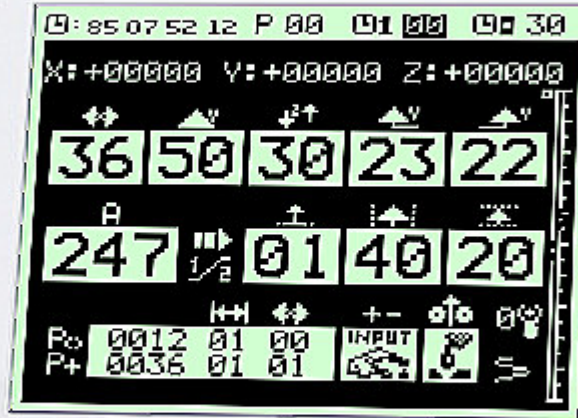


RD 2000 Remote Pendant Control

Standard Program



Symbol	Function	Symbol	Function
□:	Time, days, hours, minutes, seconds	↑:	Speed CENTER
P	Program No. 0-20	⋯:	Distance weaver layers 0-20mm
□1	Start Dwell time 0-2 seconds	▢▢▢	Multi-Area welding, or single program
□□	Stop Dwell time 0-2 seconds	1/2	Working at points, %? record, ▢ Area
X,Y,Z	Position side, forward, height	Po	Actual position at point 0-1200, value +- 0-99
↔	Speed X left/right movement	P+	Input point 0-1200, value 0-99
▲▼	Speed Y forward or reverse	⋈	Amplitude 0-50mm, 0-100mm
↕	Speed Z distance support	↔	Weaver speed at welding
▲	Speed or Time LEFT	+ -	Input mode, set values or move axis
▼	Speed or Time RIGHT	⊕	Wire feeder, Test/Weld/Feed in
A	Welding power 0-500 Ampere	⊖	Sensitivity of Arc Control 0-9
⊕	Distance upwards after stop dwell (LIFT OFF)	⇒	Welding Pattern, 2, 1, 5, 3, 3, 3, 3

Welding Patterns

For V-Shape- and Corner Welds

Flexible Patterns, with or without dwell times



High frequency weaving, also with different dwell times



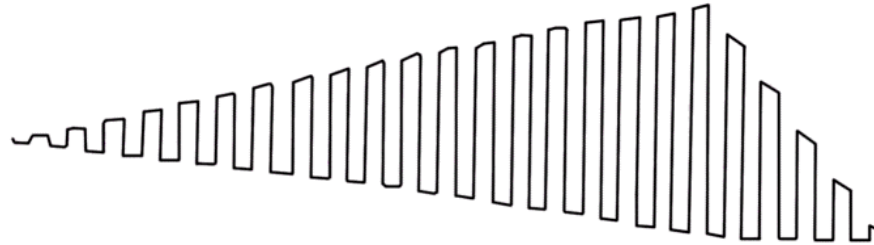
Special Weaver Pattern



for strongest seams

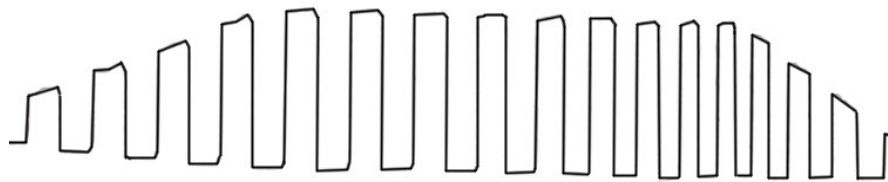
Welding Patterns

For standard Surfacing



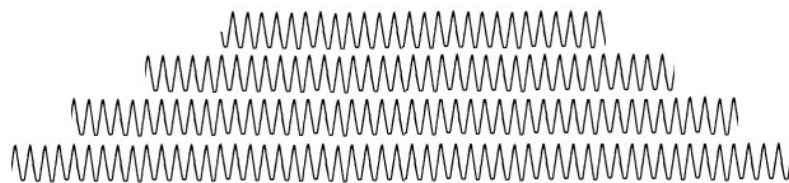
Left or right side welding, along the input line, with computer controlled adjustment.
Multiple Area welding with different parameters. For every area, a different program can be used.
For repeated works, all *Teach-In-Points* are memorized with separate programs (P 0-20).

For deep Wear Out



With changing weaver distances from layer to layer.

For Hard Facing with fast oscillating layers



With different dwell times for best overlapping and *vibration* for fixing layers.
Multiple Areas can be filled automatically. To get a *cold* work piece, for every area, a special Count Down Timer is used (0-10 Minutes).