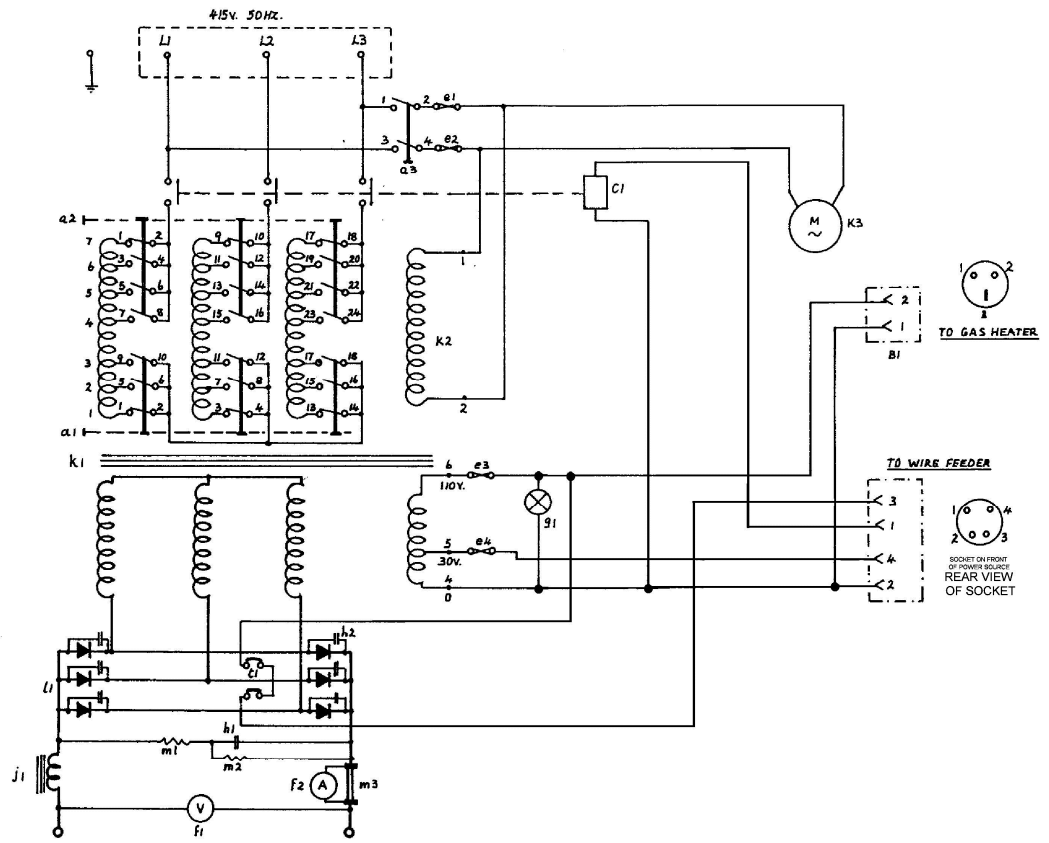
Connect wire from contactor coil (C1) to the thermostats.

Cut wire from other side of thermostats to Pin 4 (30 v supply) on 4 pin socket.

Connect thermostats to pin 2 on 4 pin socket

Connect Pin 3 and Pin 4 on 4 pin socket. (this allows use of older wirefeeders as well as W64)

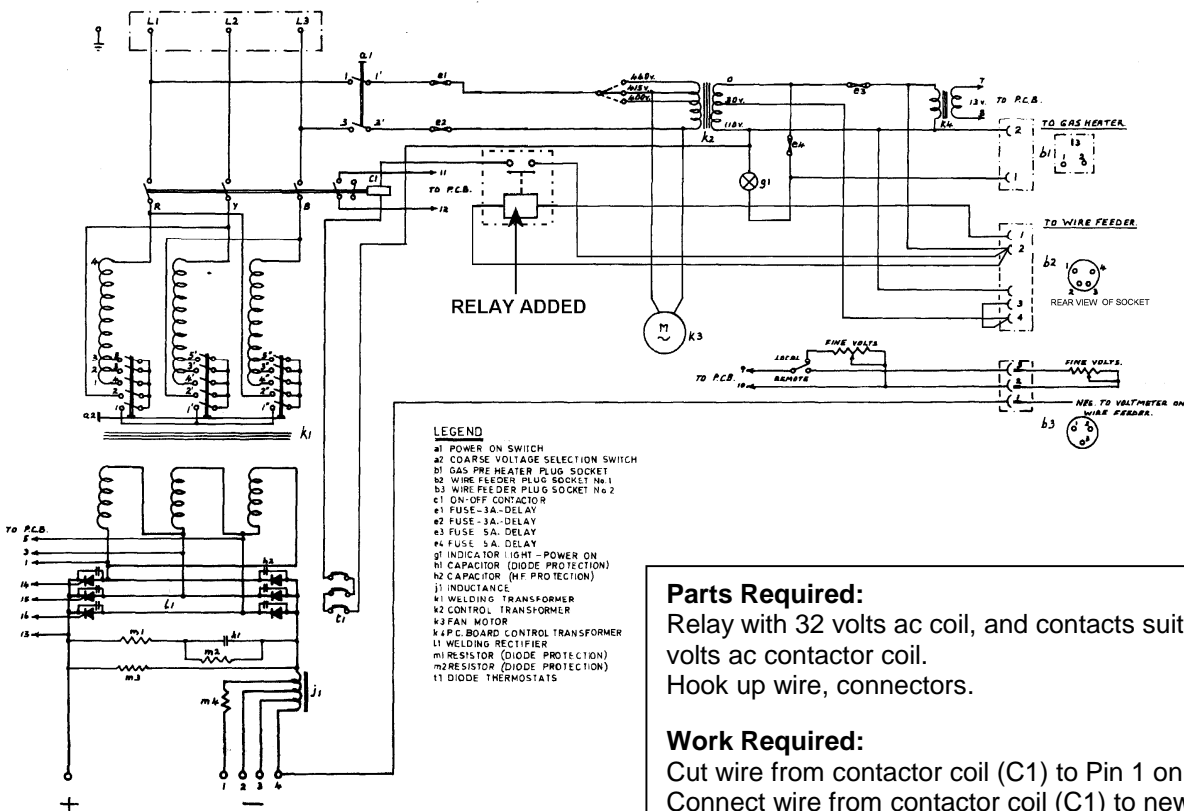
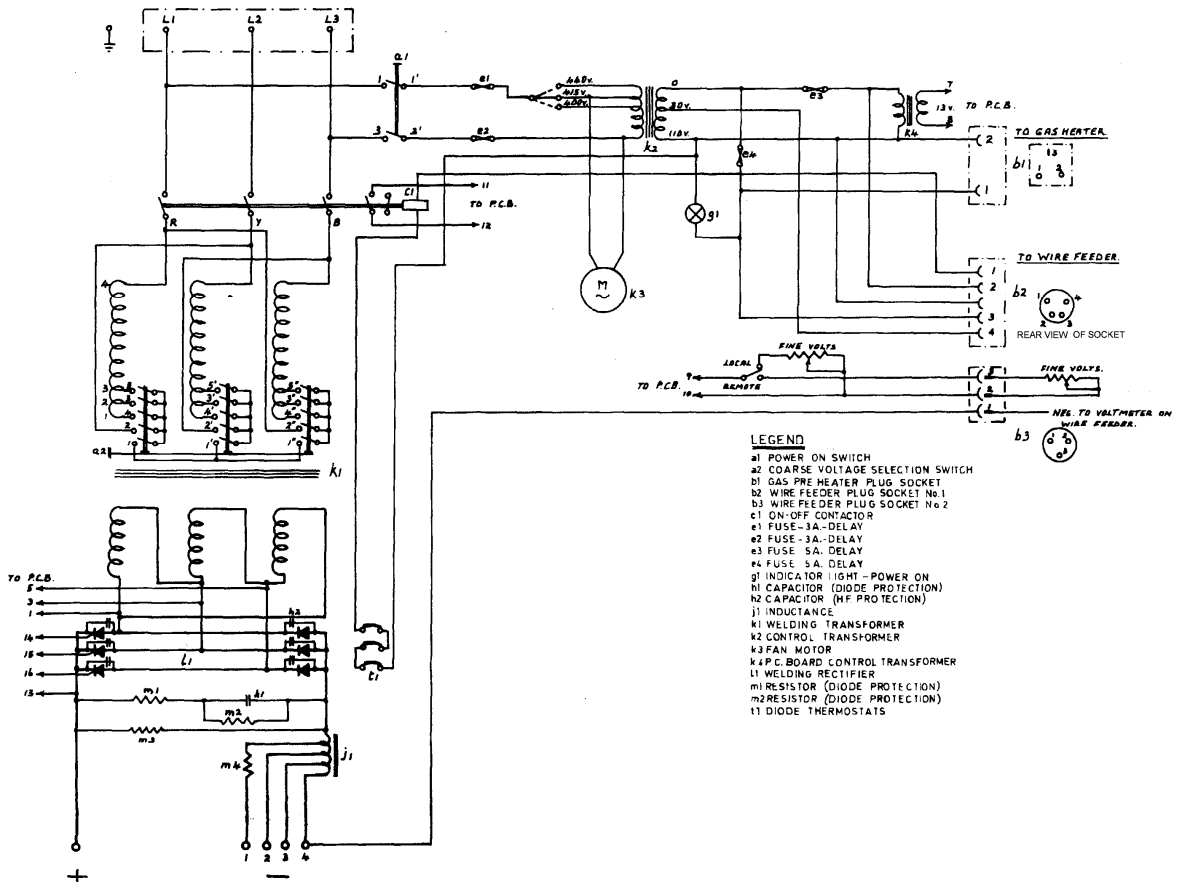
Unmodified CP33 Circuit (with 110 vac contactor coil), before serial number 33104.xx



CP33 Circuit (with 110 vac contactor coil), modified to suit W64, 3 wire wirefeeder (with 4 pin plug fitted) as well as older, 4 wire wirefeeders

- Parts Required:**  
 Relay with 32 volts ac coil, and contacts suitable to switch 110 volts ac contactor coil.  
 Hook up wire, connectors.
- Work Required:**  
 Cut wire from contactor coil (C1) to Pin 1 on 4 pin socket.  
 Connect wire from contactor coil (C1) to new relay contact (n.o.).  
 Connect wire from one side of new relay coil to pin 1 on 4 pin socket.  
 Cut wire from 110v to thermostats.  
 Connect new relay contact (common) to 110v.  
 Connect thermostats to pin 2 on 4 pin socket  
 Cut wire from the thermostats to pin 3 on 4 pin socket.  
 Connect other side of new relay coil to the thermostats.  
 Connect Pin 3 and Pin 4 on 4 pin socket.

Unmodified  
CP4 Circuit



CP4 Circuit modified to suit W64, 3 wire wirefeeder (with 4 pin plug fitted) as well as older, 4 wire wirefeeders.

**Parts Required:**

Relay with 32 volts ac coil, and contacts suitable to switch 110 volts ac contactor coil.  
Hook up wire, connectors.

**Work Required:**

Cut wire from contactor coil (C1) to Pin 1 on 4 pin socket (b2).  
Connect wire from contactor coil (C1) to new relay contact (n.o.).  
Connect new relay contact (common) to pin 2 (0v) of 4 pin socket (b2).  
Connect one side of new relay coil to pin 1 on 4 pin socket (b2).,  
Connect other side of new relay coil to pin 2 (0v) of 4 pin socket (b2).  
Remove 0v supply to Pin 3 of 4 pin socket (b2)  
Connect Pin 3 and Pin 4 together on 4 pin socket (b2). (this allows use of older wirefeeders as well as W64)