/ Perfect Welding / Solar Energy / Perfect Charging



CORRECTION & PARAMETER SETTING
参数调整

Michael Yang & Gerd Holzschuh

/伏能士中国技术专家

/ 伏能士（上海）商贸有限公司 / Fronius China Trading Co., Ltd

/ 真南路822弄129号B区1层 / 200331 上海 / 中国

BLDG 129, 822 Zhennan Rd / Shanghai 200331 / China

CMT Correction Parameter

1. CMT CORRECTION PARAMETER



CMT process parameter

The correction of the arc-length and the arc-dynamic at the CMT process is generated by an adjustment of the wire feed speed and the welding current profile.



1a. CMT ARC LENGTH CORRECTION



Arc length correction

The length of the arc in the arc burning period is adjusted by the time of the backward and forward movement. This wire speed corrections in length and height are specific for synergic line.

Unit	-
Range	-10 to + 10
Default	0

Application of the arc length correction

Positive correction causes a longer backward movement period and a reduced forward feeding speed for the wire electrode, what results in an extension of the arc within the CMT process period.

Negative correction gives a shorter arc length by reducing the time of the backward movement and increasing the amount of the forward feeding speed of the wire electrode.

1a. CMT ARC LENGTH CORRECTION



1b. CMT DYNAMIC CORRECTION



Dynamic Correction

This correction represents the dynamic or short-circuit behavior of the CMT drop transfer. The current-level at the point of reigniting in a CMT period and the acceleration ramp of the wire feeder after the point when the short circuit occurs, are adjusted with this correction.

Unit		-	
Range	-10	to	+ 10
Default		0	

Application of the dynamic correction

The positive correction rises the current level at the point of reigniting in a period and increases the acceleration ramp of the wire feed speed. As a result the drop transfer time is shortened, the process frequency is increased and CMT feels to be more intense.

The negative correction lowers the current level at reigniting and gives a reduced acceleration ramp for the wire feeder. This results in a longer duration of the drop transfer, the process frequency is lowered and CMT feels to be smoother.

1b. CMT DYNAMIC CORRECTION



1b. CMT DYNAMIC CORRECTION HEAT INPUT CONTROL



以上内容仅为本文档的试下载部分，为可阅读页数的一半内容。如要下载或阅读全文，请访问：https://d.book118.com/816054115133010201