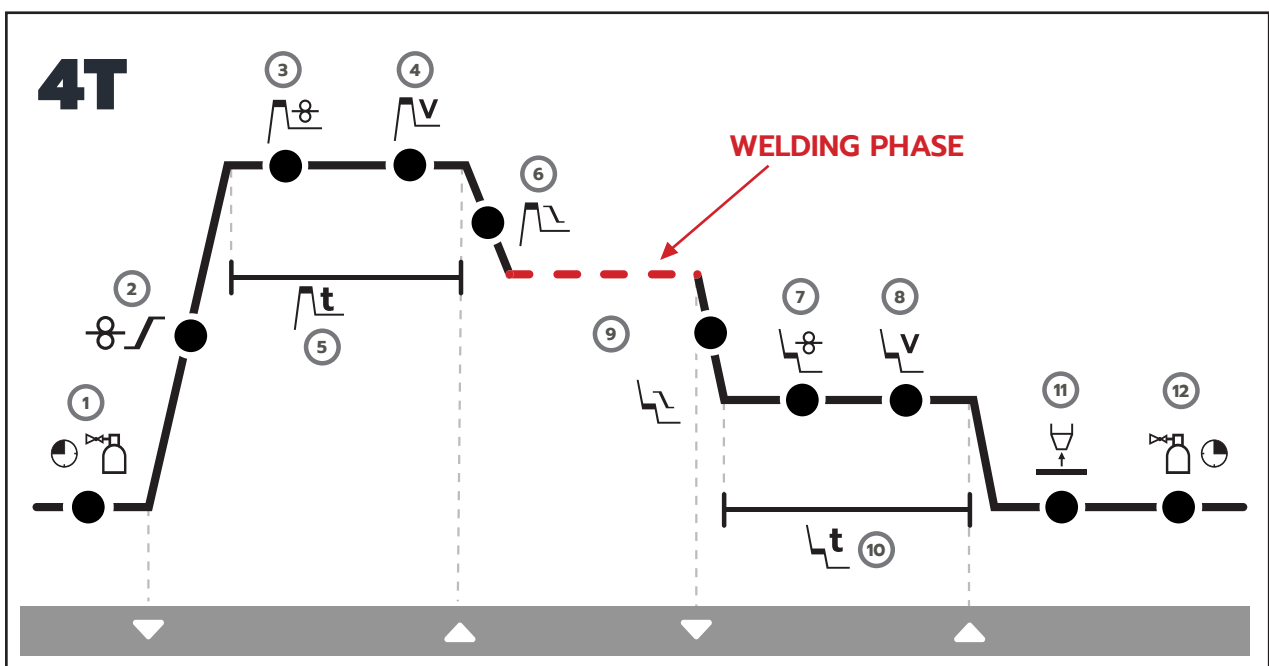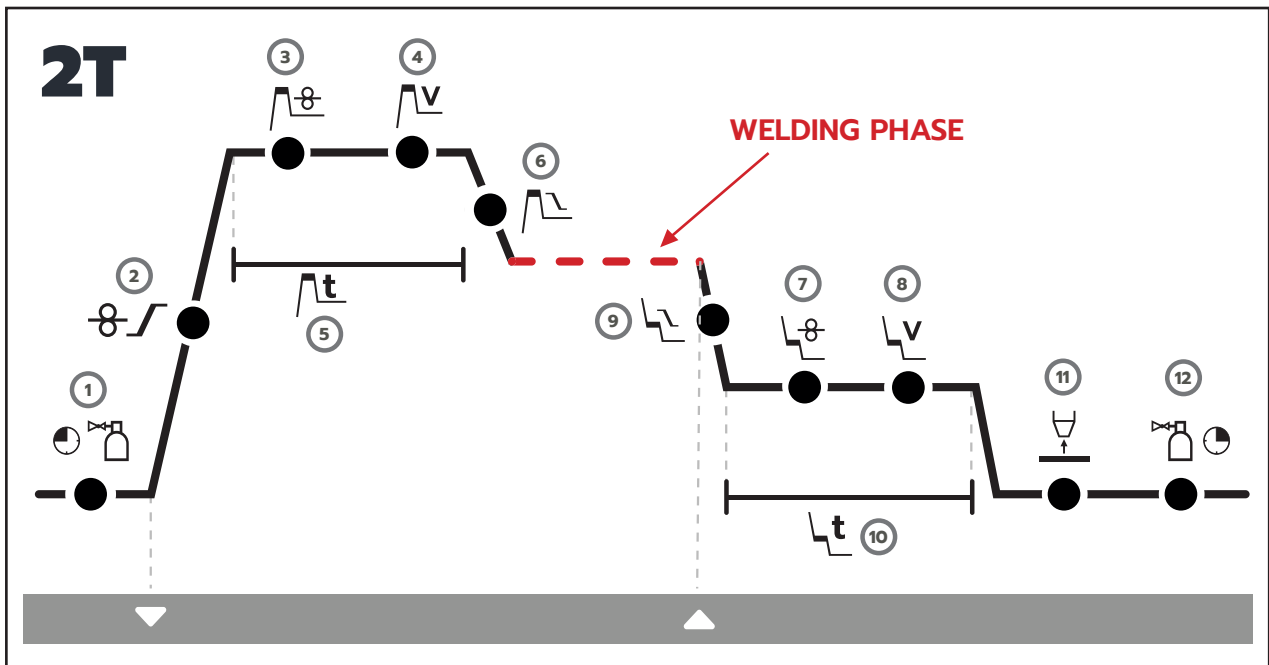# PLUS MODE - PARAMETERS ADJUSTING GUIDE

NOTE: for a correct adjustment, please contact your dealer

ENABLE THE PLUS MODE FROM BASIC SETUP

- Turn off the power source
- Turn on the power source by holding down the **"SETUP"** button until **"H2o"** appears on the display
- Using the left knob, select the "**PLus_ModE**" mode
- With the right knob, set the value **ON**
- Confirm the parameter change by pressing the **"MODE"** button on the front panel.

PLUS PARAMETER ADJUSTMENT

- Turn on the power source
- Press the "**SETUP**" button twice, illuminating the **2T LED**
- Turn the right knob to select the **2T**, **4T**, **2TP**, **4TP** modes
- Confirm the desired **PLUS** mode (**2TP** or **4TP**) by pressing the "**MODE**" button
  (the **2T** or **4T** LED will flash slowly if **PLUS** mode is confirmed)
- Activate the **QUICK SETUP** menu by holding down the "**SETUP**" button for 3 seconds
- Use the left knob to select the available functions
- Using the right knob to change or modify the parameter (see table below)

ATTENTION: when the PLUS MODE is active, the HotStart and Crater Filler functions are immediately activated with relative ramps. If you do not want to manage these parameters, please set all the values of the PLUS parameters to 0.

			DESCRIPTION	ADJUSTABLE VALUES
1		[s]	"PRE_GAS" · PRE GAS Adjustment of the Pre-gas time before ignition of the welding arc	0,0 ÷ 10,0 s
2		[s]	"SLOPE" · WIRE SLOPE Adjustment of the time needed to reach the wire speed set after the ignition of the welding arc	0,0 ÷ 2,50 s
3		[mt/min]	"HSSPEED" · (MIG-MAN) · HOT START WIRE SPEED Initial wire speed increase or decrease	1,0 ÷ 25,0 mt/min
		[%]	"HSSPEED_PERC" · (MIG-SYN) · HOT START WIRE SPEED Initial wire speed increase or decrease	-80% ÷ +50%
4		[v]	"HSVOLTAGE" · (MIG-MAN) · HOT START VOLTAGE Voltage increase or decrease of the initial wire speed	12,0 ÷ 45,0 v
		[%]	"HSBALANCEV" · (MIG-SYN) · HOT START BALANCING Voltage balancing of the initial wire speed	-9,9 ÷ +9,9 v
5		[s]	"HSTIME" · HOT START TIME Hot Start time adjustment (Parameters ② + ③)	0,0 ÷ 10,0 s
6		[s]	"HSSLOPE" · HOT START DOWN SLOPE Time adjustment from the start parameter to the welding set parameter	0,0 ÷ 10,0 s
7		[mt/min]	"CFSPEED" · (MIG-MAN) · CRATER FILLER WIRE SPEED Wire speed increase or decrease in crater filler	1,0 ÷ 25,0 mt/min
		[%]	"CFSPEED_PERC" · (MIG-SYN) · CRATER FILLER WIRE SPEED Wire speed increase or decrease in crater filler	-80% ÷ +50%
8		[v]	"CFVOLTAGE" · (MIG-MAN) · CRATER FILLER VOLTAGE Increase or decrease of tension referred to wire speed in crater filler	12,0 ÷ 45,0 v
		[%]	"CFBALANCEV" · (MIG-SYN) · CRATER FILLER BALANCING Time adjustment from the welding set parameter to the crater filler phase	-9,9 ÷ +9,9 v
9		[s]	"CFSLOPE" · CRATER FILLER SLOPE Time adjustment from the welding set parameter to the crater filler phase	0,0 ÷ 10,0 s
10		[s]	"CFTIME" · CRATER FILLER TIME Adjustment of the crater filler time (Parameters ⑦ + ⑧)	0,0 ÷ 10,0 s
11		[s]	"BBT" · BURN BACK TIME Adjustment of the Burn Back Time	1 ÷ 100
12		[s]	"POST_GAS" · POST GAS Adjustment of the Post Gas time	0,0 ÷ 2,50 s