WELD STAR

Quick Setup Guide

WS-MU4-1

INFINIUM

WS-MU4-1 ACDC
Quick Setup Guide

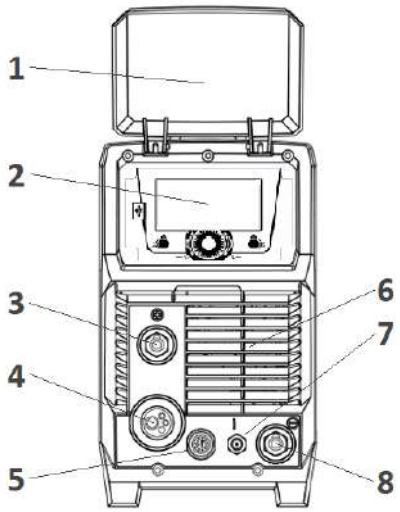
Disclaimer

Whilst every effort has been made to ensure that the information contained within this manual is complete and accurate, no liability can be accepted for any errors or omissions. Products are subject to continual development and may be subject to change without notice. www.weldstar.uk

Before starting any welding activity ensure that you have read the operating manual. Always wear suitable PPE for welding tasks and also take the necessary steps to protect any personnel within the welding area.

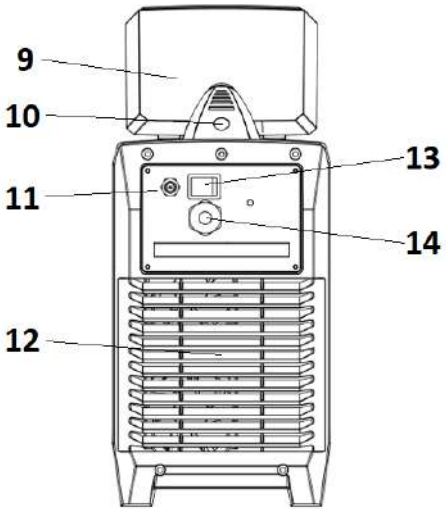
CONTROLS

Front view Weld Star WS-MU4-1



1. Protective control panel cover
2. Control panel (see below for further information)
3. Positive '+' Dinse socket outlet (35/50mm)
4. MIG torch outlet connector, the connection that allows for a euro style MIG torch to be fitted
5. Remote control socket
6. Cooling air vent
7. TIG gas outlet (10mm)
8. Negative '-' Dinse socket outlet (35/50mm)

Rear view Weld Star WS-MU4-1



9. Protective control panel cover
10. Carry handle
11. Gas inlet
12. Air vent
13. Mains power ON/OFF switch
14. Mains input power cable

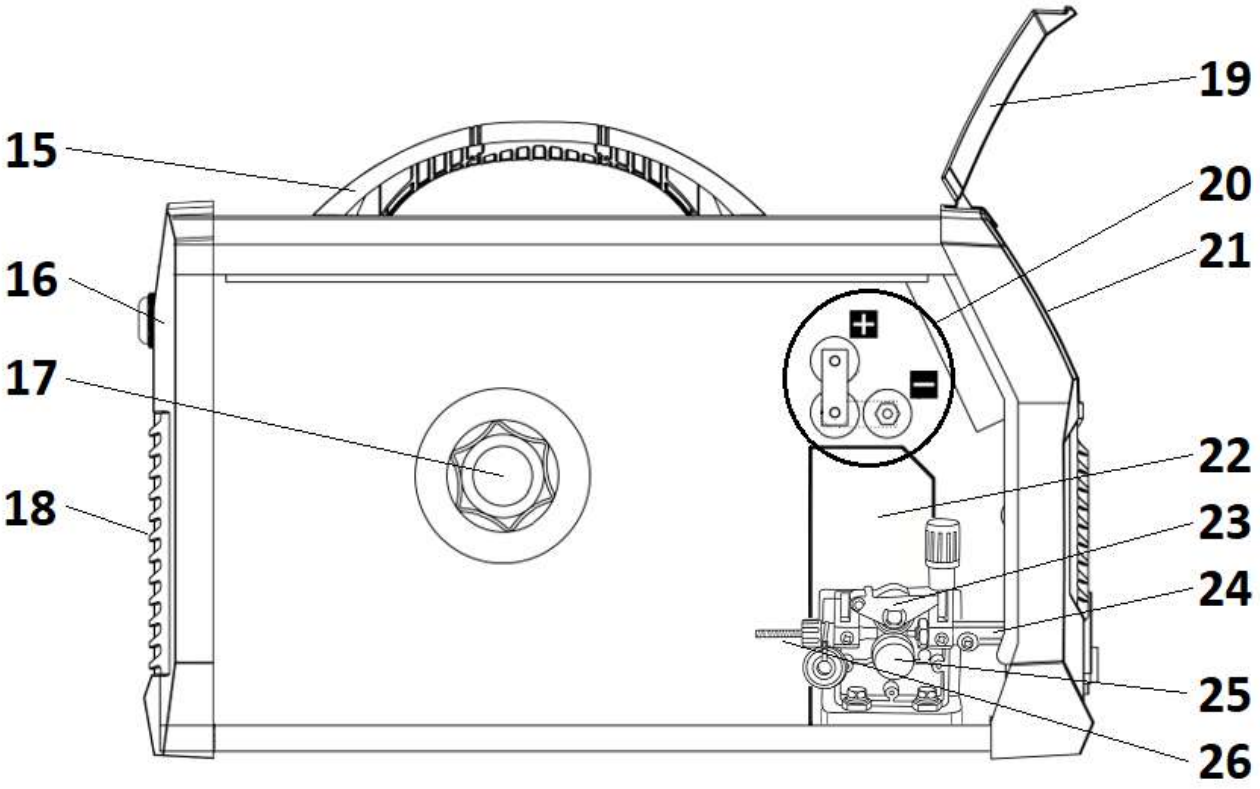
Control panel view Weld Star WS-MU4-1

27 USB Connector *
28 5" Digital screen
29 Left control button
30 Main control dial and activation button
31 Right control button

* The front panel USB socket allows for easy software updates to be loaded into the machine. By inserting a 'loaded' Weld Star USB while the machine is turned off and then switching the machine ON will the machine automatically load the updated firmware and programs (during this mode the screen displays the firmware update status). Once the update is complete the machine will boot up as normal.

CONTROLS

Side view Weld Star WS-MU4-1



15. Carry handle.
16. Rear panel.
17. Wire spool holder and tensioner: Allows a 5kg (200mm diameter) reel of wire to be located in place via an alignment pin and then locked in place with the locking nut. The spool holder also has a brake arrangement to ensure correct tension of the wire, this is done by turning the central bolt with an allen key clockwise (to tighten) or anti clockwise (to loosen).
18. Rear air vent.
19. Protective control panel cover.
20. Adjustment point to euro MIG torch outlet polarity to be either positive '+' or negative '–'. When using gas set the connection to '+' when using 'gasless' welding wire set the connection to '–'.
21. Control panel.
22. Drive Assembly feed motor and gearbox (the feed motor is located behind the plastic cover).
23. Upper pressure roll assembly: Holds the upper drive roll in place which applies pressure to the welding wire via the fitted grooved drive roll, the pressure is applied via the drive roll tensioner which allows the correct amount of tension to be applied to the top roller to ensure good feed of the wire through the MIG torch.
24. Outlet feed adaptor: Part of the Euro outlet connector assembly which contains the inner outlet guide which ensures smooth wire feed from the drive assembly through to the MIG torch.
25. Wire feed roller and retaining nut. Secures and holds the grooved drive roll in place. The feed roll supplied with the machine from new is a 0.8mm/1.0mm V.
26. Inlet wire guide: The welding wire is fed through the inlet guide prior to feeding through the drive rollers.

MULTIFUNCTIONAL DISPLAY WINDOW

Display Screen Explained WS-MU4-1

Upon powering ON your MU4-1 and boot up sequence is complete, the main menu will appear on the LCD digital screen 'F' as shown right, this allows the operator to navigate the various welding processes by rotating the control dial 'B' clockwise or anti clockwise and when the desired option is front and centre then you can press the dial 'B' to access the required welding mode.
Along with the settings option you can also navigate yourself though the welding modes that include: MMA, MIG Pulse, MIG Synergic, MIG Standard, Lift TIG, HF TIG and Smart TIG.

Button 'A' is usually associated with the icon that's circled 'D' (to access option short press A).
Button 'C' is usually associated with the icon that's circled 'E' (to access option short press C).

Navigate to one of the MIG welding process options, the example shown left is MIG manual, you will then note that just above the control dial circled 'H' it shows the polarity of the MIG torch and work return lead:

- MIG torch symbol is '+' (positive polarity)
- Work return lead clamp is '-' (negative polarity)

To check that the outputs are configured correctly, please check out the full operating manual if set correctly.

In this screen you also have the ability to check and activate gas purge along with 'inching' the wire feed.

- If you long press and release button 'A' (approx. 3 seconds) the gas solenoid will activate allowing the gas to purge and flow, allowing you to test and set the gas flow accordingly.
- If you long press and release button 'C' (approx. 3 seconds) this activates the wire feed motor which in turn pushes the welding wire through the MIG torch and contact tip.

If you press the control dial 'B' button, this will take you to the MIG manual welding process control screen, as shown left, where you can adjust (in this case being MIG Manual) the following settings:

- 1 Wire Feed Speed
- 2 Welding Voltage
- 3 MIG Torch switch control, 2T, 4T, S4t, Spot and S2t
- 4 Variable MIG Inductance control

To access these advanced setting, press the control dial 'B' and each of the green circled parameters numbered 1 - 4 will highlight red in turn as you rotate the control dial B.
To adjust a highlighted parameter, press the control dial which will allow you to adjust selected parameter by rotating the dial and then pressing the control dial again will store the parameter setting and automatically move to the next parameter option.

Please Note: Parameter options vary depending on welding process and torch trigger mode selected.

MULTIFUNCTIONAL DISPLAY WINDOW

Display Screen Explained WS-MU4-1 (continued)

As previously noted buttons A and C have 2 functions determined by either a short or long press of buttons A and C.

- Briefly pressing buttons A or C will activate the 2 option icons circled red.
- Pressing, holding the releasing buttons A and C for approx. 3 seconds will activate the 2 option circled in green (save and load in this case).

Following on from the instructions on the previous page, if you press and release (short press) button 'C' you will now enter a new screen (shown left) that allows the operator to select and adjust more advanced (in this case) MIG settings such as:

- Pre gas flow
- Slope up
- Current
- Slope down
- Post gas flow
- Burn back
- Also Start Amps, Start Amps time and final amps are available in either S2t or S4t torch trigger mode.

Please Note: These parameter options do change depending on which welding process and torch trigger mode you have selected.

Save and Load welding programs

The following information details the save and load options of welding parameters as detailed below:

Saving a welding program

If you long press (approx. 3 seconds) and release button 'A' the screen will change to the memory save option.

As you will see this screen allows the operator to save his setup to 1 of 10 memory programs.

To save, rotate the control dial to the desired program number and then press and release button 'C'.

Loading a welding program

If you long press and release button 'C' (for approx. 3 seconds) the screen will change to the memory load option.

This screen allows the operator to load previously saved welding programs.

To load a program, rotate the control dial to the desired program number and then press and release button 'C'

You will then return to the loaded welding program screen.

MULTIFUNCTIONAL DISPLAY WINDOW - MIG MODE

Welding screen/display explained MU4-1

Upon powering ON your WS-MU4-1 and boot up is complete, the control panels main menu will appear on the digital panel as shown above.

You can now navigate yourself though the various options and welding modes which include:
Settings, MIG Pulse, MIG Synergic, MIG Manual, Lift TIG, HF TIG, Smart TIG and MMA.

In the home screen, for MIG welding the following options are available:

MIG Pulse

MIG Synergic

MIG Manual

By rotating the main centre control dial you will 'scroll' through the options and by pressing the dial you will enter either MIG Pulse, MIG Synergic or MIG manual mode.

Conventional MIG welding equipment (MIG manual) run at a steady single amperage where the operator has access and controls of the wire feed speed rate and the welding voltage whereas with MIG pulsed welding the machine runs a peak and a background amperage and the unit will constantly switch between the two amperages enabling the operator to put out a lower overall heat input into the material.
One of the benefits of MIG pulse includes smoother spatter free welding to help prevent blowing through thin material.
When MIG synergic welding is referred to it means that when a single setting is adjusted (voltage or material thickness) the other settings like current or wire speed change automatically.

Please Note:
When in the selection screens (as above) for MIG welding modes, pressing and holding either the bottom left or the bottom right buttons will give you the facility of 'Gas Test' or 'Wire Feed Inch' which are noted in the top line of the display.

MULTIFUNCTIONAL DISPLAY WINDOW - MIG MODE

Welding screen/display explained MU4-1

When selecting either MIG pulse or MIG Synergic mode, the operator has the option to select material, gas and wire size as shown below, this selection is carried out by rotating and pressing the main dial to select the desired option.

Material selection choice is as follows:

- FE - Mild Steel
- Flu.Fe - Flux Cored
- SS - Stainless Steel
- AlMg - Aluminium Magnesium

Gas selection choice is as follows:

- 80% Ar 20%C02
- 100% C02

Wire diameter size selection choice is as follows:

- 0.6mm (0.024)
- 0.8mm (0.032)
- 0.9mm (0.035)
- 1.0mm (0.039)

At this point the bar along to bottom of the screen does show the operator welding mode, material, gas and wire size that have selected.

Once you have selected the key welding setup parameters as shown above, you will now enter the main welding screen that displays centrally your chosen MIG process, material, gas and wire size.

As the above screens show, the left circular section offers either current or wire feed setting and the right section shows voltage/arc length and these options can vary depending on which MIG process has been selected.
The bottom row shows, material thickness, torch trigger mode and inductance control and to adjust each setting, simply press the control dial until the parameter you wish to adjust is highlighted in red and then rotate the dial to adjust said parameter, pressing the control dial again stores that parameter setting.

When in Pulse MIG you have an additional feature called ‘Wire retract’ which is only effective when welding aluminum material. When ‘Wire Retract’ is set it ON (see page 18), at arc starting the welding wire will briefly retract when first touching the work piece and the initial start current is lowered to enhance weld starting properties. When set to OFF the ’Wire Retract’ feature will not be active.

MULTIFUNCTIONAL DISPLAY WINDOW - MIG MODE

Welding screen/display explained MU4-1

When selecting MIG manual, you will be taken directly to the welding screen shown left.
Now the left circular section offers just wire feed speed control and the right section shows voltage control, while the bottom row shows torch trigger mode and inductance control.
Again, to adjust each setting, simply press the control dial until the parameter you wish to adjust is highlighted in red and then rotate the dial to adjust said parameter, pressing the control dial again stores that parameter setting.

However depending on which MIG mode you have selected, further welding parameters are available and adjustable by following the next steps.
The selection and setting of advanced welding parameters can be carried out in the welding interface screen by pressing the bottom right button to enter the welding parameter setting interface.
In this welding parameter setting interface, press the control dial to select the parameter as required and rotate the dial to set a value for the selected parameter.

You will note from the above images that the selected parameter being adjusted is Pre-Flow Gas and the bottom bar shows the min setting (0.0) and the max setting of (20) seconds with the lines between going up/down depending where you set the adjustment rotating dial.

Depending on welding process and torch trigger selection, welding parameters options available	Unit	Welding parameters range available by rotating the dial
Pre-flow	Seconds	0 ~ 20
Slow feed	Mm/min	0 ~ 10
Start current	%	1 ~ 200
Start current (arc length)	A	-10 ~ +10 (Pulse mode only)
Up Slope	Seconds	0.0 ~ 20.0
Welding Current Range	A	25 ~ 110 (110V) / 25 ~ 200（230V）
Down Slope	Seconds	0 ~ 20
End Amp (current)	%	1 ~ 200
Final current (arc length)	-	-10 ~ +10 (Pulse mode only)
Burn Back	Seconds	0 ~ 10
Post-flow	Seconds	0 ~ 20
Wire Retract	-	ON or OFF

Please Note:

- The above listed parameter options do change depending on which welding process and torch trigger mode you have selected.
- When in S2t and S4t trigger modes, the MIG Pulse and Synergic adjustable settings (as shown above) will offer additional changeable parameter that can be adjusted to suit the operator preferences.

MULTIFUNCTIONAL DISPLAY WINDOW - MIG MODE

Welding screen/display explained MU4-1

When selecting MIG mode you can select various trigger modes noted within the red circles below. Navigate to and highlight the lower bar central option (as circled below) as shown as 4T trigger mode.

Depending on which welding mode you are in, will determine which options you can select.

As with previous pages, to select a different trigger option, press the control dial until the 4T trigger (as in the case the above images show) is highlighted red and then rotate the dial to select with trigger option you require, pressing the control dial again stores that parameter selection.

2T: normal trigger control
In this mode the torch trigger must remain depressed for the welding output to stay active.
Press and hold the torch trigger to activate the power source (weld) then release the torch trigger to stop the welding process.

4T: latch trigger control
4T (latch) mode is mainly used for long welding runs to reduce operator finger fatigue. In this mode the operator can press the torch trigger, start the weld process and then release the torch trigger and welding will remain active.
To stop welding, the trigger switch must again be depressed and released. This function eliminates the need for the operator to hold the torch trigger.

Spot weld mode
When spot is selected, this offers the operator a pre-determined time for the weld time to be active. Once selected, to adjust the spot weld time you must first access the advanced parameter feature screen (by pressing bottom right control button when in the above screen) then rotate the control knob until the spot icon (top right) is highlighted, then pressing the control knob allows you to adjustment the spot welding time. Spot time is adjustable between 0.5 ~ 20 seconds.

S2t: Special 2T control
Different from normal 2T, you can set 'Start Current Percent' and 'Start Current Time' in S2t mode.
If you press the gun torch, output current will start from the 'Start Current' and become 'Peak Current' after the 'Start Current Time'. This function is useful when welding aluminium.
To access S2t the feature, please see page 9.

S4t: Special 4T control
In S4t mode, you can set 'Start Current Percent' and 'End Current Percent'.
If you press the gun torch first time, output current will start from the 'Start Current'.
Next if you release the gun torch, current will become 'Peak Current', next if you press the gun torch again, current will become 'End Current'.
To access S4t feature, please see page 9.

Please Note: The Wire Retract function works in S2t and S4t mode (see page 8 for further details)

MULTIFUNCTIONAL DISPLAY WINDOW - TIG MODE

Welding screen/display explained MU4-1

Upon powering ON your MU4-1 and boot up is complete, the control panels main menu will appear on the digital panel as shown above.
You can now navigate yourself through the various options and welding modes which include: Settings, MIG Pulse, MIG Synergic, MIG Manual, Lift TIG, HF TIG, Smart TIG and MMA.

In the home screen, for TIG welding the following options are available:

LIFT TIG

HF TIG

SMART TIG

By rotating the main centre control dial you will 'scroll' through the options and by pressing the dial you will enter either Lift TIG, HF TIG or Smart TIG.
Once you have selected either of the above TIG options you will then be able to navigate further options of DC, AC along with various AC waveforms, Pulse, slope, 2T/4T and many more.
The following pages will explain this in a little more details.

MULTIFUNCTIONAL DISPLAY WINDOW - TIG MODE

Welding screen/display explained MU4-1

When selecting LIFT TIG or HF TIG, you will be taken directly to the welding screen shown below.

Note that the left circular section offers TIG welding current control and the right section shows TIG voltage, while the bottom row shows Pulse, torch trigger mode and DC/AC output selection.
Again, to adjust each setting, simply press the control dial until the parameter you wish to adjust is highlighted in red and then rotate the dial to adjust said parameter, pressing the control dial again stores that parameter setting.

However, when selecting Smart TIG Mode which gives the operator the options to select: Material, Joint Type and Material Thickness as shown below, this selection is carried out by rotating and pressing the main dial to select the desired option.

Material type selection choice is as follows:
- FE - Mild Steel
- SS - Stainless Steel
- Al - Aluminium

Joint Type choice is as follows:
- Butt Joint
- Fillet Joint
- Lap Joint

Material thickness selection choice is as follows:
- 1.0mm (0.039in)
- 1.5mm (0.059in)
- 2.0mm (0.079in)
- 2.5mm (0.098in)
- 3.0mm (0.119)

At this point the bar along to bottom of the screen will update showing the operator material, welding joint and material thickness selected and once the 3rd option is selected you will switch to the screen shown right.

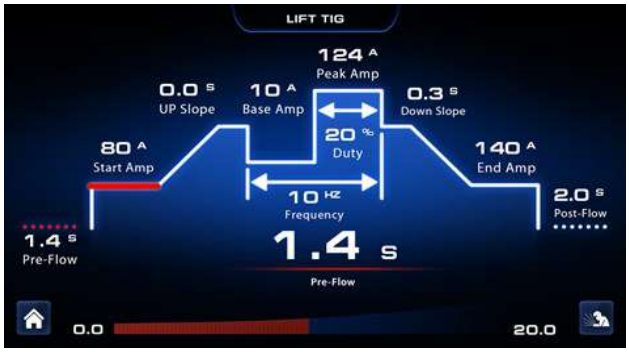
Within this screen, the left circular section offers TIG welding current control and the right section shows TIG voltage, while the bottom row (left to right) shows Tungsten size, gas mix with recommended gas flow rate, 2T torch trigger mode, recommended filler wire size, DC output and pulse being OFF.
To adjust each setting, press the control dial until the parameter you wish to adjust is highlighted in red, then rotate the dial to adjust said parameter, pressing the control dial again stores that parameter setting.

MULTIFUNCTIONAL DISPLAY WINDOW - TIG MODE

Welding screen/display explained MU4-1

Whether you have previously selected LIFT TIG, HF TIG or Smart TIG, the selection and setting of advanced welding parameters can be carried out in the welding interface screen by pressing the right button to enter the welding parameter setting interface.

In this welding parameter setting interface, pressing the control dial will select the various parameter in turn and once the required parameter is highlighted in red, rotate the dial to set a value for the selected parameter.



You will note from the image right that the selected parameter being adjusted is Start Amps and you will also note that the bottom bar shows the minimum setting (0.0) and a maximum setting of (200) amps with the variable red bar between going up/down depending where you set the adjustment rotating dial.

Additional TIG features

As with the above, whether you have selected LIFT TIG, HF TIG or Smart TIG, AC or DC, the option of further advanced welding parameters are possible, the following parameters which can be accessed via the welding interface screen by pressing the bottom right button to enter the welding parameter setting interface screen.

In this welding parameter setting interface, pressing the control dial will select the various parameter in turn and once the required parameter is highlighted in red, rotate the dial to set a value for the selected parameter.

Depending on welding process and torch trigger selection, welding parameters options available	Unit	Welding parameters range available by rotating the dial
Pre-flow	Seconds	0 ~ 20
Start current	A	1 ~ 200
Up Slope	Seconds	0 ~ 20
Down Slope	Seconds	0 ~ 20
End current	A	1 ~ 200
Post-flow	Seconds	0 ~ 20
Duty	%	5 ~ 95
Frequency	Hz	0.5 ~ 999
Balance	-	-5 ~ +5
AC Frequency	Hz	50 ~ 250
Base Amps	A	10 ~ 200
Spot Time	S	0.1 ~ 10
Tungsten size choice	mm	1 ~ 4
Q Start (DC TIG only)	S	0 ~ 60
Dynamic Arc (DC TIG only)	A	0 ~ 50
Multitack (DC TIG only)	Hz	0 ~ 6
Extra Fusion (AC TIG only)	%	0 ~ 80
Mix AC/DC (AC TIG only)	%	0 ~ 80

Please Note: The listed advanced parameter options do change depending on which welding process and torch trigger mode you have selected and the below shows the parameters adjustable range.

MULTIFUNCTIONAL DISPLAY WINDOW - TIG MODE

Welding screen/display explained MU4-1

Depending on which welding mode you are in, will determine which options you can select.

As with previous pages, to select a different trigger option, press the control dial until the 2T tigger mode (shown in the image right) is highlighted red and then rotate the dial to select with trigger option you require, pressing the control dial again stores that parameter selection.

2T: normal trigger control
In this mode the TIG torch trigger must remain depressed for the welding output to stay active.
Press and hold the torch trigger to activate the power source (weld) then release the torch trigger to stop the welding process.

4T: latch trigger control
4T (latch) mode is mainly used for long welding runs to reduce operator finger fatigue. In this mode the operator can press the TIG torch trigger, start the weld process and then release the torch trigger and welding will remain active.
To stop welding, the trigger switch must again be depressed and released.
This function eliminates the need for the operator to hold the torch trigger.

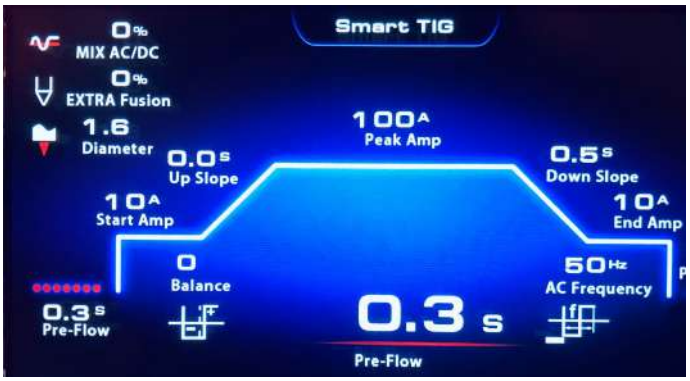
Repeat Trigger Mode
The repeat function is operated during the down slope cycle of the Slope Sequence and is active through the down slope period only. During the down slope period by opening the TIG torch Switch the current will increase back to weld current. Within the Down Slope period the repeat function can be operated as many times as required.
To continue slope cycle and end slope sequence keep the torch switch pressed and allow weld current to reach final current setting.
Once final current setting is reached depressing the TIG torch switch again will turn OFF the welding arc and post flow begins.

Spot weld mode
When spot is selected, this offers the operator a pre-determined time for the weld time to be active.
Once selected, to adjust the spot weld time you must first access the advanced parameter feature screen (by pressing the bottom right control button when in the above screen) then rotate the control knob until the spot icon (top right) is highlighted, then pressing the control knob allows you to adjustment the spot welding time.
Spot time is adjustable between 0.1 ~ 10 seconds.

MULTIFUNCTIONAL DISPLAY WINDOW - TIG MODE

Welding screen/display explained MU4-1

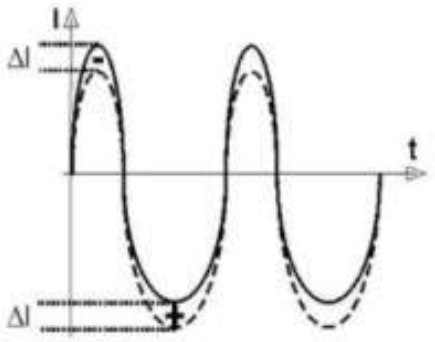
Additional TIG features continued



MIX AC/DC
AC wave in AC/DC, this parameter serves to set the AC wave percentage with respect to the DC current output.

The consequences of a higher value:
- Greater weld penetration.
- Less deformation.
- Faster creation of the weld pool.
- Reduced cleanliness of the workpiece.

EXTRA Fusion
This parameter establishes the percentage of the positive current wave (pickling) that is subtracted and added to the negative current (fusion).
The image right shows the positive wave interval AI that, if subtracted and added to the negative wave, forms the new form of broken line wave.



The consequences of a higher value:
- Tighter arc.
- Greater weld penetration.
- Reduced pickling.
- Loss of arc.
- Less deformation of the electrode.

Q-Start
This parameter allows the unit to start in synergic pulsed TIG mode for the preset time interval, before switching automatically to the welding Mode parameters already selected on the interface panel.
The Q-start parameter creates a weld pool faster with respect to the standard starting procedure.
This parameter is useful when spot welding thin gauge material.

Dynamic ARC
Welding power remains constant even when the distance between electrode and workpiece changes, the consequences of a higher value are:

- The welding arc concentration remains unchanged.
- Prevents electrode sticking.
- Thin workpieces may become deformed more easily.

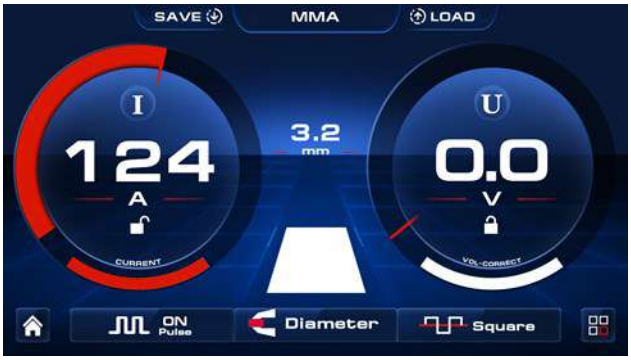
Multitrack
This parameter allows thin gauge sheet to be welded without deformation, the consequences of a higher value:

- Welding of thinner gauge sheet without deformation.
- Less melting of material, slower welding process.

MULTIFUNCTIONAL DISPLAY WINDOW - MMA MODE

Welding screen/display explained MU4-1

Upon powering ON your MU4-1 and boot up is complete, the control panels main menu will appear on the digital panel as shown above, rotate the control dial until the MMA welding option is center and then press the dial to access this welding mode.



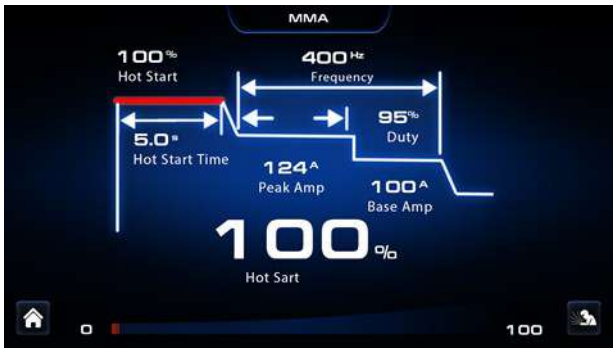
In the image right you can see how the MMA screen setup, the left dial is the preset welding amperage and in the right dial shows the associated welding voltage and in the centre it shows the selected MMA electrode size (3.2mm in this case).
The bottom row shows MMA pulse ON/OFF, welding electrode diameter and choosing between DC or AC welding output.

From this screen you can also select and control advanced MMA welding parameters via the icon  by pressing the right button to enter the welding parameter setting interface.

The following page will explain this in a little more detail.

MULTIFUNCTIONAL DISPLAY WINDOW - MMA MODE

Welding screen/display explained MU4-1



MMA Welding parameter adjustments

The image to the right shows the process flow of MMA welding, Hot Start current with hot start time, if AC is selected then AC frequency and AC duty is adjustable as shown as well as other parameters.

You will note from the image right that the selected parameter being adjusted is Hot Start and you will also note that the bottom bar shows the minimum setting (0) and the maximum setting of (100) % with the variable red bar between going up/down depending where you set the adjustment rotating dial.

In this welding MMA parameter setting interface, pressing the control dial will select the various parameter in turn and once the required parameter is highlighted in red, rotate the dial to set a value for the selected parameter.

Please Note:

The above shown advanced parameter screen options and the listed below do change depending on whether AC or DC have been selected along with pulse being ON or OFF.

The chart below shows some of the parameters available and there adjustable range.

Accessible welding parameters	Unit	Parameters range
Hot start	%	0 ~ 100
Hot start time	Seconds	0.5 ~ 5.0
Arc force	A	0 ~ 100
Duty	%	5 ~ 95
Frequency	Hz	0.5 ~ 400
Peak Amp	A	10 ~ 110 (110V input) 10 ~ 200 (230V input)
Base Amp	A	10 ~ 110 (110V input) 10 ~ 200 (230V input)

VRD

Voltage Reduction Device is an in-built electrical circuit which is used in the MMA mode to reduce the OCV to a safe voltage of less than 13V when the machine is in idle.

Activating VRD

Press and hold together for approx. 3 seconds buttons A and C, then release. You will then be taken to the 'hidden' VRD screen that allows you to turn VRD ON or OFF by rotating the control dial clockwise or anti clockwise to turn VRD ON or OFF.

Upon selecting your required status, press button A which will save the VRD setting and return you to the MMA welding mode screen.

Upon returning to the MMA screen you will now note that the U (OCV) voltage is now under 13V and located centrally it states that VRD is ON (as shown left).

MULTIFUNCTIONAL DISPLAY WINDOW - SETTINGS

Welding screen/display explained MU4-1

The ‘Settings’ parameter adjustment section can be accessed by rotating the control dial (B) until the settings icon is front and centre (as image right shows) then press to enter the setting interface which is shown below.

The settings page is divided into two sections ‘general’ and ‘machine’ and to switch between these two tabs simply press button ’C’ and the tab selected will be highlighted in red.

Within the general tab you can rotate the control dial ‘C’ which will scroll the operator through the options of Languages, Brightness, Beeper, Unit, Information, Factory Reset and Program Update and when you press the control dial you will access the chosen option, in the above image case you can see that the ‘General’ tab and then the ‘Language’ tab is selected.
You can now select further language options (if available) by rotating the control dial again and pressing the control dial ‘C’ to confirm your selection.

Pressing the button ’A’ will take you back to the main menu.

Options	Welding parameters available by press the control dial	Welding parameters available by rotating the control dial
General	Languages	English (other languages are available by request)
	Screen Brightness	Adjustable between 1 - 10
	Beeper	ON or OFF
	Unit	Metric or Imperial
	Information	Version details
	Factory Reset	Restoring to factory setting
	Program Update	Updating program (USB port)
Machine	Fan	Normal (Permanently on) Smart (Fan on demand)
	Wireless Control	Connecting a Wireless Remote or Wireless Control
	Wire Retract	ON or OFF (see page 9)
	Remote control	Off or Remote

NOTES

WELD STAR | INFINIUM

Wilkinson Star Limited
Shield Drive
Wardley Industrial Estate
Worsley
Manchester
M28 2WD

+44(0)161 793 8127

wilkinsonstar247.com

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