

The features described below are not apparent on the front panels of the system but are explained in detail in the owner's manual. These are identified with "OM". We strongly encourage you to review the manual.

**Weld program adjustments** – All weld programs are set to optimized parameters based on welding process, material, wire diameter, and gas from the factory and do not require adjustment in most applications.

### **Power Source/Stick TIG remote**

- **TIG Effective Amperage Display** - If the TIG process has been selected and a current/contactors control (14 pin wired or wireless remote) is connected, holding the TIG process select button for more than two seconds will display the effective amperage command (based on the amperage setting and the remote current/contactors control setting.) **OM**
- **Adjustable DIG and Hot Start (Stick)** - Press and hold the 'STICK' button for 2 seconds to enter adjustable DIG. The right decimal point will illuminate on the display to indicate DIG. Once in adjustable DIG, press and release the 'STICK' button again to enter adjustable Hot Start. The middle decimal point will illuminate on the display to indicate Hot Start. Pressing and releasing the 'STICK' button a third time will exit the menu. The menu will automatically exit after 10 seconds of inactivity. Pressing and releasing any button other than the 'STICK' button while in the menu will also exit the menu. **OM**
- **Electrode Negative (DCEN) Stick** - Press the 'STICK' button and down arrow (-) at the same time. Press the 'STICK' button to exit this mode. The DCEN mode can be used for EXX10 and/or EXX18 process setting. The mode has to be set for each electrode process individually. The 'DCEN (-) STICK NEG' text will illuminate if the polarity is negative while in STICK mode. Press 'STICK' to change back to DC electrode positive. **OM**
- **Restoring Factory Defaults** - A factory reset of the power source can be accomplished by pressing the 'STICK' and 'TIG' buttons simultaneously for more than four seconds. The display will show 'rSt' and then go to dashes (---) when the reset is complete. **OM**
- **Viewing Software Revision** - Press and hold the 'ELECTRODE' and 'IN USE' buttons simultaneously to view the system revision level. While still holding down the 'ELECTRODE' button, press the In Use push button again to display the User Interface software revision level. **OM**
- **VS Feeder Mode** - It is possible to run a voltage sensing feeder on the PipeWorx 350 FieldPro. To enter VS MIG mode press the 'ELECTRODE' and 'STICK' buttons at the same time. Press 'STICK' to exit VS feeder mode.

## Smart Feeder

- **Arc Control Adjustment in RMD and Pulse MIG (Arc Width)** - Press and hold 'IN USE' button until 'Arc' appears on the display then release. Use the increase (+) and decrease buttons to adjust setting from -25 to +25, factory default is 0. **OM**
- **Inductance Adjustment (FCAW and MIG)** - Press and hold 'IN USE' button until 'Ind' appears on the display then release. Use the increase (+) and decrease buttons to adjust setting from 0 to 99, factory default is 25 for carbon steel and 75 for stainless steel. **OM**
- **Timed Purge** - Hold 'PURGE' button and press 'JOG' for timed purge. The feeder will purge shielding gas for the set amount of time. The purge time can be adjusted from 5 to 60 seconds by pressing the increase (+) or decrease (-) buttons while timed purge is running. The default is 30 seconds. **OM**
- **Auto-Jog** – Hold the 'JOG' button and press 'PURGE' for auto-jog function. The feeder will jog a measured length of wire then automatically stop. The jog length can be adjusted from 5 to 30 feet by pressing the increased (+) or decrease (-) buttons while Auto-Jog is running. The default is 15 feet. **OM**
- **Preflow/Postflow Adjustment**
  - Hold the 'PURGE' button and press the 'VOLTS' or 'WIRE SPEED' increase (+) or decrease (-) button until 'PrE' is displayed on the 'VOLTS' display.
  - Release the 'PURGE' button.
  - Adjust preflow to desired value by pressing 'WIRE SPEED' increase (+) or decrease (-) button. Available selections include 'Std' (standard or .25 seconds) and numeric values from 0.9 to 10.0 seconds.
  - Press the 'VOLTS' increase (+) or decrease (-) button to change from preflow to postflow. Unit will display 'PSt' on the 'VOLTS' display.
  - Adjust postflow to desired value by pressing 'WIRE SPEED' increase (+) or decrease (-) button. Available selections include 'Std' and numeric values from 0 to 60 seconds.
  - Press any button to return to the normal display. **OM**
- **Factory Reset** - A factory reset of the Smart Feeder can be accomplished by pressing and holding the 'LOAD' and 'SAVE' buttons at the same time for more than 4 seconds until "rSt" appears on the display, reset is complete when the display shows dashes (---). **OM**
- **Viewing Software Revision** – Press the 'MIG TYPE' and 'MEMORY' front panel buttons at the same time. The software revision level will be shown on the 'WIRE SPEED' display. **OM**