

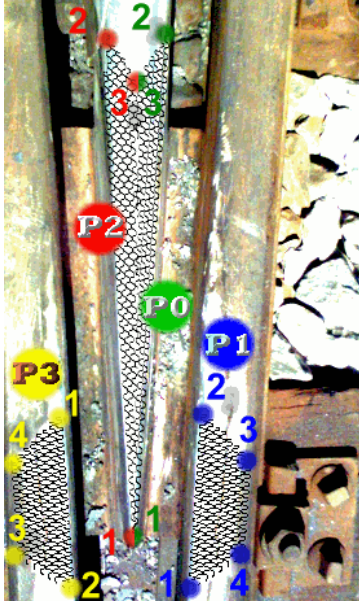


## Welding Example ,Manganese Welder'

### RD 200M/ RD 500M Manganese Welder

Special program for manganese hard facing with multiple areas and surfacing of different form of welds at big plates.

At hard facing of manganese rails, fast layers with small amplitudes are needed. If the welding gets too hot, dwell times are needed, to get a *cold* work piece.



To save time, all needed welding areas can be set by *Teach-In* points and the unit changes from one area to the next, after every layer.

The form of every area can be different as needed and will be set by up to 6 *Teach-In* points. The unit calculates the positioning and filling of all welding areas automatically. The welding parameters can be adjusted at up to 20 separate programs, which will be memorized permanently.

This example shows a multi area welding with 4 programs. The main welding line is always between point 1 and 2, which fixes the drive direction and the start position of every area.

To get both top corners of the main frog part in high quality, it's welded with two separate programs **P0** and **P2**.

#### LCD display and functions

	Time	Program	Dwell ON	Dwell OFF	
	05 69 14 24	P00	01 20	00 20	
	X:+00000 Y:+00000 Z:+00000				Position X,Y,Z
Manual Z-Speed	↕	↕	↕	↕	Movement Speed Left
Manual Y-Speed	↕	↕	↕	↕	Movement Speed Right
Manual X-Speed	45	60	35	20	20
Amplitude of Weaver	↕	↕	↕	↕	Drive Speed at weaving
Distance between Layers	25	10	30	10	25
					Distance between Weaver Layer
Teach-In Points	●1	20	00	00	00
	0 0	0 0	0 0	0 0	0 0
	0 6	3 0	0 0	0 0	0 0
	5	4	11 20	11 05	00 00
	Active Layer		Multi-Area	Arc Adjustment	
	Dwell after Layer		Arc Speed		
					Active Gun or Test
					Pattern
					Input or Movement Adjust
					Arc Amount

All standard functions for surfacing with remote control *RD2000* are available and optimized for manganese welding and hard facing.

With the new *Dwell after Layer* (0-10 Min.) function, a pause time to get cold, can be set.

The *Active Layer* can be used to start at special layer position and as indicator of work.

The *Multi-Area* symbol indicates, if this program is part of multiple welding areas or stand alone.