



Refer to PipeWorx 400 Welding System Owner's Manual for equipment safety precautions

Memory Card Insertion

1. Hold open memory card access cover
2. Insert memory card into slot (push card all the way in and then release)
3. Close memory card access cover

Memory Card Removal

1. Hold open memory card access cover
2. Push in and release memory card to eject memory card
3. Grasp memory card and remove from slot
4. Close memory card access cover

Optional Program Card

1. Insert optional program card
2. Select wire feeder
 - a. Press either the LEFT or RIGHT (dual feeder only) button on the feeder
- OR**
- b. Press the SIDE SELECT button on the power source until the desired wire feeder side is illuminated
3. Select weld process
 - a. Press the MIG TYPE button on the power source front panel until the desired process is illuminated
 - b. CARD will illuminate on the power source front panel as well as on the feeder front panel to indicate that the optional program is being used from the memory card
4. Select the wire diameter, if applicable
 - a. Press the WIRE DIA button on the power source front panel until the desired wire diameter is illuminated
 - b. NOTE: some optional program cards only support a single wire diameter, in which case only that diameter will illuminate
5. Remove memory card to revert to standard operation

Software Update Card

1. Insert software update card
2. *Optional: Save Weld Settings*
 - a. Press the SAVE button on the power source front panel – busy indicator will illuminate briefly
 - b. Wait for the busy indicator to go out
3. Perform software update
 - a. Press and hold the LOAD button on the power source front panel until UPd is displayed on the 7-segment LED display
 - b. Wait for the software update to complete (approximately two minutes) – the display will return to normal operating condition when the update is complete
 - c. NOTE: During the software update, the displays on both the power source and feeder front panels may display H99 or H98 as well as the UPd or go blank for a period of time; this is normal during a software update
 - d. NOTE: Do not remove the memory card until the software update has completed
 - e. NOTE: Do not turn off the power source until the software update has completed
4. *Optional: Restore Weld Settings*
 - a. Press the LOAD button on the power source front panel – busy indicator will illuminate briefly
 - b. Wait for the busy indicator to go out
5. Remove memory card



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Optional Memory Card

Usage Instructions