



Service Bulletin



20/09/2021

BULLETIN # 278

WELDARC 185I

VRD ACTIVATION

CAUTION: The following information is intended for use by qualified service personnel. When the unit is energised LETHAL VOLTAGES are present on the electrical and electronic components. It is not intended that persons without suitable training and knowledge attempt to perform service tasks on the components of welding equipment.

Introduction

The Weldarc 185i will arrive as standard with the VRD **enabled**. It is understood that some customers may require the VRD to be disabled.

In order to disable the VRD, the following procedure should be followed.

Enabling/Disabling the VRD

The Machine has to be placed into a service mode before the VRD status can be changed.



1. Remove Handle – 4 screws

Figure 1 - Weldarc 185i with handle

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.



Figure 2 - Front panel screw with handle removed

2. Remove screw on front panel only (as Figure 2).



Figure 3 - Service mode switch

3. Move the front panel forward to reveal the the small DIP switch on the front panel PCB (Figure 3).

4. With a small screw driver (or similar) move the switch UP into ON position. Machine is now in service mode.



Figure 4 - Switch in to Service mode

5. Apply power to the machine.

6. On front panel press and hold the Mode button until the display shows VRD. Release button.

7. Display will then show the status of the VRD, either ON (enabled) or OFF (disabled).

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Figure 5 - VRD activation status

8. Rotate the current knob clockwise to turn VRD on, or anti clockwise for VRD off (Figure 5).

9. Remove power from the machine.



Figure 6 - Movement of DIP switch

With small screwdriver (or similar) move the switch down into OFF position (Figure 6).

10. Reassemble machine (opposite and reverse of stages 1, 2, 3).

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Check machine operation.

11. Power machine up, listen for fan running on start-up. Fan plug can sometimes be pulled out during panel removal and assembly.
12. With VRD enabled the open circuit volts should be approx. 13-17 volts DC and the VRD Safe indicator on the front panel should be illuminated until an arc is struck. During welding the VRD Safe indicator will not be illuminated.
13. Once welding ceases, the open circuit volts should be approx. 13-17 Volts DC and the VRD Safe indicator on the front panel should be illuminated.
14. With VRD disabled the open circuit volts should be approx. 81 volts DC and the VRD Safe indicator on the front panel should never be illuminated.

Affected serial number:

All MC107, Weldarc 185i machines are affected by this bulletin.

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