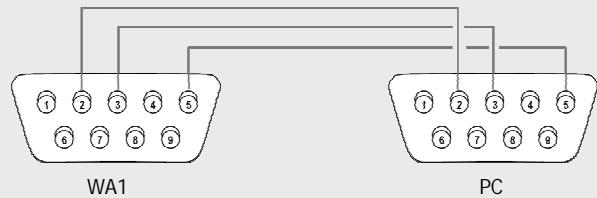


BF ENTRON Weld Analyser

Keypad operations

Key	Function on each display			
	Data	Detail	Setup	File
	power on/off			
	backlight on/off			
	previous/next pulse	scroll up/down	previous/next parameter	
	n/a	goto start/end when used with scroll keys	decrease/increase value	
	goto next display/confirm			

WA1 to PC connections



ASCII output • 19200 bits per second • 8 data bits • no parity • 1 stop bit • no flow control

Specifications

LCD	128 x 64 pixels FSTN transreflective with yellow/green backlight
keypad	embossed disc tactile switches with antiglare display window
maximum weld current	60 kA
maximum weld time	9999 cycles (AC) or 199.9 seconds (DC)
maximum capture	300 ½ cycles (AC) or 3 seconds (DC)
conduction angle	0° to 180° ± 4° (AC)
battery life	8 hours continuous with NiMH cells
auto power-off	10 minutes
dimensions	85w x 30d x 170h mm
weight	500 g including NiMH cells



Weld Analyser

WA 1



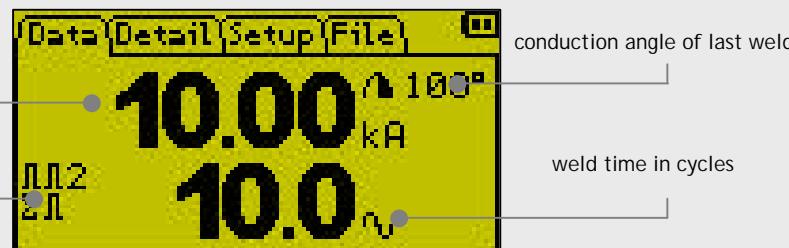
BF ENTRON Weld Analyser

BF ENTRON Weld Analyser

AC operation

Data display

weld current in kA



conduction angle of last weld

weld time in cycles

Detail display

pulse number (in weld)

JUL	Ms	kA	°
1	1+	9.79	101
1	1-	9.99	97
1	2+	10.09	102
1	2-	9.97	102
1	3+	9.93	102

current for every ½ cycle
+ indicates highest ½ cycle
- indicates lowest ½ cycle

conduction angle for each
½ cycle

Setup display

AC welding

Data Detail Setup File	
Mode AC	
Frequency	50 Hz
DC threshold	80 %
Print off	
Blanking	2 cycles
Stop after	all cys.

line frequency

printing off/all/summary

end of capture for long

welds

Setup notes

Mode should be set to the type of welding current AC or DC

Frequency should be set to the supply frequency 50 or 60 Hz (AC welding only)

DC threshold - readings below this percentage of the maximum current will be excluded from the RMS and duration calculations (DC welding only)

Printing is via the RS-232 connector
off - no printing • all - prints every ½ cycle (AC) or 10ms (DC) reading • summary - prints average current and duration for each weld pulse

ASCII output • 19200 bits per second • 8 data bits • no parity • 1 stop bit • no flow control

Blanking is the number of cycles/ms after the start of the weld that will be excluded from the RMS calculation

Stop after nn cycles/ms can be used to capture a specific section of a long weld. If the weld is longer than this parameter, a **•** symbol will be shown alongside the weld time.

DC operation

Data display

weld current in kA



weld time in cycles

weld time in ms

Detail display

pulse number (in weld)

JUL	Ms	kA
1	10	9.79
1	20	9.99
1	30	10.09
1	40	9.97
1	50	9.93

current for every 10ms
+ indicates highest 10ms
- indicates lowest 10ms

Setup display

% of weld included in RMS and duration calculations

Data Detail Setup File	
Mode DC	
Frequency	50 Hz
DC threshold	80 %
Print off	
Blanking	20 ms
Stop after	all ms

DC welding

printing off/all/summary

end of capture for long

welds

File operation

available memory

E Empty

F Full



action cancel / save / load / erase / print

file ID

0 to 99 or all