TPS 270i C
Quick Guide

Fronius

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1 — Set the filler metal and shielding gas

Open the material selection

Turn and press to enable the desired settings

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2 — Set the welding process
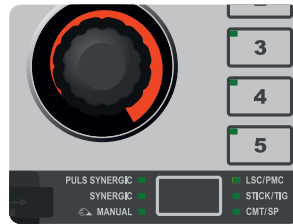
Press to select the desired welding process

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3 — Set the operating mode

Press to select the desired mode

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4 — Set the welding power

Sheet thickness

A Welding current

Wire speed

F1 Special function F1

> select desired parameter

set desired parameter

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5 — Adjust the parameters for correction

Arc length correction

V Welding voltage

Pulse/dynamic correction

F2 Special function F2

< select desired parameter

set desired parameter

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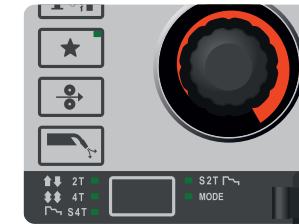
6 — Text display

Activate / deactivate = press left adjusting dial

Scroll through full text = turn left adjusting dial

Abbreviation | AlS 0.0 | + | Full text | = | Start arclength

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i — Operating Instructions
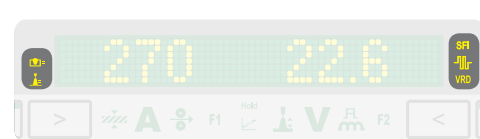

https://manuals.fronius.com/html/4204260206

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7 — Status indicators (light up when the respective function is acti**ve**)

Arc length stabilizer

Penetration stabilizer

SFI Spatter Free Ignition
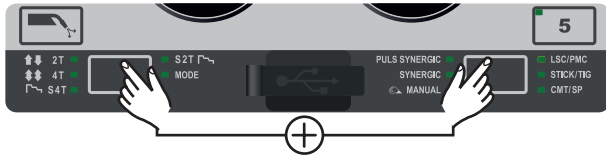
SynchroPulse

VRD Voltage Reduction Device

Entering/exiting the Setup menu

Process parameters

Start/End

I-S	Starting current (135)
AlS	Start arc length correction (0)
t-S	Starting current time (off)
SL1	Slope 1 (1.0)
SL2	Slope 2 (1.0)
I-E	Final current (50)
AlE	End arc length correction (0.0)
t-E	Final current time (off)
SFI	SFI ignition (off)
SFI-HS	SFI HotStart (off)
W-r	Wire retract (0.0)
IgC	Ignition current (manual), (450)
W-r (man.)	Wire retract (manual), (0.0)

Gas Setup

Gpr	Gas pre-flow (0.1)
GPo	Gas post-flow (0.5)

Process control

PSt	Penetration stabilizer (0.0)
AISt	Arc length stabilizer (0.0)

Components

C-C	Cooling unit operating mode (auto)
C-t	Filter time flow sensor (10)
Fdi	Feeder inching speed (10.0)
ito	Ignition timeout (off)

STICK

I-S	Starting current (150)
Hti	Starting current time (0.5)
Eln	Characteristic (I-constant)
Ast	Anti-stick (on)
Uco	Break voltage (90.0)

TIG

Uco	Break voltage (14.0)
CSS	Comfort-Stop sensitivity (0.8)

Synchropuls

Syn-Puls	SynchroPulse (off)
vd	Wire speed (5.0)
dFd	Delta wire feed (2.0)
F	Frequency (3.0)
DC	Duty cycle (50)
Al-h	Arc correction high (0.0)
Al-l	Arc correction low (0.0)

Prozess-Mix

vd	Wire speed (1.5)
AlC	Arc length correction (0.0)
PDc	Pulse/dynamic correction (0.0)
Hptc	Upper power time correction (0)
Lptc	Lower power time correction (0.0)
Lpc	Lower power correction (0.0)

Entering/exiting the Setup menu

R/L-check / alignment
Aligning welding circuit resistance
welding circuit inductivity

Settings

Display

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Einh.	Units
Norm	Standards
UIBS	Display brightness setting
F1/F2 Param.	User-defined parameters for F1 and F2
Favorit	Favourite key
IP	System data

System

CLS	Housing lighting setup
FAC	Restore factory settings
Web-PW reset	Reset website password
Information	IM-V. / SWV / IP
Operating mode setup	S4T / iJob

Language
cs, de, en, etc.

(Values/entries in brackets show the factory setting)
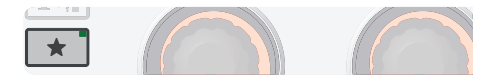

Activating/deactivating the key lock
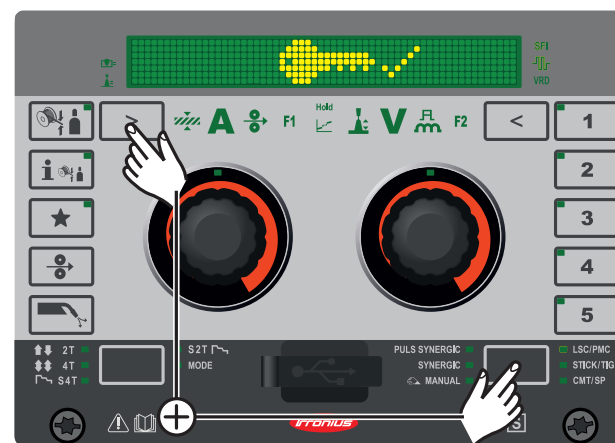
Text display

Abbreviation	Full text

Favourite

The Favourite key can be assigned the Setup parameter or Setup folder that is currently selected.

Retrieve:	
Save:	
Delete:	

EasyJobs

The EasyJob keys allow up to 5 operating points to be saved. Specifically, the current welding-relevant settings are saved.

Retrieve:	
Save:	
Delete:	

F1 / F2 special function parameters

F1 and F2 can be assigned the currently selected setup parameters.

Retrieve:	
Save:	
Delete:	

Use the key for F2!