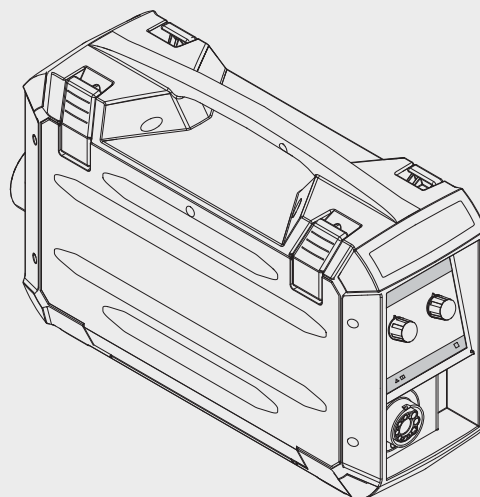


**WF 25i Case D200**  
**WF 25i Case D300**

EN

Operating instructions

Wire-feed unit



42,0426,0187,EN 017-14092020



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# Safety rules

## Explanation of safety notices

### **DANGER!**

Indicates **immediate danger**.

- ▶ If not avoided, death or serious injury will result.

### **WARNING!**

Indicates a **potentially hazardous situation**.

- ▶ If not avoided, death or serious injury may result.

### **CAUTION!**

Indicates a **situation where damage or injury could occur**.

- ▶ If not avoided, minor injury and/or damage to property may result.

### **NOTE!**

Indicates a **risk of flawed results and possible damage to the equipment**.

## General

The device is manufactured using state-of-the-art technology and according to recognised safety standards. If used incorrectly or misused, however, it can cause:

- injury or death to the operator or a third party,
- damage to the device and other material assets belonging to the operating company,
- inefficient operation of the device.

All persons involved in commissioning, operating, maintaining and servicing the device must:

- be suitably qualified,
- have sufficient knowledge of welding and
- read and follow these operating instructions carefully.

The operating instructions must always be at hand wherever the device is being used. In addition to the operating instructions, attention must also be paid to any generally applicable and local regulations regarding accident prevention and environmental protection.

All safety and danger notices on the device

- must be in a legible state,
- must not be damaged,
- must not be removed,
- must not be covered, pasted or painted over.

For the location of the safety and danger notices on the device, refer to the section headed "General" in the operating instructions for the device.

Before switching on the device, rectify any faults that could compromise safety.

**This is for your personal safety!**

## Proper use

The device is to be used exclusively for its intended purpose.

The device is intended solely for the welding processes specified on the rating plate. Any use above and beyond this purpose is deemed improper. The manufacturer shall not be held liable for any damage arising from such usage.

---

Proper use includes:

- carefully reading and following all the instructions given in the operating instructions
  - studying and obeying all safety and danger notices carefully
  - performing all stipulated inspection and maintenance work.
- 

Never use the device for the following purposes:

- Thawing out pipes
  - Charging batteries
  - Starting engines
- 

The device is designed for use in industry and the workshop. The manufacturer accepts no responsibility for any damage caused through use in a domestic setting.

---

The manufacturer likewise accepts no liability for inadequate or incorrect results.

---

### **Environmental conditions**

Operation or storage of the device outside the stipulated area will be deemed as not in accordance with the intended purpose. The manufacturer shall not be held liable for any damage arising from such usage.

---

Ambient temperature range:

- during operation: -10 °C to + 40 °C (14 °F to 104 °F)
  - during transport and storage: -20 °C to +55 °C (-4 °F to 131 °F)
- 

Relative humidity:

- up to 50% at 40 °C (104 °F)
  - up to 90% at 20 °C (68 °F)
- 

The surrounding air must be free from dust, acids, corrosive gases or substances, etc. Can be used at altitudes of up to 2000 m (6561 ft. 8.16 in.)

---

### **Obligations of the operator**

The operator must only allow persons to work with the device who:

- are familiar with the fundamental instructions regarding safety at work and accident prevention and have been instructed in how to use the device
  - have read and understood these operating instructions, especially the section "safety rules", and have confirmed as much with their signatures
  - are trained to produce the required results.
- 

Checks must be carried out at regular intervals to ensure that operators are working in a safety-conscious manner.

---

### **Obligations of personnel**

Before using the device, all persons instructed to do so undertake:

- to observe the basic instructions regarding safety at work and accident prevention
  - to read these operating instructions, especially the "Safety rules" section and sign to confirm that they have understood them and will follow them.
- 

Before leaving the workplace, ensure that people or property cannot come to any harm in your absence.

---

### **Mains connection**

Devices with a higher rating may affect the energy quality of the mains due to their current consumption.

---

This may affect a number device types in terms of:

- Connection restrictions
- Criteria with regard to the maximum permissible mains impedance <sup>\*)</sup>
- Criteria with regard to the minimum short-circuit power requirement <sup>\*)</sup>

<sup>\*)</sup> at the interface with the public grid  
see "Technical data"

---

In this case, the plant operator or the person using the device should check whether the device may be connected, where appropriate by discussing the matter with the power supply company.

---

**IMPORTANT!** Ensure that the mains connection is earthed properly

---

### Protecting yourself and others

Anyone working with the device exposes themselves to numerous risks, e.g.

- flying sparks and hot pieces of metal
- Arc radiation, which can damage eyes and skin
- Hazardous electromagnetic fields, which can endanger the lives of those using cardiac pacemakers
- Risk of electrocution from mains current and welding current
- Greater noise pollution
- Harmful welding fumes and gases

---

Suitable protective clothing must be worn when working with the device. The protective clothing must have the following properties:

- Flame-resistant
- Insulating and dry
- Covers the whole body, is undamaged and in good condition
- Safety helmet
- Trousers with no turn-ups

---

Protective clothing refers to a variety of different items. Operators should:

- Protect eyes and face from UV rays, heat and sparks using a protective visor and regulation filter
- Wear regulation protective goggles with side protection behind the protective visor
- Wear stout footwear that provides insulation even in wet conditions
- Protect the hands with suitable gloves (electrically insulated and providing protection against heat)
- Wear ear protection to reduce the harmful effects of noise and to prevent injury

---

Keep all persons, especially children, out of the working area while any devices are in operation or welding is in progress. If, however, there are people in the vicinity:

- Make them aware of all the dangers (risk of dazzling by the arc, injury from flying sparks, harmful welding fumes, noise, possible risks from mains current and welding current, etc.)
- Provide suitable protective equipment
- Alternatively, erect suitable safety screens/curtains.

---

### Danger from toxic gases and vapours

The fumes produced during welding contain harmful gases and vapours.

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Welding fumes contain substances that cause cancer, as stated in Monograph 118 of the International Agency for Research on Cancer.

---

Use at-source extraction and a room extraction system.

If necessary, use a welding torch with an integrated extraction device.

---

Keep your face away from welding fumes and gases.

---

Fumes and hazardous gases

- must not be breathed in
- must be extracted from the working area using appropriate methods.

---

Ensure an adequate supply of fresh air. Ensure that there is a ventilation rate of at least 20 m<sup>3</sup> per hour at all times.

---

Otherwise, a welding helmet with an air supply must be worn.

---

If there is any doubt about whether the extraction capacity is sufficient, the measured toxic emission values should be compared with the permissible limit values.

---

The following components are responsible, amongst other things, for the degree of toxicity of welding fumes:

- Metals used for the workpiece
- Electrodes
- Coatings
- Cleaners, degreasers, etc.
- Welding process used

---

The relevant material safety data sheets and manufacturer's specifications for the listed components should therefore be studied carefully.

---

Recommendations for trade fair scenarios, risk management measures and for identifying working conditions can be found on the European Welding Association website under Health & Safety (<https://european-welding.org>).

---

Flammable vapours (e.g. solvent fumes) should be kept away from the arc's radiation area.

---

Close the shielding gas cylinder valve or main gas supply if no welding is taking place.

---

---

### **Danger from flying sparks**

Flying sparks may cause fires or explosions.

---

Never weld close to flammable materials.

---

Flammable materials must be at least 11 metres (36 ft. 1.07 in.) away from the arc, or alternatively covered with an approved cover.

---

A suitable, tested fire extinguisher must be available and ready for use.

---

Sparks and pieces of hot metal may also get into adjacent areas through small gaps or openings. Take appropriate precautions to prevent any danger of injury or fire.

---

Welding must not be performed in areas that are subject to fire or explosion or near sealed tanks, vessels or pipes unless these have been prepared in accordance with the relevant national and international standards.

---

Do not carry out welding on containers that are being or have been used to store gases, propellants, mineral oils or similar products. Residues pose an explosive hazard.

---

---

### **Risks from mains current and welding current**

An electric shock is potentially life threatening and can be fatal.

---

Do not touch live parts either inside or outside the device.

---

During MIG/MAG welding and TIG welding, the welding wire, the wirespool, the feed rollers and all pieces of metal that are in contact with the welding wire are live.

---

Always set the wirefeeder up on a sufficiently insulated surface or use a suitable, insulated wirefeeder holder.

---



Make sure that you and others are protected with an adequately insulated, dry base or cover for the earth or ground potential. This base or cover must extend over the entire area between the body and the earth or ground potential.

All cables and leads must be secured, undamaged, insulated and adequately dimensioned. Replace loose connections and scorched, damaged, or inadequately dimensioned cables and leads immediately.

Use the handle to ensure the power connections are tight before every use.

In the case of power cables with a bayonet connector, rotate the power cable around the longitudinal axis by at least 180° and pretension.

Do not wrap cables or leads around the body or parts of the body.

The electrode (rod electrode, tungsten electrode, welding wire, etc.) must

- never be immersed in liquid for cooling
- Never touch the electrode when the power source is switched on.

Double the open circuit voltage of a power source can occur between the welding electrodes of two power sources. Touching the potentials of both electrodes at the same time may be fatal under certain circumstances.

Arrange for the mains cable to be checked regularly by a qualified electrician to ensure the ground conductor is functioning properly.

Protection class I devices require a mains supply with ground conductor and a connector system with ground conductor contact for proper operation.

Operation of the device on a mains supply without ground conductor and on a socket without ground conductor contact is only permitted if all national regulations for protective separation are observed.

Otherwise, this is considered gross negligence. The manufacturer shall not be held liable for any damage arising from such usage.

If necessary, provide adequate earthing for the workpiece.

Switch off unused devices.

Wear a safety harness if working at height.

Before working on the device, switch it off and pull out the mains plug.

Attach a clearly legible and easy-to-understand warning sign to the device to prevent anyone from plugging the mains plug back in and switching it on again.

After opening the device:

- Discharge all live components
- Ensure that all components in the device are de-energised.

If work on live parts is required, appoint a second person to switch off the main switch at the right moment.

### **Meandering welding currents**

If the following instructions are ignored, meandering welding currents can develop with the following consequences:

- Fire hazard
- Overheating of parts connected to the workpiece
- Irreparable damage to ground conductors
- Damage to device and other electrical equipment

Ensure that the workpiece is held securely by the workpiece clamp.

Attach the workpiece clamp as close as possible to the area that is to be welded.

Position the device with sufficient insulation against electrically conductive environments, e.g. Insulation against conductive floor or insulation to conductive racks.

---

If distribution boards, twin-head mounts, etc., are being used, note the following: The electrode of the welding torch / electrode holder that is not used is also live. Make sure that the welding torch / electrode holder that is not used is kept sufficiently insulated.

---

In the case of automated MIG/MAG applications, ensure that only an insulated wire electrode is routed from the welding wire drum, large wirefeeder spool or wirepool to the wirefeeder.

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---

### **EMC Device Classifications**

Devices in emission class A:

- Are only designed for use in industrial settings
  - Can cause line-bound and radiated interference in other areas
- 

Devices in emission class B:

- Satisfy the emissions criteria for residential and industrial areas. This is also true for residential areas in which the energy is supplied from the public low-voltage mains.
- 

EMC device classification as per the rating plate or technical data.

---

### **EMC measures**

In certain cases, even though a device complies with the standard limit values for emissions, it may affect the application area for which it was designed (e.g. when there is sensitive equipment at the same location, or if the site where the device is installed is close to either radio or television receivers).

If this is the case, then the operator is obliged to take appropriate action to rectify the situation.

---

Check and evaluate the immunity to interference of nearby devices according to national and international regulations. Examples of equipment that may be susceptible to interference from the device include:

- Safety devices
  - Power, signal and data transfer lines
  - IT and telecommunications devices
  - Measuring and calibrating devices
- 

Supporting measures for avoidance of EMC problems:

1. Mains supply
  - If electromagnetic interference arises despite correct mains connection, additional measures are necessary (e.g. use a suitable line filter).
2. Welding power leads
  - must be kept as short as possible
  - must run close together (to avoid EMF problems)
  - must be kept well apart from other leads
3. Equipotential bonding
4. Earthing of the workpiece
  - If necessary, establish an earth connection using suitable capacitors.
5. Shielding, if necessary
  - Shield off other nearby devices
  - Shield off entire welding installation

**EMF measures**

Electromagnetic fields may pose as yet unknown risks to health:

- effects on the health of others in the vicinity, e.g. wearers of pacemakers and hearing aids
- wearers of pacemakers must seek advice from their doctor before approaching the device or any welding that is in progress
- for safety reasons, keep distances between the welding cables and the welder's head/torso as large as possible
- do not carry welding cables and hosepacks over the shoulders or wind them around any part of the body

**Specific hazards**

Keep hands, hair, clothing and tools away from moving parts. For example:

- Fans
- Cogs
- Rollers
- Shafts
- Wirespools and welding wires

---

Do not reach into the rotating cogs of the wire drive or into rotating drive components.

---

Covers and side panels may only be opened/removed while maintenance or repair work is being carried out.

---

During operation

- Ensure that all covers are closed and all side panels are fitted properly.
  - Keep all covers and side panels closed.
- 

The welding wire emerging from the welding torch poses a high risk of injury (piercing of the hand, injuries to the face and eyes, etc.).

---

Therefore always keep the welding torch away from the body (devices with wire-feed unit) and wear suitable protective goggles.

---

Never touch the workpiece during or after welding - risk of burns.

---

Slag can jump off cooling workpieces. The specified protective equipment must therefore also be worn when reworking workpieces, and steps must be taken to ensure that other people are also adequately protected.

---

Welding torches and other parts with a high operating temperature must be allowed to cool down before handling.

---

Special provisions apply in areas at risk of fire or explosion - observe relevant national and international regulations.

---

Power sources that are to be used in areas with increased electric risk (e.g. near boilers) must carry the "Safety" sign. However, the power source must not be located in such areas.

---

Risk of scalding from escaping coolant. Switch off cooling unit before disconnecting coolant flow or return lines.

---

Observe the information on the coolant safety data sheet when handling coolant. The coolant safety data sheet may be obtained from your service centre or downloaded from the manufacturer's website.

---

Use only suitable load-carrying equipment supplied by the manufacturer when transporting devices by crane.

- Hook chains and/or ropes onto all suspension points provided on the load-carrying equipment.
- Chains and ropes must be at the smallest angle possible to the vertical.
- Remove gas cylinder and wire-feed unit (MIG/MAG and TIG devices).

---

If the wire-feed unit is attached to a crane holder during welding, always use a suitable, insulated wirefeeder hoisting attachment (MIG/MAG and TIG devices).

---

All lifting accessories (straps, handles, chains, etc.) used in connection with the device or its components must be tested regularly (e.g. for mechanical damage, corrosion or changes caused by other environmental factors).

The testing interval and scope of testing must comply with applicable national standards and directives as a minimum.

---

Odourless and colourless shielding gas may escape unnoticed if an adapter is used for the shielding gas connection. Prior to assembly, seal the device-side thread of the adapter for the shielding gas connection using suitable Teflon tape.

---

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**Requirement for the shielding gas**

Especially with ring lines, contaminated shielding gas can cause damage to equipment and reduce welding quality.

Meet the following requirements regarding shielding gas quality:

- Solid particle size < 40 µm
  - Pressure condensation point < -20 °C
  - Max. oil content < 25 mg/m<sup>3</sup>
- 

Use filters if necessary.

---

---

**Danger from shielding gas cylinders**

Shielding gas cylinders contain gas under pressure and can explode if damaged. As the shielding gas cylinders are part of the welding equipment, they must be handled with the greatest of care.

---

Protect shielding gas cylinders containing compressed gas from excessive heat, mechanical impact, slag, naked flames, sparks and arcs.

---

Mount the shielding gas cylinders vertically and secure according to instructions to prevent them falling over.

---

Keep the shielding gas cylinders well away from any welding or other electrical circuits.

---

Never hang a welding torch on a shielding gas cylinder.

---

Never touch a shielding gas cylinder with an electrode.

---

Risk of explosion - never attempt to weld a pressurised shielding gas cylinder.

---

Only use shielding gas cylinders suitable for the application in hand, along with the correct and appropriate accessories (regulator, hoses and fittings). Only use shielding gas cylinders and accessories that are in good condition.

---

Turn your face to one side when opening the valve of a shielding gas cylinder.

---

Close the shielding gas cylinder valve if no welding is taking place.

---

If the shielding gas cylinder is not connected, leave the valve cap in place on the cylinder.

---

The manufacturer's instructions must be observed as well as applicable national and international regulations for shielding gas cylinders and accessories.

---

---

**Danger from escaping shielding gas**

Risk of suffocation from the uncontrolled escape of shielding gas

---

Shielding gas is colourless and odourless and, in the event of a leak, can displace the oxygen in the ambient air.

---

- Ensure an adequate supply of fresh air with a ventilation rate of at least 20 m<sup>3</sup>/hour.
- Observe safety and maintenance instructions on the shielding gas cylinder or the main gas supply.
- Close the shielding gas cylinder valve or main gas supply if no welding is taking place.
- Check the shielding gas cylinder or main gas supply for uncontrolled gas leakage before every start-up.

### **Safety measures at the installation location and during transport**

A device toppling over could easily kill someone. Place the device on a solid, level surface such that it remains stable

- The maximum permissible tilt angle is 10°.

Special regulations apply in rooms at risk of fire or explosion

- Observe relevant national and international regulations.

Use internal directives and checks to ensure that the workplace environment is always clean and clearly laid out.

Only set up and operate the device in accordance with the degree of protection shown on the rating plate.

When setting up the device, ensure there is an all-round clearance of 0.5 m (1 ft. 7.69 in.) to ensure that cooling air can flow in and out freely.

When transporting the device, observe the relevant national and local guidelines and accident prevention regulations. This applies especially to guidelines regarding the risks arising during transport.

Do not lift or transport operational devices. Switch off devices before transport or lifting.

Before transporting the device, allow coolant to drain completely and detach the following components:

- Wirefeeder
- Wirespool
- Shielding gas cylinder

After transporting the device, the device must be visually inspected for damage before commissioning. Any damage must be repaired by trained service technicians before commissioning the device.

### **Safety measures in normal operation**

Only operate the device when all safety devices are fully functional. If the safety devices are not fully functional, there is a risk of

- injury or death to the operator or a third party
- damage to the device and other material assets belonging to the operator
- inefficient operation of the device

Any safety devices that are not functioning properly must be repaired before switching on the device.

Never bypass or disable safety devices.

Before switching on the device, ensure that no one is likely to be endangered.

Check the device at least once a week for obvious damage and proper functioning of safety devices.

Always fasten the shielding gas cylinder securely and remove it beforehand if the device is to be transported by crane.

Only the manufacturer's original coolant is suitable for use with our devices due to its properties (electrical conductivity, anti-freeze agent, material compatibility, flammability, etc.).

---

Only use suitable original coolant from the manufacturer.

---

Do not mix the manufacturer's original coolant with other coolants.

---

Only connect the manufacturer's system components to the cooling circuit.

---

The manufacturer accepts no liability for damage resulting from use of other system components or a different coolant. In addition, all warranty claims will be forfeited.

---

Cooling Liquid FCL 10/20 does not ignite. The ethanol-based coolant can ignite under certain conditions. Transport the coolant only in its original, sealed containers and keep well away from any sources of ignition.

---

Used coolant must be disposed of properly in accordance with the relevant national and international regulations. The coolant safety data sheet may be obtained from your service centre or downloaded from the manufacturer's website.

---

Check the coolant level before starting to weld, while the system is still cool.

---

---

### **Commissioning, maintenance and repair**

It is impossible to guarantee that bought-in parts are designed and manufactured to meet the demands made of them, or that they satisfy safety requirements.

- Use only original spare and wearing parts (also applies to standard parts).
  - Do not carry out any modifications, alterations, etc. to the device without the manufacturer's consent.
  - Components that are not in perfect condition must be replaced immediately.
  - When ordering, please give the exact designation and part number as shown in the spare parts list, as well as the serial number of your device.
- 

The housing screws provide the ground conductor connection for earthing the housing parts.

Only use original housing screws in the correct number and tightened to the specified torque.

---

### **Safety inspection**

The manufacturer recommends that a safety inspection of the device is performed at least once every 12 months.

---

The manufacturer recommends that the power source be calibrated during the same 12-month period.

---

A safety inspection should be carried out by a qualified electrician

- after any changes are made
  - after any additional parts are installed, or after any conversions
  - after repair, care and maintenance has been carried out
  - at least every twelve months.
- 

For safety inspections, follow the appropriate national and international standards and directives.

---

Further details on safety inspection and calibration can be obtained from your service centre. They will provide you on request with any documents you may require.

---

### **Disposal**

Do not dispose of this device with normal domestic waste! To comply with the European Directive on Waste Electrical and Electronic Equipment and its implementation as national law, electrical equipment that has reached the end of its life must be collected

separately and returned to an approved recycling facility. Any device that you no longer require must either be returned to your dealer or given to one of the approved collection and recycling facilities in your area. Ignoring this European Directive may have potentially adverse effects on the environment and your health!

---

**Safety symbols**

Devices with the CE mark satisfy the essential requirements of the low-voltage and electromagnetic compatibility directives (e.g. relevant product standards of the EN 60 974 series).

Fronius International GmbH hereby declares that the device is compliant with Directive 2014/53/EU. The full text on the EU Declaration of Conformity can be found at the following address: <http://www.fronius.com>

---

Devices marked with the CSA test mark satisfy the requirements of the relevant standards for Canada and the USA.

---

**Data protection**

The user is responsible for the safekeeping of any changes made to the factory settings. The manufacturer accepts no liability for any deleted personal settings.

---

**Copyright**

Copyright of these operating instructions remains with the manufacturer.

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The text and illustrations are all technically correct at the time of printing. We reserve the right to make changes. The contents of the operating instructions shall not provide the basis for any claims whatsoever on the part of the purchaser. If you have any suggestions for improvement, or can point out any mistakes that you have found in the instructions, we will be most grateful for your comments.



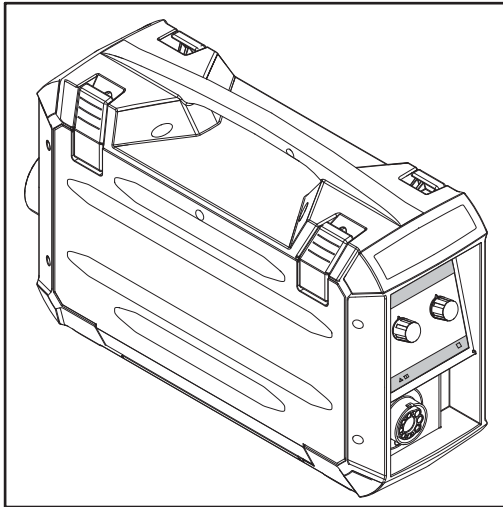


# General



# General

## Device concept



WF 25i Case D200

The WF 25i Case D200 / WF 25i Case D300 wire-feed unit is contained in a fully sealed plastic housing and is suitable for wirepools with max. diameter 200 mm (7.87 in.) / 300 mm (11.81 in.).

The standard 4-roller drive has good wirefeeding properties. The wire-feed unit is also suitable for long hosepacks.

## Warning notices on the device

**NOTE!**

**The wire-feed unit is fitted with safety symbols and a rating plate.**  
The safety symbols and rating plate must not be removed or painted over. The safety symbols warn against operating the equipment incorrectly, as this may result in serious injury and damage.

	1.1	1.2	1.3	3	3.1	3.2	3.3	5	40.0006.3033		

**fronius**

www.fronius.com

Part No.:		Ser.No.:	
IEC 60 974-5/-10 Cl.A			IP 23
=	U <sub>11</sub> 60 V	I <sub>11</sub> 1.2 A	
	U <sub>12</sub> 24 V	I <sub>12</sub> 0.5 A	
%	1 - 25 m/min	40-984 ipm	
	I <sub>2</sub> 360A/100%	450A/60%	500A/40%
CE	CS		

Caution: Parts may be at welding voltage  
Attention: Les pièces peuvent être à la tension de soudage



Do not use the functions described here until you have thoroughly read and understood the following documents:

- these operating instructions
- all the operating instructions for the system components, especially the safety rules



Welding is dangerous. The following basic requirements must be met to ensure the equipment is used properly:

- Welders must be sufficiently qualified
- Suitable protective equipment must be used
- All persons not involved must be kept at a safe distance from the wire-feed unit and the welding process



Do not dispose of used devices with domestic waste. Dispose of them according to the safety rules.



Keep hands, hair, clothing and tools away from moving parts. For example:

- Cogs
- Feed rollers
- Wirespools and wire electrodes

Do not reach into the rotating cogs of the wire drive or into rotating drive components.

Covers and side panels may only be opened/removed while maintenance or repair work is being carried out.

During operation

- Ensure that all covers are closed and all side panels are fitted properly.
  - Keep all covers and side panels closed.
-

**Crane transport**

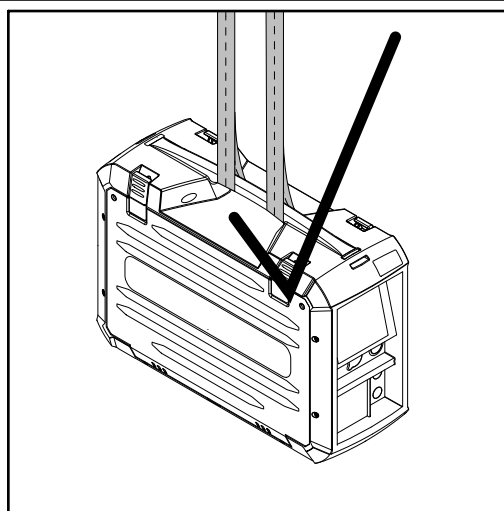
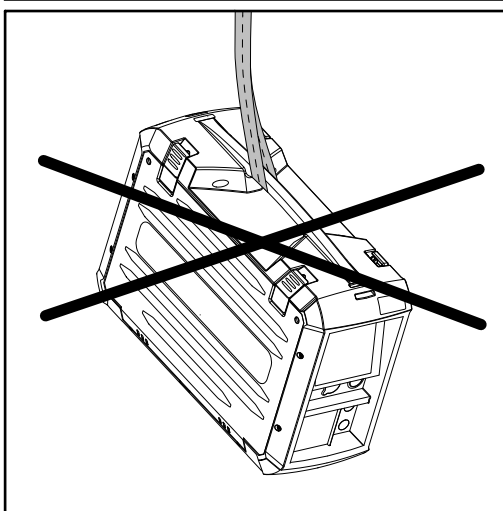
The wirefeeder can be transported by crane using its handle.

The maximum load-bearing capacity of the handle is dependent upon the model:

- D200: 15 kg (33.07 lb.)
- D300: 35 kg (77.16 lb.)

**⚠ WARNING!****Falling equipment can cause death or serious injury.**

- ▶ Only use a suitable lifting tackle when transporting devices by crane (e.g. belt with round slings)
- ▶ The lifting tackle must be undamaged and in perfect condition
- ▶ Always attach the lifting tackle to both ends of the handle - see diagram below
- ▶ Do not transport any other loads by the handle apart from the wirefeeder itself
- ▶ Do not hang from the wirefeeder as it is being transported



Before transporting by crane:

- feed out the wire electrode, remove the wirespool
- disconnect the torch hosepack and interconnecting hosepack from the wirefeeder
- if present, unplug the coolant connections



# **Controls, connections and mechanical components**





# WF 25i Case D200 controls, connections and mechanical components

## Safety



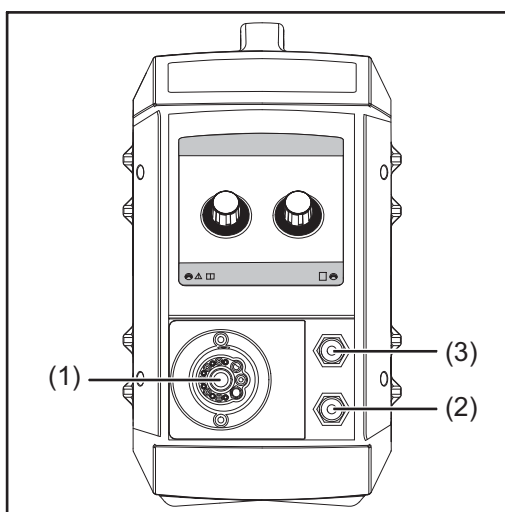
### WARNING!

#### Danger from incorrect operation.

This can result in severe personal injury and damage to property.

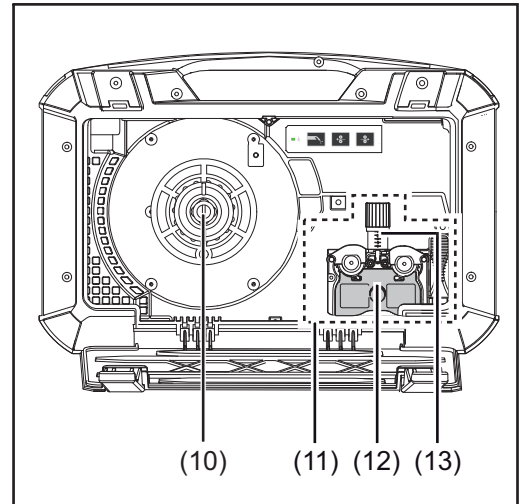
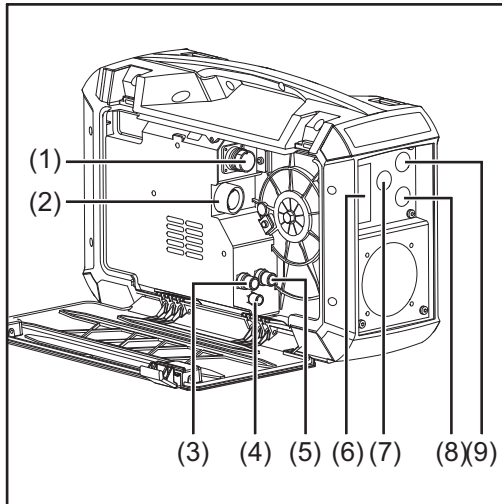
- ▶ All the functions described may only be used by trained and qualified personnel.
- ▶ Fully read and understand this document.
- ▶ Fully read and understand all the Operating Instructions for the system components, especially the safety rules.

## Front of wire-feed unit



- (1) **Welding torch connection**  
for connecting the welding torch
- (2) **Coolant flow connection (blue) - option**  
for connecting the coolant hose from the torch hosepack
- (3) **Coolant return connection (red) - option**  
for connecting the coolant hose from the torch hosepack

**Wire-feed unit  
side**



- 
- (1) **SpeedNet connection**  
for connecting the SpeedNet cable from the interconnecting hosepack
- 
- (2) **(+) - current socket with fine-pitch thread**  
for connecting the power cable from the interconnecting hosepack
- 
- (3) **Coolant return connection (red) - option**  
for connecting the coolant hose from the interconnecting hosepack
- 
- (4) **Shielding gas connection**
- 
- (5) **Coolant flow connection (blue) - option**  
for connecting the coolant hose from the interconnecting hosepack
- 
- (6) **Blanking cover**  
for optional gas flow meter
- 
- (7) **Blanking cover**  
for optional component
- 
- (8) **Blanking cover**  
for optional component
- 
- (9) **Blanking cover**  
for optional component
- 
- (10) **Wirepool holder with brake**  
for holding standard wirepools with a max. diameter of 200 mm (7.87 in.) and max. weight of 5 kg (11.02 lb.)
- 
- (11) **4-roller drive**
- 
- (12) **Protective cover for the 4-roller drive**
- 
- (13) **Clamping lever**  
for setting the contact pressure of the feed rollers
-

# WF 25i Case D300 controls, connections and mechanical components

## Safety

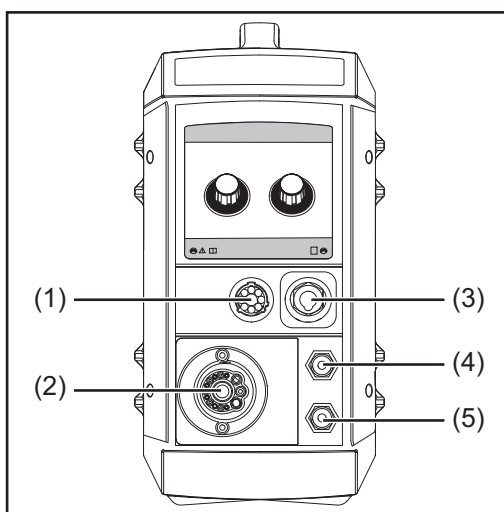
### **WARNING!**

#### **Danger from incorrect operation.**

This can result in severe personal injury and damage to property.

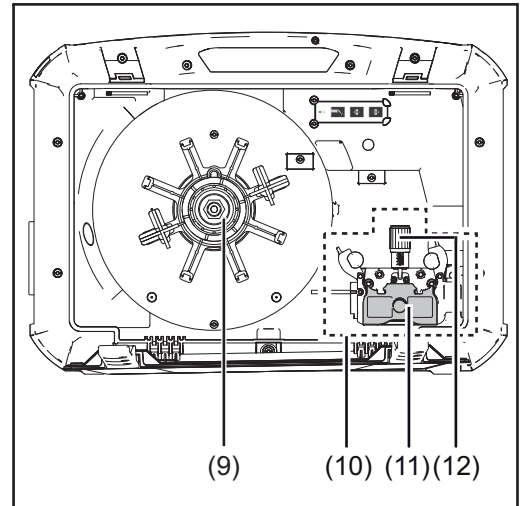
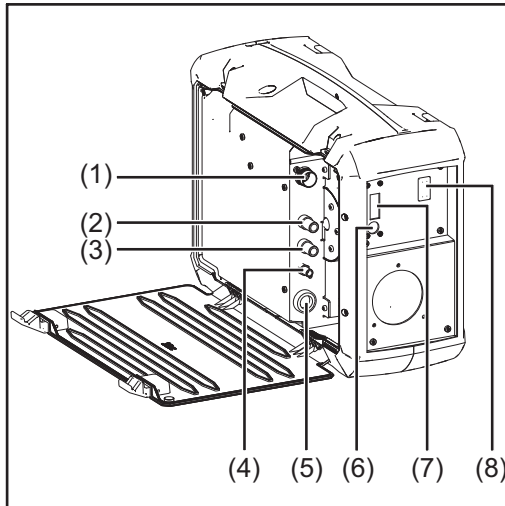
- ▶ All the functions described may only be used by trained and qualified personnel.
- ▶ Fully read and understand this document.
- ▶ Fully read and understand all the Operating Instructions for the system components, especially the safety rules.

## Front of wire-feed unit



- (1) **SpeedNet connection - option**  
for connecting optional components (for example, a remote control)
- (2) **Welding torch connection**  
for connecting the welding torch
- (3) **(+) - current socket with bayonet latch - option**  
for connecting the electrode holder
- (4) **Coolant return connection (red) - option**  
for connecting the coolant hose from the torch hosepack
- (5) **Coolant flow connection (blue) - option**  
for connecting the coolant hose from the torch hosepack

**Wire-feed unit  
side**



- 
- (1) **SpeedNet connection**  
for connecting the SpeedNet cable from the interconnecting hosepack
- 
- (2) **Coolant return connection (red) - option**  
for connecting the coolant hose from the interconnecting hosepack
- 
- (3) **Coolant flow connection (blue) - option**  
for connecting the coolant hose from the interconnecting hosepack
- 
- (4) **Shielding gas connection**
- 
- (5) **(+) - current socket with fine-pitch thread**  
for connecting the power cable from the interconnecting hosepack
- 
- (6) **Blanking cover**  
for optional component
- 
- (7) **Blanking cover**  
for optional component
- 
- (8) **Blanking cover**  
for optional component
- 
- (9) **Wirespool holder with brake**  
for holding standard wirespools with a max. diameter of 300 mm (11.81 in.) and max. weight of 19 kg (41.89 lb.)
- 
- (10) **4-roller drive**
- 
- (11) **Protective cover for the 4-roller drive**
- 
- (12) **Clamping lever**  
for setting the contact pressure of the feed rollers
-

# Optional control panels

## Safety

### **WARNING!**

#### **Danger from incorrect operation.**

This can result in severe personal injury and damage to property.

- ▶ All the functions described may only be used by trained and qualified personnel.
- ▶ Fully read and understand this document.
- ▶ Fully read and understand all the Operating Instructions for the system components, especially the safety rules.

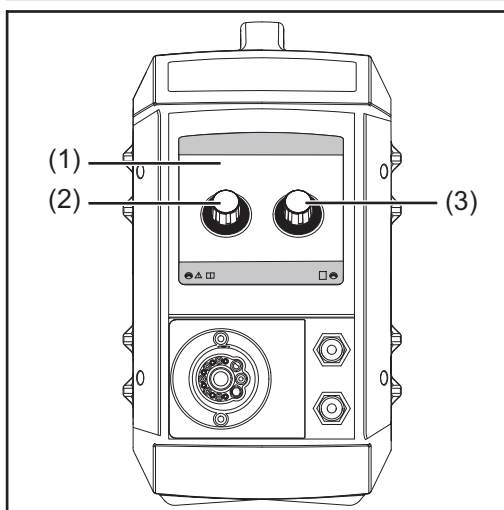
## General

### **NOTE!**

**Optional control panels are available for the WF 25i Case D200 and WF 25i Case D300 wire-feed units.**

The design and position of the control panels are identical for both wire-feed units.

## OPT/i WF POT control panel



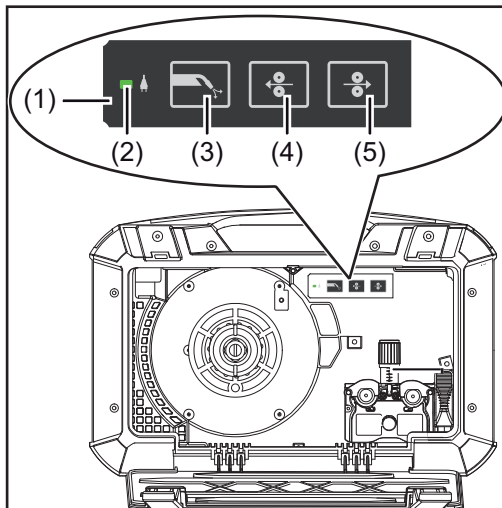
### No. Function

- | No. | Function   |
|-----|--|
| (1) | <b>OPT/i WF POT control panel</b>  |
| (2) | - <b>Setting the welding power</b><br>(during MIG/MAG synergic welding - Standard, Puls, PMC, LSC) |
|     | - <b>Setting the wire feed speed</b><br>(during MIG/MAG standard manual welding)                   |

### No. Function

- |     |   |
|-----|---|
| (3) | - <b>Correcting the arc length</b><br>(during MIG/MAG synergic welding - Standard, Puls, PMC, LSC)<br>- = shorter arc length<br>0 = neutral arc length<br>+ = longer arc length |
|     | - <b>Setting the welding voltage</b><br>(during MIG/MAG standard manual welding)  |

**OPT/i WF gas test & wire threading**



No.	Function
(1)	<b>OPT/i WF gas test &amp; wire threading</b>
(2)	<b>Operating status LED</b> lights green when the device is ready for use
(3)	<b>Gas-test button</b> for setting the required gas flow rate on the pressure regulator - Gas will flow out for 30 s after pressing the gas-test button. Press the button again to stop the gas test flow before the end of this period

No.	Function
-----	----------

(4) **Wire retract button**  
retraction of wire electrode without accompanying flow of gas or current

The wire electrode can be retracted using one of two methods:

**Variant 1**

retracting the wire electrode using the preset wire retract speed:

- Press and hold the wire retract button
- The wire electrode will be retracted 1 mm (0.039 in.) after the wire retract button is pressed
- After a short pause, the wire-feed unit continues to retract the wire electrode. If the wire retract button remains pressed, the speed will increase every second at a rate of 10 m/min (393.70 ipm) until the preset wire retract speed is reached.

**Variant 2**

retracting the wire electrode in 1 mm stages (0.039 in. stages) - always press the wire retract button for less than one second (tap)

**NOTE!**

**Do not allow long lengths of wire electrode to be retracted, as the wire electrode is not wound onto the wirespool when retracted.**

**NOTE!**

**If there was a ground earth connection with the contact tip before the wire retract button was pressed, the wire electrode will be retracted when the button is pressed until it is short-circuit-free - it retracts by no more than 10 mm (0.39 in.) with each press of the button.**

If the wire electrode still needs to be retracted further, press the wire retract button again.

No.	Function
-----	----------

(5)	<b>Wire threading button</b>
-----	------------------------------

to thread the wire electrode into the torch hosepack with no accompanying flow of gas or current

There are two wire threading variants available:

#### Variant 1

threading the wire electrode using the preset feeder inching speed:

- Press and hold the wire threading button.
- The wire electrode will be threaded 1 mm (0.039 in.) after the wire threading button is pressed.
- After a short pause, the wire-feed unit continues to thread the wire electrode. If the wire threading button remains pressed, the speed will increase every second at a rate of 10 m/min (393.70 ipm) until the preset feeder inching speed is reached.
- If the wire electrode comes into contact with a ground earth connection, the wire feeding will be stopped and the wire electrode will be retracted again by 1 mm (0.039 in.).

#### Variant 2

threading the wire electrode in 1 mm stages (0.039 in. stages) - always press the wire threading button for less than one second (tap):

- If the wire electrode comes into contact with a ground earth connection, the wire feeding will be stopped and the wire electrode will be retracted again by 1 mm (0.039 in.).

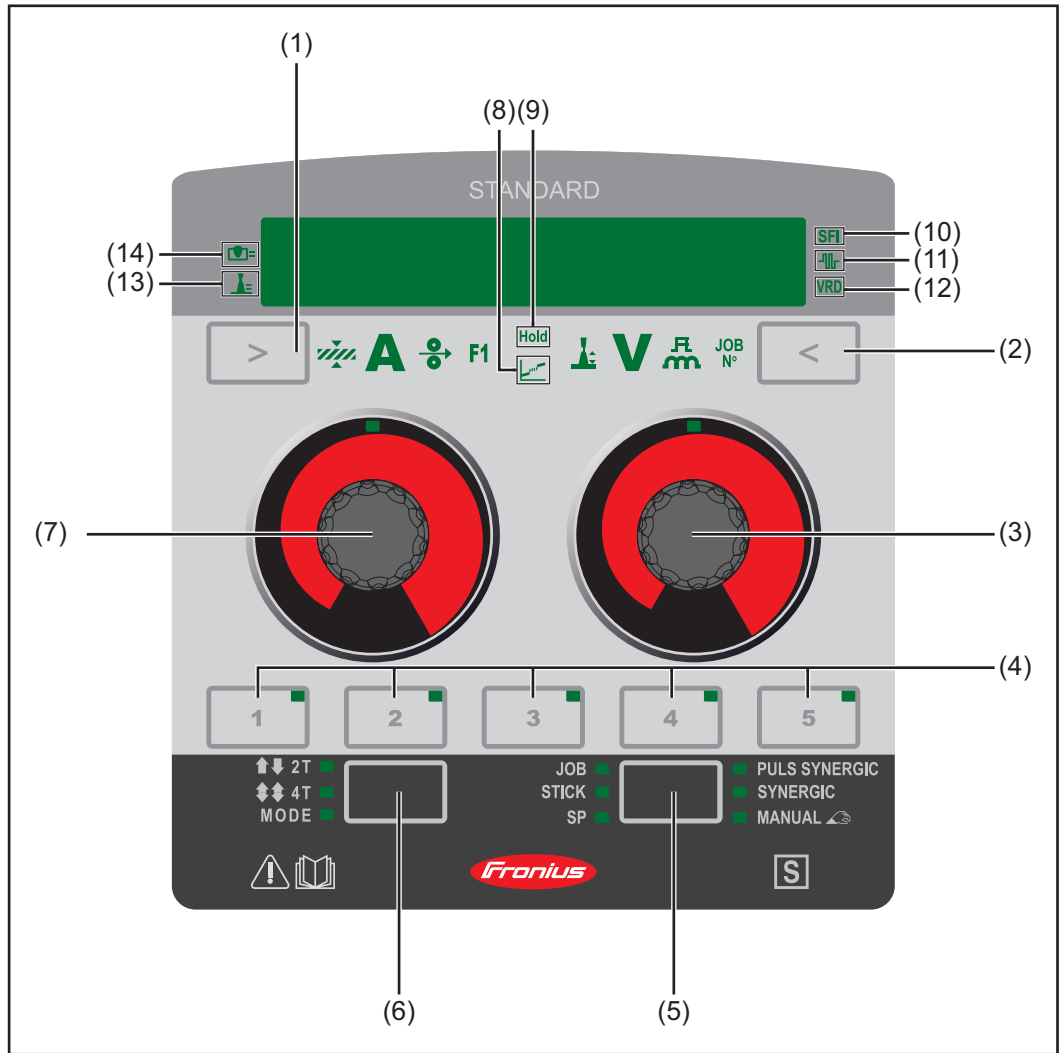
#### **NOTE!**

**If there is a ground earth connection with the contact tip before the wire threading button is pressed, the wire electrode will be retracted when the button is pressed.**




The wire electrode is only retracted until the short circuit no longer exists, however by more than 10 mm (0.39 in.) with each press of the button.







If there is still a ground earth connection with the contact tip after 10 mm (0.39 in.) of wire retraction, pressing the wire threading button again will cause the wire electrode to be retracted again by a maximum of 10 mm (0.39 in.). The process will be repeated until there is no longer a ground earth connection with the contact tip.





**OPT/i WF Stand-  
ard control panel**









Number	Control	Indicator	Function
(1)			<p><b>Parameter selection button (left)</b></p> <p>for selecting the parameters listed below. The corresponding indicator lights up when a parameter is selected.</p>
		  <b>A</b>    <b>F1</b>	<p><b>Material thickness *)</b></p> <p>in mm or inches</p> <p><b>Current *)</b></p> <p>current in A Before the start of welding, the machine automatically displays a standard value based on the programmed parameters. During welding, the actual value is displayed.</p> <p><b>Wire feed speed *)</b></p> <p>in m/min or ipm</p> <p><b>Special function</b> can only be selected if the SP welding process and the LSC or PMC special program has first been selected using the "Welding process" button (5).</p> <p>The following process control parameters can be selected and adjusted on all devices:</p> <ul style="list-style-type: none"> <li>- Penetration stabiliser</li> <li>- Arc length stabiliser</li> </ul> <p>As soon as F1 is selected, the current adjustable process control parameter is marked with an arrow on the display. Press the "Parameter selection" button (left) (1) again to select the second process control parameter.</p> <p>The following special functions can be selected depending on the configuration.</p>
			<p>*) = Synergic parameter When a synergic parameter is changed, the synergic function automatically changes all other synergic parameters to match.</p>

Number	Control	Indicator	Function
(2)			<p><b>Parameter selection button (right)</b></p> <p>for selecting the parameters listed below. The corresponding indicator lights up when a parameter is selected.</p>
		      	<p><b>Arc length correction</b></p> <p>for correcting the arc length - ... shorter arc length 0 ... neutral arc length + ... longer arc length</p> <p><b>Voltage *)</b></p> <p>in V Before the start of welding, the machine automatically displays a standard value based on the programmed parameters. During welding, the actual value is displayed.</p> <p><b>Pulse/dynamic correction</b></p> <p>for correcting the pulse energy during pulsed arc welding - ... lower droplet detachment force 0 ... neutral droplet detachment force + ... increased droplet detachment force</p> <p><b>Job number</b></p> <p>(can only be selected if the JOB welding process has first been selected using the "Welding process" button (5))</p> <p>for selecting a job number</p>
			<p>*) = Synergic parameter When a synergic parameter is changed, the synergic function automatically changes all other synergic parameters to match.</p>
(3)			<p><b>Adjusting dial with turn/press function</b></p> <ul style="list-style-type: none"> <li>- for changing the arc length correction, voltage, pulse/dynamic correction parameters</li> <li>- for selecting the job number</li> </ul>

Number	Control	Indicator	Function
(4)			<p><b>EasyJob button</b></p> <p>for saving, opening and deleting EasyJobs. The LED in the button indicates that EasyJob is selected</p> <p>How it works:</p> <ul style="list-style-type: none"> <li>- Press and hold the button for 3 seconds = save EasyJob (all current settings are saved). After saving, the LED in the button lights up and 'Store' is shown on the display</li> <li>- Press and hold the button for 5 seconds = delete EasyJob. 'Store' is shown on the display after 3 seconds, 'Clear' is shown after 5 seconds and the LED in the button goes out</li> <li>- Press the button = select the saved EasyJob</li> </ul>
(5)			<p><b>Welding process button</b></p> <p>for selecting the welding process</p> <ul style="list-style-type: none"> <li>- PULS SYNERGIC - MIG/MAG pulse synergic welding</li> <li>- SYNERGIC - MIG/MAG standard synergic welding</li> <li>- MANUAL - MIG/MAG standard manual welding</li> <li>- JOB - Job Mode</li> <li>- STICK - Manual metal arc welding</li> <li>- SP (SP = special programs: LSC, PMC, TIG, etc.) - Depending on which package of functions is enabled, various welding processes can be selected. Press the button to see the available welding processes shown on the display one after the other</li> </ul>
(6)			<p><b>Mode button</b></p> <p>for selecting the operating mode</p>
		<p>↑↓ 2T</p> <p>↕↕ 4T</p> <p><b>MODE</b></p>	<p>2-step mode</p> <p>4-step mode</p> <p>Depending on the function package, various special operating modes can be selected. Press the button to see the available operating modes shown on the display one after the other</p>
(7)			<p><b>Adjusting dial with turn/press function</b></p> <ul style="list-style-type: none"> <li>- for changing the material thickness, current, wire feed speed and special function parameters</li> <li>- for selecting and changing parameters in the Setup menu</li> </ul>
Number	Indicator		Function
(8)	Hold		<p><b>Hold indicator</b></p> <p>the actual values are displayed automatically at the end of each welding operation (current, voltage, wire feed speed, etc.). The actual values are displayed through the HOLD indicator lighting up.</p>

Number	Indicator	Function
(9)		<p><b>Intermediate arc indicator</b></p> <p>a spatter-prone intermediate arc occurs between the short arc and the spray arc. The intermediate arc indicator lights up to draw attention to this critical area.</p>
(10)	<b>SFI</b>	<p><b>SFI (Spatter Free Ignition) indicator</b></p> <p>lights up when the Spatter Free Ignition function is active</p>
(11)		<p><b>SynchroPuls indicator</b></p> <p>lights up when the SynchroPuls function is active</p>
(12)	<b>VRD</b>	<p><b>VRD (Voltage Reduction Device) indicator</b></p> <p>lights up when the voltage reduction device (VRD) is active</p>
(13)		<p><b>Penetration stabiliser indicator</b></p> <p>lights up when the penetration stabiliser function is active</p>
(14)		<p><b>Arc length stabiliser indicator</b></p> <p>lights up when the arc length stabiliser function is active</p>

# **Installation and commissioning**



# Before installation and commissioning

---

## Safety



### WARNING!

#### **Danger due to incorrect operation and incorrectly performed work.**

This can result in severe personal injury and damage to property.

- ▶ All the functions described may only be used by trained and qualified personnel.
  - ▶ Fully read and understand this document.
  - ▶ Fully read and understand all the Operating Instructions for the system components, especially the safety rules.
- 

## Proper use

The device is intended exclusively for wire feeding in MIG/MAG welding in conjunction with Fronius system components.

Utilisation for any other purpose, or in any other manner, shall be deemed to be not in accordance with the intended purpose.

The manufacturer shall not be held liable for any damages arising from such usage.

Proper use includes:

- carefully reading these operating instructions
  - following all the instructions and safety rules in these operating instructions
  - performing all stipulated inspection and maintenance work
- 

## Setup regulations



### WARNING!

#### **If one of these devices falls or topples over, it could cause serious or even fatal injury.**

Place all system components, upright consoles and trolleys on a solid, level surface in such a way that they remain stable. If a swivel pin holder is being used, always make sure that the wire-feed unit is seated securely on the swivel pin of the swivel pin holder.

---

The device is tested to IP 23 protection, meaning:

- protection against penetration by solid foreign bodies with diameters exceeding 12.5 mm (0.49 in.).
- protection against direct sprays of water at any angle up to 60° from the vertical

The device can be set up and operated outdoors in accordance with IP23. Avoid direct wetting (e.g. from rain).

# Connecting the interconnecting hosepack and MIG/MAG welding torches

## Safety

### **WARNING!**

#### **Danger from electric current.**

This can result in severe personal injury and damage to property.

- ▶ Turn the power source mains switch to the "O" position.
- ▶ Disconnect the power source from the mains.
- ▶ Ensure that the power source remains disconnected from the mains until all work has been completed.

## General information

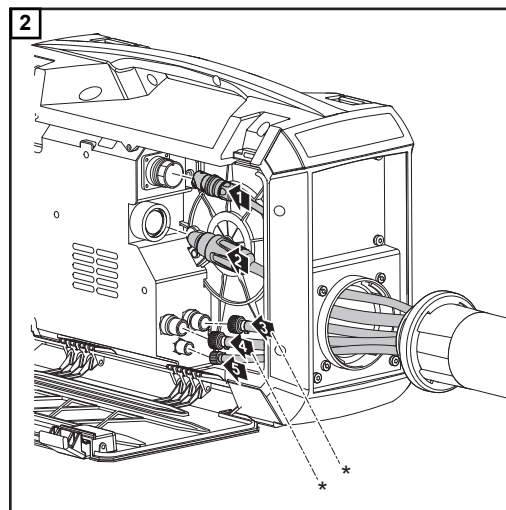
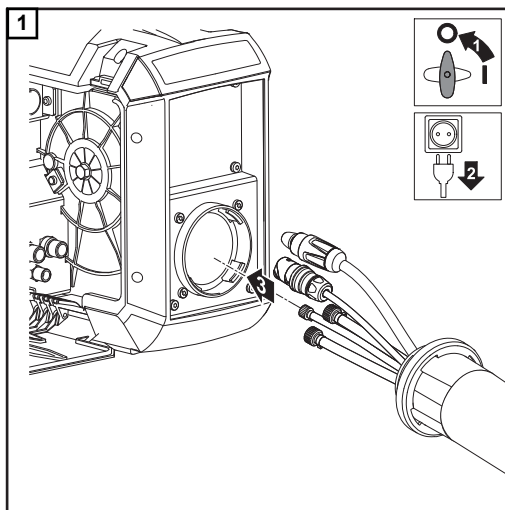
The wire-feed unit is connected to the power source using the interconnecting hosepack.

## Connecting the interconnecting hosepack

### **CAUTION!**

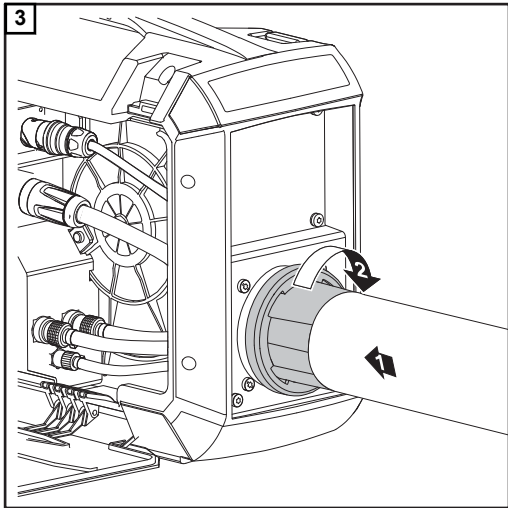
#### **Risk of injury and damage from loose connections.**

All cables, lines and hosepacks must be properly secured, undamaged, insulated and adequately dimensioned at all times.

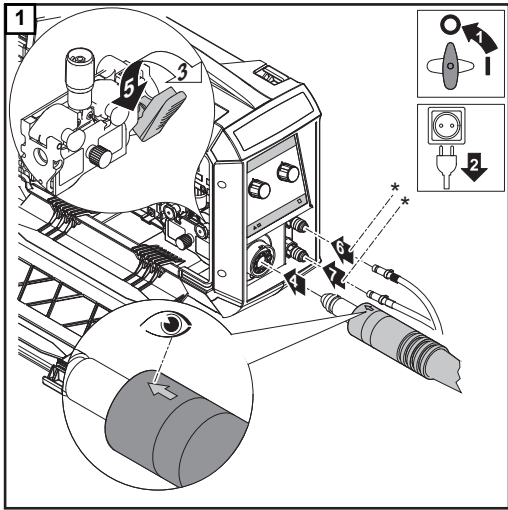


\* Only if the coolant connections are fitted in the wirefeeder and when using a water-cooled welding torch





**Connecting a  
MIG/MAG welding  
torch**



**⚠ CAUTION!**

**Risk of injury and damage from loose connections.**  
All cables, lines and hosepacks must be properly secured, undamaged, insulated and adequately dimensioned at all times.

\* Only if the coolant connections are fitted in the wirefeeder and when using a water-cooled welding torch

# Inserting/replacing feed rollers

## Safety

### **WARNING!**

#### **Danger from electric current.**

This can result in severe personal injury and damage to property.

- ▶ Turn the power source mains switch to the "O" position.
- ▶ Disconnect the power source from the mains.
- ▶ Ensure that the power source remains disconnected from the mains until all work has been completed.

## General

The feed rollers are not installed in the device when it is first delivered.

In order to achieve optimum wire electrode feed, the feed rollers must be suitable for the diameter and alloy of the wire being welded.

### **NOTE!**

#### **Risk from inadequate feed rollers.**

This can result in poor weld properties.

- ▶ Only use feed rollers that match the wire electrode.

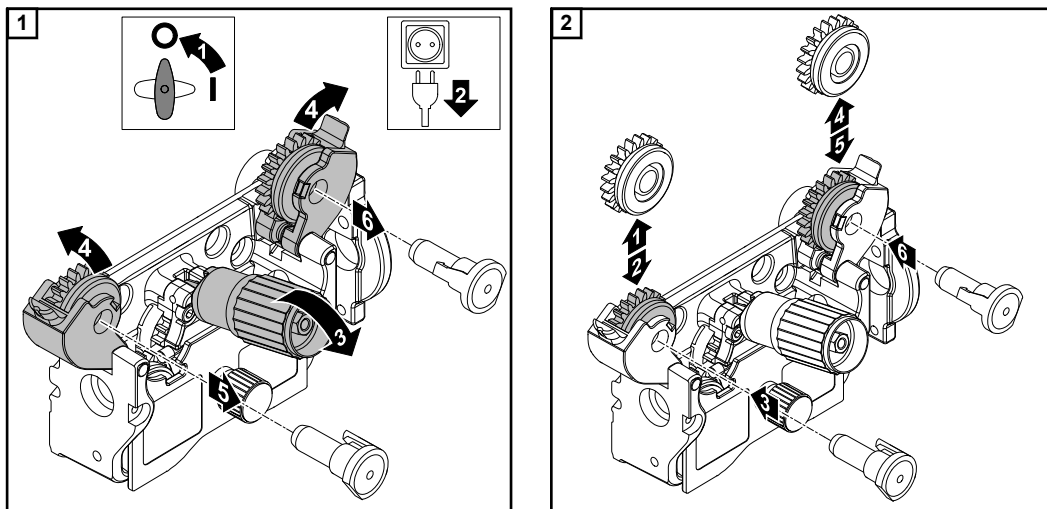
An overview of the feed rollers available and their possible areas of use can be found in the Spare Parts Lists.

## Inserting/replacing feed rollers

### **CAUTION!**

#### **Risk of injury if the feed roller holders fly upwards.**

When unlocking the clamping lever, keep fingers away from the area to the left and right of the lever.





# Inserting the wirepool, inserting the basket-type spool

## Safety

### **WARNING!**

#### **Danger from electric current.**

An electric shock can be fatal.

- ▶ Turn the power source mains switch to the "O" position.
- ▶ Disconnect the power source from the mains.
- ▶ Ensure that the power source remains disconnected from the mains until all work has been completed.

### **CAUTION!**

#### **Danger from elasticity of the spooled wire electrode.**

This can result in severe injuries.

- ▶ When inserting the wirepool/basket-type spool, hold the end of the wire electrode firmly to avoid injuries caused by the wire electrode springing back.

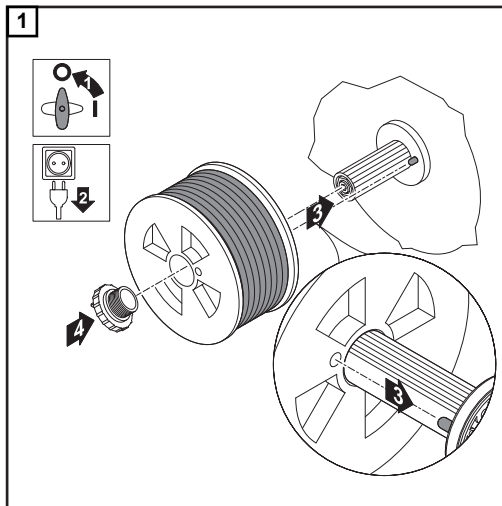
### **CAUTION!**

#### **Danger from falling wirepool/basket-type spool.**

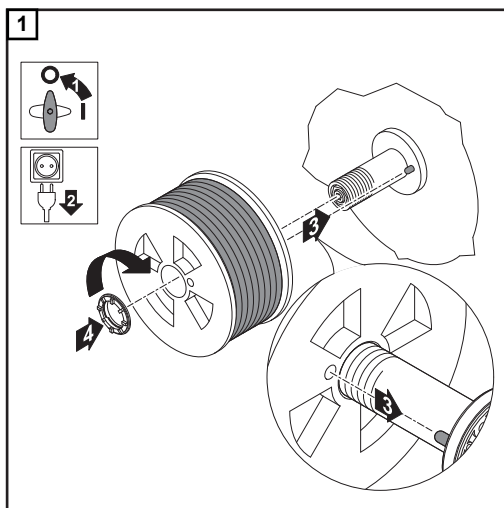
This can result in severe injuries.

- ▶ Ensure that the wirepool/basket-type spool and basket-type spool adapter are always seated securely on the wirepool holder.

## Inserting a wirepool: D200 device



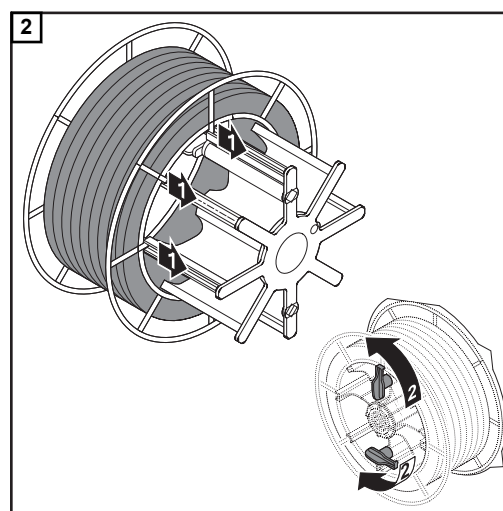
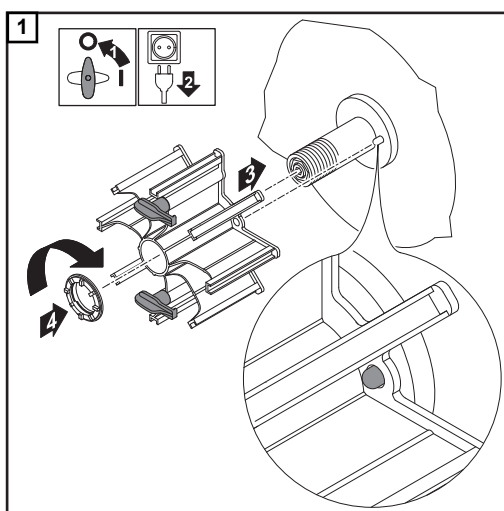
Inserting a  
wirespool: D300  
device



Inserting a bas-  
ket-type spool:  
D300 device

**⚠ CAUTION!**

**Risk of injury and material damage from falling basket-type spool.**  
Place the basket-type spool on the adapter provided in such a way that the bars on the spool are inside the adapter guideways.



# Threading the wire electrode

## General

### NOTE!

If there is no wire threading button on the wire-feed unit, use the wire threading button of another of the manufacturer's system components to thread the wire, for example the power source wire threading button.

The wire threading button functions in the same way for all system components from the manufacturer.

### NOTE!

Further details on the function of the wire threading button can be found in its description ("Optional control panels" section, "OPT/i WF gas test & wire threading" sub-section).

## Preparations

### ⚠ CAUTION!

**Risk of injury and material damage from the welding current and accidental ignition of an arc.**

Before starting work, disconnect the ground earth connection between the welding system and the workpiece.

### ⚠ CAUTION!

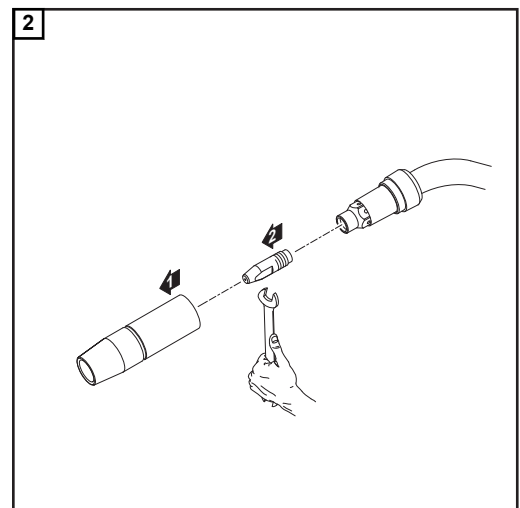
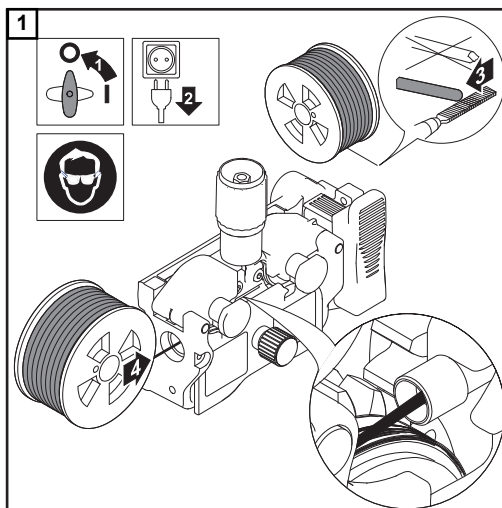
**Risk of damage to the welding torch from sharp end of wire electrode.**

Deburr the end of the wire electrode well before feeding in.

### ⚠ CAUTION!

**Risk of injury from springiness of spooled wire electrode.**

When inserting the wire electrode into the 4-roller drive, hold the end of the wire electrode firmly to avoid injuries caused by the wire springing back.



## Threading the wire electrode

### ⚠ CAUTION!

#### Danger from welding current and accidental ignition of an arc.

This can result in severe personal injury and damage to property.

- ▶ Before starting work, disconnect the ground earth connection between the welding system and the workpiece.

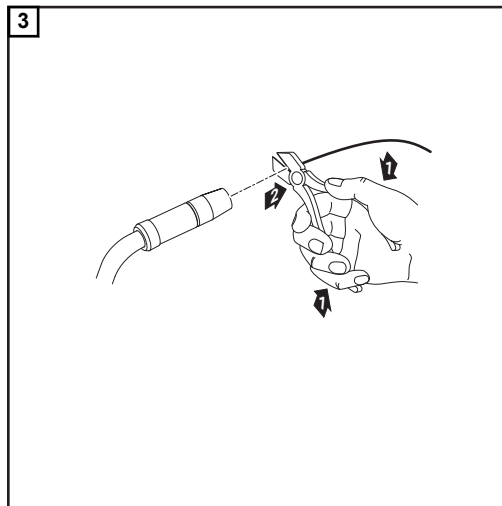
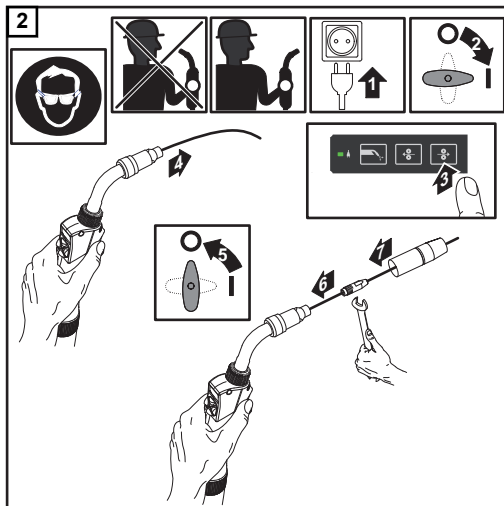
### ⚠ CAUTION!

#### Danger from emerging wire electrode.

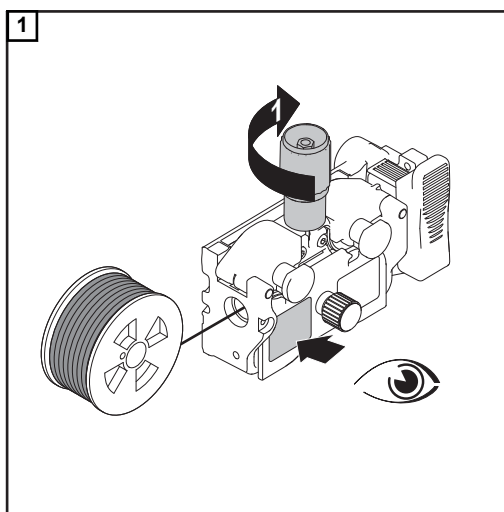
This can result in severe personal injury and damage to property.

- ▶ Hold the welding torch with the end directed away from the face and body.
- ▶ Wear suitable protective goggles.
- ▶ Do not point the welding torch at people.
- ▶ Make sure that the wire electrode does not touch any conductive or earthed parts (e.g. housing).

1 Lay the torch hosepack out straight



## Setting the contact pressure



### NOTE!

Set the contact pressure in such a way that the wire electrode is not deformed but nevertheless ensures proper wirefeed.

See the standard values on the sticker on the protective cover for setting the contact pressure.

# Adjust the brake

## General

### CAUTION!

**Risk of injury and material damage from the welding current and accidental ignition of an arc.**

Before starting work, disconnect the ground earth connection between the welding system and the workpiece.

### CAUTION!

**Risk of injury and damage from wire electrode emerging.**

While working:

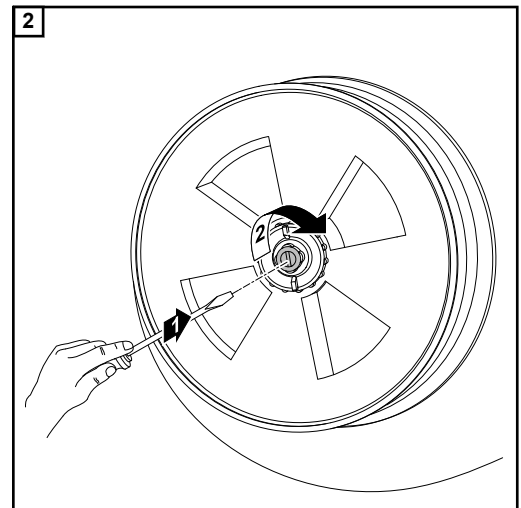
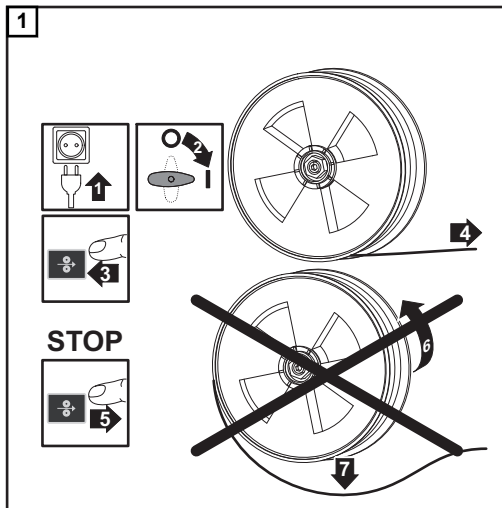
- ▶ hold the welding torch with the point directed away from the face and body
- ▶ wear suitable protective goggles
- ▶ do not point the welding torch at people
- ▶ make sure that the wire electrode does not touch any conductive or earthed parts, such as the housing, etc.

### NOTE!

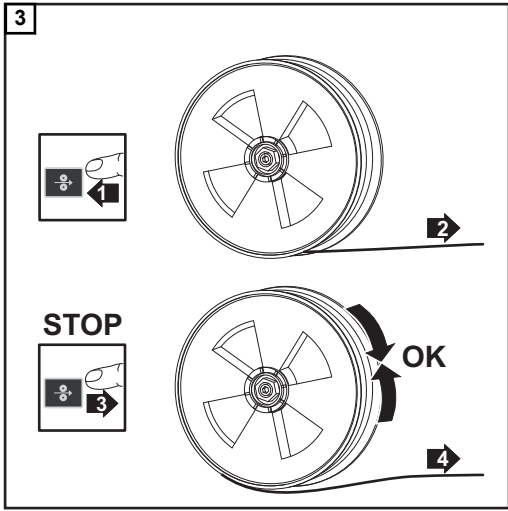
**After releasing the torch trigger the wirepool must stop unreeling.**

If it continues unreeling, readjust the brake.

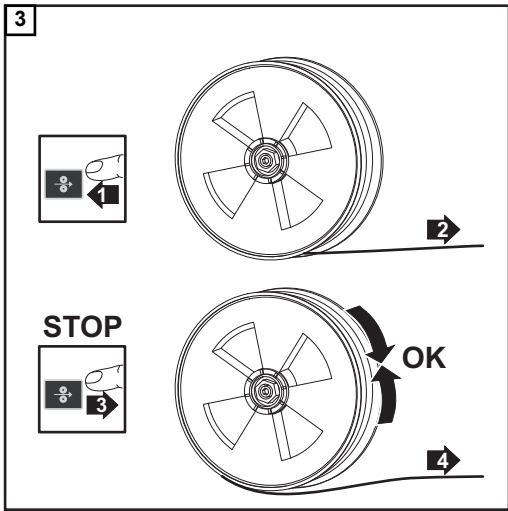
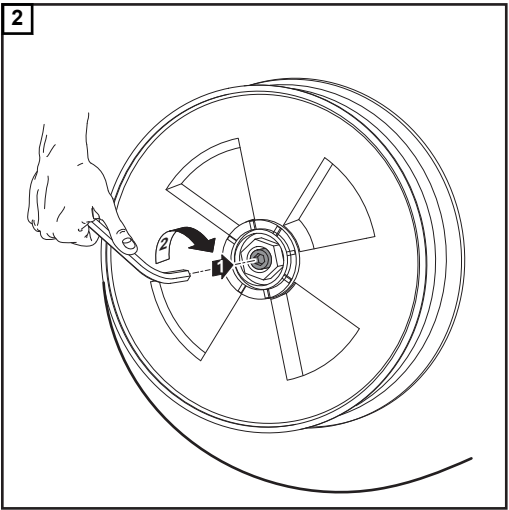
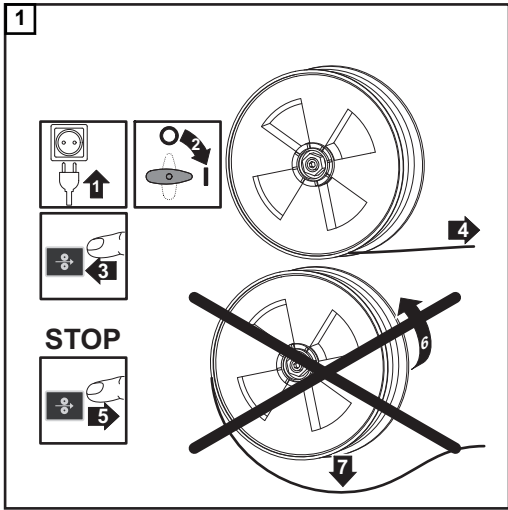
## Setting the brake: D200 device







Setting the brake:  
D300 device



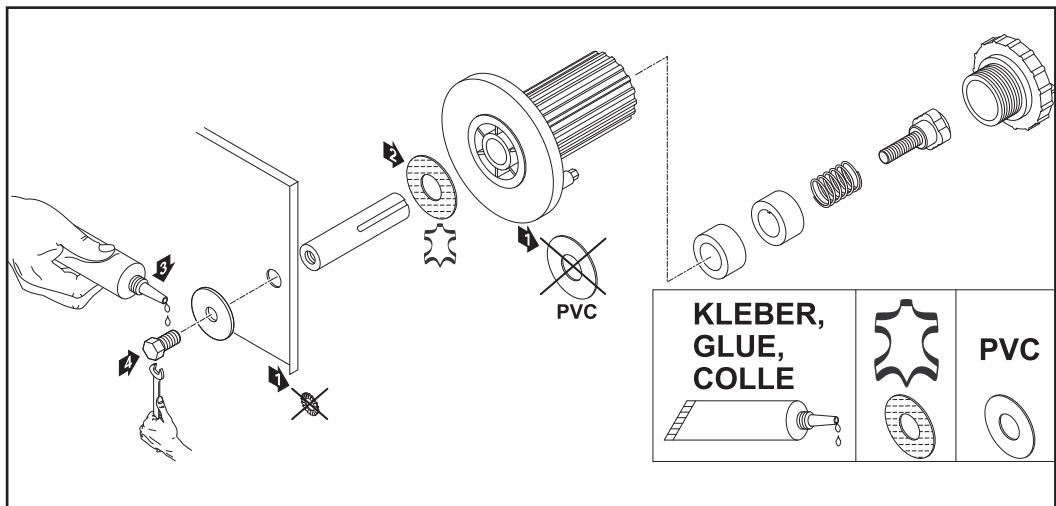
**Brake setup:  
D200 device**

**⚠ WARNING!**

**Fitting the equipment incorrectly can cause serious injury and damage.**

- ▶ Do not dismantle the brake.
- ▶ Maintenance and servicing of brakes is to be carried out by trained, qualified personnel only.

The brake is only available as a complete unit.  
This illustration is for information purposes only.



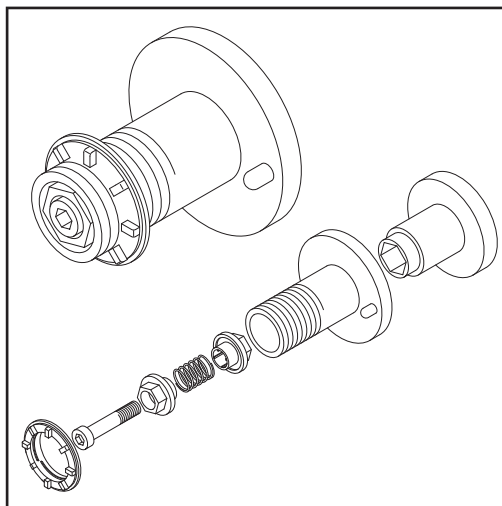
**Brake setup:  
D300 device**

**⚠ WARNING!**

**Fitting the equipment incorrectly can cause serious injury and damage.**

- ▶ Do not dismantle the brake.
- ▶ Maintenance and servicing of brakes is to be carried out by trained, qualified personnel only.

The brake is only available as a complete unit.  
This illustration is for information purposes only.



## Safety



### WARNING!

#### **Danger due to incorrect operation and incorrectly performed work.**

This can result in severe personal injury and damage to property.

- ▶ All the functions described may only be used by trained and qualified personnel.
  - ▶ Fully read and understand this document.
  - ▶ Fully read and understand all the Operating Instructions for the system components, especially the safety rules.
- 

## Prerequisites

When commissioning the wire-feed unit, the following requirements must be met:

- Wire-feed unit connected to the power source using the interconnecting hosepack
  - Welding torch connected to wire-feed unit
  - Feed rollers inserted in the wire-feed unit
  - Wirespool or basket-type spool and adapter inserted in the wire-feed unit
  - Wire electrode threaded in
  - Feed roller contact pressure set
  - Brake adjusted
  - All covers closed, all side panels in place, all protection devices intact and in their proper place
- 

## General

The wire-feed unit is started by pressing the torch trigger (for manual applications) or by means of a welding start-up signal (for automatic applications).



# **Troubleshooting, maintenance and disposal**



# Troubleshooting

---

## Safety



### WARNING!

#### **Danger due to work that has been carried out incorrectly.**

This can result in severe personal injury and damage to property.

- ▶ All the work described below must only be carried out by trained and qualified personnel.
  - ▶ Fully read and understand this document.
  - ▶ Fully read and understand all the Operating Instructions for the system components, especially the safety rules.
- 



### WARNING!

#### **Danger from electric current.**

An electric shock can be fatal.

- ▶ Turn the power source mains switch to the "O" position.
  - ▶ Disconnect the power source from the mains.
  - ▶ Ensure that the power source remains disconnected from the mains until all work has been completed.
  - ▶ After opening the device, use a suitable measuring instrument to check that electrically charged components (e.g. capacitors) have been discharged.
- 



### CAUTION!

#### **Danger from hot system components.**

This can result in severe personal injury and damage to property.

- ▶ Before starting work, allow all hot system components to cool down to room temperature (+25 °C, +77 °F). For example:
- 

Examples of hot system components include

- Coolant.
  - Water-cooled system components.
  - Wirefeeder drive motor.
- 

## Troubleshooting

Make a note of the serial number and configuration of the device and contact our After-Sales Service team with a detailed description of the error, if

- errors occur that are not listed below
- the troubleshooting measures listed are unsuccessful

---

**Power source does not function**

Mains switch is on, but indicators are not lit up

Cause: There is a break in the mains lead; the mains plug is not plugged in

Remedy: Check the mains lead, ensure that the mains plug is plugged in

Cause: Mains socket or mains plug faulty

Remedy: Replace faulty parts

Cause: Mains fuse protection

Remedy: Change the mains fuse protection

Cause: Short circuit on the 24 V supply of SpeedNet connection socket or external sensor

Remedy: Unplug connected components

---

**Nothing happens when the torch trigger is pressed**

Power source mains switch is ON and indicators are lit up

Cause: Only for welding torches with an external control plug: The control plug is not plugged in

Remedy: Plug in the control plug

Cause: Welding torch or welding torch control line is faulty

Remedy: Replace welding torch

---

**Nothing happens when the torch trigger is pressed**

Power source mains switch is on, display on the power source is active, indications on the wire-feed unit not on

Cause: Interconnecting hosepack faulty or not connected properly

Remedy: Connect the interconnecting hosepack properly or replace the hosepack

---

**No welding current**

Mains switch is ON and indicators are lit up

Cause: Grounding (earthing) connection is incorrect

Remedy: Check the grounding (earthing) connection for correct polarity

Cause: There is a break in the power cable in the welding torch

Remedy: Replace the welding torch



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**No protective gas shield**

All other functions are OK

Cause: Gas cylinder is empty

Remedy: Change the gas cylinder

Cause: The gas pressure regulator is faulty

Remedy: Replace the gas pressure regulator

Cause: Gas hose is not fitted or is damaged

Remedy: Fit or change the gas hose

Cause: Welding torch is faulty

Remedy: Change the welding torch

Cause: Gas solenoid valve is faulty

Remedy: Contact After-Sales Service

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**Irregular wire feed speed**

Cause: Braking force has been set too high

Remedy: Loosen the brake

Cause: Hole in the contact tip is too narrow

Remedy: Use a suitable contact tip

Cause: Faulty inner liner in welding torch

Remedy: Check the inner liner for kinks, dirt, etc. and replace if necessary

Cause: The feed rollers are not suitable for the wire electrode being used

Remedy: Use suitable feed rollers

Cause: Feed rollers have the wrong contact pressure

Remedy: Optimise the contact pressure

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**Wirefeed problems**

when using long hosepacks

Cause: Incorrect arrangement of hosepack

Remedy: Arrange the hosepack in as straight a line as possible, avoid tight bends

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**Welding torch becomes very hot**

Cause: The specification of the welding torch is inadequate

Remedy: Observe the duty cycle and loading limits

Cause: Only on water-cooled systems: Inadequate coolant flow

Remedy: Check coolant level, coolant flow, for coolant contamination, etc. For further information refer to the cooling unit operating instructions.

---

**Poor weld properties**

Cause: Incorrect welding parameters

Remedy: Check the settings

Cause: Poor ground earth connection

Remedy: Ensure good contact to workpiece

Cause: Inadequate or no protective gas shield

Remedy: Check the pressure regulator, gas hose, gas solenoid valve, torch gas connection, etc.

Cause: Welding torch is leaking

Remedy: Change the welding torch

Cause: Wrong contact tip, or contact tip is worn out

Remedy: Replace the contact tip

Cause: Wrong wire alloy or wrong wire diameter

Remedy: Check the wire electrode that has been inserted

Cause: Wrong wire alloy or wrong wire diameter

Remedy: Check weldability of the base material

Cause: The shielding gas is not suitable for this wire alloy

Remedy: Use the correct shielding gas

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# Care, maintenance and disposal

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## General

Under normal operating conditions, the device requires only a minimum of care and maintenance. However, it is vital to observe some important points to ensure the welding system remains in a usable condition for many years.

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## Safety



### WARNING!

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  - ▶ Fully read and understand all the Operating Instructions for the system components, especially the safety rules.
- 



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  - ▶ Ensure that the power source remains disconnected from the mains until all work has been completed.
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- 



### CAUTION!

#### **Danger from hot system components.**

This can result in severe personal injury and damage to property.

- ▶ Before starting work, allow all hot system components to cool down to room temperature (+25 °C, +77 °F). For example:
- 

Examples of hot system components include

- Coolant.
  - Water-cooled system components.
  - Wirefeeder drive motor.
- 

## Every start-up

- Check all hosepacks and the ground earth connection for damage. Replace any damaged components.
- Check feed rollers and inner liners for signs of damage. Replace any damaged components.
- Check contact pressure of feed rollers and adjust if necessary.

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**Every 6 months**



**CAUTION!**

**Danger of damage to electronic components.**

▶ Do not bring the air nozzle too close to electronic components.

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- Open covers, remove device side panels and clean inside of device with dry reduced compressed air. After cleaning, restore device to its original state.
- 

**Disposal**

Dispose of in accordance with the applicable national and local regulations.

# Technical data



# Technical data

## WF 25i Case D200

Supply voltage	24 V DC / 60 V DC
Nominal current	0.5 A / 1.2 A
Welding current at 10 min/40 °C (104 °F)	40% D.C.*    60 % D.C.*    100 % D.C.*
	500 A    450 A    360 A
Maximum shielding gas pressure	7 bar 101.53 psi
Coolant	Original Fronius
Maximum coolant pressure	5 bar 72.53 psi
Wire feed speed	1 - 25 m/min 39.37 - 984.25 ipm
Wire drive	4-roller drive
Wire diameter	0.8 - 1.6 mm 0.03 - 0.06 in.
Wirespool diameter	max. 200 mm max. 7.87 in.
Wirespool weight	max. 5 kg max. 11.02 lb.
Degree of protection	IP 23
Mark of conformity	S, CE
Dimensions l x w x h	507 x 200 x 320 mm 19.96 x 7.87 x 12.6 in.
Weight	9.5 kg 20.94 lb.
*) D.C. = Duty cycle	

## WF 25i Case D300

Supply voltage	24 V DC / 60 V DC
Nominal current	0.5 A / 1.2 A
Welding current at 10 min/40 °C (104 °F)	40% D.C.*    60 % D.C.*    100 % D.C.*
	500 A    450 A    360 A
Maximum shielding gas pressure	7 bar 101.53 psi
Coolant	Original Fronius
Maximum coolant pressure	5 bar 72.53 psi
Wire feed speed	1 - 25 m/min 39.37 - 984.25 ipm
Wire drive	4-roller drive

Wire diameter	0.8 - 1.6 mm 0.03 - 0.06 in.
Wirespool diameter	max. 300 mm max. 11.81 in.
Wirespool weight	max. 19 kg max. 41.89 lb.
Degree of protection	IP 23
Mark of conformity	S, CE
Dimensions l x w x h	613 x 244 x 437 mm 24.13 x 9.61 x 17.2 in.
Weight	14.8 kg 32.63 lb.

\*) D.C. = Duty cycle

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**HP 70i Case**

Welding current at	10 min / 40 °C (104 °F)	40% D.C.*	60 % D.C.*	100 % D.C.*
		400 A	365 A	320 A

\*) D.C. = Duty cycle

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**HP 95i Case**

Welding current at	10 min / 40 °C (104 °F)	40% D.C.*	60 % D.C.*	100 % D.C.*
		500 A	450 A	360 A

\*) D.C. = Duty cycle









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