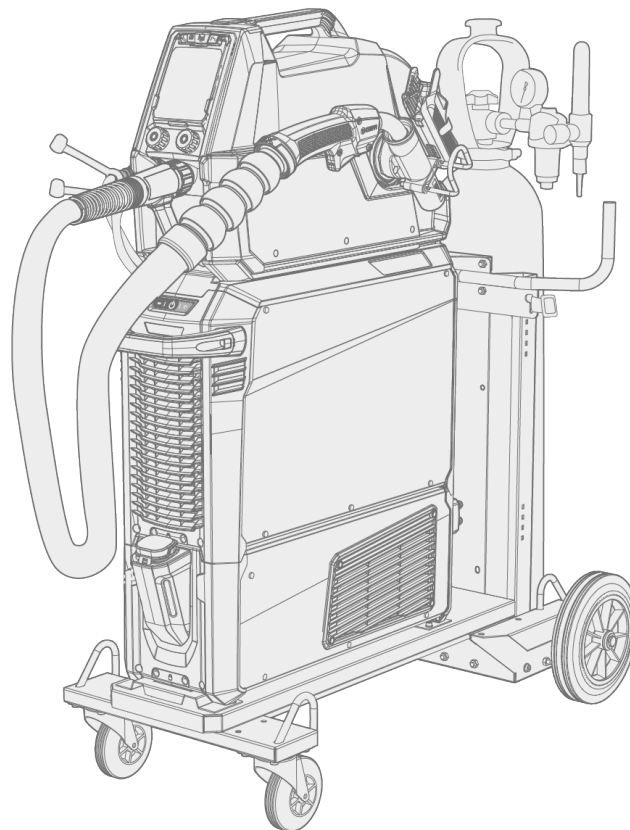


X5 FASTMIG

X5 FASTMIG PULSE



CONTENTS

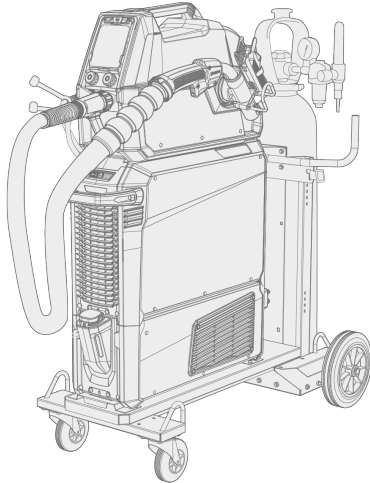
1. General	5
1.1 Welding safety	8
1.2 Equipment description	9
1.3 X5 Power Source 400 and 500	14
1.4 X5 Wire Feeder 200	16
1.4.1 Wire spool and hub (200)	17
1.4.2 Wire feed mechanism	18
1.5 X5 Wire Feeder 300	20
1.5.1 Wire spools and hubs (300)	22
1.5.2 Wire feed mechanism	23
1.6 X5 Wire Feeder HD200	24
1.6.1 Wire spool and hub (200)	26
1.6.2 Wire feed mechanism	27
1.7 X5 Wire Feeder HD300	28
1.7.1 Wire spools (HD300)	30
1.7.2 Wire feed mechanism	32
1.8 X5 control panels	33
1.8.1 Control panel of X5 WF 200 Manual	33
1.8.2 Control panel of X5 WF 300 Manual and HD200 Manual	33
1.8.3 AP/APC control panel	34
1.9 X5 interconnection cable	36
1.10 X5 cooling unit (optional)	40
1.11 Optional accessories	41
1.12 WeldEye introduction	47
2. Installation	48
2.1 Installing power source mains plug	50
2.2 Installing cooling unit (optional)	51
2.3 Installing equipment on cart (optional)	54
2.4 Installing wire feeder with fixed plate	57
2.5 Installing wire feeder with standard rotating plate	60
2.6 Installing wire feeder with lockable rotating plate	63
2.7 Installing cables (X5 WF 200, X5 WF 300, X5 WF HD300)	66
2.8 Installing cables (X5 WF HD200)	72
2.9 Connecting welding torch	76
2.9.1 Installing welding torch holder	76
2.10 Installing remote control	78
2.11 Installing and changing wire (X5 WF 200)	79

2.12 Installing and changing wire (X5 WF 300)	84
2.13 Installing and changing wire (X5 WF HD200)	90
2.14 Installing and changing wire (X5 WF HD300)	95
2.15 Installing and replacing feed rolls	99
2.16 Installing and replacing wire guide tubes	102
2.17 Installing gas bottle and testing gas flow	104
2.18 How to get welding programs	107
3. Operation	108
3.1 Preparing welding system for use	109
3.1.1 Filling cooler and circulating coolant	110
3.1.2 Calibrating welding cable	110
3.1.3 Using voltage sensing cable	111
3.2 Using X5 Manual control panel	111
3.2.1 Manual control panel: Settings	113
3.3 Using X5 AP/APC control panel	119
3.3.1 AP/APC control panel: Home view	120
3.3.2 AP/APC control panel: Weld Assist	122
3.3.3 AP/APC control panel: Channels	123
3.3.4 APC control panel: WPS view	125
3.3.5 APC control panel: WeldEye	128
3.3.6 AP/APC control panel: Welding parameters	135
3.3.7 AP/APC control panel: Weld history	143
3.3.8 AP/APC control panel: Info view	143
3.3.9 AP/APC control panel: Device settings	144
3.3.10 AP/APC control panel: Applying welding programs	147
3.3.11 AP/APC control panel: Weld data view	150
3.4 Additional guidance to functions and features	151
3.4.1 Trigger logic functions	151
3.4.2 Hot start and crater fill functions	152
3.4.3 1-MIG	155
3.4.4 WiseFusion feature	155
3.4.5 WisePenetration feature	155
3.4.6 WiseSteel feature	156
3.4.7 Pulse welding	157
3.4.8 WiseRoot+ process	157
3.4.9 WiseThin+ process	158
3.4.10 MAX Cool process	158
3.4.11 MAX Position process	159

3.4.12 MAX Speed process	159
3.4.13 Wireless connection (WLAN)	160
3.4.14 Digital Welding Procedure Specification (dWPS)	161
3.4.15 WeldEye	162
3.4.16 WeldEye ArcVision	162
3.4.17 WeldEye with DCM	163
3.4.18 USB backup and restore	164
3.4.19 USB update	165
3.4.20 Cycle timer	167
3.4.21 Demo time	168
3.4.22 Settings lock	168
3.5 Using remote control HR40/HR43	170
3.6 Using remote control HR55	171
3.7 Lifting equipment	173
3.8 Troubleshooting	175
3.9 Error codes	177
4. Maintenance	179
4.1 Daily, periodic and annual maintenance	180
4.2 Installing and cleaning power source air filter	182
4.3 Disposal	184
5. Technical data	185
5.1 X5 power sources	186
5.2 X5 wire feeders	197
5.3 X5 cooling units	207
5.4 X5 ordering info	209
5.5 Wire feeder consumables	210
5.6 Welding program work packs	213

1. GENERAL

These instructions describe the use of Kemppi's X5 FastMig equipment. X5 FastMig consists of multi-purpose welding power sources, wire feeders and cooling unit (optional) designed for demanding professional use in both, normal and pulsed MIG/MAG welding.



The X5 FastMig equipment range includes automatic 1-MIG control capabilities with X5 Wire Feeder 300 AP/APC and X5 Wire Feeder HD200/HD300 AP/APC. The 1-MIG process is accompanied by welding programs and advanced software features as well as Wise and MAX processes as optional. By default, basic welding program work packs are included with the automatic 1-MIG- and pulse-enabled equipment.

APC wire feeder models have also wireless connectivity features built in allowing digital Welding Procedure Specification (dWPS) and WeldEye use as optional.

X5 FastMig is designed to be used together with Kemppi's Flexlite MIG welding torches.

X5 FastMig can be used also for MMA welding, gouging and TIG welding. Note that TIG welding requires the use of dedicated Flexlite TX TIG torches.

System configurations

X5 FastMig allows different system configurations for different purposes of use. All X5 power source and wire feeder model combinations are possible and allow welding, but to access all of the features of each system configuration option, the configuration guidelines presented in the table below are to be followed.

Table. X5 FastMig minimum configuration requirements for each system (Manual/Auto/Pulse/Pulse+):

	X5 FastMig Manual ⁽¹⁾	X5 FastMig Auto ⁽²⁾	X5 FastMig Pulse ⁽³⁾	X5 FastMig Pulse+ ⁽⁴⁾
Wire Feeder:	X5 Wire Feeder 200 Manual	X5 Wire Feeder 300 AP	X5 Wire Feeder 300 AP	X5 Wire Feeder 300 AP
	X5 Wire Feeder 300 Manual	X5 Wire Feeder 300 APC	X5 Wire Feeder 300 APC	X5 Wire Feeder 300 APC
	X5 Wire Feeder HD300 M	X5 Wire Feeder HD300 AP	X5 Wire Feeder HD300 AP	X5 Wire Feeder HD300 AP
		X5 Wire Feeder HD300 APC	X5 Wire Feeder HD300 APC	X5 Wire Feeder HD300 APC
	X5 Wire Feeder HD200 M	X5 Wire Feeder HD200 AP	X5 Wire Feeder HD200 AP	
		X5 Wire Feeder HD200 APC	X5 Wire Feeder HD200 APC	
Power Source:	X5 Power Source 400	X5 Power Source 400	X5 Power Source 400 Pulse	X5 Power Source 400 Pulse+
	X5 Power Source 500	X5 Power Source 500	X5 Power Source 500 Pulse	X5 Power Source 500 Pulse+
	X5 Power Source 400 MV	X5 Power Source 400 MV		X5 Power Source 400 MV Pulse+

¹⁾ X5 FastMig Manual equipment is meant for welding with manual controls.

²⁾ X5 FastMig Auto equipment allows also automatic 1-MIG welding featuring additional welding processes as optional.

³⁾ X5 FastMig Pulse equipment allows also automatic 1-MIG and pulse welding featuring additional welding processes as optional. WiseRoot+ and WiseThin+ not available.


⁴⁾ X5 FastMig Pulse+ equipment allows also automatic 1-MIG and pulse welding featuring additional welding processes as optional. WiseRoot+ and WiseThin+ available.

For more information on the individual X5 FastMig devices, refer to the "Equipment description" on page 9 chapter.


Important notes

Read the instructions through carefully.

Items in the manual that require particular attention in order to minimize damage and harm are indicated with the below symbols. Read these sections carefully and follow their instructions.

 **Note:** Gives the user a useful piece of information.

 **Caution:** Describes a situation that may result in damage to the equipment or system.

 **Warning:** Describes a potentially dangerous situation. If not avoided, it will result in personal damage or fatal injury.

DISCLAIMER


While every effort has been made to ensure that the information contained in this guide is accurate and complete, no liability can be accepted for any errors or omissions. Kempfi reserves the right to change the specification of the product described at any time without prior notice. Do not copy, record, reproduce or transmit the contents of this guide without prior permission from Kempfi.

Kempfi symbols: [Userdoc](#).

General notices: [Userdoc](#).

1.1 WELDING SAFETY

Welding is always classified as hot work, and welding equipment typically contains high-voltage circuits. If you are not familiar with welding and welding principles, it is recommended that you acquire welding training or professional guidance before commencing welding. The welding equipment mentioned in this manual is intended for professional use in an industrial environment.

 *For your own safety, and that of your working environment, pay particular attention to the safety instructions delivered with the equipment.*

You can also access and download the safety instructions by using these links:

- [Safety](https://kemp.cc/safety/general)
(<https://kemp.cc/safety/general>)
- [Welding guns and torches](https://kemp.cc/safety/torches)
(<https://kemp.cc/safety/torches>)

1.2 EQUIPMENT DESCRIPTION

X5 FastMig has several power source and wire feeder options to choose from. The control panel is always fixed to the wire feeder.

X5 FastMig supports welding cable calibration without an additional voltage sensing cable.

By default, the X5 FastMig power sources come with a standard set of welding programs (work pack) that are available with 1-MIG and pulse processes as applicable. The equipment technical data and welding programs included in the X5 FastMig work packs are shown here: "Technical data" on page 185 and "Welding program work packs" on page 213.

X5 power sources (400 A):

- **X5 Power Source 400**
 - >> Standard power source with support for automatic 1-MIG process as well as MAX Speed and MAX Cool processes
- **X5 Power Source 400 MV**
 - >> Multi-voltage power source with support for automatic 1-MIG process as well as MAX Speed and MAX Cool processes
- **X5 Power Source 400 Pulse**
 - >> Pulse power source with support for automatic 1-MIG process as well as all MAX processes
- **X5 Power Source 400 Pulse+**
 - >> Pulse power source with support for automatic 1-MIG process as well as all Wise and MAX processes
- **X5 Power Source 400 MV Pulse+**
 - >> Multi-voltage pulse power source with support for automatic 1-MIG process as well as all Wise and MAX processes.

For the power source part descriptions, refer to "X5 Power Source 400 and 500" on page 14.

X5 power sources (500 A):

- **X5 Power Source 500**
 - >> Standard power source with support for automatic 1-MIG process as well as MAX Speed and MAX Cool processes
- **X5 Power Source 500 Pulse**
 - >> Pulse power source with support for automatic 1-MIG process as well as all MAX processes
- **X5 Power Source 500 Pulse+**
 - >> Pulse power source with support for automatic 1-MIG process as well as all Wise and MAX processes.

For the power source part descriptions, refer to "X5 Power Source 400 and 500" on page 14.

X5 wire feeders (Manual):

- **X5 Wire Feeder 200 Manual**
 - >> Includes 2-knob membrane control panel (Manual control panel)
 - >> Maximum wire spool diameter 200 mm
 - >> Stackable with X5 power source only when the additional steel pipe frame is used
 - >> Optional model version with built-in rotameter for gas available.
- **X5 Wire Feeder 300 Manual**
 - >> Includes 2-knob membrane control panel (Manual control panel)
 - >> Maximum wire spool diameter 300 mm
 - >> Includes subfeeder support.

For the X5 Wire Feeder 200 part descriptions, refer to "X5 Wire Feeder 200" on page 16, "Wire spool and hub (200)" on page 26 and "Wire feed mechanism" on page 27.

For the X5 Wire Feeder 300 part descriptions, refer to "X5 Wire Feeder 300" on page 20, "Wire spools and hubs (300)" on page 22 and "Wire feed mechanism" on page 23.

For the control panel descriptions, refer to "Control panel of X5 WF 200 Manual" on page 33 (WF 200) and "Control panel of X5 WF 300 Manual and HD200 Manual" on page 33 (WF 300).

X5 wire feeders (AP/APC)

- **X5 Wire Feeder 300 APC**
 - >> Includes 2-knob 5.7" TFT/LCD control panel (APC control panel)
 - >> Includes automatic 1-MIG process that supports welding programs as well as Wise/MAX features & processes
 - >> Includes wireless connectivity features (for Digital Welding Procedure Specification (dWPS) and WeldEye)
 - >> Includes Weld Assist
 - >> Maximum wire spool diameter 300 mm
 - >> Includes subfeeder support
 - >> Includes additional voltage sensing cable support
 - >> USB backup feature.
- **X5 Wire Feeder 300 AP**
 - >> Includes 2-knob 5.7" TFT/LCD control panel (AP control panel)
 - >> Includes automatic 1-MIG process that supports welding programs as well as Wise/MAX features & processes
 - >> Includes Weld Assist
 - >> Maximum wire spool diameter 300 mm
 - >> Includes subfeeder support
 - >> Includes additional voltage sensing cable support
 - >> USB backup feature.

For the X5 Wire Feeder 300 part descriptions, refer to "X5 Wire Feeder 300" on page 20, "Wire spools and hubs (300)" on page 22 and "Wire feed mechanism" on page 23.

For the control panel descriptions, refer to "AP/APC control panel" on page 34.

X5 wire feeders (HD200)

- **X5 Wire Feeder HD200 M**
 - >> Includes 2-knob membrane control panel (Manual control panel)
 - >> Maximum wire spool diameter 200 mm
 - >> Stackable with X5 power source when the additional protection sliders are used
 - >> Optional model version with built-in rotameter for gas available.
- **X5 Wire Feeder HD200 AP**
 - >> Includes 2-knob 5.7" TFT/LCD control panel (AP control panel)
 - >> Includes automatic 1-MIG process that supports welding programs as well as Wise/MAX features & processes, except WiseRoot+ and WiseThin+
 - >> Includes Weld Assist
 - >> Maximum wire spool diameter 200 mm
 - >> Stackable with X5 power source when the additional protection sliders are used
 - >> USB backup feature
 - >> Optional model version with built-in rotameter for gas available.
- **X5 Wire Feeder HD200 APC**
 - >> Includes 2-knob 5.7" TFT/LCD control panel (APC control panel)

- >> Includes automatic 1-MIG process that supports welding programs as well as Wise/MAX features & processes, except WiseRoot+ and WiseThin+
- >> Includes wireless connectivity features (for Digital Welding Procedure Specification (dWPS) and WeldEye)
- >> Includes Weld Assist
- >> Maximum wire spool diameter 200 mm
- >> Stackable with X5 power source when the additional protection sliders are used
- >> USB backup feature
- >> Optional model version with built-in rotameter for gas available.

For the X5 Wire Feeder HD200 part descriptions, refer to "X5 Wire Feeder HD200" on page 24, "Wire spool and hub (200)" on page 26 and "Wire feed mechanism" on page 27.

For the control panel descriptions, refer to "AP/APC control panel" on page 34 and "Control panel of X5 WF 300 Manual and HD200 Manual" on page 33.

X5 wire feeders (HD300)

- **X5 Wire Feeder HD300 M**
 - >> Heavy-duty wire feeder for more demanding environments
 - >> Includes 2-knob membrane control panel (Manual control panel)
 - >> Maximum wire spool diameter 300 mm
 - >> Built-in LED work lights with battery (charged when connected to mains)
 - >> Includes subfeeder support.
- **X5 Wire Feeder HD300 APC**
 - >> Heavy-duty wire feeder for more demanding environments
 - >> Includes 2-knob 5.7" TFT/LCD control panel (APC control panel)
 - >> Includes automatic 1-MIG process that supports welding programs as well as Wise/MAX features & processes
 - >> Includes wireless connectivity features (for Digital Welding Procedure Specification (dWPS) and WeldEye ArcVision)
 - >> Includes Weld Assist
 - >> Built-in LED work lights with battery (charged when connected to mains)
 - >> Maximum wire spool diameter 300 mm
 - >> Includes subfeeder support
 - >> Includes additional voltage sensing cable support
 - >> USB backup feature.
- **X5 Wire Feeder HD300 AP**
 - >> Heavy-duty wire feeder for more demanding environments
 - >> Includes 2-knob 5.7" TFT/LCD control panel (AP control panel)
 - >> Includes automatic 1-MIG process that supports welding programs as well as Wise/MAX features & processes
 - >> Includes Weld Assist
 - >> Built-in LED work lights with battery (charged when connected to mains)
 - >> Maximum wire spool diameter 300 mm
 - >> Includes subfeeder support
 - >> Includes additional voltage sensing cable support
 - >> USB backup feature.

For the X5 Wire Feeder HD300 part descriptions, refer to "X5 Wire Feeder HD300" on page 28 and "Wire feed mechanism" on page 23.

For the control panel descriptions, refer to "AP/APC control panel" on page 34 and "Control panel of X5 WF 300 Manual and HD200 Manual" on page 33.

X5 cooling units:

- X5 Cooler, 1 kW
- X5 Cooler 1400, 1.4 kW
- X5 Cooler MV, 1 kW, multi-voltage.


For the cooling unit part descriptions, refer to "X5 cooling unit (optional)" on page 40.


MIG welding torches:

- Flexlite GX/GXe MIG welding torches.

For more information on the Flexlite MIG welding torches, refer to [Kempfi Userdoc](#).

Welding programs:


 *Welding programs and Wise features are supported by the automatic, 1-MIG-enabled wire feeders. WiseRoot+, WiseThin+ and MAX Position processes require a pulse welding system. With the Wise processes, specifically a Pulse+ power source is required.*

 *Except for WiseSteel and WiseFusion, MAX and Wise software features are extra cost performance options (optional extras).*

- Welding program work pack (factory installed by default)
- 1-MIG Wise features: WiseSteel and WiseFusion (with welding program work pack)
- 1-MIG Wise features: WisePenetration (optional extra)
- Additional 1-MIG welding programs (optional extras)
- Additional advanced welding processes: WiseThin+, WiseRoot+, MAX Cool, MAX Speed and MAX Position (optional extras).

For more information on acquiring additional welding programs and optional welding processes, contact your local Kempfi dealer.

Subfeeders:

 *Subfeeder support is available with all new X5 Wire Feeder 300 and HD300 models.*

- SuperSnake GTX subfeeder.

For more information on the SuperSnake GTX subfeeder, refer to [Kempfi Userdoc](#).

For more information on optional accessories, refer to "Optional accessories" on page 41 or contact your local Kempfi dealer.

EQUIPMENT IDENTIFICATION

Serial number

Serial number of the device is marked on the rating plate or in another distinctive location on the device. It is important to make correct reference to the serial number of the product when ordering spare parts or making repairs for example.

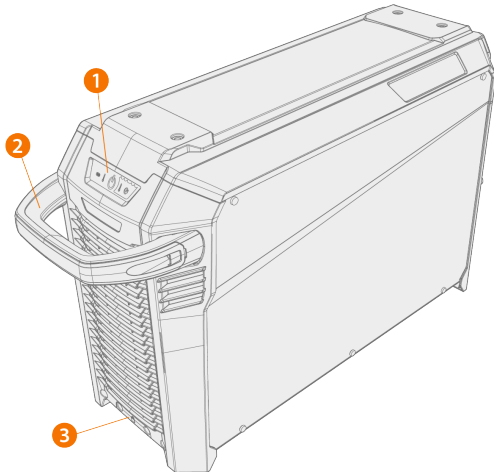
Quick Response (QR) code

The serial number and other device-related identification information may also be saved in the form of a QR code (or a barcode) on the device. Such code can be read by a smartphone camera or with a dedicated code reader device providing fast access to the device-specific information.

1.3 X5 POWER SOURCE 400 AND 500

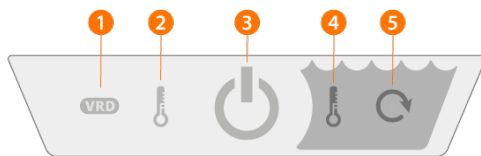
This section describes the structure of X5 Power Source 400 and X5 Power Source 500 models.

Front:



1. Indicator panel *
2. Transportation handle (not intended for mechanical lifting)
3. Front locking interface (locking on top of the cooling unit or on the cart)


*** Indicator panel**



1. VRD (Voltage Reduction Device) indicator
 - >> The LED is green when VRD is switched on and the no-load voltage is under 35 V.
 - >> The LED blinks red when VRD is switched on and the no-load voltage is above 35 V.
 - >> The LED is off when VRD is switched off or during welding.
 - >> The LED blinks green when the MMA or Gouging power save mode is on (the power save mode is automatically applied after 15 minutes of idling).


 *VRD is in use with MMA and Gouging modes only.*

2. High temperature indicator (overheating)
 - >> The LED is yellow when the unit is overheating.

 *If the power source overheats, a thermal cutoff switches the unit off and does not allow it to be used until it has cooled down.*

3. Power on/off indicator
 - >> The LED is green when the unit is on.

4. Coolant temperature warning
 - >> The LED is yellow when the cooler is overheating.

 *If the coolant liquid overheats, a thermal cutoff switches the welding system off and does not allow it to be used until the coolant liquid has cooled down.*

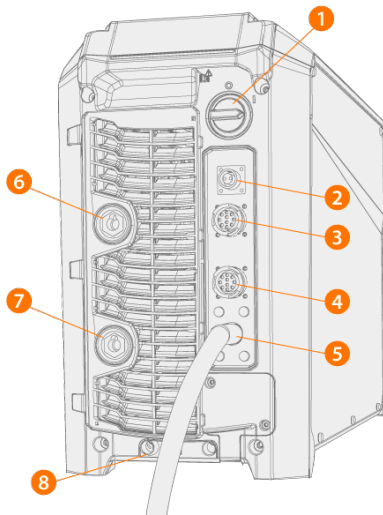
5. Coolant circulation warning

- >> The LED is green when the coolant circulation is working normally.
- >> The LED is red when there is a problem in the coolant circulation.



If the circulation of the coolant liquid is obstructed, a thermal cutoff switches the welding system off. Check and fix the error before using the welding system again.



Rear:

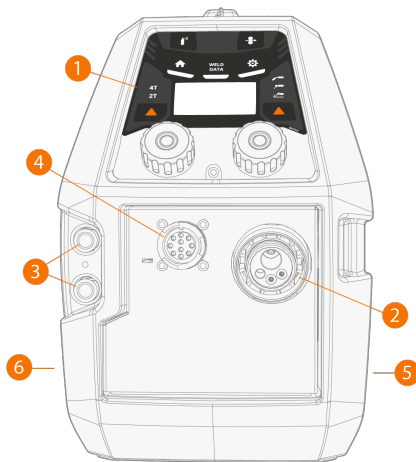


1. Power switch
2. Voltage sensing cable connector (Pulse+ power sources only)
3. Control cable connector
4. Control cable connector
5. Mains cable
6. Welding current cable connector, plus (+) connector
7. Earth return cable connector, minus (-) connector
8. Rear locking interface
 - >> For locking on top of the cooling unit or on the cart.

1.4 X5 WIRE FEEDER 200

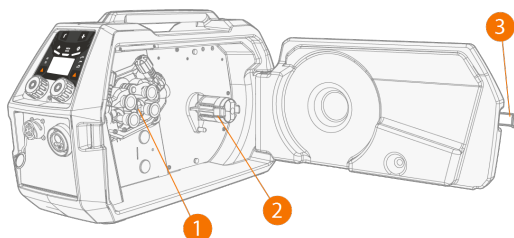
This section describes the structure of the X5 Wire Feeder 200 Manual.

-  *Keep the wire feeder covers closed during welding to reduce the risk of injury or an electric shock. Keep the covers closed also at other times to keep the inside of the wire feeder clean.*
-  *The handle is intended for short distance manual carrying. Suspending the equipment temporarily from the handle with slings (e.g. for moving) is allowed.*

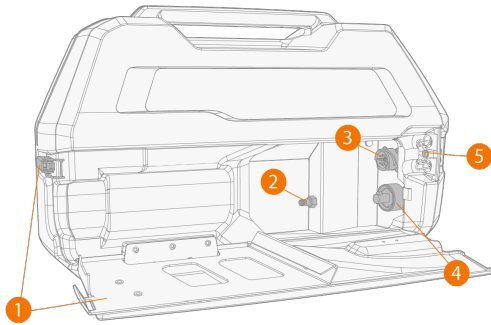


1. Control panel
 >> For more information on the X5 Wire Feeder 200 Manual control panel, refer to "Control panel of X5 WF 200 Manual" on page 33.
2. Euro connector for welding cable connection
3. Coolant inlet and outlet connectors (color-coded)
4. Control cable connector
5. Wire feed cabinet side
6. Interconnection cable cabinet side

Inside wire feeder (wire feed cabinet)



1. Wire feed roll mechanism
2. Wire spool hub
 >> For more information on the wire spools, refer to "Wire spool and hub (200)" on page 26.
3. Wire feeder cabinet door latch

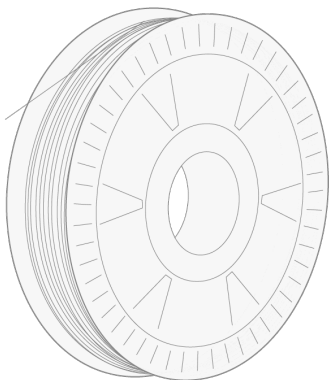
Inside wire feeder (interconnection cable cabinet)

1. Interconnection cable cabinet hatch and locking latch
>> The rear section of the hatch acts also as a strain relief for the cable
2. Shielding gas hose connector
3. Control cable connector
4. Welding current cable connector
5. Coolant hose mounting slot

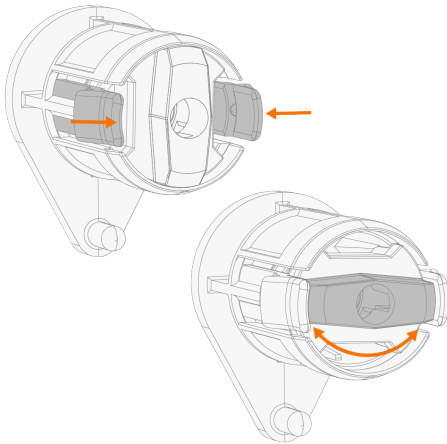
For installing and connecting the cables, refer to "X5 interconnection cable" on page 36 and "Installing cables (X5 WF 200, X5 WF 300, X5 WF HD300)" on page 66.

Wire feeder fixing accessories

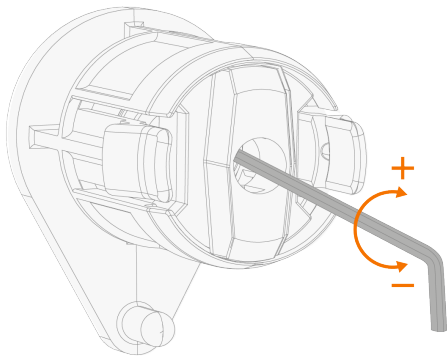
X5 Wire Feeder 200 can be equipped with a steel pipe frame for additional protection and installation options. When the steel pipe frame is used, X5 Wire Feeder 200 can also be installed on top of the X5 power sources using the same optional fixing accessory sets than with the X5 Wire Feeder 300.

1.4.1 WIRE SPOOL AND HUB (200)

The wire spool can be released and removed by opening the lock and pushing the locking clips towards the center. The locking clips are locked by turning the lock knob between the locking levers:

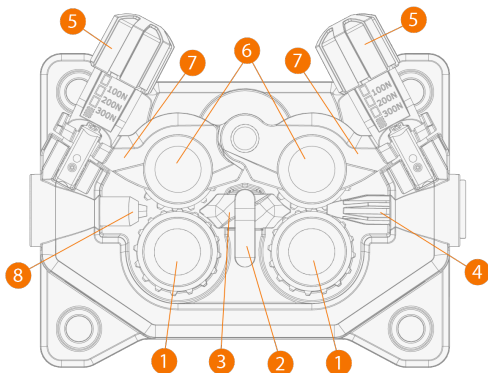


Spool brake adjustment:



1.4.2 WIRE FEED MECHANISM

X5 Wire Feeder 200 wire feed mechanism:



1. Drive rolls and drive roll mounting caps
2. Middle guide tube locking clip

3. Middle guide tube
4. Inlet guide tube
5. Pressure handles
6. Pressure rolls and pressure roll mounting pins
7. Pressure roll locking arms
8. Outlet guide tube.

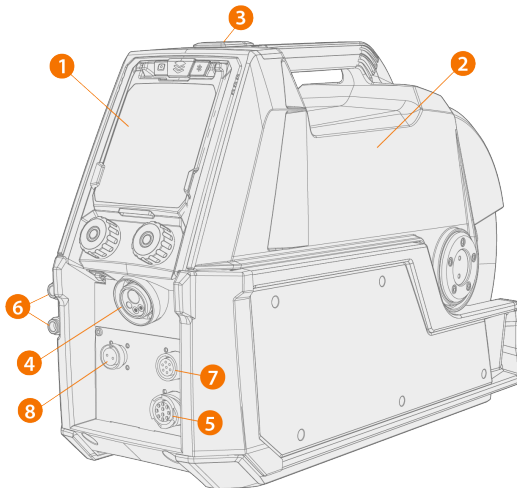
For replacing the wire feed rolls, refer to "Installing and replacing feed rolls" on page 99.

For replacing the wire guide tubes, refer to "Installing and replacing wire guide tubes" on page 102

1.5 X5 WIRE FEEDER 300

This section describes the structure of the X5 Wire Feeder 300 Manual and 300 AP/APC.

 *Model-specific variations may occur.*



1. Control panel (and control panel display cover)


>> For more information on the X5 Wire Feeder 300 AP/APC control panel, refer to "AP/APC control panel" on page 34.


>> For more information on the X5 Wire Feeder 300 Manual control panel, refer to "Control panel of X5 WF 300 Manual and HD200 Manual" on page 33.

2. Top cover

>> Wire feeder cabinet door

>> Handle

 *Keep the wire feeder top cover closed during welding to reduce the risk of injury or an electric shock. Keep the top cover closed also at other times to keep the inside of the wire feeder clean.*

 *The handle is intended for short distance manual carrying. Suspending the equipment temporarily from the handle with slings (e.g. for moving) is allowed.*

3. Top cover latch

4. Euro connector for welding cable connection

5. Control cable connector

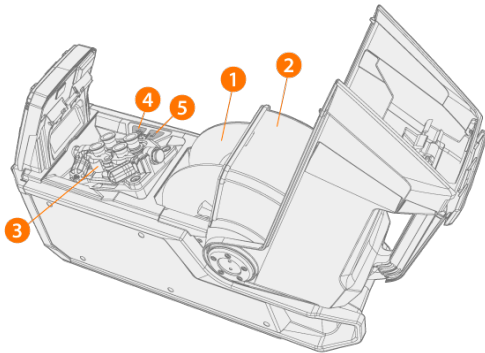
6. Coolant inlet and outlet connectors (color-coded)

7. Subfeeder synchronization connector

8. X5 Wire Feeder 300 AP/APC only: Voltage sensing cable connector

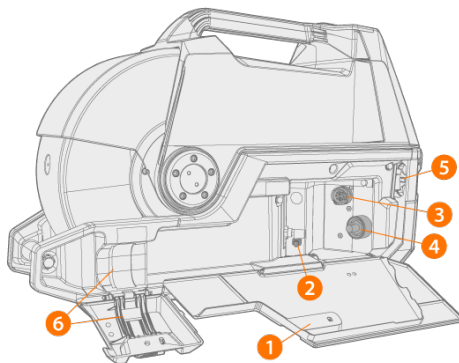
 *Refer to the control panel settings for the supported subfeeders.*

Inside wire feeder (wire feeder cabinet)

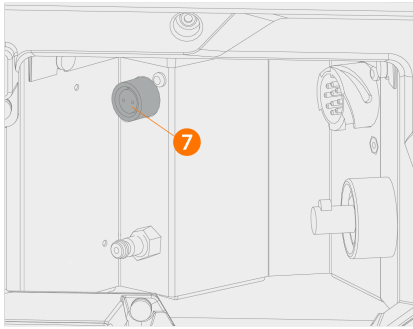


1. Wire spool
>> For more information on the wire spools, refer to "Wire spools and hubs (300)" on the next page.
2. Wire spool locking cover
3. Wire feed roll mechanism
4. Wire inch button
>> Drive the filler wire forward (with arc off).
5. Gas test button
>> Test the shielding gas flow and flush the gas line.

Inside wire feeder (interconnection cable cabinet)



1. Interconnection cable cabinet door and latch
2. Shielding gas hose connector
3. Control cable connector
4. Welding current cable connector
5. Coolant hose mounting slot
6. Interconnection cable strain relief



7. X5 Wire Feeder 300 AP/APC: Voltage sensing cable connector for interconnection cable

For installing and connecting the cables, refer to "X5 interconnection cable" on page 36 and "Installing cables (X5 WF 200, X5 WF 300, X5 WF HD300)" on page 66.

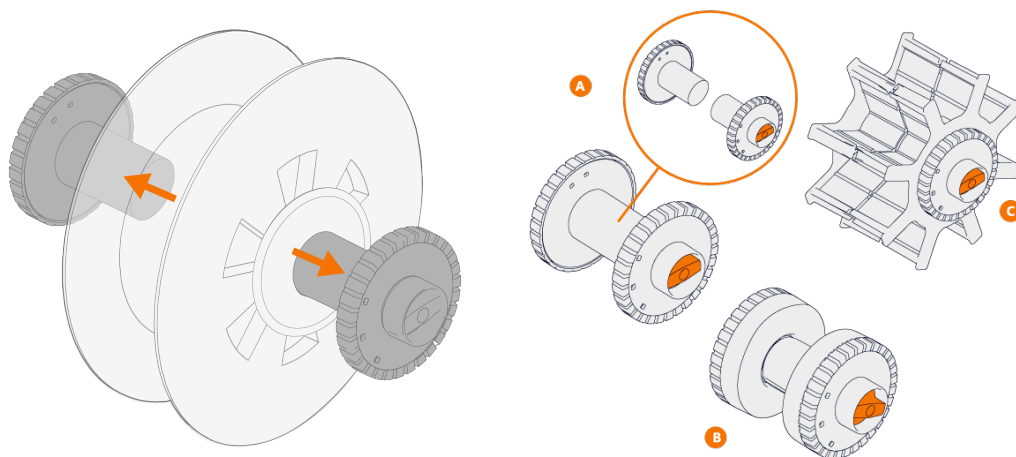
If the built-in rotameter for gas is included, it is also located in the interconnection cable cabinet.

Wire feeder fixing accessories

X5 Wire Feeder 300 can be installed on top of an X5 power source with the following optional fixing accessory sets:

- Fixed fixing plates and locking mechanism for one wire feeder
- Rotating plate with locking mechanism for one wire feeder
- Double rotating plate with two locking mechanisms for two wire feeders
- Rotating plate with counter-balance arm for one wire feeder.

1.5.1 WIRE SPOOLS AND HUBS (300)



X5 Wire Feeder 300 has three different wire spool hub options available for different wire spools:

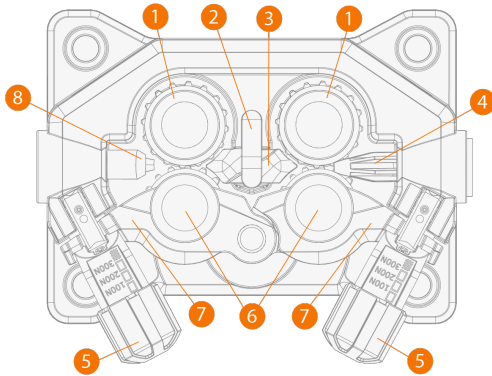
- Standard spool (A)
- Spool hub for the small wire spool (B)
 - >> Attach the extension pieces to the standard spool halves.
- Spool hub for the wire spool with a large center hole (C) (e.g. a wire basket rim)

All parts are delivered with the wire feeder.

Loosen and pull the spool hub halves apart to detach them.

1.5.2 WIRE FEED MECHANISM

X5 Wire Feeder 300 wire feed mechanism:




1. Drive rolls and drive roll mounting caps
2. Middle guide tube locking clip
3. Middle guide tube
4. Inlet guide tube
5. Pressure handles
6. Pressure rolls and pressure roll mounting pins
7. Pressure roll locking arms
8. Outlet guide tube.

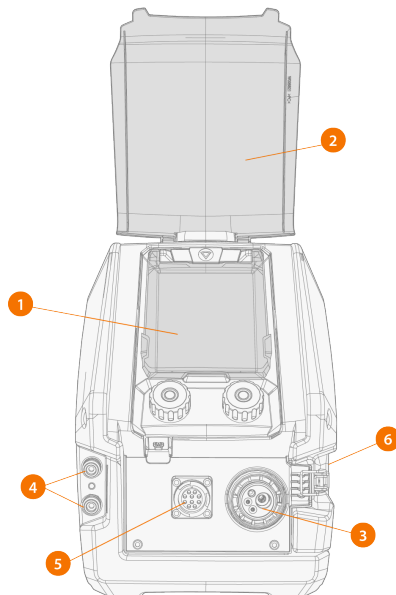
For replacing the wire feed rolls, refer to "Installing and replacing feed rolls" on page 99.

For replacing the wire guide tubes, refer to "Installing and replacing wire guide tubes" on page 102

1.6 X5 WIRE FEEDER HD200

This section describes the structure of the X5 Wire Feeder HD200 Manual, AP and APC.

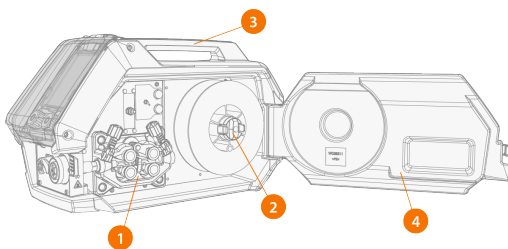
-  *Keep the wire feeder covers closed during welding to reduce the risk of injury or an electric shock. Keep the covers closed also at other times to keep the inside of the wire feeder clean.*



1. Control panel (and control panel display cover *)
 - >> For more information on the X5 Wire Feeder HD200 Manual control panel, refer to "Control panel of X5 WF 300 Manual and HD200 Manual" on page 33.
 - >> For more information on the X5 Wire Feeder HD200 AP/APC control panel, refer to "AP/APC control panel" on page 34.
2. Control panel cover *
3. Euro connector for welding cable connection
4. Coolant inlet and outlet connectors (color-coded)
5. Control cable connector (10-pin)
6. Wire feed cabinet and cabinet door latch.

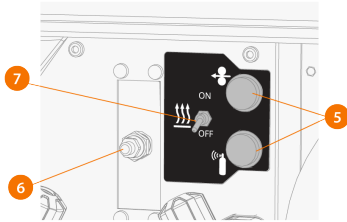
** Display and control panel covers come as standard. Either can be removed according to your requirements.*

Wire feed cabinet




1. Wire feed roll mechanism
2. Wire spool hub
 - >> For more information on the wire spools, refer to "Wire spool and hub (200)" on page 26.
3. Wire feeder handle

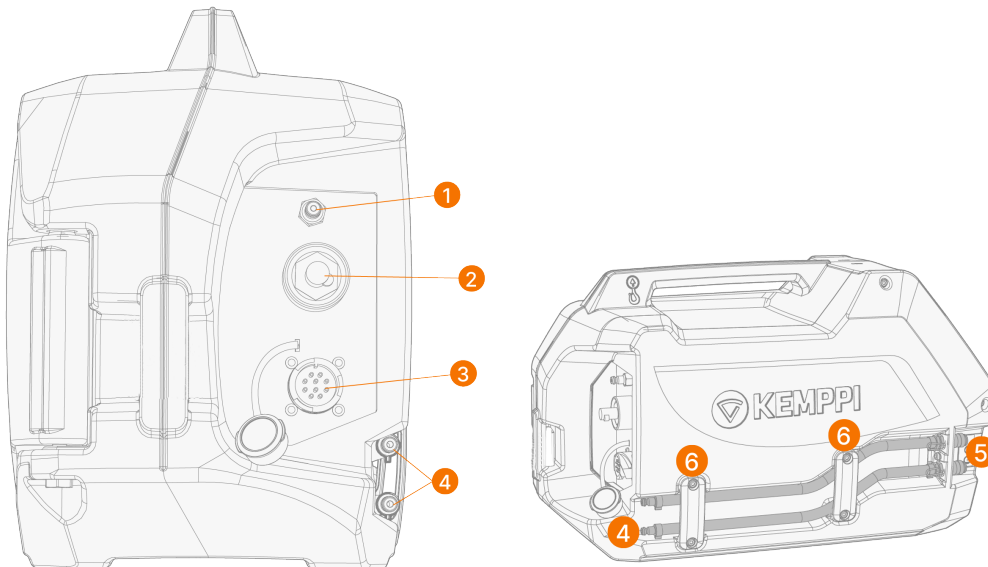
4. Wire feeder cabinet door



- 5. Wire inch and gas test buttons
- 6. Shielding gas flow regulator valve
- 7. Cabinet heater switch (cabinet heater is optional).

 A separate model version with a built-in rotameter for gas is also available. In that case, the gas flow regulator valve is replaced with the rotameter adjustment knob and scale.

Interconnection cable connectors



- 1. Shielding gas hose connector
- 2. Welding current cable connector (DIX)
- 3. Control cable connector
- 4. Coolant hose connectors *
- 5. Coolant inlet and outlet connector holder
- 6. Coolant hose duct brackets.

* With the X3 HD200 wire feeder, the coolant hoses are connected to the continuation hoses that are guided to the front.

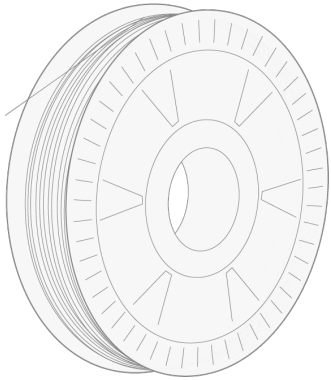
For installing and connecting the cables, refer to "X5 interconnection cable" on page 36 and "Installing cables (X5 WF HD200)" on page 72.

Wire feeder fixing accessories

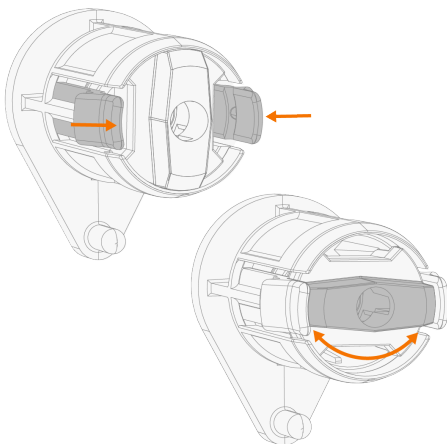
X5 Wire Feeder HD200 can be equipped with wire feeder protection sliders for additional protection and installation options. When the protection sliders are used, X5 Wire Feeder HD200 can also be installed on top of the X5 power sources using the same optional fixing accessory sets than with the X5 Wire Feeder

300. With the protection sliders, connecting directly to the wire feeder cart and 2-wheel trolley is also possible.

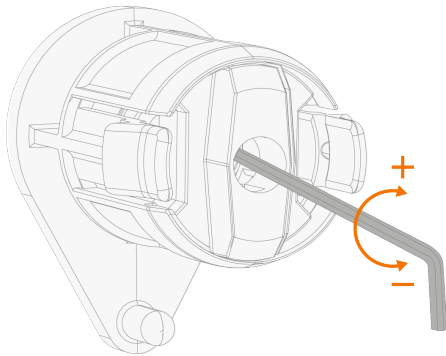
1.6.1 WIRE SPOOL AND HUB (200)



The wire spool can be released and removed by opening the lock and pushing the locking clips towards the center. The locking clips are locked by turning the lock knob between the locking levers:

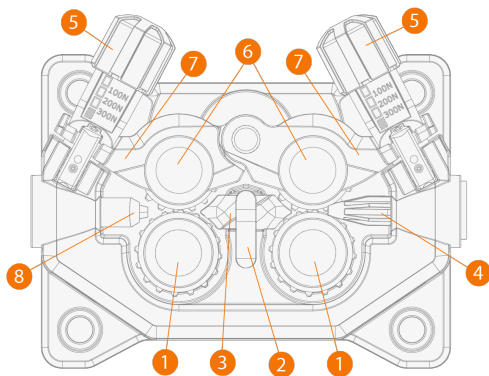


Spool brake adjustment:



1.6.2 WIRE FEED MECHANISM

X5 Wire Feeder 200 wire feed mechanism:



1. Drive rolls and drive roll mounting caps
2. Middle guide tube locking clip
3. Middle guide tube
4. Inlet guide tube
5. Pressure handles
6. Pressure rolls and pressure roll mounting pins
7. Pressure roll locking arms
8. Outlet guide tube.

For replacing the wire feed rolls, refer to "Installing and replacing feed rolls" on page 99.

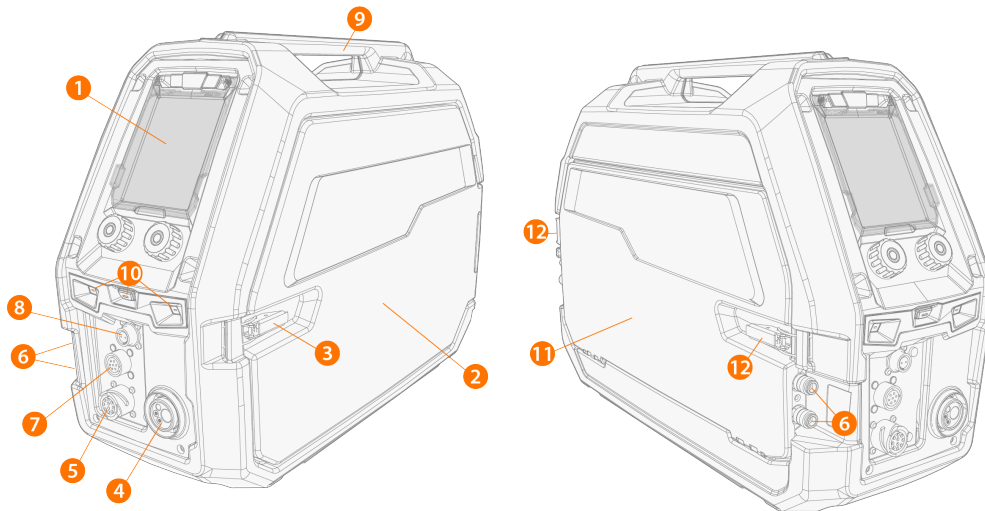
For replacing the wire guide tubes, refer to "Installing and replacing wire guide tubes" on page 102

1.7 X5 WIRE FEEDER HD300

This section describes the structure of the X5 Wire Feeder HD300.

 *Model-specific variations may occur.*

X5 Wire Feeder HD300:




1. Control panel (and control panel display cover)

>> For more information on the X5 Wire Feeder 300 Manual control panel, refer to "Control panel of X5 WF 300 Manual and HD200 Manual" on page 33.

>> For more information on the X5 Wire Feeder 300 AP/APC control panel, refer to "AP/APC control panel" on page 34.

2. Wire feeder cabinet door

 *Keep the wire feeder cabinet door closed during welding to reduce the risk of injury or an electric shock. Keep the cabinet door closed also at other times to keep the inside of the wire feeder clean.*


3. Wire feeder cabinet door latch

4. Euro connector for welding cable connection

5. Control cable connector


6. Coolant inlet and outlet connectors (color-coded)

7. Subfeeder synchronization connector

 *Refer to "AP/APC control panel: Device settings" on page 144 for the full list of supported sub-feeders.*

8. AP/APC models only: Voltage sensing cable connector

9. Handle

 *Suspending the equipment from the handle with dedicated suspension accessories (i.e. for lifting or moving) is possible.*

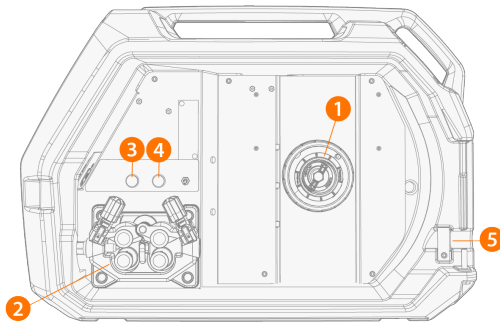
10. LED work lights with light switch in the middle

>> Light switch: First press turns the lights on (full brightness), second press dims the lights (medium brightness), third press turns the lights off

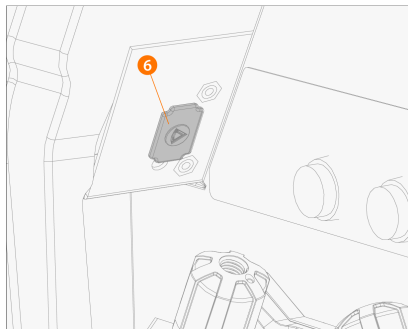
>> Includes a built-in battery (the battery is charged when the equipment is connected to mains).

11. Interconnection cable cabinet hatch

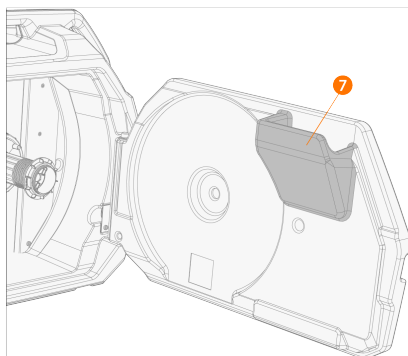
12. Interconnection cable cabinet hatch latches

Inside wire feeder (wire feeder cabinet)

- 1. Wire spool hub**
>> For more information on the wire spool, refer to "Installing and changing wire (X5 WF HD300)" on page 95.
- 2. Wire feed roll mechanism**
- 3. Gas test button**
>> Test the shielding gas flow and flush the gas line.
- 4. Wire inch button**
>> Drive the filler wire forward (with arc off).
- 5. Aperture for wire drum kit conduit (optional)**
- 6. USB connector**
>> For updating software/firmware.



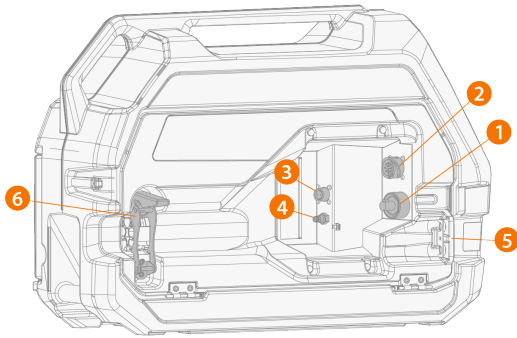
- 7. Parts storage**
>> For temporarily storage of smaller items.



If the optional built-in rotameter for gas is used, it is also located in the wire feeder cabinet.

If the optional cabinet heater is used, its ON/OFF switch is located in the wire feeder cabinet.

Inside wire feeder (interconnection cable cabinet)

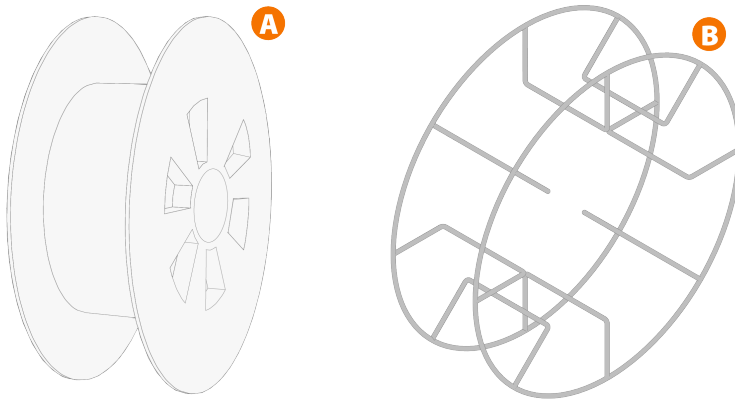


1. Welding current cable connector
2. Control cable connector
3. Voltage sensing cable connector
4. Shielding gas hose connector
5. Coolant hose mounting slot
6. Interconnection cable strain relief (adjustable)

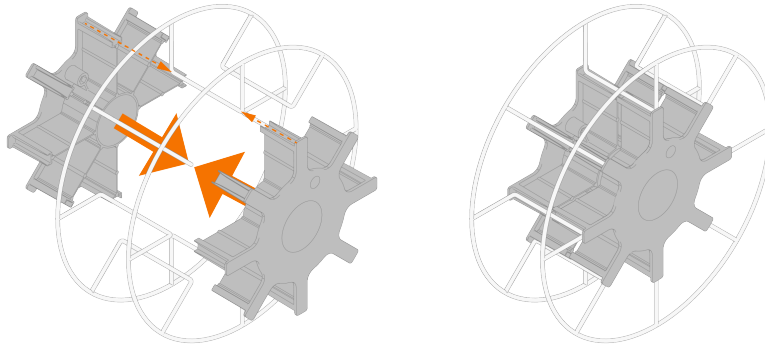
For installing and connecting the cables, refer to "X5 interconnection cable" on page 36 and "Installing cables (X5 WF 200, X5 WF 300, X5 WF HD300)" on page 66.

i With X5 Wire Feeder HD300, the wire feeder cabinet door opens on the side. This should be noted when considering installing a double wire feeder setup on a double rotating plate.

1.7.1 WIRE SPOOLS (HD300)

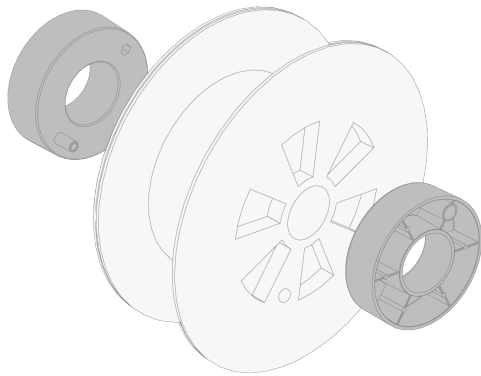


X5 Wire Feeder HD300 uses the standard wire spools (A) without additional adapters. Wire spools with a large center hole, e.g. a wire basket rim (B), require an additional spool adapter (available as Kemppi accessory):

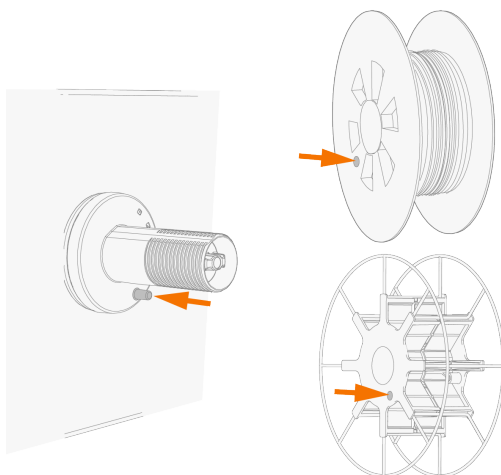


- i** Wire basket rims may vary in dimensions, therefore compatibility with the HD300 wire feeder and the additional spool adapter cannot be guaranteed in all cases.

The narrower 200 mm standard wire spool can also be used with the X5 HD wire feeder, when used together with spacer adapters (available as Kemppi accessory (SP008959)):



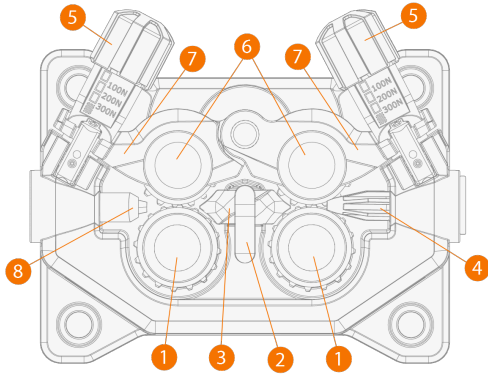
- i** When installed, the pin next to the wire spool hub in the wire feeder must align and go into the hole in the spool or spool adapter.



"Installing and changing wire (X5 WF HD300)" on page 95

1.7.2 WIRE FEED MECHANISM

X5 Wire Feeder HD300 wire feed mechanism:



1. Drive rolls and drive roll mounting caps
2. Middle guide tube locking clip
3. Middle guide tube
4. Inlet guide tube
5. Pressure handles
6. Pressure rolls and pressure roll mounting pins
7. Pressure roll locking arms
8. Outlet guide tube.

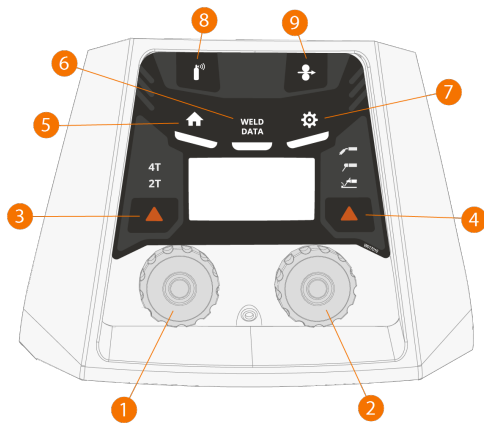
For replacing the wire feed rolls, refer to "Installing and replacing feed rolls" on page 99.

For replacing the wire guide tubes, refer to "Installing and replacing wire guide tubes" on page 102

1.8 X5 CONTROL PANELS

1.8.1 CONTROL PANEL OF X5 WF 200 MANUAL

This section describes the controls and features of the X5 Wire Feeder 200 Manual control panel (X5 FP 200R).

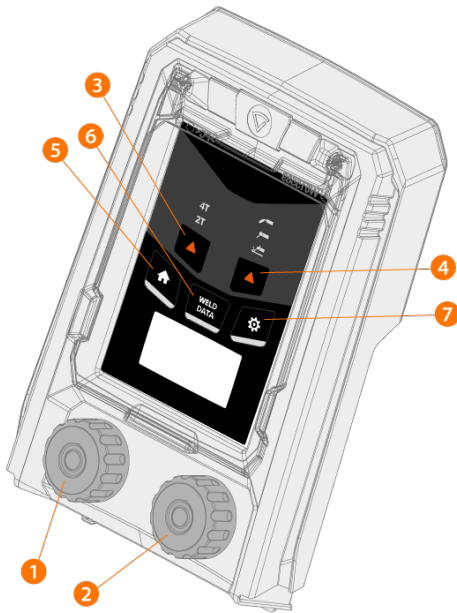


1. Left control knob
2. Right control knob
3. Trigger logic selection (2T/4T)
4. Process selection (MIG/MMA/Gouging/TIG)
5. Home button (default welding mode)
6. Weld data button
7. Settings button
8. Gas test button
9. Wire inch button

For using the control panel, refer to "Using X5 Manual control panel" on page 111.

1.8.2 CONTROL PANEL OF X5 WF 300 MANUAL AND HD200 MANUAL

This section describes the controls and features of the X5 Wire Feeder 300 Manual and X5 Wire Feeder HD200 Manual control panel (X5 FP 300R).



1. Left control knob
2. Right control knob
3. Trigger logic selection (2T/4T)
4. Process selection (MIG/MMA/Gouging/TIG)
5. Home button (default welding mode)
6. Weld data button
7. Settings button

For using the control panel, refer to "Using X5 Manual control panel" on page 111.

1.8.3 AP/APC CONTROL PANEL

This section describes the control panel (X5 FP 300 AP/APC) features of the following wire feeders:

- X5 Wire Feeder 300 AP/APC
- X5 Wire Feeder HD200 AP/APC
- X5 Wire Feeder HD300 AP/APC.



1. Left control knob (with push button function)
2. Right control knob (with push button function)
3. Memory channel selection (shortcut button)
4. View selection (shortcut button)
5. Welding parameters view (shortcut button).

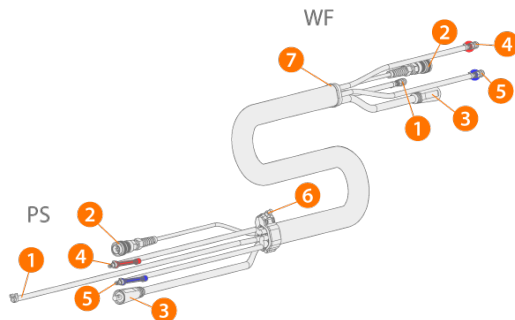
For using the control panel, refer to "Using X5 AP/APC control panel" on page 119.

1.9 X5 INTERCONNECTION CABLE

The X5 FastMig interconnection cables come in multiple different lengths and configurations to suit your equipment setup.

For installing the interconnection cable, refer to "Installing cables (X5 WF 200, X5 WF 300, X5 WF HD300)" on page 66 and "Installing cables (X5 WF HD200)" on page 72.

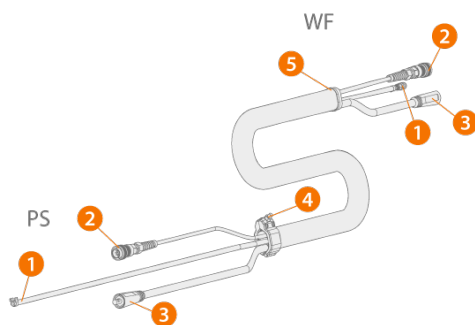
With water-cooling



(PS = Power source end of the interconnection cable, WF = Wire feeder end of the interconnection cable.)

1. Shielding gas hose
2. Control cable
3. Welding current cable
4. Coolant hose (outlet/inlet, color-coded)
5. Coolant hose (outlet/inlet, color-coded)
6. Strain relief collar (at the power source end)
7. Strain relief block (at the wire feeder end).

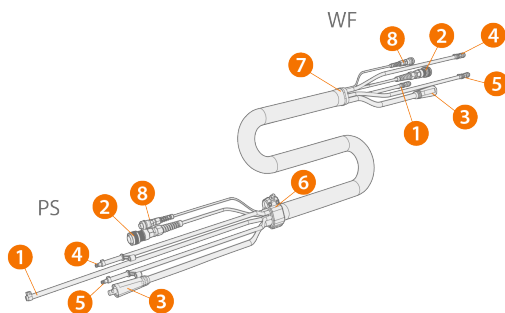
Without water-cooling



(PS = Power source end of the interconnection cable, WF = Wire feeder end of the interconnection cable.)

1. Shielding gas hose
2. Control cable
3. Welding current cable
4. Strain relief collar (at the power source end)
5. Strain relief block (at the wire feeder end).

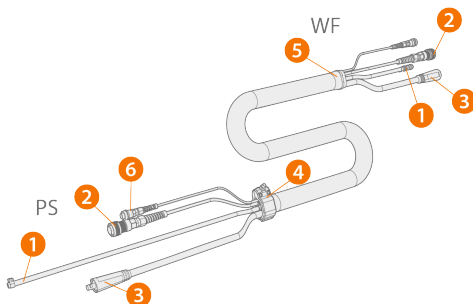
With voltage sensing cable and water-cooling



(PS = Power source end of the interconnection cable, WF = Wire feeder end of the interconnection cable.)

1. Shielding gas hose
2. Control cable
3. Welding current cable
4. Coolant hose (outlet/inlet, color-coded)
5. Coolant hose (outlet/inlet, color-coded)
6. Strain relief collar (at the power source end)
7. Strain relief block (at the wire weeder end)
8. Voltage sensing cable.

With voltage sensing cable, without water-cooling

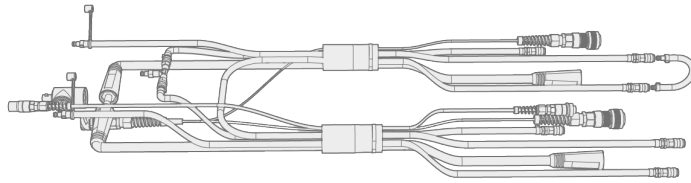


(PS = Power source end of the interconnection cable, WF = Wire feeder end of the interconnection cable.)

1. Shielding gas hose
2. Control cable
3. Welding current cable
4. Strain relief collar (at the power source end)
5. Strain relief block (at the wire weeder end)
6. Voltage sensing cable.

Adapter cable for double wire feeder installation

The adapter cable for a double wire feeder installation divides one interconnection cable for two wire feeders.



Interconnection cable specifications

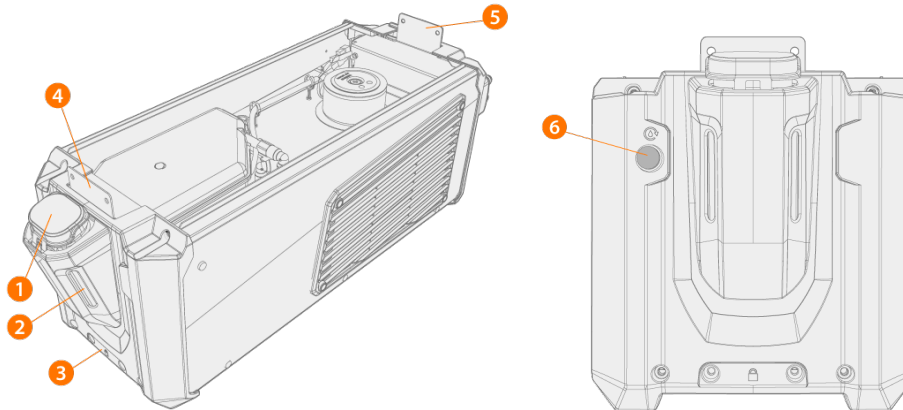
Cable	Cable type*	Cable length	Cooling	Connector types
X57002MW	70 mm ²	2 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current)
X57005MW	70 mm ²	5 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current)
X57010MW	70 mm ²	10 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current)
X57015MW	70 mm ²	15 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current)
X57020MW	70 mm ²	20 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current)
X57030MW	70 mm ²	30 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current)
X57040MW	70 mm ²	40 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current)
X57002MG	70 mm ²	2 m	Gas-cooled	10-pin (control), snap (gas), DIX (current)
X57005MG	70 mm ²	5 m	Gas-cooled	10-pin (control), snap (gas), DIX (current)
X57010MG	70 mm ²	10 m	Gas-cooled	10-pin (control), snap (gas), DIX (current)
X57015MG	70 mm ²	15 m	Gas-cooled	10-pin (control), snap (gas), DIX (current)
X57020MG	70 mm ²	20 m	Gas-cooled	10-pin (control), snap (gas), DIX (current)
X57025MG	70 mm ²	25 m	Gas-cooled	10-pin (control), snap (gas), DIX (current)
X57030MG	70 mm ²	30 m	Gas-cooled	10-pin (control), snap (gas), DIX (current)
X57035MG	70 mm ²	35 m	Gas-cooled	10-pin (control), snap (gas), DIX (current)
X57005MWW	70 mm ²	5 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current), 2-pin (voltage sensing)
X57010MGV	70 mm ²	10 m	Gas-cooled	10-pin (control), snap (gas), DIX (current), 2-pin (voltage sensing)

X57010MWW	70 mm ²	10 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current), 2-pin (voltage sensing)
X57002MGV	70 mm ²	2 m	Gas-cooled	10-pin (control), snap (gas), DIX (current), 2-pin (voltage sensing)
X57002MWW	70 mm ²	2 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current), 2-pin (voltage sensing)
X57005MGV	70 mm ²	5 m	Gas-cooled	10-pin (control), snap (gas), DIX (current), 2-pin (voltage sensing)
X57020MGV	70 mm ²	20 m	Gas-cooled	10-pin (control), snap (gas), DIX (current), 2-pin (voltage sensing)
X57020MWW	70 mm ²	20 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current), 2-pin (voltage sensing)
X57030MGV	70 mm ²	30 m	Gas-cooled	10-pin (control), snap (gas), DIX (current), 2-pin (voltage sensing)
X57030MWW	70 mm ²	30 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current), 2-pin (voltage sensing)
X59502MW	95 mm ²	2 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current)
X59502MWW	95 mm ²	2 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current), 2-pin (voltage sensing)
X59505MW	95 mm ²	5 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current)
X59510MW	95 mm ²	10 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current)
X59502MG	95 mm ²	2 m	Gas-cooled	10-pin (control), snap (gas), DIX (current)
X59505MG	95 mm ²	5 m	Gas-cooled	10-pin (control), snap (gas), DIX (current)
X59510MG	95 mm ²	10 m	Gas-cooled	10-pin (control), snap (gas), DIX (current)
X59502MWW	95 mm ²	2 m	Water-cooled	10-pin (control), snap (water/gas), DIX (current), 2-pin (voltage sensing)

* Welding current cable

1.10 X5 COOLING UNIT (OPTIONAL)

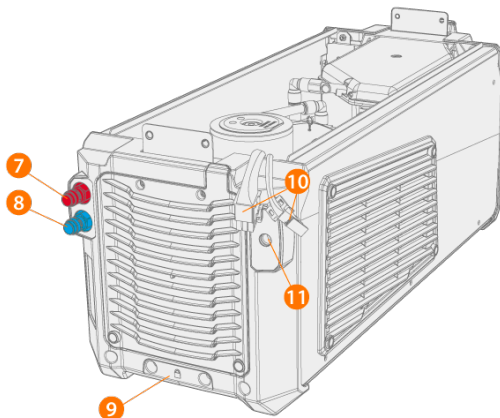
Front:



1. Cooler container cap
2. Cooling liquid level indicator
3. Front locking interface (for locking on the cart)
4. Front locking interface (for locking to the power source)
5. Rear locking interface (for locking to the power source)
6. Cooling liquid circulation button

>> Keeping the button pressed activates the pump and circulates the cooling liquid throughout the system. Once released, the pump stops.

Rear:



7. Coolant inlet/outlet connector (color-coded)
8. Coolant inlet/outlet connector (color-coded)
9. Rear locking interface (for locking on the cart)
10. Cooling unit to power source connectors
11. Additional strain relief mount.

1.11 OPTIONAL ACCESSORIES

	X5 PS X5 CU	X5 WF 300 AP/APC	X5 WF 300 Manual	X5 WF 200 Manual	X5 WF HD200 M/AP/APC	X5 WF HD300 M/AP/APC
4-wheel cart with gas bottle rack ¹	●	●	●	o	oo	●
2-wheel cart ¹	●	●	●	o	oo	●
Remote control HR40 (2-knob control)	-	●	●	●	●	●
Remote control HR43 (1-knob control)	-	●	●	●	●	●
Remote control HR55 (digital)	-	●	●	●	●	●
Accessory rack	●	-	-	-	-	-
Wire feeder cabinet heater	-	●	●	●	●	●
Built-in rotameter for gas	-	●	●	● ³	●	●
Gas guard	-	-	-	-	-	●
SuperSnake GTX subfeeder	-	●	●	-	-	●
Wire feeder cart, 4-wheel	-	●	●	o	oo	●
Wire feeder cart, 2-wheel	-	●	●	-	oo	●
Wire feeder rotating plate, single and double	-	●	●	o	oo	●
Wire feeder hanger for boom, single and double ²	-	●	●	-	-	●
Wire feeder counterbalance arm	-	●	●	o	-	-
Gun holder	-	●	●	-	-	-
Wire drum kit	-	●	●	-	-	●
Additional steel pipe frame	-	-	-	●	-	-
Wire feeder protection sliders	-	●	●	-	●	●
Remote pendant kit	-	●	●	-	-	-
Power source stand	●	-	-	-	-	-
Power source air filter	●	-	-	-	-	-

● = Available

o = Can be used with the additional steel pipe frame

oo = Can be used with the additional wire feeder protection sliders

- = Not available or not applicable

¹⁾ Designed to be used with a full system (equipment stacked on top of each other).

²⁾ Double wire feeder hanger for boom not available with X5 Wire Feeder HD300 models.

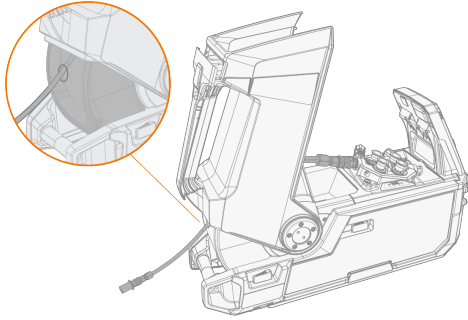
³⁾ Cannot be installed afterward, a separate wire feeder model with the rotameter factory-installed is available.

Read also the installation notes here: "Installation" on page 48.

The accessories described here are delivered with dedicated installation instructions.


Wire drum kit (for X5 WF 300)

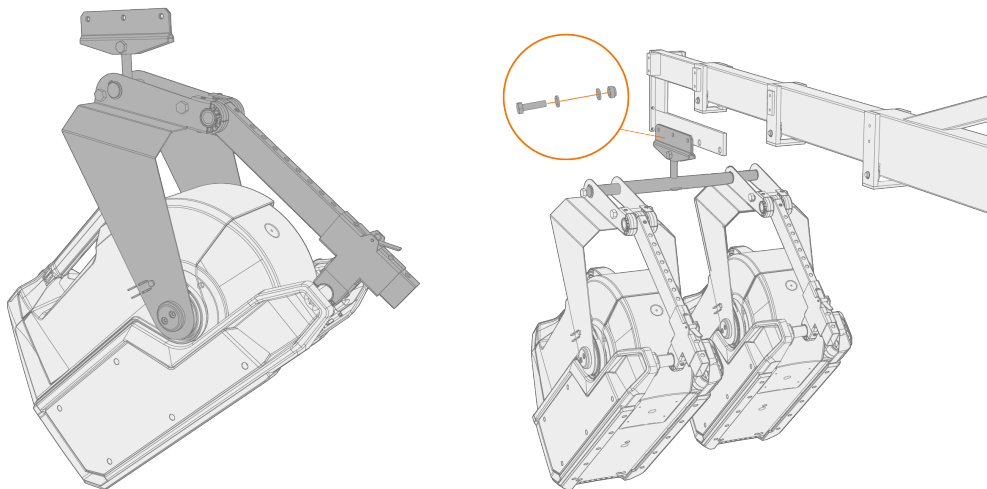
To use the wire drum kit, drill a hole at the back of X5 Wire Feeder 300 transparent cover.



Wire feeder hanger for boom (for X5 WF 300)

The wire feeder hanger for boom facilitates welding where it is difficult to bring the full X5 FastMig welding system.

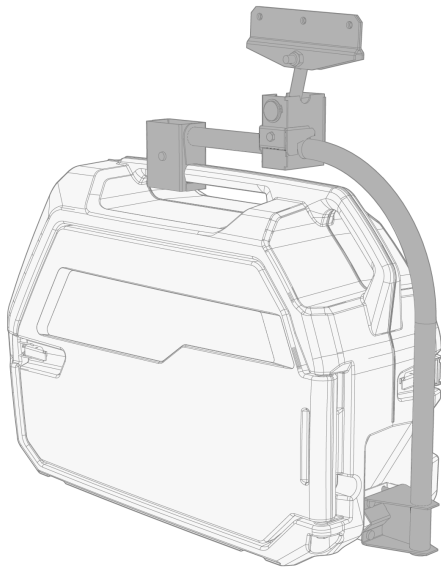
 *Do not hang the wire feeder from the handle. Use the wire feeder hanger for boom instead.*



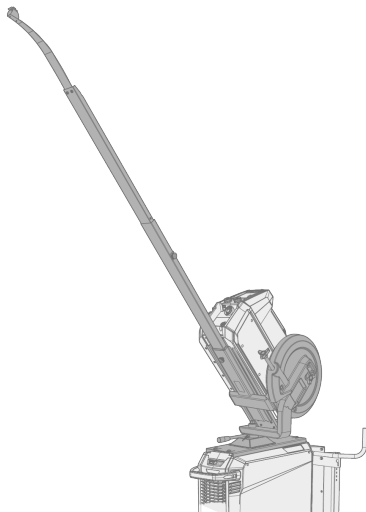
Wire feeder hanger for boom (for X5 WF HD300)

The wire feeder hanger for boom facilitates welding where it is difficult to bring the full X5 FastMig welding system.

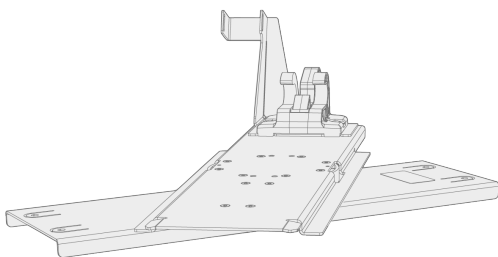
 *Do not hang the wire feeder from the handle. Use the wire feeder hanger for boom instead.*

**Wire feeder counterbalance arm (for X5 WF 300)**

The wire feeder counterbalance arm reduces the weight of the cable bundle over the working area.

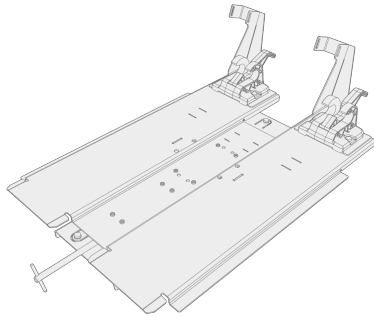
**Single wire feeder rotating plate (for X5 WF 300)**

The single wire feeder rotating plate allows the use of one wire feeder on one power source.



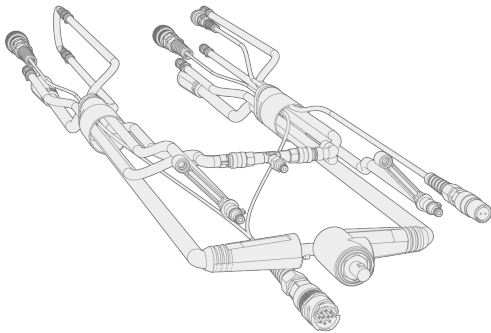
Double wire feeder rotating plate (for X5 WF 300)

The double wire feeder rotating plate allows the use of two wire feeders on one power source.



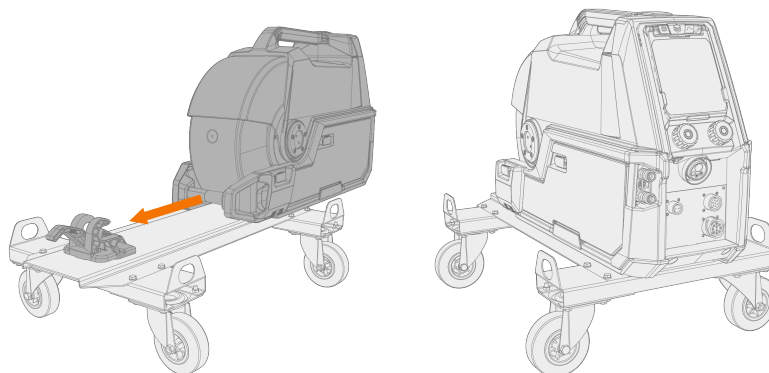
Double interconnection cable adapter

The double interconnection cable adapter allows to connect two wire feeders to one power source.



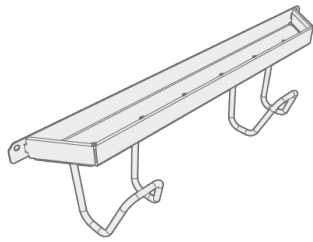
Wire feeder cart (for X5 WF 300)

The wire feeder cart allows more convenient wire feeder movement on site.



Accessory rack

The accessory rack holds the small parts and tools needed for welding. Install it on the side of the welding machine.

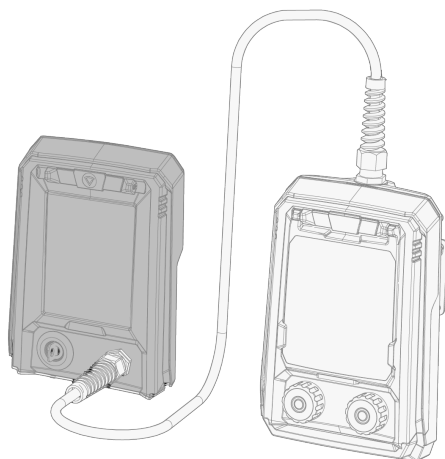


Wire feeder cabinet heater

The wire feeder cabinet heater keeps the temperature higher to prevent moisture from condensing inside the cabinet.

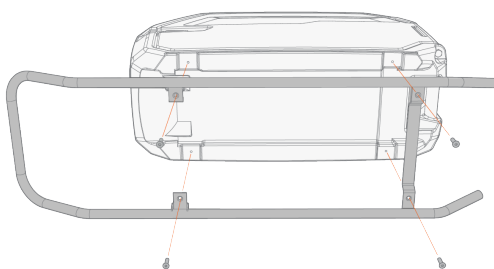
Control panel remote pendant kit (for X5 WF 300)

The control panel remote pendant kit allows the wire feeder control panel to be removed from the wire feeder device and to be used remotely, within the remote cable length distance.



Wire feeder protection sliders (for X5 WF 300/HD300)

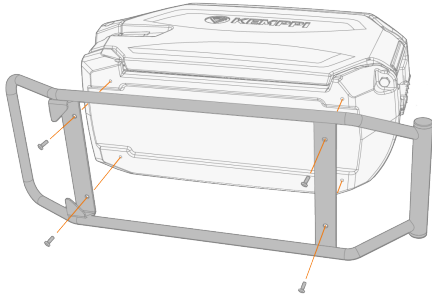
Protection sliders can be used under the wire feeder to prevent damaging the wire feeder bottom. With X5 Wire Feeder HD300 protection sliders, an additional bracket provides also mechanical support for the welding cable connection.



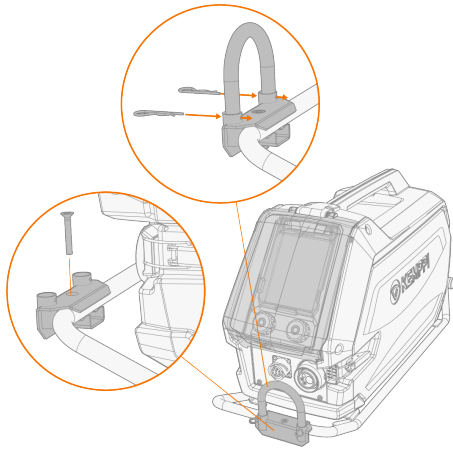
This illustration is for general reference only. Different wire feeder models may require different model-specific protection sliders. For more information, contact your local Kemppi dealer.

Wire feeder protection sliders (for X5 WF HD200)

Protection sliders can be used under the wire feeder to prevent damaging the wire feeder bottom. The X5 Wire Feeder HD200 protection sliders are also required when the wire feeder is installed on top of the X5 power source (with the power source fixing accessories). The protection sliders also allow the X5 wire feeder cart to be used with X5 Wire Feeder HD200.



The protection sliders include a welding torch cable support bracket:



For more information on optional accessories, contact your local Kemppi dealer.

For installing the optional accessories, refer to the installation instructions delivered with the equipment.

1.12 WELDEYE INTRODUCTION

WeldEye is a universal software solution to manage welding production. It has been designed to make every-day tasks of welding, quality and production departments easier. It offers cloud-based tools for managing welding procedure specifications (WPS) and WPQRs, welding personnel and their qualifications, welding documentation, work orders, welding parameter monitoring, and heat input verification.

WeldEye's modular structure is based on various useful functions that serve the needs of wide-ranging industries and welding-related tasks:





- **Welding procedures**
 - >> Includes the digital library and management of pWPS, WPQR and WPS templates according to the most important welding standards.
- **Personnel and qualifications**
 - >> Includes the management and renewal processes of all personnel - welders and inspectors - qualification certificates.
- **Quality management**
 - >> Includes quality verification functionalities with digital WPS and qualification compliance control against automatically collected digital welding data.

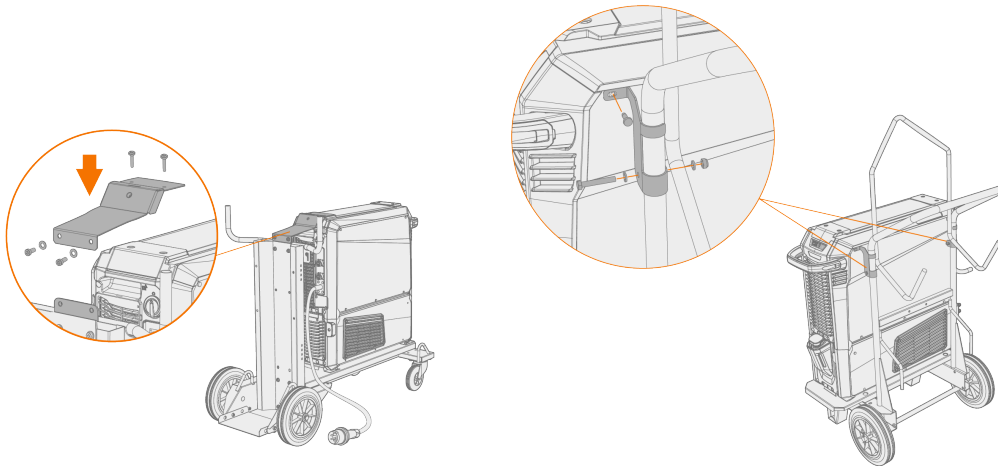
WeldEye options with the X5 FastMig equipment:


- **"WeldEye" on page 162**
 - >> Work orders, work completion and heat input reporting, WPS (Welding Procedure Specification) compliance verification, Welder qualification verification.
- **"Digital Welding Procedure Specification (dWPS)" on page 161**
 - >> WPS compliance verification.
- **"WeldEye ArcVision" on page 162**
 - >> Built-in tracking of the welding operations carried out with the welding equipment.
- **"WeldEye with DCM" on page 163**
 - >> Tracking of the welding operations carried out with the welding equipment using a Digital Connectivity Module (DCM) device and WeldEye App mobile application.

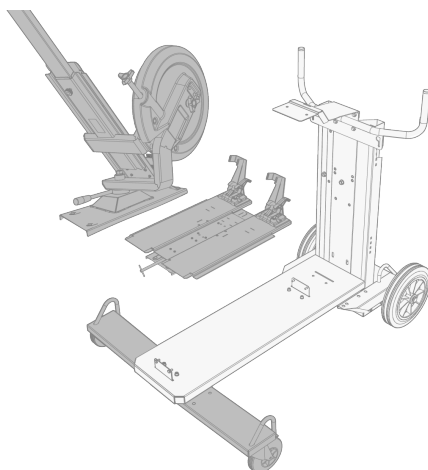
For more information on WeldEye, refer to weldeye.com or contact your Kemppi representative.


2. INSTALLATION

-  Do not connect the equipment to the mains before the installation is complete.
-  Do not modify the welding equipment in any way, except for the changes and adjustments covered in the manufacturer's instructions.
-  Do not attempt to move or hang the equipment mechanically (e.g. with a hoist) from the handle on the power source unit or on the wire feeder unit. The handles are for manual moving only. With wire feeders, this applies to the non-HD wire feeder models. HD wire feeder models allow mechanical lifting from the handle when not fixed on top of the power source.
-  When installing the full set of equipment stacked as a tower – water cooler at the bottom, power source in the middle and wire feeder at the top – always install and secure the equipment onto a Kemppli cart compatible with X5 FastMig or secure the equipment to other adequate support on site.



-  When installing the full set of equipment stacked as a tower and using the double wire feeder rotating plate or counterbalance arm, always use the broader front roller support plate delivered with the equipment. This applies to the 4 wheel cart.





-  Place the machine on a horizontal, stable and clean ground. Protect the machine from rain and direct sunshine. Check that there is enough space for cooling air circulation in the machine vicinity.

Before installation

- Make sure to acknowledge and follow the local and national requirements regarding installation and use of high voltage units.
- Check the contents of the packages and make sure the parts are not damaged.
- Before you install the power source on site, see the requirements for the mains cable type and fuse rating.




Distribution network

 *This Class A equipment is not intended for use in residential locations where the electrical power is provided by the public low-voltage supply system. There can be potential difficulties in ensuring electromagnetic compatibility in those locations, due to conducted as well as radiated radio-frequency disturbances.*

 *Provided that the short circuit power of public low voltage system at the point of common coupling is higher than mentioned in the table below (*), the equipment is compliant with IEC 61000-3-11:2017 and IEC 61000-3-12:2011 and can be connected to public low voltage systems. It is the responsibility of the installer or user of the equipment to ensure, by consultation with the distribution network operator if necessary, that the system impedance complies with the impedance restrictions.*

Equipment	*
X5 power source 400A:	5.8 MVA
X5 power source 500A:	6.4 MVA
X5 pulse power source 400A:	6.3 MVA
X5 pulse power source 500A:	6.7 MVA

2.1 INSTALLING POWER SOURCE MAINS PLUG

-  Only an authorized electrician is allowed to install the mains cable and plug.
-  Only connect the welding machine to an earthed electric network.
-  Do not connect the machine to the mains before the installation is complete.

Install the 3-phase plug according to the X5 FastMig power source and site requirements. Refer also to "Technical data" on page 185 for power source specific technical information.

The mains cable includes the following wires:

1. Brown: L1
2. Black: L2
3. Grey: L3
4. Yellow-green: Protective earth

Table. Cable type and fuse rating requirements:

Unit amperage	High voltage version (380-460V)	
	Cable type	Fuse rating
400 A	4 mm ²	25 A
500 A	6 mm ²	32 A

Unit amperage	Multi-voltage version (380-460V / 220-230V)	
	Cable type	Fuse rating
400 A MV	6 mm ²	32 A / 25 A

*MV = Multi-voltage

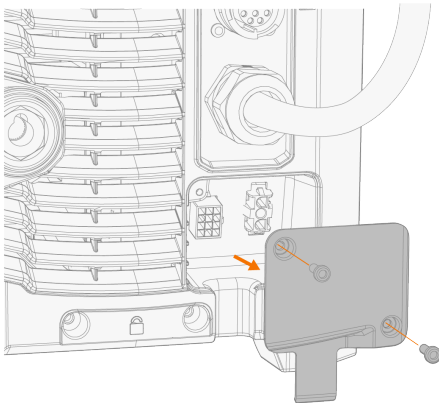
2.2 INSTALLING COOLING UNIT (OPTIONAL)

 *The X5 cooling unit must be installed by authorized service personnel.*


Tools needed:

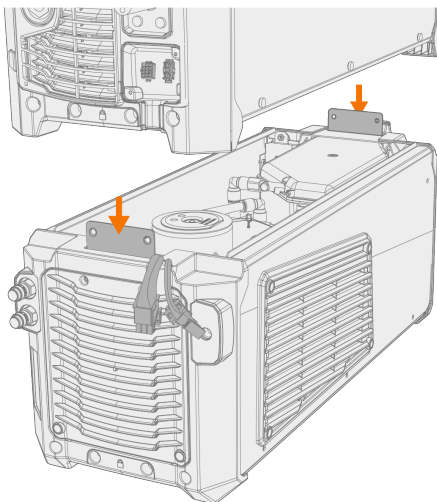


1. Remove the small connector cover in the rear of the power source.

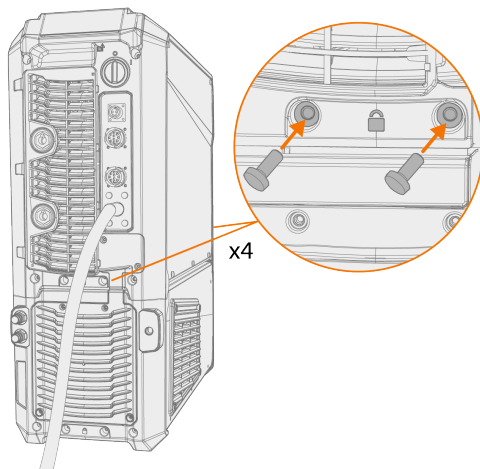


2. Route the cooling unit's connection cables so that they remain accessible through the next steps.
3. Lift the power source on top of the cooling unit so that the fixing plates align and go into their slots.

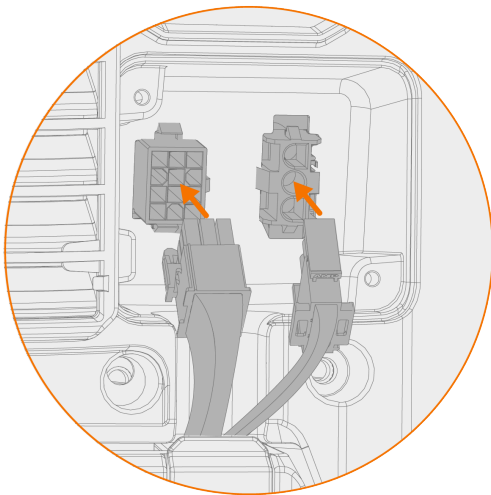
 *Ensure that the cooling unit's connection cables are not caught and/or damaged between the edges.*




4. Fix the units together with two screws (M5x12) in the front and two screws (M5x12) in the rear.

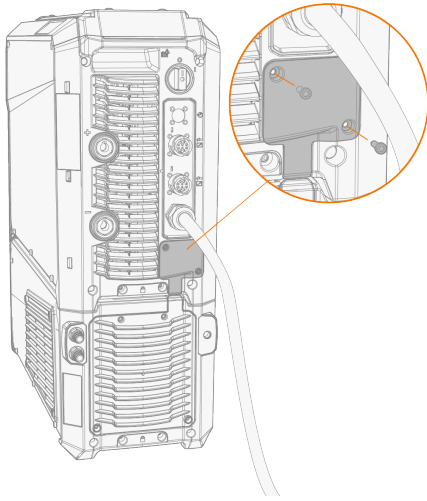


5. Connect the cooling unit cables.



 *Do not use force, but make sure the connectors are properly connected.*



6. Replace the small connector cover.

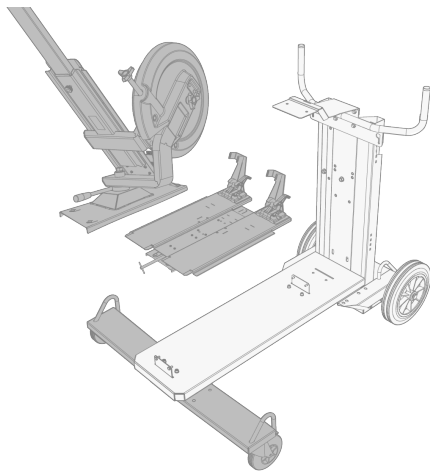


2.3 INSTALLING EQUIPMENT ON CART (OPTIONAL)

The X5 FastMig has two transport unit options: a 4-wheel cart with gas bottle rack and a 2-wheel cart without gas bottle rack. The X5 FastMig equipment can be installed on the cart with or without the cooling unit.

For more information on the connection interface and installing the power source on top of the cooling unit, refer to "Installing cooling unit (optional)" on page 51.

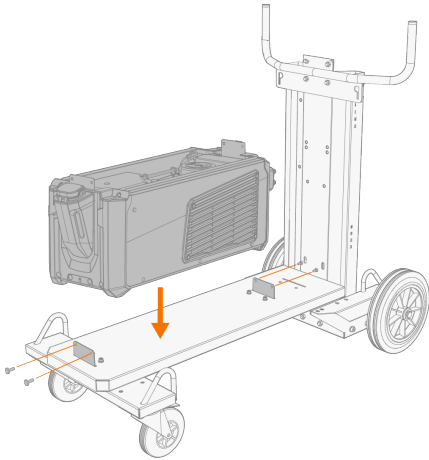
-  *The equipment installation principle and the bottom securing interface is the same with both carts. Only the top cart connection bracket installation is different.*
-  *When installing the full set of equipment stacked as a tower and using the double wire feeder rotating plate or counterbalance arm, always use the broader front roller support plate delivered with the equipment. This applies to the 4 wheel cart.*



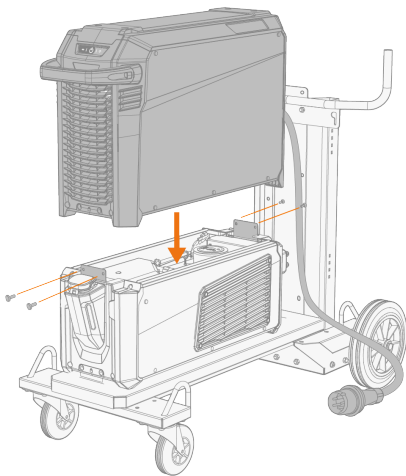
Tools needed:



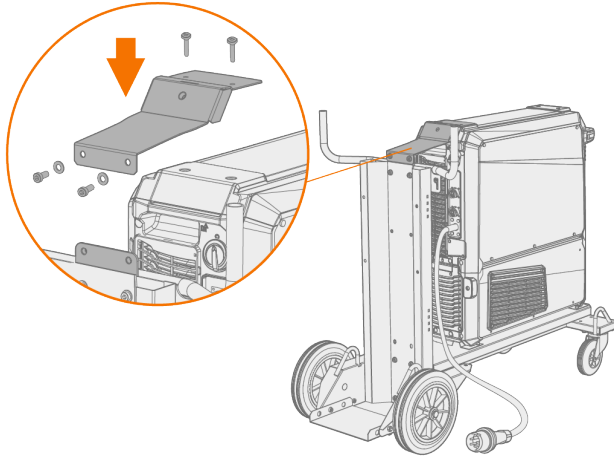
1. Install the cooling unit on the cart.



2. Fix the cooling unit to the cart with two screws (M5x12) in the front and two screws (M5x12) in the rear.
3. Install the power source on top of the cooling unit. Refer to "Installing cooling unit (optional)" on page 51 for installation details.



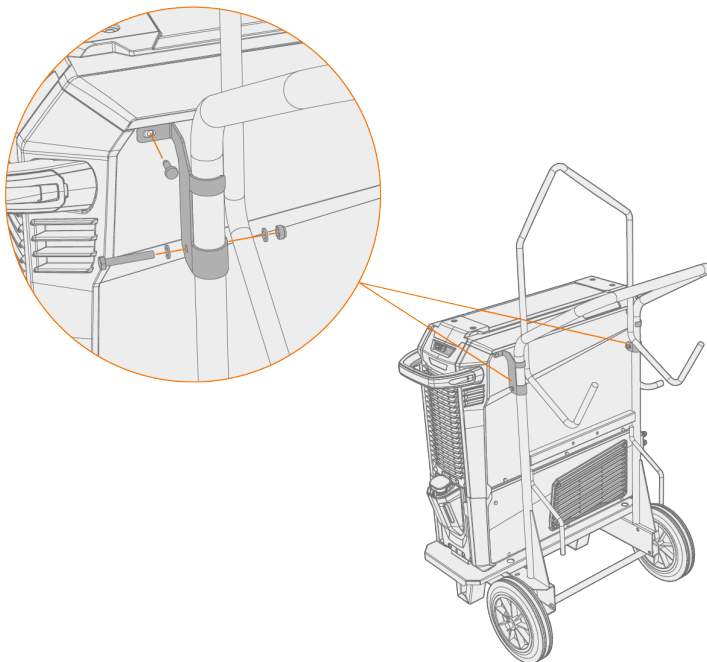
4. 4-wheel cart: Secure the equipment to the cart with the rear connection bracket (rear fixing plate, long).
Rear screws: M8x16, top screws: M6x30.



5. 2-wheel cart: Secure the equipment to the cart with the two side connection brackets.



The 2-wheel cart's side connection brackets use the X5 power source's side plate top screw holes for securing. Replace the side plate top screws with the ones delivered with the 2-wheel cart side connection brackets.




For more information on fixing plates and wire feeders, refer to "Installing wire feeder with fixed plate" on the next page.

For lifting the equipment, refer to "Lifting equipment" on page 173.

2.4 INSTALLING WIRE FEEDER WITH FIXED PLATE

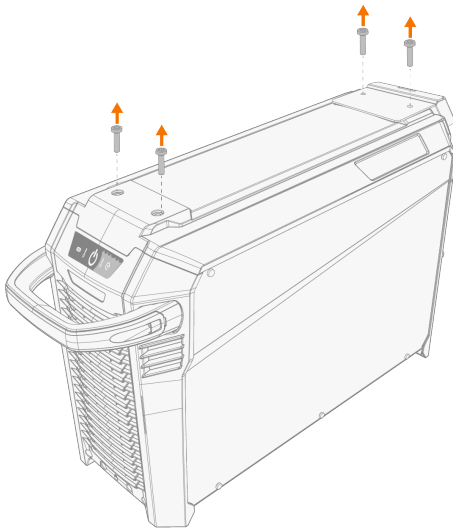
This section describes the fixed installation of X5 Wire Feeder 300 (on top of the power source).

 For stacked installation, additional support is required. Read the installation notes here: "Installation" on page 48.

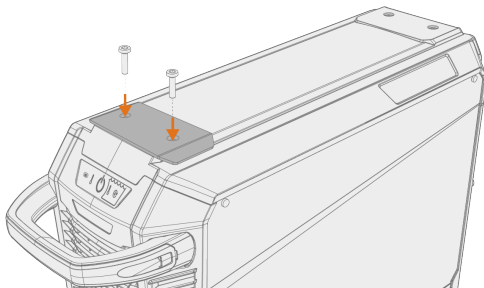
Tools needed:



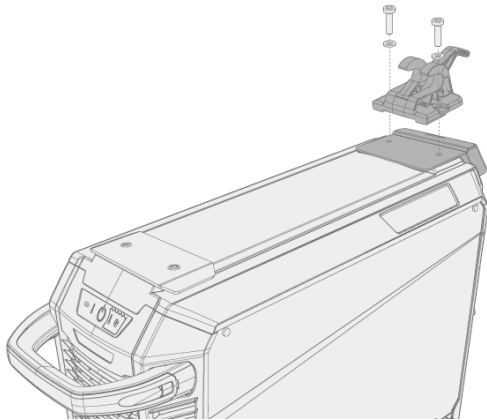
1. Temporarily remove the power source top cover screws.



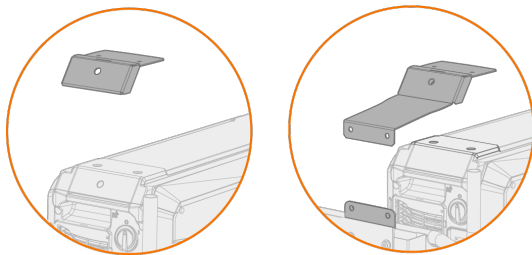
2. Place the front fixing plate on the power source and secure it in place using two of the power source top cover screws (M6x30).



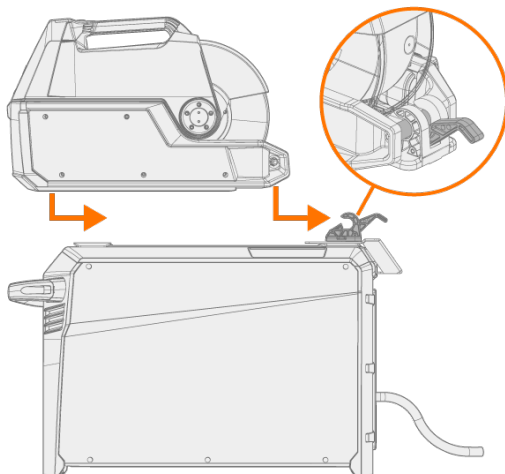
- Place the rear fixing plate and the wire feeder locking mechanism on the power source. Secure them in place with the two screws (M6x40) provided with the locking mechanism.



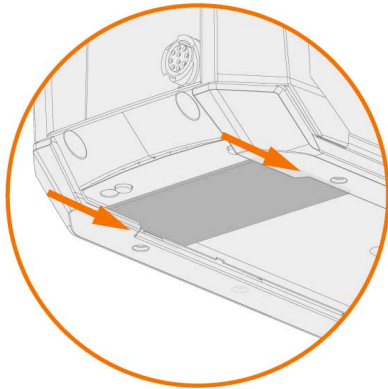
- i** Depending on your X5 FastMig setup, two different rear fixing plate options are available. Both include an interface for the interconnection cable strain relief mechanism, but the longer one acts also as a cart connection bracket.



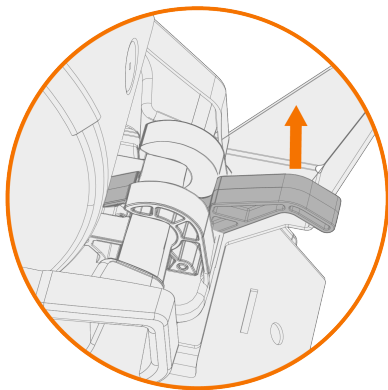
- Slide the wire feeder from front to back until the bar in the back locks into the locking mechanism on the power source.



5. Ensure that also the front of the wire feeder is locked in position (to the front fixing plate edge).




The rear locking is released by pulling the locking mechanism lever:



2.5 INSTALLING WIRE FEEDER WITH STANDARD ROTATING PLATE

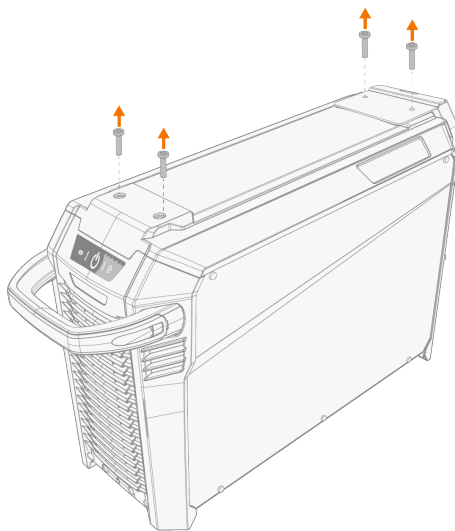
This section describes the installation of X5 Wire Feeder 300 (on top of the power source) with the standard rotating plate. Refer also to the installation instructions delivered with the rotating plate.

 For stacked installation, additional support is required. Read the installation notes here: "Installation" on page 48 and "Optional accessories" on page 41.


Tools needed:




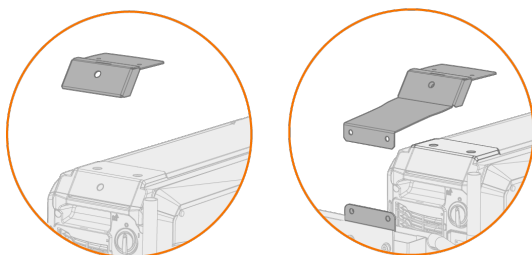
1. Temporarily remove the power source top cover screws.



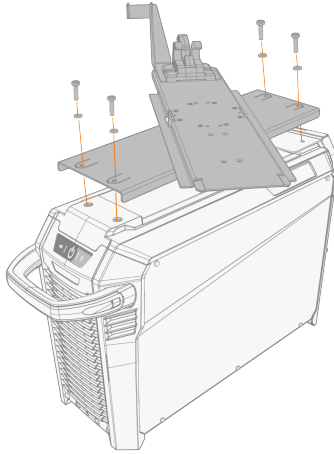
2. Place the wire feeder rotating plate on top of the power source.

 If the rear fixing plate was not yet installed at this stage, install it together with the rotating plate.

 Depending on your X5 FastMig setup, two different rear fixing plate options are available. Both include an interface for the interconnection cable strain relief mechanism, but the longer one acts also as a cart connection bracket.

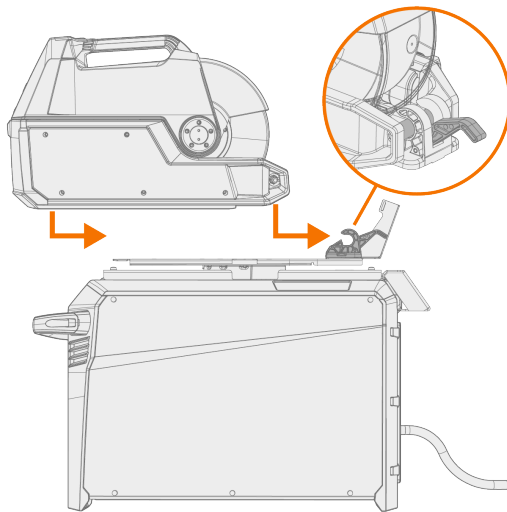


3. Secure the rotating plate in place (together with the rear fixing plate) using the power source top cover screws (M6x30).

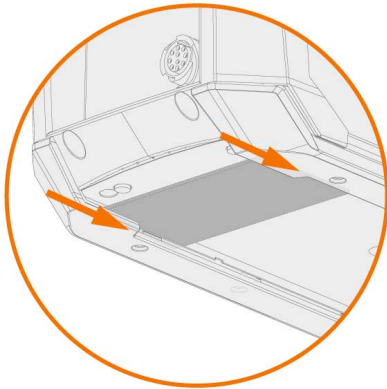


Tip: To gain access to the fixing holes in the lower plate, turn the top plate.

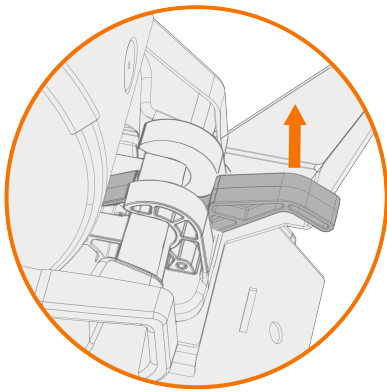
4. Slide the wire feeder from front to back until the bar in the back of the unit locks into the locking mechanism on the rotating plate.



5. Ensure that the front of the unit has also locked in position (to the front edge of the rotating plate).



The rear locking is released by pulling the locking mechanism lever:



2.6 INSTALLING WIRE FEEDER WITH LOCKABLE ROTATING PLATE

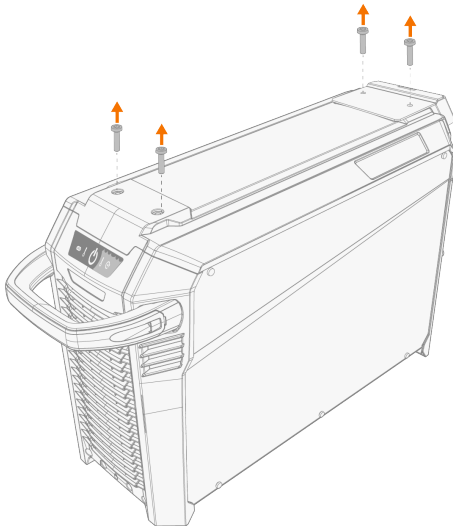
This section describes the installation of X5 Wire Feeder 300 (on top of the power source) with the lockable rotating plate. Refer also to the installation instructions delivered with the rotating plate.

- i *The installation of the wire feeder rotating plate and the wire feeder double rotating plate on top of the power source is identical. However, for stacked installation, additional support is required. Read the installation notes here: "Installation" on page 48 and "Optional accessories" on page 41.*

Tools needed:

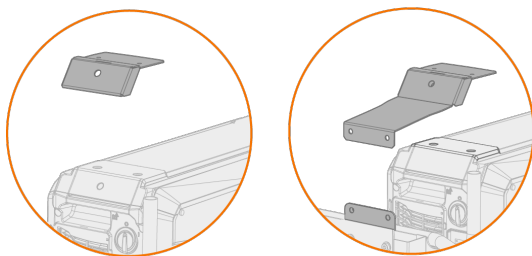


1. Temporarily remove the power source top cover screws.

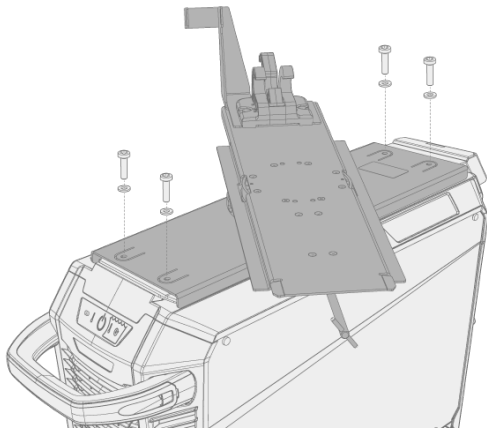


2. Place the wire feeder rotating plate on top of the power source.

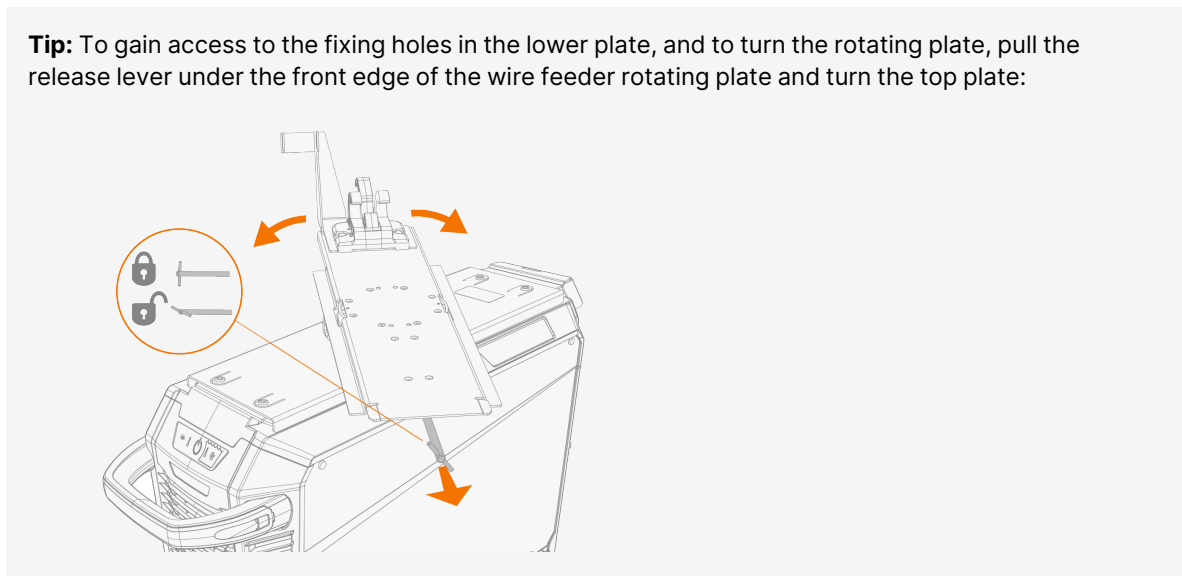
- i *If the rear fixing plate was not yet installed at this stage, install it together with the rotating plate.*
- i *Depending on your X5 FastMig setup, two different rear fixing plate options are available. Both include an interface for the interconnection cable strain relief mechanism, but the longer one acts also as a cart connection bracket.*



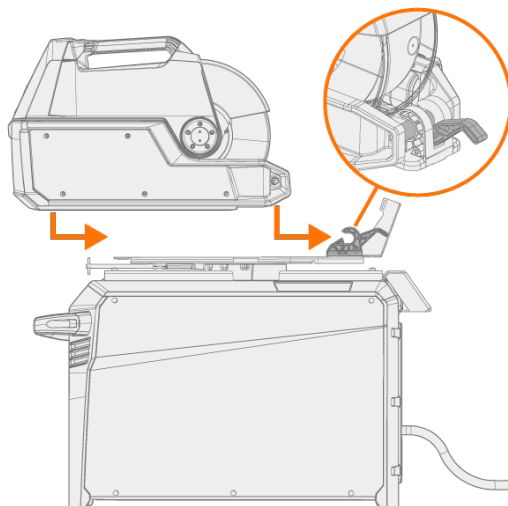
- Secure the rotating plate in place (together with the rear fixing plate) using the power source top cover screws (M6x30).



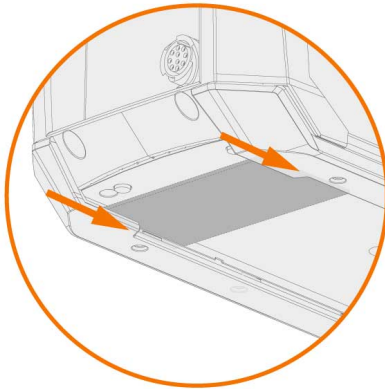
Tip: To gain access to the fixing holes in the lower plate, and to turn the rotating plate, pull the release lever under the front edge of the wire feeder rotating plate and turn the top plate:



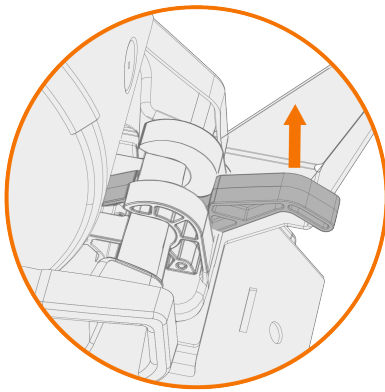
- Slide the wire feeder from front to back until the bar in the back of the unit locks into the locking mechanism on the rotating plate.



5. Ensure that the front of the unit has also locked in position (to the front edge of the rotating plate).



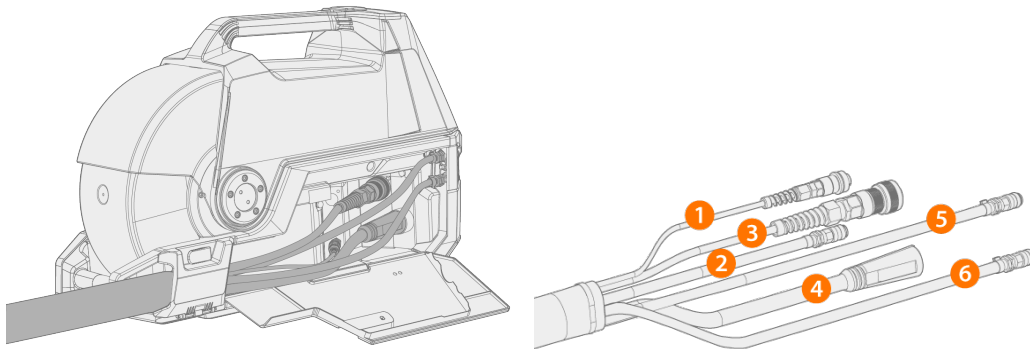
The rear locking is released by pulling the locking mechanism lever:




2.7 INSTALLING CABLES (X5 WF 200, X5 WF 300, X5 WF HD300)

Connect the interconnection cable first to the wire feeder and then to the power source. For the connector descriptions and their locations, refer to "X5 Wire Feeder 200" on page 16, "X5 Wire Feeder 300" on page 20 or "X5 Wire Feeder HD300" on page 28 (depending on your wire feeder model).

Connecting interconnection cable to wire feeder

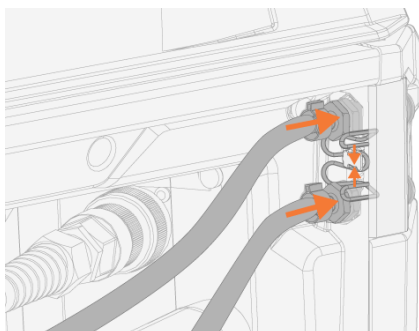


1. Open the cable cabinet hatch to reveal the connectors.
2. Connect the welding current cable (4) to the wire feeder. Push the cable as far as it goes and turn the connector clockwise to tighten the cable to its place.


 *Tighten the welding current cable as much as you can by hand. If the welding current cable connection is loose, it may overheat.*

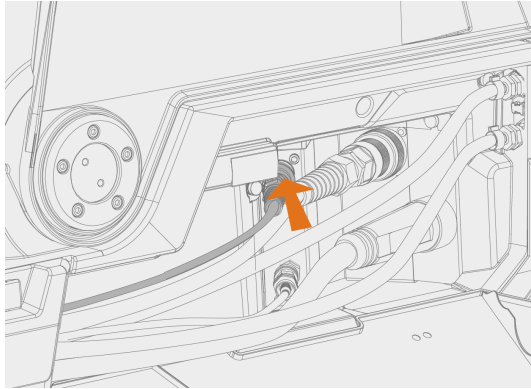
3. Push the shielding gas hose (2) to the shielding gas hose connector so that it locks down.
4. Connect the control cable (3) to the connector. Rotate the collar clockwise to lock it in place.
5. If you have the optional cooling unit, place the cooling liquid hose connectors (5, 6) into the slot and through the aperture.

>> Compress the spring fastener to get the hose connectors in place. Once released, ensure that the spring fastener locks in place into the hose connector grooves.



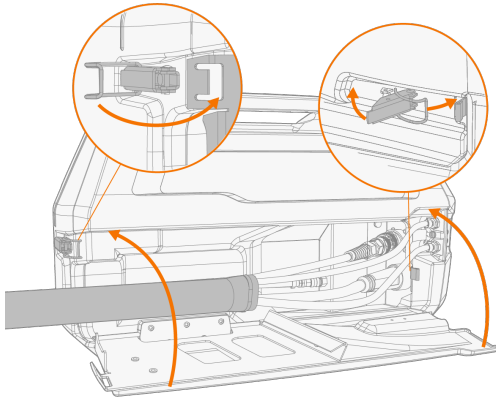
6. If you have the voltage sensing cable (1) in use, connect it to the voltage sensing cable connector inside the cabinet.

 *The separate voltage sensing cable is supported by Pulse+ power sources only.*

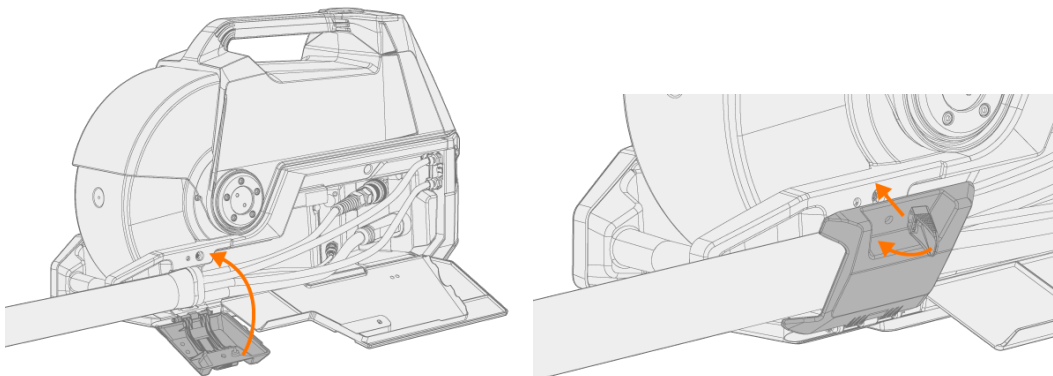


7. Secure cable strain relief.

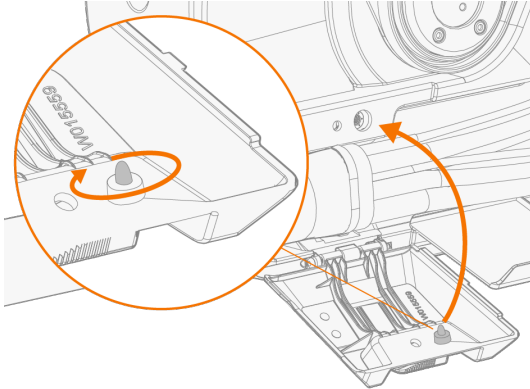
>> X5 Wire Feeder 200: Place the cable to the slot on the wire feeder and secure it in place by closing the hatch and locking the latches.



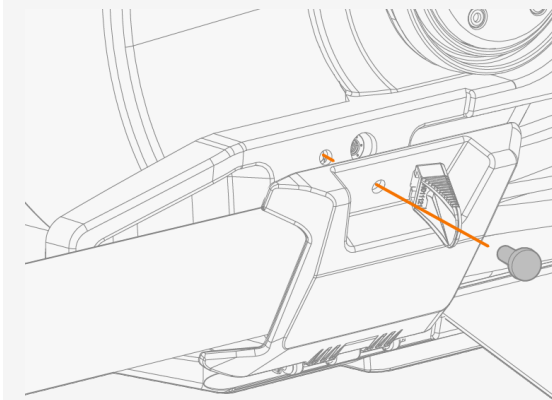
>> X5 Wire Feeder 300: Place the cable's strain relief block to the slot on the wire feeder and secure it in place by closing and locking the strain relief latch.



- i** Check the expanding locking knob tightness and tighten if necessary:



Tip: Additional X5 Wire Feeder 300 strain relief fixing (M6x16 screw), optional:

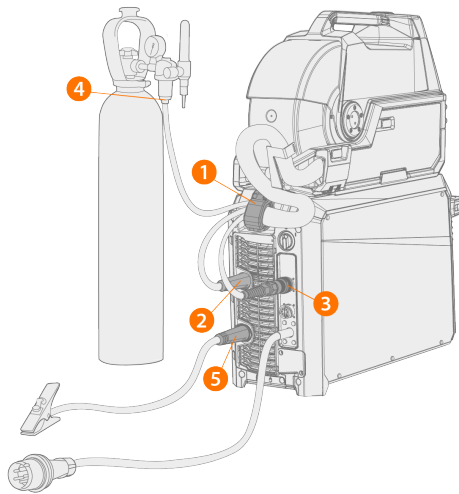


- 8.** X5 Wire Feeder 300: Close and lock the cable cabinet door.

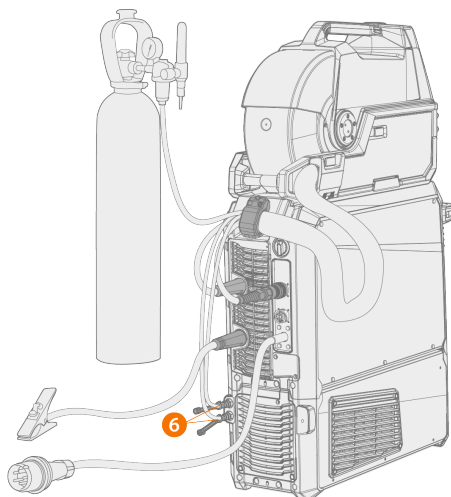
i When connecting the cables to the wire feeder, route the cables neatly so that the cable cabinet door closes properly.

! The interconnection cable heats up during welding. The wire feeder's cable cabinet door must be kept closed when welding, and the cables must be handled with caution if the cabinet door is opened right after welding.

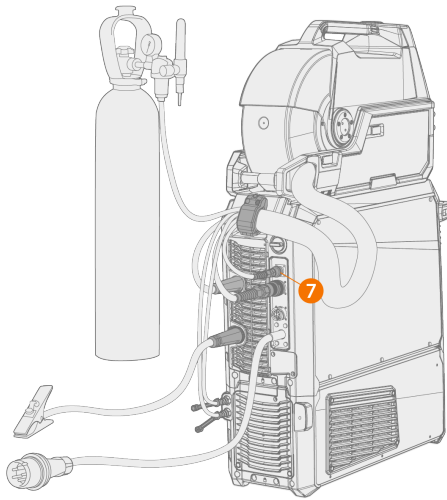
Connecting interconnection cable and earth return cable to power source



1. Attach the cable's strain relief (1) to the rear fixing plate.
2. Connect the welding current cable to the plus (+) connector (2) on the power source.
3. Connect the earth return cable to the minus (-) connector (5) on the power source.
4. Connect the control cable (3) to the power source.
5. Connect the shielding gas hose (4) to the gas bottle.
6. If you have the optional cooling unit, connect the cooling liquid hoses (6). The hoses are color-coded.



7. Pulse+ power source only: If you have the voltage sensing cable in use, connect it to the connector (7) on the rear of the power source.

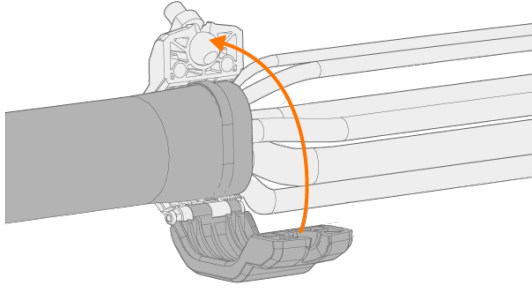


- i** Most MIG/MAG applications and filler wires run the wire feed unit's welding current cable connected to the positive terminal of the power source. The polarity can be selected by connecting the welding current cable and earth return cable accordingly to either the positive or negative connectors on the power source.
- i** For TIG welding, the polarity (+/-) must be switched. The polarity can be selected by connecting the welding current cable and earth return cable accordingly to either the positive or negative connectors on the power source.
- i** For double wire feeder installation, use the interconnection cable designed for two wire feeders.
- ⚠** Ensure that you have connected and tightened all the cables properly.

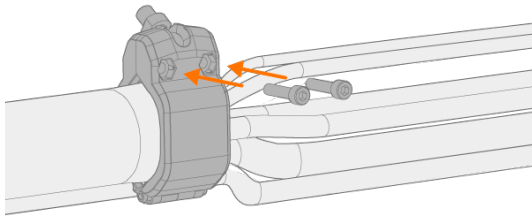
Strain relief replacement

Removing and replacing the strain relief at the power source end of the interconnection cable:

1.



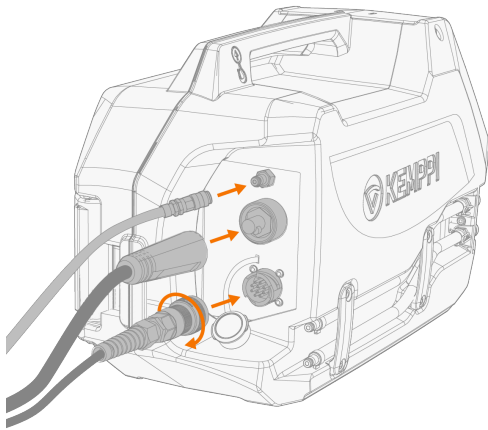
2.




2.8 INSTALLING CABLES (X5 WF HD200)

Connect the interconnection cable first to the wire feeder and then to the power source. For the connector descriptions and their locations, refer to "X5 Wire Feeder HD200" on page 24.

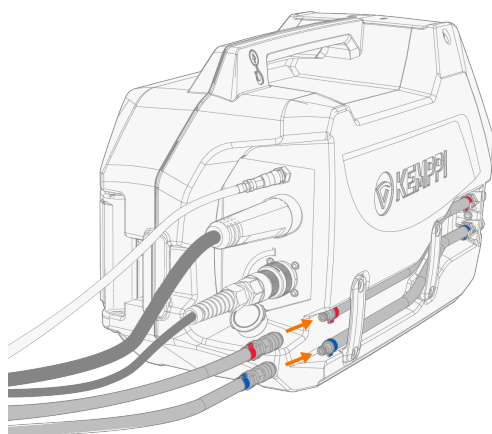
Connecting interconnection cable to wire feeder



1. Connect the welding current cable to the wire feeder. Push the cable as far as it goes and turn the connector clockwise to tighten the cable to its place.

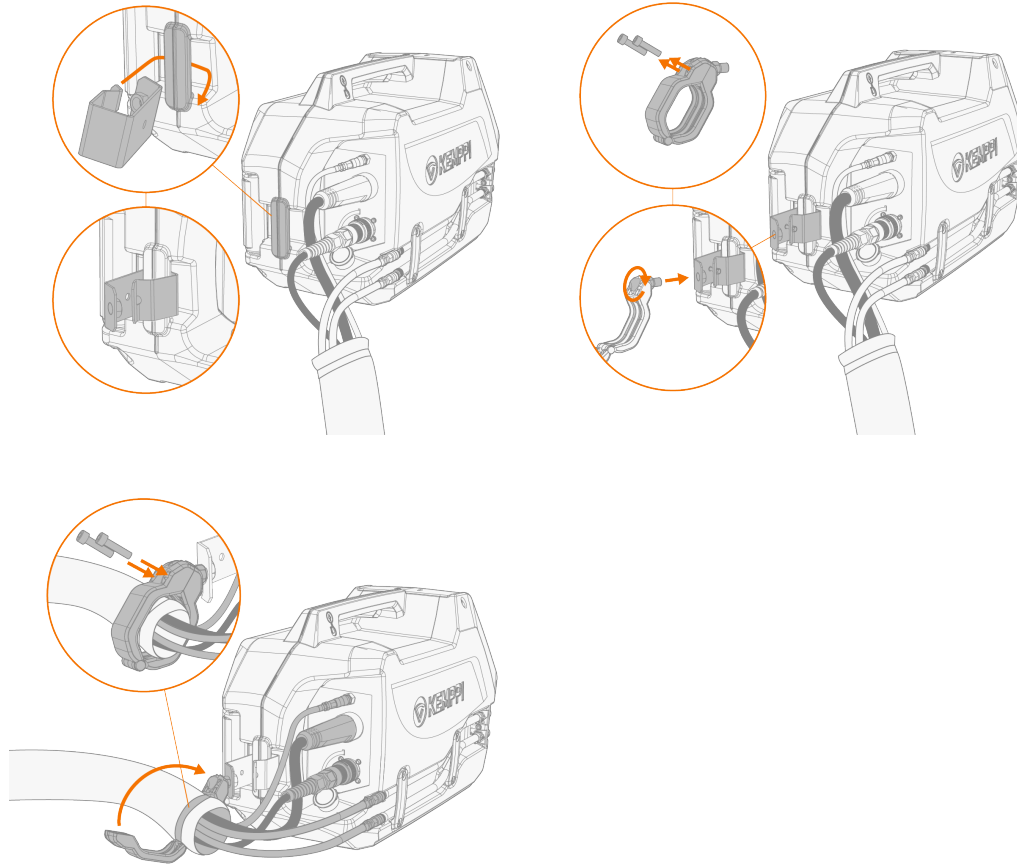
 *Tighten the welding current cable as much as you can by hand. If the welding current cable connection is loose, it may overheat.*

2. Push the shielding gas hose to the shielding gas hose connector so that it locks down.
3. Connect the control cable to the connector. Rotate the collar clockwise to lock it in place.
4. If you have the optional cooling unit, connect the coolant liquid hoses to the continuation hose connectors. The outlet and inlet connectors are color-coded.



5. Secure cable strain relief.

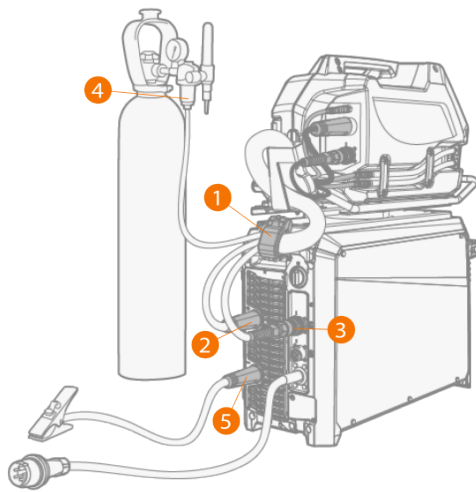
- >> Release the strain relief block screws to open the top section. Then place the cable pack to the block and secure it by closing the top section and replacing the screws.
- >> If not already, connect the strain relief block to the interface on the rear of the wire feeder.



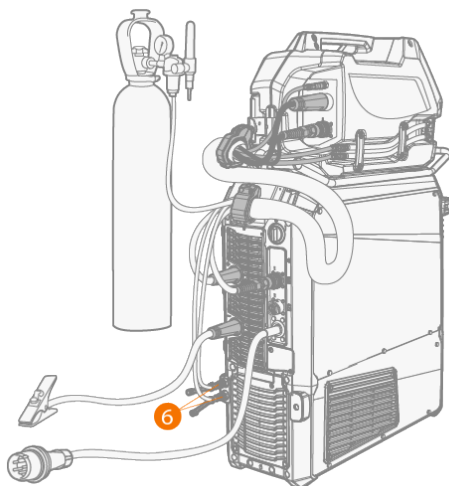
i When connecting the cables to the wire feeder, route the cables neatly.

! The interconnection cable heats up during welding, the cables must be handled with caution.


Connecting interconnection cable and earth return cable to power source



1. Attach the cable's strain relief (1) to the rear fixing plate.
2. Connect the welding current cable to the plus (+) connector (2) on the power source.
3. Connect the earth return cable to the minus (-) connector (5) on the power source.
4. Connect the control cable (3) to the power source.
5. Connect the shielding gas hose (4) to the gas bottle.
6. If you have the optional cooling unit, connect the cooling liquid hoses (6). The hoses are color-coded.



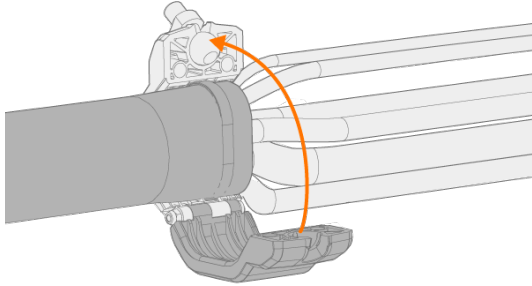
- i Most MIG/MAG applications and filler wires run the wire feed unit's welding current cable connected to the positive terminal of the power source. The polarity can be selected by connecting the welding current cable and earth return cable accordingly to either the positive or negative connectors on the power source.
- i For TIG welding, the polarity (+/-) must be switched. The polarity can be selected by connecting the welding current cable and earth return cable accordingly to either the positive or negative connectors on the power source.
- i For double wire feeder installation, use the interconnection cable designed for two wire feeders.

 *Ensure that you have connected and tightened all the cables properly.*

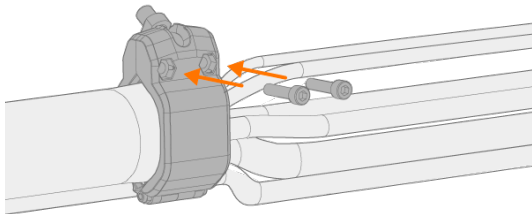
Strain relief replacement

Removing and replacing the strain relief at the power source end of the interconnection cable:

1.



2.



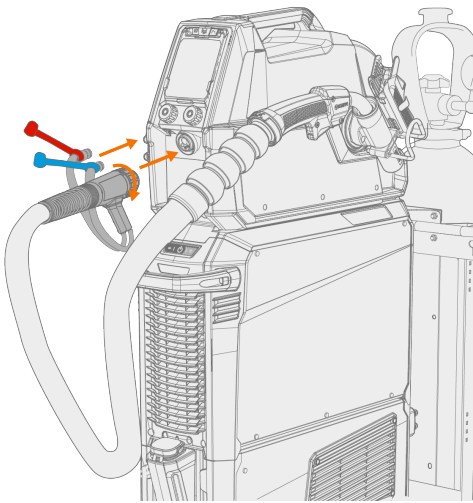
2.9 CONNECTING WELDING TORCH

X5 FastMig is designed to be used with the Kemppi Flexlite MIG welding torches. For the Flexlite operating instructions, refer to userdoc.kemppi.com.

 Always check that the wire liner, contact tip and gas nozzle are suitable for the job.


To connect the welding torch to the X5 wire feeder, proceed as follows:

1. Push the welding torch connector into the wire feeder's welding torch connector and hand-tighten the collar.
2. If your setup includes a water-cooled welding torch, connect the cooling liquid hoses to the wire feeder. The hoses are color-coded.



3. Install and load the filler wire as described here (depending on your wire feeder model):
 - >> "Installing and changing wire (X5 WF 200)" on page 79
 - >> "Installing and changing wire (X5 WF 300)" on page 84
 - >> "Installing and changing wire (X5 WF HD200)" on page 90
 - >> "Installing and changing wire (X5 WF HD300)" on page 95
4. Check the gas flow. Refer to "Installing gas bottle and testing gas flow" on page 104 for more information.

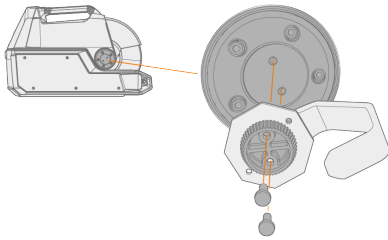
Tip: When not using the welding torch, keep it in the welding torch holder on the wire feeder. Refer to "Installing welding torch holder" below for more information.

 **TIG welding** requires the use of dedicated Flexlite TX TIG torches.

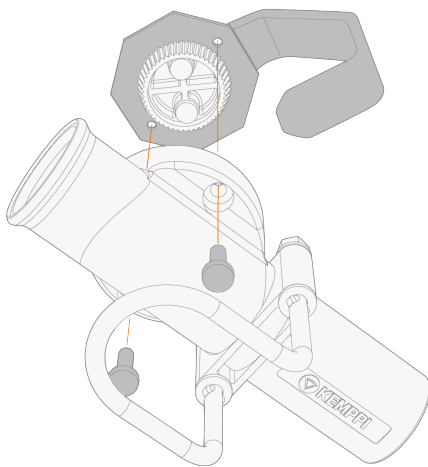
2.9.1 INSTALLING WELDING TORCH HOLDER

X5 Wire Feeder 300 can be equipped with a welding torch holder for holding the welding torch when not welding.

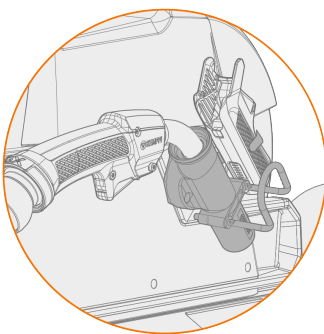
1. Attach the pistol grip handle holder with the cogged center hub and screws to the wire feeder.



2. Attach the welding torch holder to the pistol grip handle holder with screws.



-  You can adjust the angle of the welding torch holder before tightening the screws.

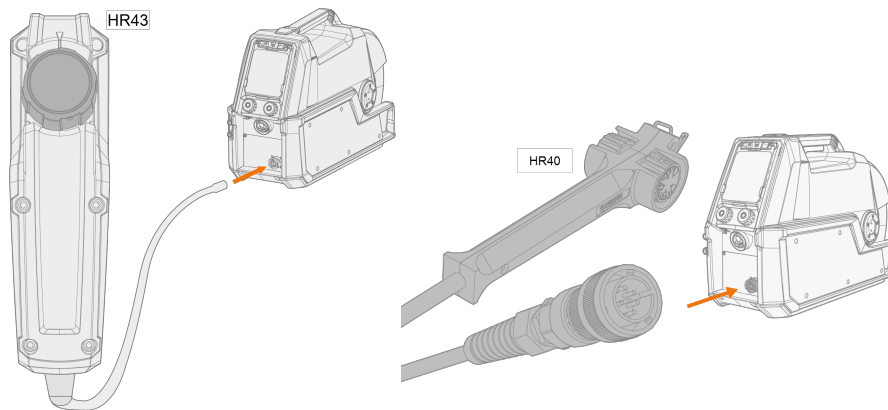


2.10 INSTALLING REMOTE CONTROL

Remote controls are optional. To enable remote operation, connect the remote control device to the X5 FastMig welding equipment.

Remote control HR43/HR40

1. Connect the remote control cable to the wire feeder's control cable connector.




2. To adjust the remote control parameters, refer to the control panel settings.

The remote control mode can be set and adjusted in the control panel settings ("AP/APC control panel: Device settings" on page 144 or "Manual control panel: Settings" on page 113).




Remote control HR55

1. Connect the remote control cable to the wire feeder's control cable connector.

 *The remote control selections in the control panel settings are not required with HR55 remote control. When connected, the HR55 remote control is automatically in use.*

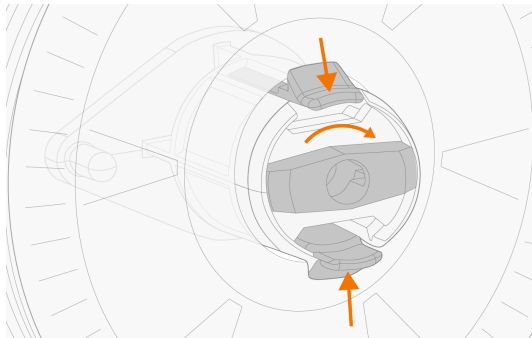
2.11 INSTALLING AND CHANGING WIRE (X5 WF 200)

This section describes how to install the wire and spool on X5 Wire Feeder 200.

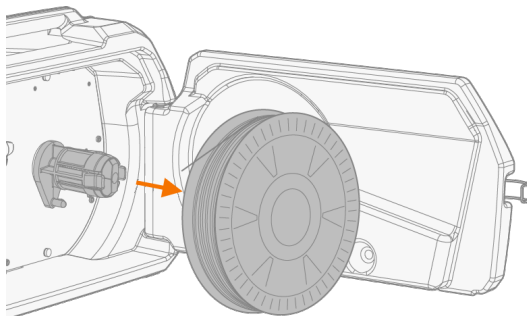
-  *Install the welding gun to the wire feeder before installing the wire spool.*
-  *When changing the wire spool, remove the remaining filler wire from the welding gun and wire feed mechanism before removing the wire spool.*
-  *Always ensure that the feed rolls are suitable for the filler wire (diameter and material) in question. Refer also to "Installing and replacing feed rolls" on page 99.*

To remove the wire spool:



1. Open the wire feeder side hatch.
2. Release the hub's lock and push the wire spool locking clips towards the center.

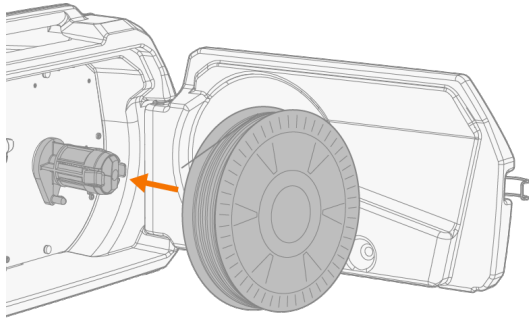


3. Remove the wire spool from the wire feeder.

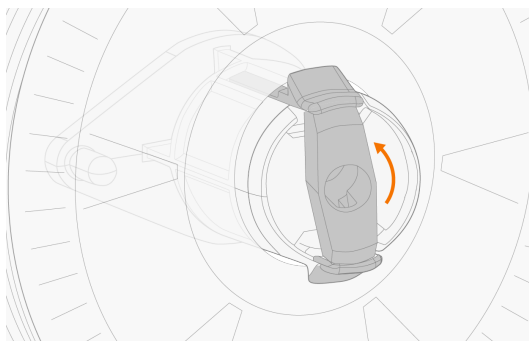


To install a new wire spool:

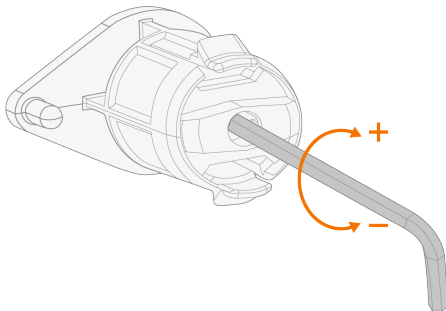
1. Open the wire feeder side hatch.
 2. If not already, release the hub's lock so that the locking clips can move towards the center.
 3. Insert the wire spool onto the hub in the wire feeder.
-  *Ensure that the wire spool is facing the right direction, the filler wire running from the top of the spool to the feed rolls.*
 -  *Ensure that the hub locking clips lock once the wire spool is in place.*



4. Secure the wire spool in place by turning to lock knob in closed position.




If needed, adjust the spool brake by turning the screw (with Allen key) in the center of the hub locking mechanism.

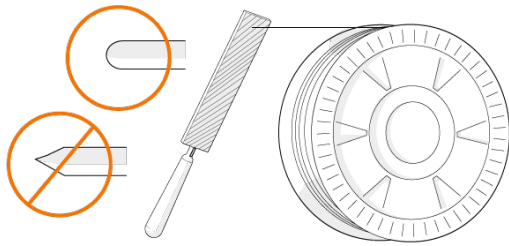



To install the filler wire:

1. Release the filler wire end from the spool and cut off any deformed section so that the end is straight.

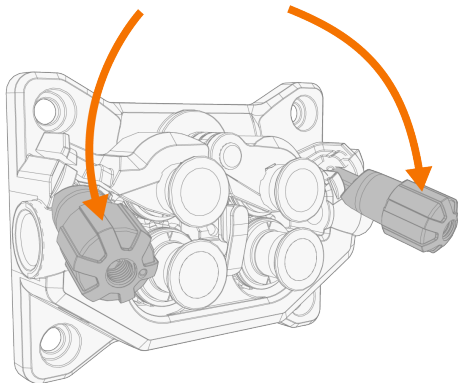
 *Ensure that the filler wire does not spill from the spool when it is released.*

2. File the tip of the filler wire smooth.

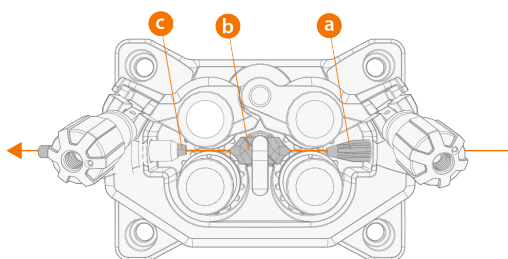


 Sharp edges on the filler wire tip may damage the wire liner.

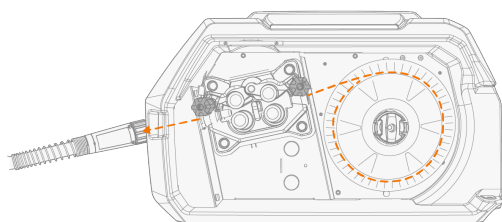
3. Release the pressure arms to move the feed rolls apart.



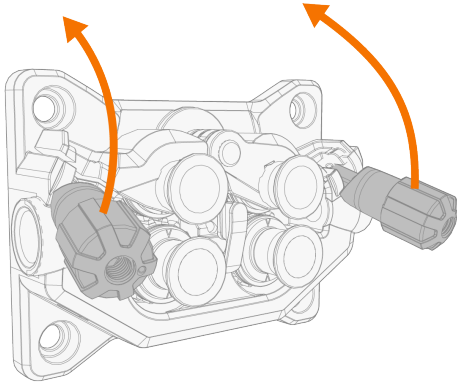
4. Guide the filler wire through the inlet tube (a) and middle wire guide tube (b) and into the outlet tube (c), which feeds the filler wire to the welding gun.



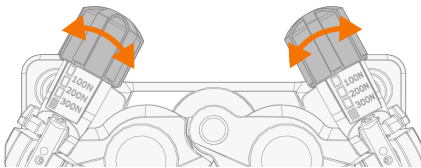
5. Push the filler wire by hand into the gun so that the wire reaches the wire liner (approx. 20 cm).



6. Close the pressure arms so that the filler wire is locked between the feed rolls. Ensure that the filler wire sits in the feed roll grooves.



7. Adjust the pressure of the feed rolls with the pressure adjustment wheels. The pressure is the same for both feed roll pairs.



The graduated scales on the pressure handle indicate the pressure applied to the feed rolls. Adjust the pressure of the feed rolls according to the table below.

Filler wire	Feed roll profile	Filler wire diameter (mm)	Adjustment (x100N)
Fe/Ss solid	V-groove V	0.8–1.0	1.5–2.0
		≥ 1.2	2.0–2.5
Metal and flux cored	V-groove, knurled V≡	≥ 1.2	1.0–2.0
Self-shielded (gasless)	V-groove, knurled V≡	≥ 1.6	2.0–3.0
Aluminum	U-groove U	1.0	0.5–1.0
		1.2	1.0–1.5
		1.4	1.5–2.0
		≥ 1.6	2.0–2.5



Excessive pressure flattens the filler wire and may damage coated or cored filler wires. Excessive pressure also unnecessarily wears the feed rolls and increases gearbox load.

8. Press the wire inch button to drive the filler wire into the welding gun. Stop when the wire reaches the welding gun's contact tip.

>> In X5 Wire Feeder 200 the wire inch button is located in the control panel.



- !** *Watch out for the wire when it reaches the contact tip and exits the gun.*




9. Before welding, ensure that the welding parameters and settings on the control panel conform to your welding setup.

>> Refer to "Using X5 Manual control panel" on page 111 and "Using X5 AP/APC control panel" on page 119 for more information.

"Wire spool and hub (200)" on page 26

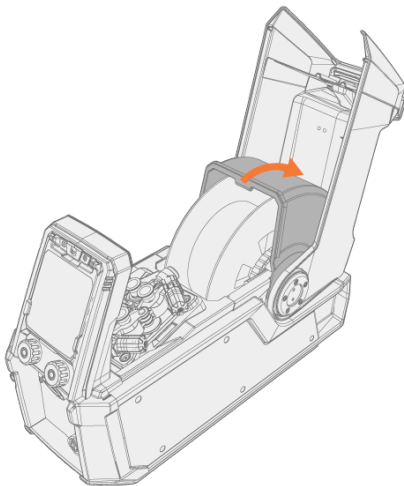
2.12 INSTALLING AND CHANGING WIRE (X5 WF 300)

This section describes how to install the wire and spool on X5 Wire Feeder 300.

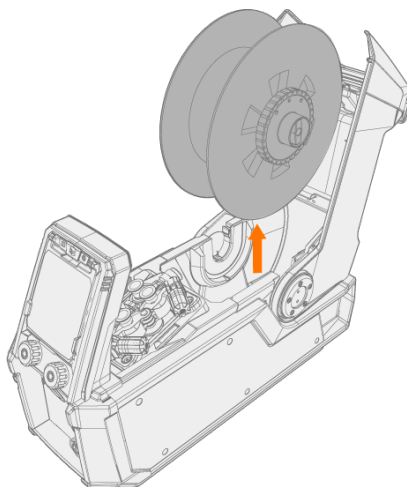
-  *Install the welding gun to the wire feeder before installing the wire spool.*
-  *When changing the wire spool, remove the remaining filler wire from the welding gun and wire feed mechanism before removing the wire spool.*
-  *Always ensure that the feed rolls are suitable for the filler wire (diameter and material) in question. Refer also to "Installing and replacing feed rolls" on page 99.*

To remove the wire spool:

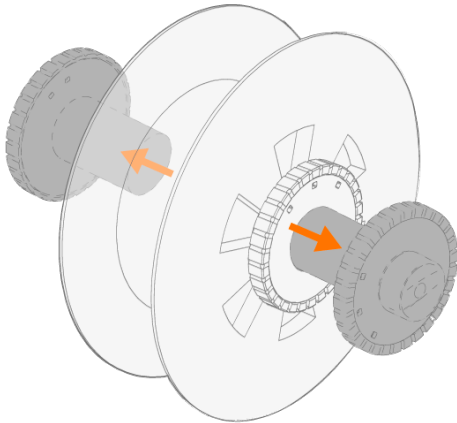
1. Open the wire feeder top cover.
2. Push the wire spool locking cover to the rear.



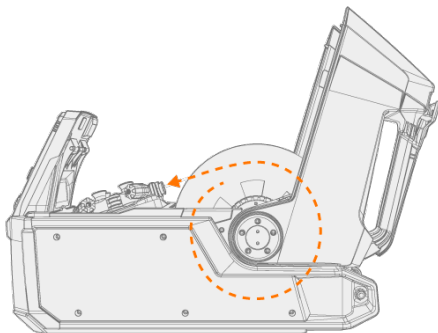
3. Remove the wire spool from the wire feeder.



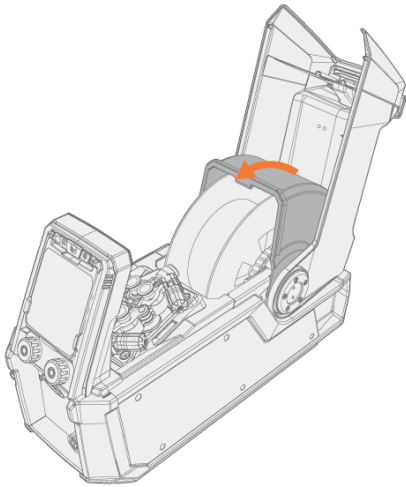
4. To remove the spool brake hub, release the spool brake tightening knob in the brake center and pull the brake halves apart.

**To install a new wire spool:**

1. Open the wire feeder top cover and the wire spool locking cover.
2. Attach the wire spool brake halves to the new wire spool by pushing them together inside the wire spool. Secure them together by turning the tightening knob in the brake center.
 - ⓘ Attach the spool brake hub to the wire spool so that the tightening knob is on the right, seen from the front.*
3. Place the wire spool into its socket.
 - ⓘ Ensure that the wire spool is facing the right direction, the filler wire running from the top of the spool to the feed rolls.*




4. Secure the wire spool in place by closing the wire spool locking cover.

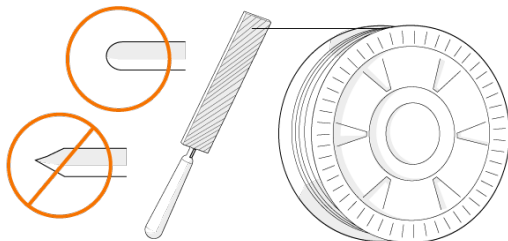



To install the filler wire:

1. Release the filler wire end from the spool and cut off any deformed section so that the end is straight.

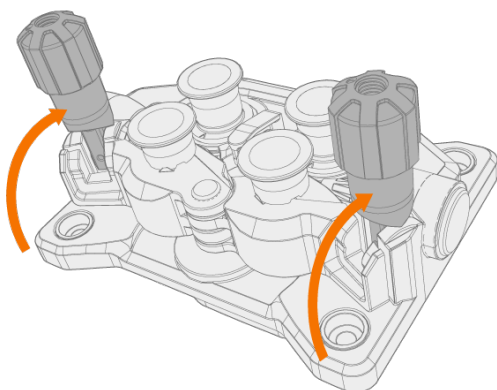
 *Ensure that the filler wire does not spill from the spool when it is released.*

2. File the tip of the filler wire smooth.

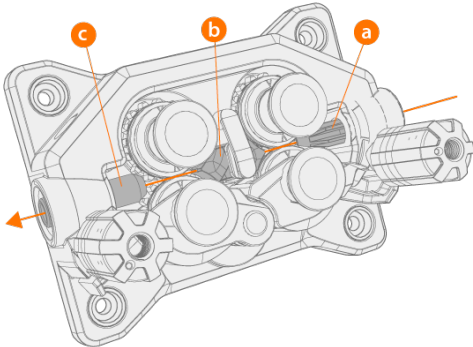


 *Sharp edges on the filler wire tip may damage the wire liner.*

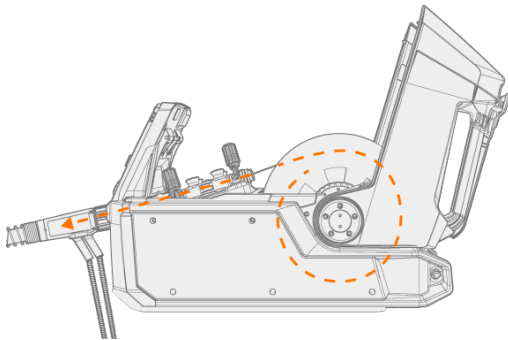
3. Release the pressure arms to move the feed rolls apart.



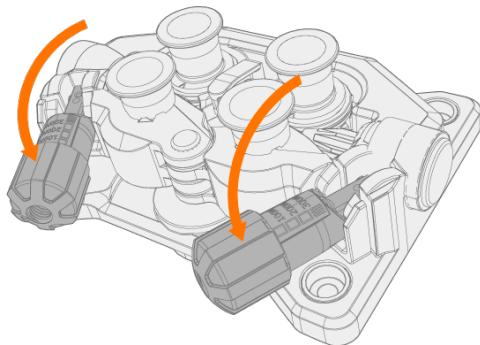
4. Guide the filler wire through the inlet tube (a) and middle wire guide tube (b) and into the outlet tube (c), which feeds the filler wire to the welding gun.



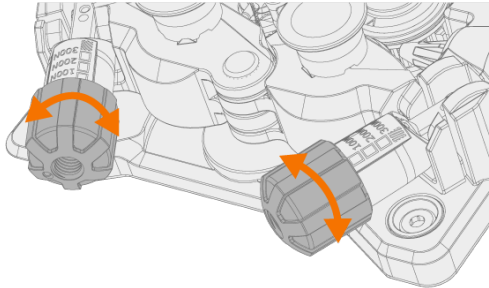
5. Push the filler wire by hand into the gun so that the wire reaches the wire liner (approx. 20 cm).



6. Close the pressure arms so that the filler wire is locked between the feed rolls. Ensure that the filler wire sits in the feed roll grooves.




- Adjust the pressure of the feed rolls with the pressure adjustment wheels. The pressure is the same for both feed roll pairs.

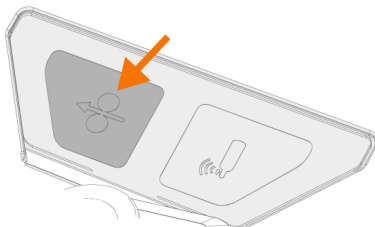


The graduated scales on the pressure handle indicate the pressure applied to the feed rolls. Adjust the pressure of the feed rolls according to the table below.

Filler wire	Feed roll profile	Filler wire diameter (mm)	Adjustment (x100N)
Fe/Ss solid	V-groove V	0.8–1.0	1.5–2.0
		≥ 1.2	2.0–2.5
Metal and flux cored	V-groove, knurled V≡	≥ 1.2	1.0–2.0
Self-shielded (gasless)	V-groove, knurled V≡	≥ 1.6	2.0–3.0
Aluminum	U-groove U	1.0	0.5–1.0
		1.2	1.0–1.5
		1.4	1.5–2.0
		≥ 1.6	2.0–2.5

 *Excessive pressure flattens the filler wire and may damage coated or cored filler wires. Excessive pressure also unnecessarily wears the feed rolls and increases gearbox load.*

- Press the wire inch button to drive the filler wire into the welding gun. Stop when the wire reaches the welding gun's contact tip.



 *Watch out for the wire when it reaches the contact tip and exits the gun.*




9. Before welding, ensure that the welding parameters and settings on the control panel conform to your welding setup.

>> Refer to "Using X5 Manual control panel" on page 111 and "Using X5 AP/APC control panel" on page 119 for more information.

"Wire spools and hubs (300)" on page 22

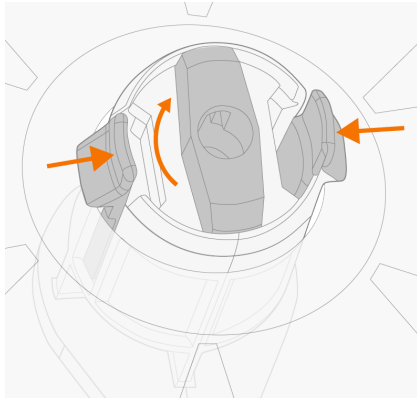
2.13 INSTALLING AND CHANGING WIRE (X5 WF HD200)

This section describes how to install the wire and spool on X5 Wire Feeder HD200.

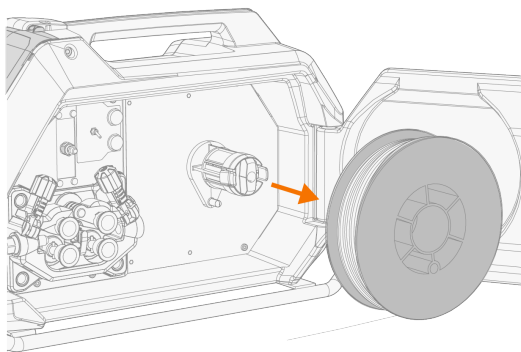
-  *Install the welding torch to the wire feeder before installing the wire spool.*
-  *When changing the wire spool, remove the remaining filler wire from the welding gun and wire feed mechanism before removing the wire spool.*
-  *Always ensure that the feed rolls are suitable for the filler wire (diameter and material) in question. Refer also to "Installing and replacing feed rolls" on page 99.*

To remove the wire spool:



1. Open the wire feeder side hatch.
2. Release the hub's lock and push the wire spool locking clips towards the center.

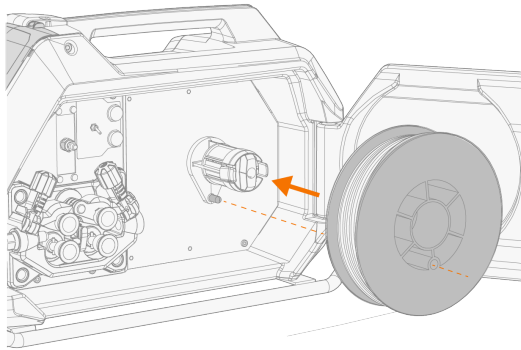


3. Remove the wire spool from the wire feeder.

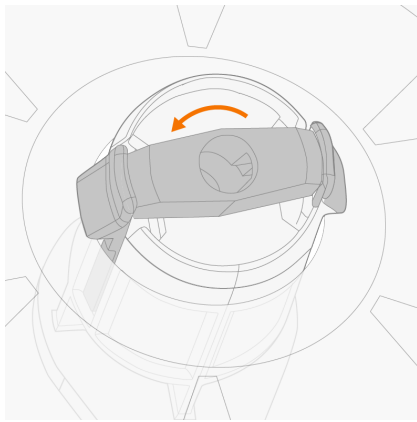


To install a new wire spool:

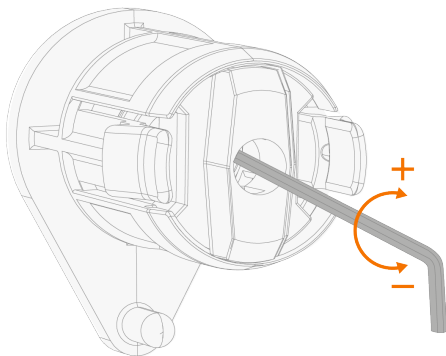
1. Open the wire feeder side hatch.
 2. If not already, release the hub's lock so that the locking clips can move towards the center.
 3. Insert the wire spool onto the hub in the wire feeder.
-  *Ensure that the wire spool is facing the right direction, the filler wire running from the bottom of the spool to the feed rolls.*
 -  *Ensure that the hub locking clips lock once the wire spool is in place.*



4. Secure the wire spool in place by turning to lock knob in closed position.




If needed, adjust the spool brake by turning the screw (with Allen key) in the center of the hub locking mechanism.

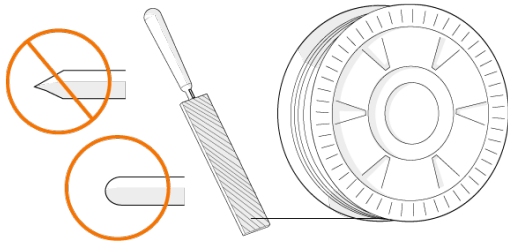


To install the filler wire:

1. Release the filler wire end from the spool and cut off any deformed section so that the end is straight.

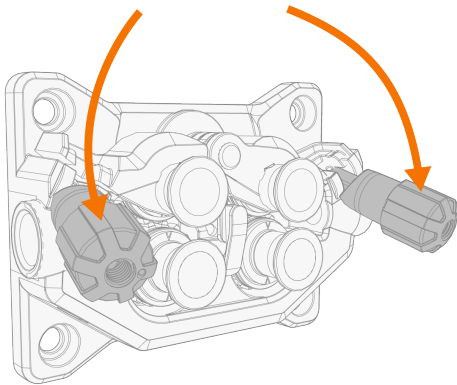
 Ensure that the filler wire does not spill from the spool when it is released.

2. File the tip of the filler wire smooth.

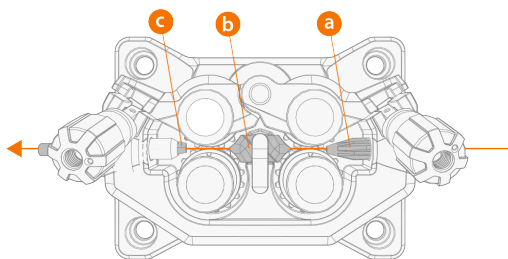


⚠ Sharp edges on the filler wire tip may damage the wire liner.

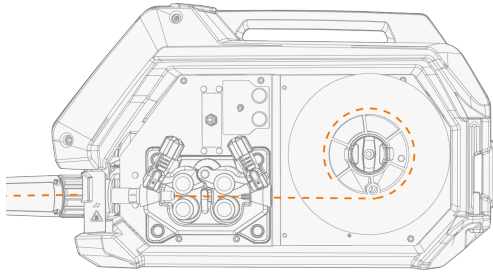
3. Release the pressure arms to move the feed rolls apart.



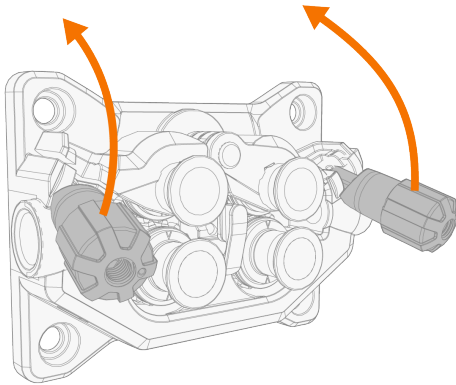
4. Guide the filler wire through the inlet tube (a) and middle wire guide tube (b) and into the outlet tube (c), which feeds the filler wire to the welding torch.



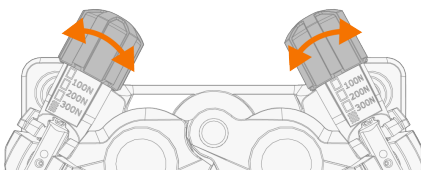
5. Push the filler wire by hand into the gun so that the wire reaches the wire liner (approx. 20 cm).



6. Close the pressure arms so that the filler wire is locked between the feed rolls. Ensure that the filler wire sits in the feed roll grooves.



7. Adjust the pressure of the feed rolls with the pressure adjustment wheels. The pressure is the same for both feed roll pairs.



The graduated scales on the pressure handle indicate the pressure applied to the feed rolls. Adjust the pressure of the feed rolls according to the table below.

Filler wire	Feed roll profile	Filler wire diameter (mm)	Adjustment (x100N)
Fe/Ss solid	V-groove V	0.8–1.0	1.5–2.0
		≥ 1.2	2.0–2.5
Metal and flux cored (MC/FC)	V-groove, knurled V≡	≥ 1.2	1.0–2.0

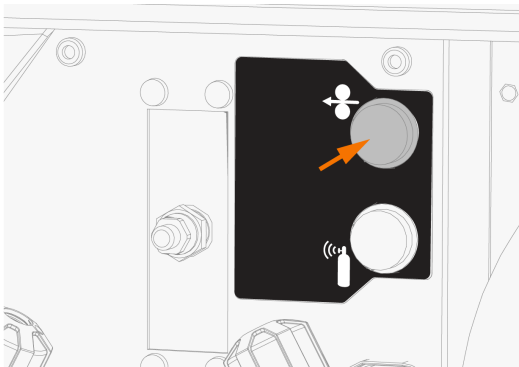
Self-shielded (gasless)	V-groove, knurled V ≡	≥ 1.6	2.0–3.0
Aluminum	U-groove U	1.0	0.5–1.0
		1.2	1.0–1.5
		1.4	1.5–2.0
		≥ 1.6	2.0–2.5



Excessive pressure flattens the filler wire and may damage coated or cored filler wires. Excessive pressure also unnecessarily wears the feed rolls and increases gearbox load.

8. Press the wire inch button to drive the filler wire into the welding torch. Stop when the wire reaches the welding torch's contact tip.

>> In X5 Wire Feeder HD200 the wire inch button is located in the wire feed cabinet.



Watch out for the wire when it reaches the contact tip and exits the welding torch.




9. Before welding, ensure that the welding parameters and settings on the control panel conform to your welding setup.

>> Refer to "Using X5 Manual control panel" on page 111 and "Using X5 AP/APC control panel" on page 119 for more information.

"Wire spool and hub (200)" on page 26

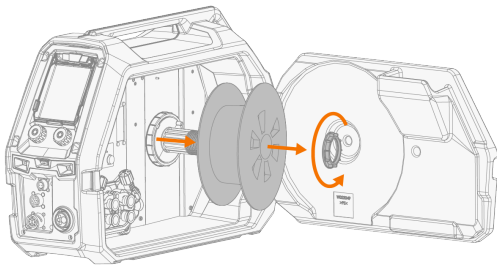
2.14 INSTALLING AND CHANGING WIRE (X5 WF HD300)

This section describes how to install the wire and spool on X5 Wire Feeder HD300.

-  *Install the welding gun to the wire feeder before installing the wire spool.*
-  *When changing the wire spool, remove the remaining filler wire from the welding gun and wire feed mechanism before removing the wire spool.*
-  *Always ensure that the feed rolls are suitable for the filler wire (diameter and material) in question. Refer also to "Installing and replacing feed rolls" on page 99.*


To remove the wire spool:

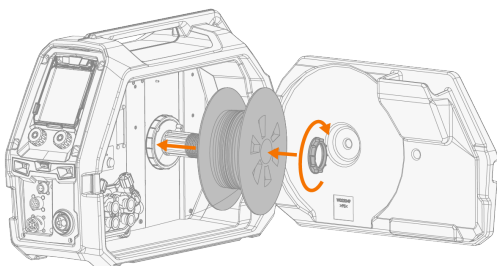
1. Open the wire feed cabinet door.
2. Loosen and remove the spool fastener and remove the wire spool.



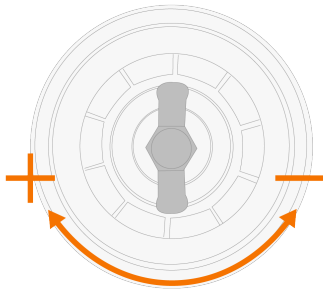
To install a new wire spool:

1. Open the wire feed cabinet door.
2. Insert the wire spool onto the spool hub. Secure the wire spool in place by inserting and tightening the spool fastener.

-  *Ensure that the wire spool is facing the right direction, the filler wire running from the bottom of the spool to the feed rolls.*




3. If needed, adjust the spool brake by turning the spool brake tightening knob in the center of the spool hub.

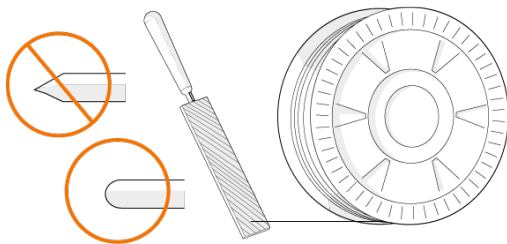



To install the filler wire:

1. Release the filler wire end from the spool and cut off any deformed section so that the end is straight.

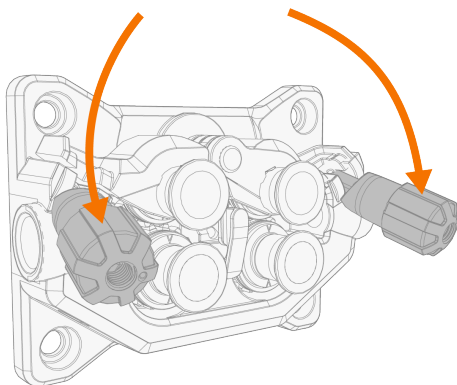
 *Ensure that the filler wire does not spill from the spool when it is released.*

2. File the tip of the filler wire smooth.

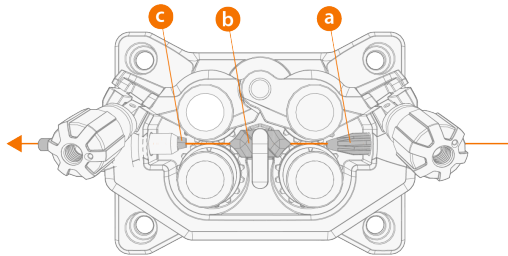


 *Sharp edges on the filler wire tip may damage the wire liner.*

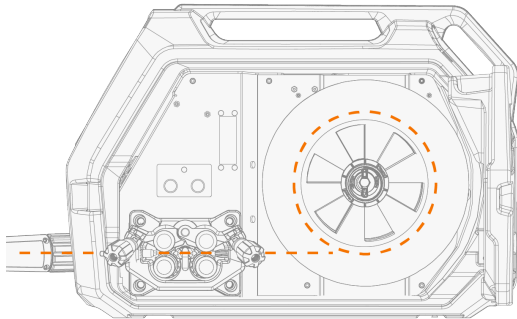
3. Release the pressure arms to move the feed rolls apart.



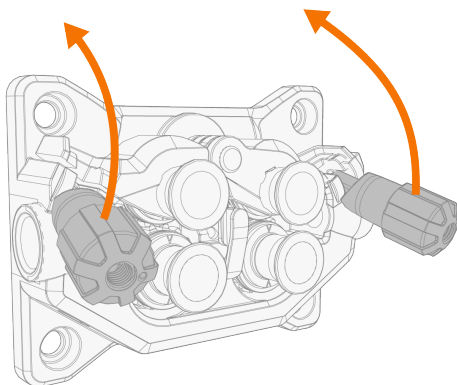
4. Guide the filler wire through the inlet tube (a) and middle wire guide tube (b) and into the outlet tube (c), which feeds the filler wire to the welding gun.



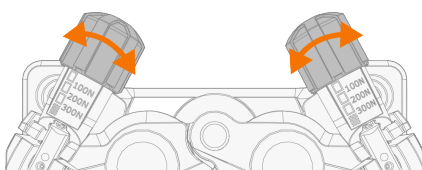
5. Push the filler wire by hand into the gun so that the wire reaches the wire liner (approx. 20 cm).



6. Close the pressure arms so that the filler wire is locked between the feed rolls. Ensure that the filler wire sits in the feed roll grooves.




7. Adjust the pressure of the feed rolls with the pressure adjustment wheels. The pressure is the same for both feed roll pairs.

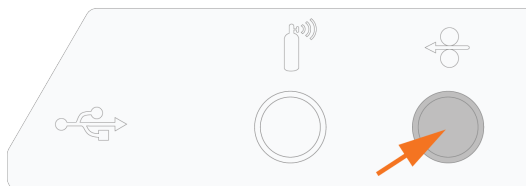


The graduated scales on the pressure handle indicate the pressure applied to the feed rolls. Adjust the pressure of the feed rolls according to the table below.

Filler wire	Feed roll profile	Filler wire diameter (mm)	Adjustment (x100N)
Fe/Ss solid	V-groove V	0.8–1.0	1.5–2.0
		≥ 1.2	2.0–2.5
Metal and flux cored (MC/FC)	V-groove, knurled V≡	≥ 1.2	1.0–2.0
Self-shielded (gasless)	V-groove, knurled V≡	≥ 1.6	2.0–3.0
Aluminum	U-groove U	1.0	0.5–1.0
		1.2	1.0–1.5
		1.4	1.5–2.0
		≥ 1.6	2.0–2.5

 *Excessive pressure flattens the filler wire and may damage coated or cored filler wires. Excessive pressure also unnecessarily wears the feed rolls and increases gearbox load.*

- Press the wire inch button to drive the filler wire into the welding gun. Stop when the wire reaches the welding gun's contact tip.




 *Watch out for the wire when it reaches the contact tip and exits the gun.*

- Before welding, ensure that the welding parameters and settings on the control panel conform to your welding setup.

>> Refer to "Using X5 AP/APC control panel" on page 119 for more information.

2.15 INSTALLING AND REPLACING FEED ROLLS

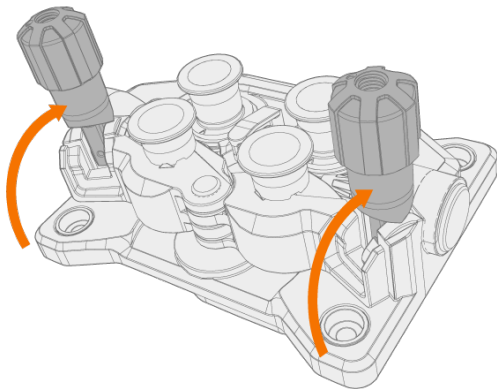
 *The installation method described here is the same with both X5 Wire Feeder 200 and X5 Wire Feeder 300. Model-specific variations in the visual appearance and positioning may occur.*

Replace the wire feed rolls when the material and diameter of the filler wire changes.

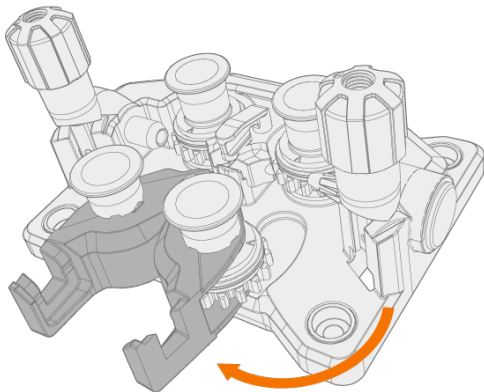
Select the new wire feed rolls according to the tables here: "Wire feeder consumables" on page 210.

To replace the wire feed rolls:

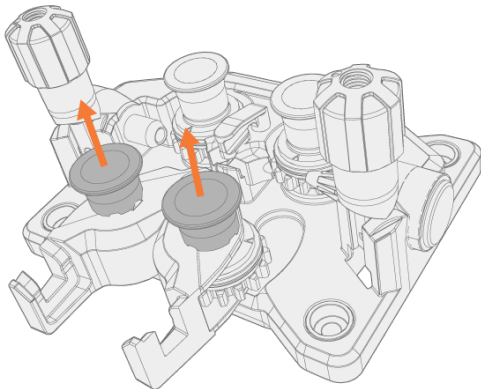
1. Open the wire feeder cabinet.
2. Release the pressure handles on the wire feed mechanism.



3. Open the locking arms to release the feed rolls.

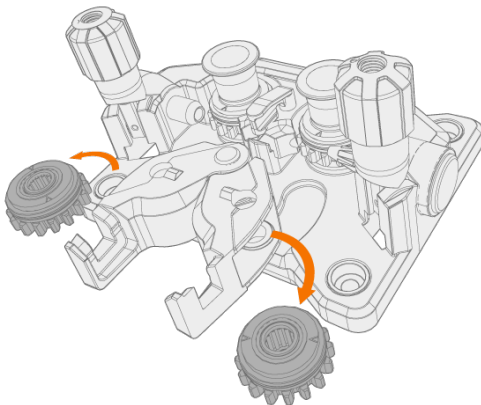


4. Remove the pressure feed roll mounting pins by pulling them.

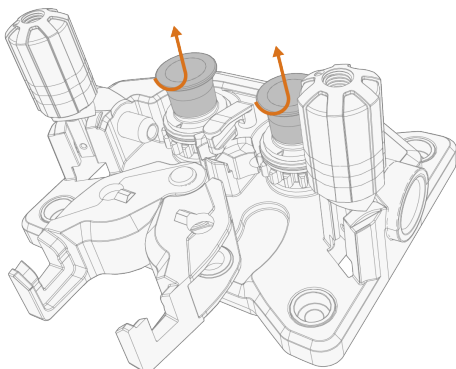


i The pressure rolls' mounting pins have central axles attached to them, whereas the drive rolls' central axles act as drive shafts attached directly to the wire feed mechanism/motor.

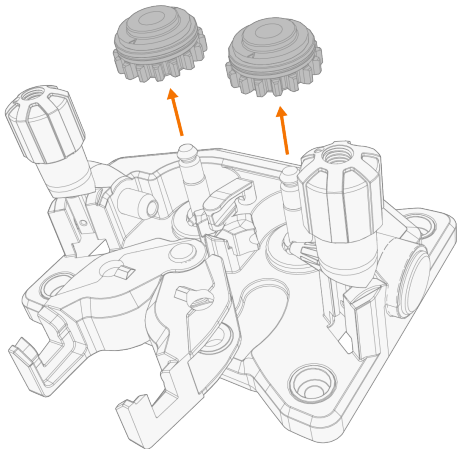
5. Remove the pressure feed rolls.



6. Remove the drive feed roll mounting caps by turning and pulling them.



7. Remove the drive feed rolls.

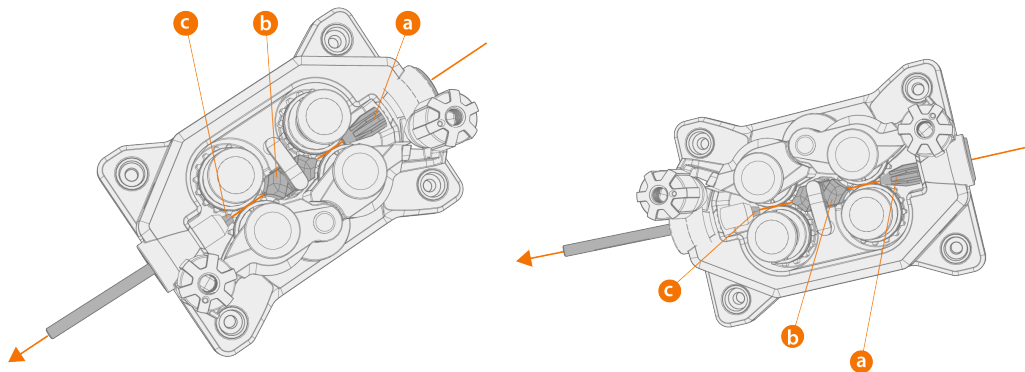


8. Follow the previous steps in reverse to install the wire feed rolls. Align the cut on the drive rolls' bottom with the pin on the drive shaft.
9. Reattach the mounting caps and mounting pins to lock the drive and pressure rolls into their places.
10. Close the locking arms and lower the pressure handles on the feed rolls. Refer to "Installing and changing wire (X5 WF 300)" on page 84 and "Installing and changing wire (X5 WF 200)" on page 79 for more information on the wire installation.
11. Close the wire feeder cabinet.

2.16 INSTALLING AND REPLACING WIRE GUIDE TUBES

The wire feed mechanism includes three wire guide tubes. Replace them when the filler wire diameter grows or the material changes.

i When replacing the outlet guide tube, the welding gun must be detached.

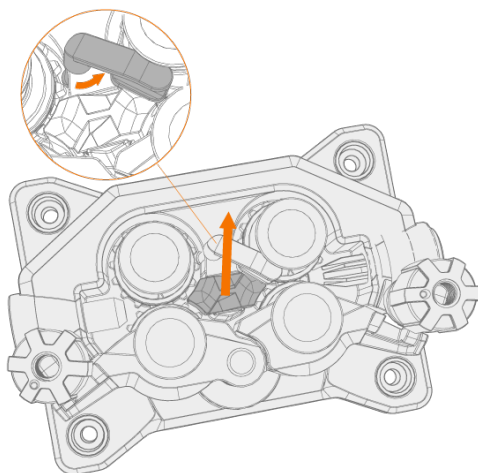


- a. Inlet guide tube
- b. Middle guide tube
- c. Outlet guide tube

Select the new wire guide tubes according to the tables here: "Wire feeder consumables" on page 210.




To replace the wire guide tubes:

1. Release the pressure arms and remove the filler wire from the system.
2. Pull out the inlet guide tube (a) and insert a new one in its place.
3. Turn the locking clip aside to free the middle guide tube (b) for replacement.
4. Insert a new middle guide tube in its slot and push it properly in place. Ensure that the mark arrow points to the wire running direction.
5. Turn locking clip back to lock down the new middle tube.



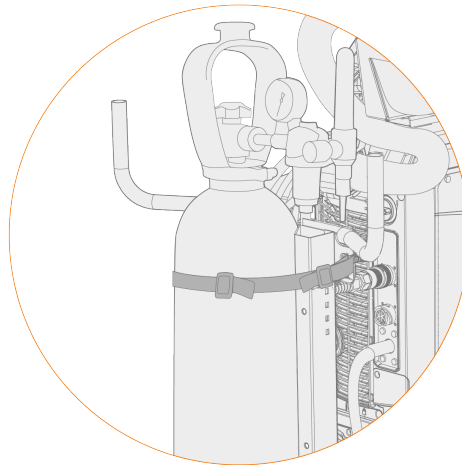
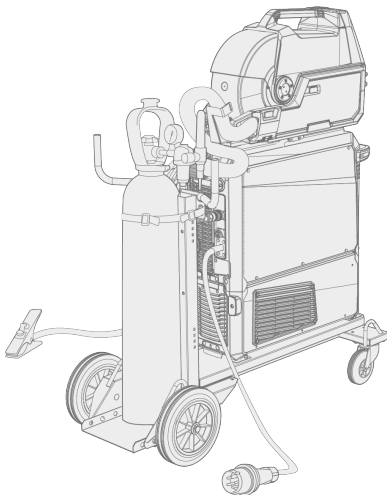
6. Replace the outlet guide tube (c) by pushing the old outlet tube out from either direction.


2.17 INSTALLING GAS BOTTLE AND TESTING GAS FLOW

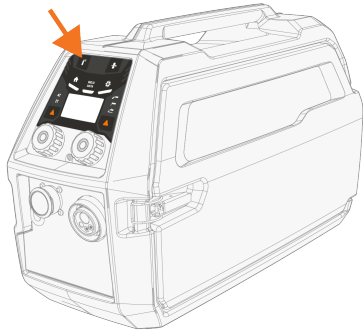
-  *Handle gas bottles with care. There is a risk of injury if the gas bottle or the bottle valve is damaged!*
-  *Always secure the gas bottle properly in an upright position to a special holder on the wall or on the welding equipment cart. Always keep the gas bottle valve closed when not welding.*
-  *- If a transport unit with a gas bottle rack is used, install the gas bottle on the transport unit first, then make the connections.*
- Install the welding torch to the wire feeder before installing and testing the gas bottle.*
- Do not use the whole contents of the bottle.*
- Always use an approved and tested regulator and flow meter.*

Contact your local Kemppi dealer for choosing the gas and the equipment.

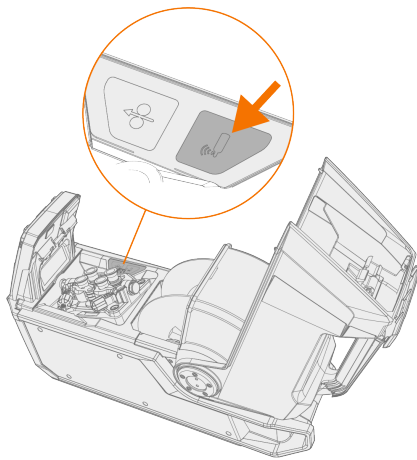
1. Without gas bottle cart: Place the gas bottle in a suitable, secure location.
2. With gas bottle cart: Move the gas bottle on the transport unit's gas bottle rack and secure it in place with the straps and fixing points provided.



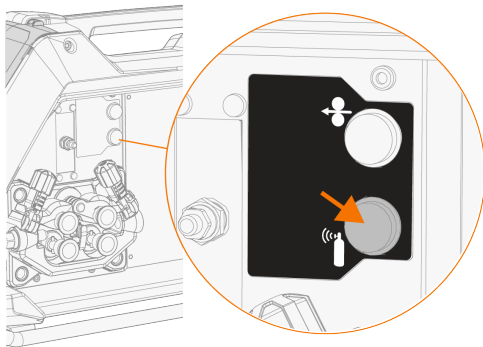
3. If not already, connect the welding torch to the wire feeder.
4. Connect the gas hose to the wire feeder.
-  *In a standard setup, the gas hose is included in the interconnection cable bundle (for more information, refer to "Installing cables (X5 WF 200, X5 WF 300, X5 WF HD300)" on page 66 or "Installing cables (X5 WF HD200)" on page 72).*
5. Open the gas bottle valve.
6. Press the Gas test button in the wire feed cabinet to flush the previous shielding gas and to run the new gas into the system.
 - >> With X5 Wire Feeder 200 Manual the Gas test button is located on the control panel:



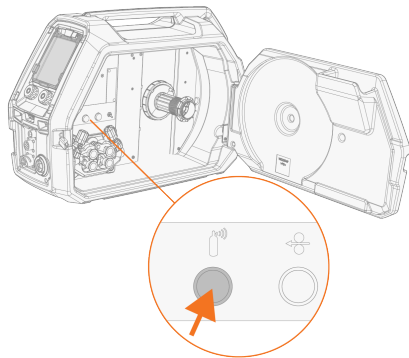
>> With X5 Wire Feeder 300 the Gas test button is located in the wire feed cabinet:




>> With X5 Wire Feeder HD200 the Gas test button is located in the wire feed cabinet:



>> With X5 Wire Feeder HD300 the Gas test button is located in the wire feed cabinet:



7. Press the Gas test button again to adjust the gas flow. Use either the built-in rotameter or an external flow meter and regulator for measuring and adjustment.

 Use the Gas test button also to test that the gases flow through the system properly.

Recommended gas flow rates (for general guidance only):

	TIG*	MIG**
Argon	5...15 l/min	10...25 l/min
Helium	15...30 l/min	-
Argon + 18-25% CO ₂	-	10...25 l/min
CO ₂	-	10...25 l/min

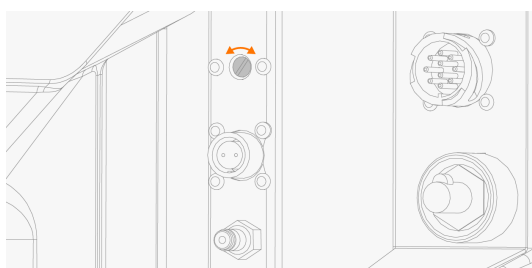
* Depending on the gas nozzle size.

** Depending on the gas nozzle size and welding current.

Adjusting gas guard (optional)

The sensitivity level of the optional (with X5 Wire Feeder HD300 only) gas guard can be adjusted as follows.


1. Open the interconnection cable cabinet.
2. Turn the gas guard adjustment screw with a flathead screwdriver to adjust the sensitivity in the desired direction (+/-).



3. Test that the gas guard works correctly with the new setting.

The gas guard can be turned on and off in the control panel settings: "Manual control panel: Settings" on page 113 and "AP/APC control panel: Device settings" on page 144.

2.18 HOW TO GET WELDING PROGRAMS

 *The use of welding programs and Wise and MAX features and processes is possible with the X5 FastMig Auto and Pulse system configurations (see "General" on page 5). WiseRoot+, WiseThin+ and MAX Position processes require a pulse welding system (with the Wise processes specifically a Pulse+ power source is required).*

By default, the equipment comes with a welding program work pack preinstalled. These work packs cover the basic welding tasks with the automatic 1-MIG and pulsed welding processes.

The additional welding programs, Wise processes (WiseRoot+, WiseThin+) and MAX processes (MAX Cool, MAX Speed, MAX Position) for each individual X5 FastMig equipment are installed at the time of purchase according to your specific welding requirements. This can be done by your local Kemppi dealer. Welding programs as well as the advanced welding features can also be added later on.

For more information on the available X5 FastMig welding program options and installing the welding programs or software updates, contact your local Kemppi dealer or go to Kemppi.com.

The manual MIG process doesn't require additional welding programs.







For applying the welding programs installed on your X5 FastMig equipment, refer to "AP/APC control panel: Applying welding programs" on page 147 (AP/APC).

The list of installed welding programs on your equipment can be seen in the control panel's info view under **Welding software**.

The welding programs included in the X5 FastMig work packs are shown here: Technical data > "Welding program work packs" on page 213.

3. OPERATION

Before using the equipment, ensure that all the necessary installation actions have been completed according to your equipment setup and instructions.

-  *Only connect the welding machine to an earthed electric network.*
-  *Welding is forbidden in places where there is an immediate fire or explosion hazard!*
-  *The interconnection cable heats up during welding. The wire feeder's cable cabinet door must be kept closed when welding, and the cables must be handled with caution if the cabinet door is opened right after welding.*
-  *Check that there is enough space for cooling air circulation in the machine vicinity.*
-  *If the welding equipment is left unused for a longer period, disconnect the mains plug from the mains.*
-  *Always check before use that interconnection cable, shielding gas hose, earth return cable and clamp and mains cable are in serviceable condition. Ensure that the connectors are correctly fastened. Loose connectors can impair welding performance and damage connectors.*

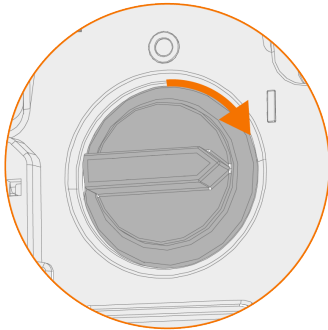
3.1 PREPARING WELDING SYSTEM FOR USE

Before starting the use of the welding equipment


- Ensure the installation has been completed
- Switch the welding equipment on
- Prepare the cooler
- Connect the earth return cable to the work piece
- Connect the voltage sensing cable to the work piece if applicable (available with Pulse+ power source)
- Calibrate the welding cable (in MIG operation mode only)
 - >> Refer to "Calibrating welding cable" on the next page for instructions.

Turning on welding system

To turn on the welding equipment, turn the power source main switch to ON (I).




Turn the main switch to start and shut down the welding equipment. Do not use the mains plug as a switch.

-  *If the welder is left unused for a longer period, detach the mains plug to disconnect it from the mains.*

Preparing cooler

Fill the coolant container inside the cooler with Kemppi cooling liquid. For instructions on filling the cooler, refer to "Filling cooler and circulating coolant" on the next page. To weld, you must pump the coolant through the system by pressing the coolant circulation button in the front panel of the cooling unit.

Connecting earth return cable



-  *Keep the welding piece connected to earth to reduce the risk of injury to users or damage to electrical equipment.*

Attach the earth return cable clamp on the welding piece.

Ensure that the surface contact to the work piece is clean of metal oxide and paint and that the clamp is firmly secured.


Selecting operation mode and process


To select the operation mode (MIG/TIG/MMA/Gouging), refer to "Using X5 Manual control panel" on page 111 or "AP/APC control panel: Device settings" on page 144, depending on your equipment setup.

-  *Replace also the welding cable accordingly, and remove or replace the filler wire in the wire feeder.*
-  *For TIG welding, the polarity (+/-) must be switched. The polarity can be selected by connecting the welding current cable and earth return cable accordingly to either the positive or negative connectors on the power source.*

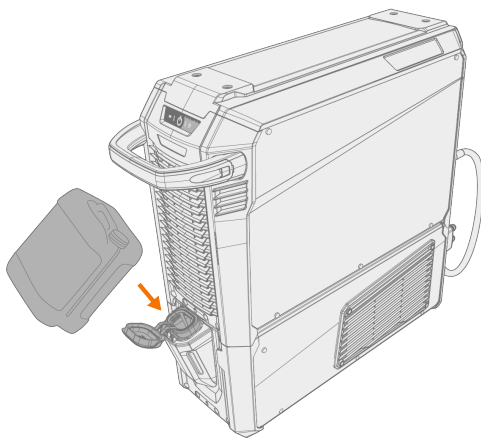
3.1.1 FILLING COOLER AND CIRCULATING COOLANT

Fill the cooler with pre-mixed coolant solution. The mixing ratio should be 20...50% as standard. Use only ethylene or propylene glycol mixture intended for welding cooling systems, for example Kemppi cooling liquid.

 *Do not add water to the pre-mixed coolant solution. Do not use automotive cooling solutions or ethanol-based mixtures.*

 *Especially with a long welding cable setup, observe the coolant level and add coolant if needed.*

1. Open the cooler cap.
2. Fill the cooler with coolant. Do not fill over the max. marking.



3. Close the cooler cap.

To circulate the coolant:

Press the coolant circulation button in the cooler front panel. It activates the motor, which pumps the coolant to the hoses and to the welding torch.

Complete the coolant circulation operation after each time you change the welding torch.

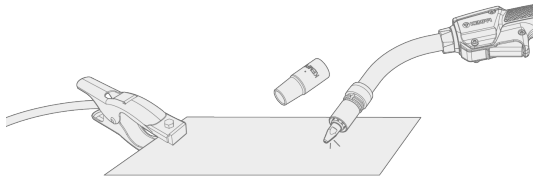
3.1.2 CALIBRATING WELDING CABLE

With X5 FastMig, the welding cable resistance can be measured using the built-in cable calibration function without additional measurement cable. This calibration function is available only in MIG operation mode.

1. Connect the earth return cable between the power source and work piece.
2. Remove the welding torch gas nozzle.
3. Connect the welding torch to the wire feeder.
4. Turn the welding equipment on.
5. On the control panel, go to settings and enable cable calibration.

>> For more information, refer to "Manual control panel: Settings" on page 113 or "AP/APC control panel: Device settings" on page 144.

6. Touch the cleaned work piece briefly with the welding torch contact tip.



i *There is no need to pull the trigger. Trigger function is disabled at this stage.*

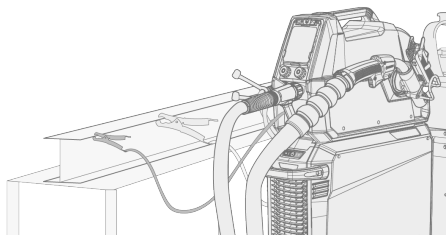
7. Using the control panel, confirm the measured values.

3.1.3 USING VOLTAGE SENSING CABLE

Available with Pulse+ power sources.

While the continuous use of the separate voltage sensing cable is not necessary with X5 FastMig, the voltage sensing cable is required with the advanced WiseRoot+ and WiseThin+ processes. These processes are based on the accurate measurement of arc voltage.

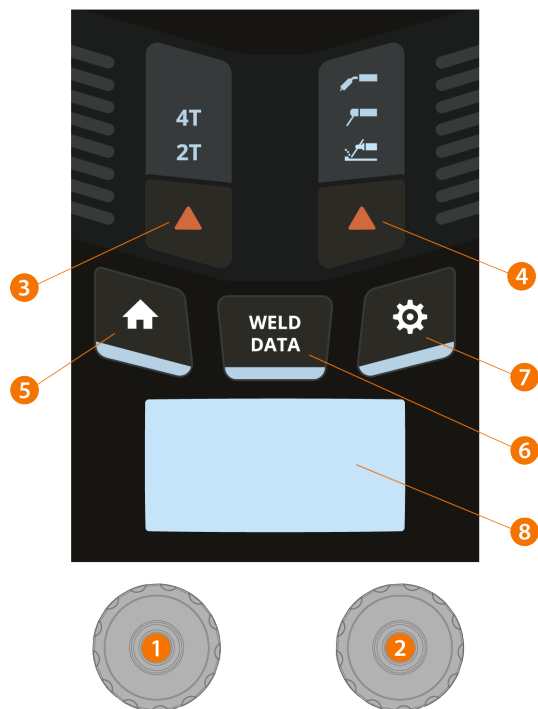
Before welding with WiseRoot+ or WiseThin+ process, connect the voltage sensing cable to the workpiece. For optimal voltage measurement, connect the earth return cable and the voltage sensing cable close to each other and away from the other welding units' cables.



If the voltage sensing cable is not connected or it is broken, an error message is displayed.

3.2 USING X5 MANUAL CONTROL PANEL

The X5 Wire Feeder 200 Manual and 300 Manual control panels include the most essential features and functions for MIG welding with the option to use the X5 FastMig also for TIG (DC) and MMA welding and gouging.

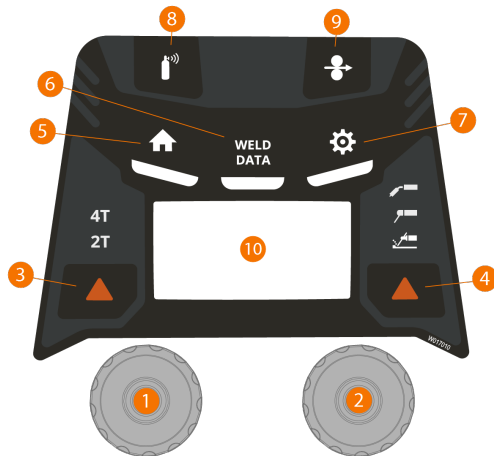
X5 Wire Feeder 300 Manual control panel (X5 FP 300R)


- 1. Left control knob**
 - >> In MIG mode: Wire feed speed
 - >> In MMA mode: Welding current adjustment
 - >> In Gouging mode: Current adjustment
- 2. Right control knob**
 - >> In MIG mode: Welding voltage adjustment
 - >> In MIG mode (push button): Switch between welding voltage and dynamics adjustment
 - >> In MMA mode: Dynamics adjustment
- 3. Trigger logic selection**
 - >> Switches between 2T and 4T trigger logic modes
- 4. Welding process / operation mode selection**
 - >> Switches between MIG, MMA and Gouging modes
 - >> Long press for TIG mode
- 5. Home button**
 - >> Switches to the default welding view/mode
- 6. Weld data button**
 - >> Shows the duration, current and voltage of the last weld
- 7. Settings menu button**
- 8. Main display**
 - >> Shows the wire feed speed, current and/or voltage (content shown depends on the welding process selected).

To change the control panel settings and welding parameters, refer to "Manual control panel: Settings" on the next page.

Safety lock: By long-pressing the control knobs 1 and 2 simultaneously, the device can be locked for safety. This prevents welding and operating the device by accident without having to turn the equipment off. Unlock the device by pressing the control knobs 1 and 2 simultaneously for 2 seconds.

X5 Wire Feeder 200 Manual control panel (X5 FP 200R)



1. **Left control knob**
 - >> In MIG mode: Wire feed speed
 - >> In MMA mode: Welding current adjustment
 - >> In Gouging mode: Current adjustment
2. **Right control knob**
 - >> In MIG mode: Welding voltage adjustment
 - >> In MIG mode (push button): Switch between welding voltage and dynamics adjustment
 - >> In MMA mode: Dynamics adjustment
3. **Trigger logic selection**
 - >> Switches between 2T and 4T trigger logic modes
4. **Welding process / operation mode selection**
 - >> Switches between MIG, MMA and Gouging modes
 - >> Long press for TIG mode
5. **Home button**
 - >> Switches to the default welding view/mode
6. **Weld data button**
 - >> Shows the duration, current and voltage of the last weld
7. **Settings menu button**
8. **Gas test button**
 - >> Tests the shielding gas flow and flushes the gas line
9. **Wire inch button**
 - >> Drives the filler wire forward (with arc off)
10. **Main display**
 - >> Shows the wire feed speed, current and/or voltage (content shown depends on the welding process selected).


To change the control panel settings and welding parameters, refer to "Manual control panel: Settings" below.

Safety lock: By long-pressing the control knobs 1 and 2 simultaneously, the device can be locked for safety. This prevents welding and operating the device by accident without having to turn the equipment off. Unlock the device by pressing the control knobs 1 and 2 simultaneously for 2 seconds.

3.2.1 MANUAL CONTROL PANEL: SETTINGS

To enter and use Settings menu:

1. Press the Settings menu button.
2. Switch between the menu items by turning the control knob.
3. Select a menu item for adjustment by pressing the control knob button.
4. Adjust the parameter value (or other settings value) by turning the control knob.
5. Exit the adjustment dialog by pressing the control knob button again.

 *Rarely used settings items are hidden by default. Those are available in the advanced settings menu. To enter the advanced Settings menu, press the Settings button for approx. 5 seconds.*

Welding parameters, settings and feature descriptions

MIG settings

The parameters listed here are available for adjustment with the MIG process.

Parameter	Parameter value	Description
Pre gas	Min/Max = 0 ... 9.9 s, step 0.1 s 0 = OFF Default = auto	Welding function that starts the shielding gas flow before the arc ignites. This ensures that the metal does not come into contact with air at the start of the weld. Time value is preset by the user. Used for all metals, but especially for stainless steel, aluminum and titanium.
Post gas	Min/Max = 0 ... 9.9 s, step 0.1 s 0 = OFF Default = auto	Welding function that continues the shielding gas flow after the arc has extinguished. This ensures that the hot weld does not come into contact with air after the arc is extinguished, protecting the weld and also the electrode. Used for all metals. Especially stainless steel and titanium require longer post gas times.
Creep start level	Min/Max = 10 ... 90 %, step 1 % Default = auto	The Creep start function defines the wire feed speed before the welding arc ignites, that is, before the filler wire comes in contact with the workpiece. When the arc ignites, the wire feed speed is automatically switched to the normal user-set speed. The Creep start function is always on.
Touch Sense Ignition	ON/OFF Default = OFF	Touch Sense Ignition delivers minimum spatter and stabilizes the arc immediately after ignition.

Crater fill	ON/OFF Default = OFF	When welding with high power, a crater is usually formed at the end of the weld. The Crater fill function decreases the welding power / wire feed speed at the end of the welding job so that the crater can be filled using a lower power level. The Crater fill level, voltage and time (only in 2T trigger mode) are preset by the user.
- Crater fill time	Min/Max = 0.1 ... 5 s, step 0.1 s Default = 1.0 s	
- Crater fill wire feed speed	Min/Max = 0.5 ... 25 m/min Step: 0.05 (if wire feed speed < 5 m/min), 0.1 (if wire feed speed >= 5 m/min) Default: 5 m/min	
- Crater fill voltage	Min/Max = 8 ... 60 V, step 0.1 V Default = 18 V	
WF end step	ON/OFF Default = OFF	Wire feed end step feature prevents the filler wire from sticking to the contact tip when the welding ends.
Dynamics	Min/Max = -10.0 ... +10.0, step 0.2 Default = 0	Controls the short circuit behavior of the arc. The lower the value the softer the arc, the higher the value the rougher the arc.
Post current	-30 ... +30, step 1 Default = 0	Post current setting affects the wire length at the weld end. This also enables the optimum wire length for the start of the next weld.
Wire feed speed min	Min/Max = 0.5 ... 25 m/min, step 0.1 Default = 0.5 m/min	Minimum and maximum limits for the wire feed speed adjustment.
Wire feed speed max	Min/Max = 0.5 ... 25 m/min, step 0.1 Default = 25 m/min	
Voltage min	Min/Max = According to welding equipment specifications, step 0.1	Minimum and maximum limits for the welding voltage adjustment.
Voltage max	Min/Max = According to welding equipment specifications, step 0.1	
Remote mode	OFF/Remote/Gun Default = OFF	If remote controller is not connected, this selection is not available. Note: This setting does not affect and is not affected by the HR55 remote control.
Water cooler	OFF/Auto/ON Default = OFF	
Wire retract	OFF/ON	This is an automatic wire retract feature. Once the arc is extinguished, the wire is retracted for additional safety. The user can change the wire retract delay and length settings.
- Retract delay	2...10 s, step 1 Default = 5 s	
- Retract length	1...10 cm, step 1 Default = 2 cm	

Weld data averages	Without slopes / Entire weld Default = Without slopes	This feature allows the user to change how the weld data averages are calculated: with or without the slope phases in the beginning and in the end of the weld. This setting affects the calculation of the averages for the following: welding voltage (terminal and arc voltage), welding current, welding power and wire feed speed.
Voltage display mode	Terminal voltage / Arc voltage Default = Arc voltage	This defines which is shown on the control panel display, terminal or arc voltage.
Safe wire inch	ON/OFF Default = OFF	When ON, and the arc doesn't ignite, the filler wire is fed 5 cm. When OFF, 5 m of filler wire is fed.
Cable calibration	Calibrate/Cancel	The date and time and the calibration information of the previous calibration is also shown. Refer to "Calibrating welding cable" on page 110 for cable calibration.
Subfeeder (with X5 Wire Feeder 300/HD300 only)	<i>Subfeeder model</i> / OFF Default = OFF	If a compatible subfeeder is connected, select the subfeeder from the list. Compatible subfeeders: <i>SuperSnake GTX/GT02S(10m, 15m, 20m, 25m), Binzel PP401D, Binzel PP36D.</i> Note: With SuperSnake GT02S models, only motor synchronization is supported.

TIG welding parameters

The parameters listed here are available for adjustment with the TIG process.

Parameter	Parameter value	Description
Post gas	0.0 ... 30.0 s, step 0.1 0.0 = OFF	Welding function that continues the shielding gas flow after the arc has extinguished. This ensures that the hot weld does not come into contact with air after the arc is extinguished, protecting the weld and also the electrode. Used for all metals. Especially stainless steel and titanium require longer post gas times.
Current limit min	Min/Max = 10 ... machine size A, step 1 Default = 10 A	Minimum and maximum limits for the current adjustment.
Current limit max	Min/Max = 10 ... machine size A, step 1 Default = 10 A	
Water cooler	OFF/Auto/ON Default = OFF	

MMA and gouging settings

The parameters listed here are available for adjustment with the MMA welding process and gouging process.

Parameter	Parameter value	Description
Hot start	Min/Max = -30 ... +30, step 1 Default = 0	Welding function that uses higher or lower welding current at the start of the weld. During the Hot start period the current changes to the normal welding current level. The Hot start value affects the current level and duration. Use it to prevent the electrode from sticking to the work piece.
VRD	OFF/12V/24V Default = OFF	Voltage reduction device (VRD) reduces the open-circuit voltage to maintain below a certain voltage value.
Current limit min	Min/Max = According to machine size (A), step 1	Minimum and maximum limits for the current adjustment.
Current limit max	Min/Max = According to machine size (A), step 1	

Common settings

The parameters listed here are common system settings.

Parameter	Parameter value	Description
Weld data	Min/Max = 0 ... 10 s, step 1 0 = OFF Default = 5 s	This defines how long the weld data summary is shown after each weld.
Gas guard	OFF/ON Default = OFF	Gas guard prevents welding without shielding gas. This setting is not available if the gas guard is not installed.
Display off	Min/Max = 5 ... 120 min, step 1 Default = 5 min	Not available with MMA or gouging.
Date	Current date	Adjusting date: Select day by pressing the knob key Adjust day by rotating the knob (Min/Max = 1...28/29/30/31) Select month by pressing the knob key Adjust month by rotating the knob (Min/Max = 1...12) Select year by pressing the knob key Adjust year by rotating the knob (Min/Max = 2000...2099) Press the knob key to end adjustment.

Time	Current time	Adjusting time: Select hours by pressing the knob key Adjust hours by rotating the knob (Min/Max = 0...23) Select minutes by pressing the knob key Adjust minutes by rotating the knob (Min/Max = 0...59) Press the knob key to end adjustment.
Time counter total	>>>	This shows the total arc time and power on time.
Time counter since	>>>	This shows the total arc time and power on time since the last reset.
Reset time counter	Reset	This resets the time counter.
Language	Available languages	
Help	>>>	Panel display shows QR code for quick access to Kemppi Userdoc on a mobile device.
Error log *	>>>	Shows error code, date & time and short description of the error.
Info *	>>>	Displays the serial numbers of the wire feeder and the power source connected.
Software version *	>>>	Displays the software version numbers.
Factory reset *	Reset/Cancel Default = Cancel	This performs a full reset to factory settings.

* These are available in the advanced settings menu.

3.3 USING X5 AP/APC CONTROL PANEL

X5 AP/APC control panel (X5 FP 300 AP/APC) is included in:

- X5 Wire Feeder 300 AP/APC
- X5 Wire Feeder HD200 AP/APC
- X5 Wire Feeder HD300 AP/APC.

The X5 AP/APC wire feeder and control panel include advanced features and functions for MIG welding with the option to use the X5 FastMig also for TIG (DC) and MMA welding and gouging.

The automatic 1-MIG process is available along with the Kemppi welding programs as well as Wise and MAX features and processes (optional). For more information, refer to "How to get welding programs" on page 107.

X5 AP/APC control panel



General


1. Left control knob
>> Adjustment and selection
2. Right control knob
>> Adjustment and selection

- 3. Memory channels button**
 - >> Shortcut to the memory channel selection
 - >> Changed welding parameters can be quickly saved onto the active memory channel by keeping the Memory channels button pressed for approx. 2 seconds. This works in any view.
- 4. View menu button**
 - >> Enter view selection
 - >> Long press of the button returns to Home view, or if already in Home view, to the last used view.
- 5. Welding parameters button**
 - >> Shortcut to the welding parameters view
- 6. View selection**
 - >> Change view by turning the control knob (2)
 - >> Confirm view change by pressing the control knob (2).

Safety lock: By long-pressing the control knobs 1 and 2 simultaneously, the device can be locked for safety. This prevents welding and operating the device by accident without having to turn the equipment off. Unlock the device by pressing the control knobs 1 and 2 simultaneously for 2 seconds.

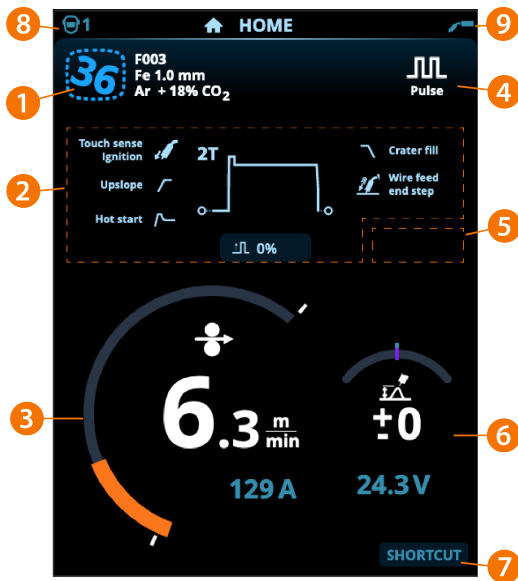
Views (7)

- A. [Home view](#)
- B. [Weld Assist view](#)
- C. [Memory channels view](#)
- D. [WPS view](#) (available with APC model)
- E. [WeldEye view](#) (available with APC model)
- F. [Welding parameters view](#)
- G. [Weld history view](#)
- H. [System settings view](#)
- I. [WLAN view](#) (available with APC model)
- J. [Info view](#)

 After each weld, a weld summary ([Weld data](#)) is displayed briefly.

3.3.1 AP/APC CONTROL PANEL: HOME VIEW

X5 AP/APC control panel's home view is also the main welding view.



1. Memory channel information
2. Applied welding parameters and functions
3. Wire feed speed (MIG) or current (TIG, MMA, Gouging)
4. Active welding process
5. Applied device settings (e.g. remote control or subfeeder)
6. Welding voltage
 - >> With 1-MIG process voltage fine tuning is displayed
 - >> With Wise/MAX process a corresponding Wise/MAX parameter adjustment is displayed.
7. Configurable function for the right control knob button
 - >> To define a shortcut, keep the right control knob button pressed for 3 seconds and select the shortcut function from the list of available options.
 - >> Once defined, the shortcut is used by short press of the right control knob button when in Home view.
8. Active user
9. Active operation mode.

Control knob functions in Home view

Left control knob:

- Manual MIG: Wire feed speed adjustment
- 1-MIG: Wire feed speed adjustment
- Pulse MIG: Wire feed speed adjustment
- DPulse MIG: Wire feed speed adjustment and switching between pulse levels with control knob button
- TIG/MMA: Welding current adjustment
- Gouging: Current adjustment.

Right control knob:

- Manual MIG: Welding voltage adjustment
- 1-MIG: Fine tuning of welding voltage or Wise/MAX parameter adjustment
- Pulse MIG: Fine tuning of welding voltage or Wise/MAX parameter adjustment
- DPulse MIG: Fine tuning of welding voltage
- MMA: Dynamics adjustment.

- i With Wise features, Wise processes or MAX processes turned on, the control knob functions in Home view and during welding may differ from the above. For more information on these features and processes, refer to "Additional guidance to functions and features" on page 151.

Weld data overlay view during welding



3.3.2 AP/APC CONTROL PANEL: WELD ASSIST

Weld Assist is available with X5 Wire Feeder AP/APC.

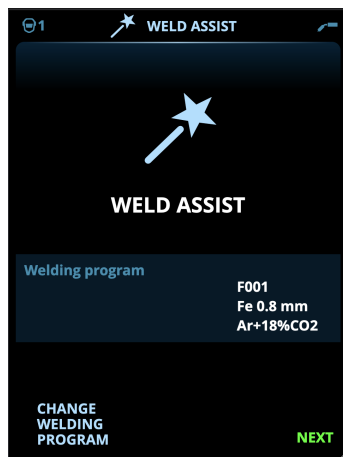
Weld Assist is a wizard-like utility for easy selection of welding parameters. The utility walks the user step-by-step through the selection of required parameters.

In Weld Assist, the selections are made with the two control knobs.

To use Weld Assist with MIG welding:

- i The currently selected welding program, including filler wire and shielding gas information, is shown and used as a basis in Weld Assist. If necessary, the welding program can be changed before continuing by selecting 'Change welding program'.
- i If the currently selected welding program (on the active memory channel) is not supported by Weld Assist, the user is guided to change the welding program.

1. To start, go to the **Weld Assist** view and select 'Next' with the control knob button.



2. Select:
 - >> The welding joint type: butt joint / corner joint / edge joint / lap joint / T-joint / tube joint / tube+plate joint.
 - >> The welding position: PA / PB / PC / PD / PE / PF / PG
 - >> The plate thickness (1...10 mm). Note: With PG position, the maximum plate thickness is 3 mm.



3. Weld Assist gives you a recommendation for these welding parameters:
 - >> Welding process
 - >> Wire feed speed
 - >> Gas flow rate
 - >> Travel speed
 - >> Separate values for root and fill passes (where applicable).
4. Save the Weld Assist's recommendation for welding settings by selecting 'Save'.



5. Select the memory channel slot for saving.
6. Once saved, the memory channel can be taken into use by selecting **Use** in Weld Assist, or later in the **Memory channels** view.

The welding parameters created with Weld Assist are still adjustable as per normal.

Tip: You can go back step by step in Weld Assist by pressing the left control knob button.

3.3.3 AP/APC CONTROL PANEL: CHANNELS

The memory channel view can be accessed either via the panel's view selection or by pressing the physical memory channel shortcut button above the display (refer to "Using X5 AP/APC control panel" on page 119 for more information).

The amount of available memory channels differs between different operation modes: MIG (100 channels), TIG (10 channels), MMA (10 channels) and gouging (10 channels).

 The operation mode set in the control panel [Settings](#) determines for which main welding process the memory channels are shown.



Changing memory channel

Turn the right control knob to highlight the desired memory channel. The highlighted memory channel is automatically activated.

Managing memory channels

The memory channels are managed through the **Actions** menu.

1. Enter the actions menu by pressing the right control knob.
2. Turn the control knob to highlight the desired action.
3. Select the action by pressing the right control knob.
4. Make further selections as required.

Available actions are:

- **Save changes:** Save changes to the currently selected channel
- **Save to:** Save the current settings to another channel
- **Rename:** Rename the channel
- **Delete:** Delete the currently selected channel
- **Link to WPS:** Link the currently selected channel to a weld pass on a digital welding procedure specification (dWPS) document. (Optional. The WPS feature is available with X5 Wire Feeder APC.)
- **Create channel:** Create a new channel based on the welding program(s)
 - >> MIG only: Welding programs can be filtered by base material, wire material, wire diameter, shielding gas and process. For more information, refer to "AP/APC control panel: Applying welding programs" on page 147.
- **Create from programs:** Create new channels based on all of the unused welding programs available (in MIG mode only)
- **Delete all:** Delete all channels.

The skewed channel number in the top left corner of the channel selection indicates that the set welding parameters are different from the ones currently saved on the active memory channel:



Tip: Changed welding parameters can be quickly saved onto the active memory channel by keeping the Memory channels button pressed for approx. 2 seconds. This works in any view.

3.3.4 APC CONTROL PANEL: WPS VIEW

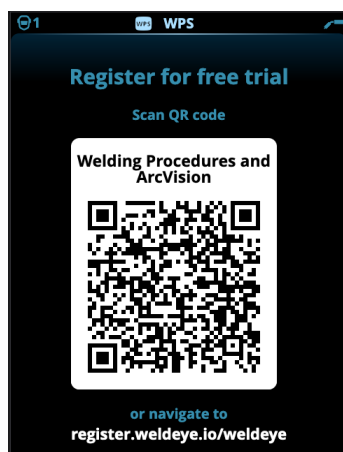
The use of digital WPS (Welding Procedure Specification, dWPS) and WeldEye cloud service requires X5 Wire Feeder APC model and a valid Kemppi WeldEye subscription with the Welding Procedures module. The X5 equipment includes a link to a free trial registration – featuring also a free trial option for WeldEye ArcVision. For more information on WeldEye, refer to weldeye.com or contact your Kemppi representative.

To take the digital WPS feature in use, the equipment must be connected to the internet via the built-in wireless connection (WLAN). Refer to "Wireless connection (WLAN)" on page 160 for instructions.



Trial registration

The X5 FastMig with APC wire feeder comes preinstalled with a trial license for the WeldEye Welding Procedures module. The trial license can be activated by following these steps:

1. On the X5 APC control panel, go to the **WPS view**.
2. Use a QR code reader on your mobile device to open the WeldEye web link or navigate to 'https://register.weldeye.io/weldeye' on your web browser.



3. Complete the registration process as instructed on the registration page.

-  You will be required to fill in the serial number and four-digit security pin of your X5 power source. These can be found on the power source rating plate.
-  The free trial registration includes both the WeldEye Welding Procedures and WeldEye ArcVision modules.

Using dWPS

The **WPS view** shows the digital WPSs with one or more weld passes assigned to the welder or welding station in the Kemppi WeldEye cloud service.

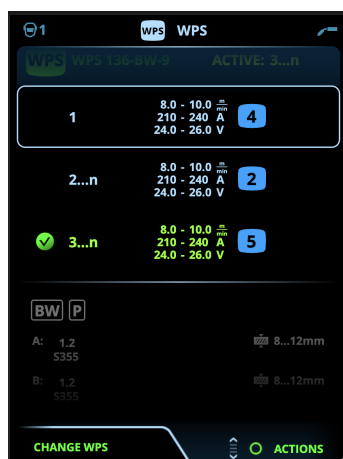
To take a dWPS in use:

1. Select the desired dWPS for viewing and for selecting a weld pass by turning the right control knob and pressing the right control knob button.



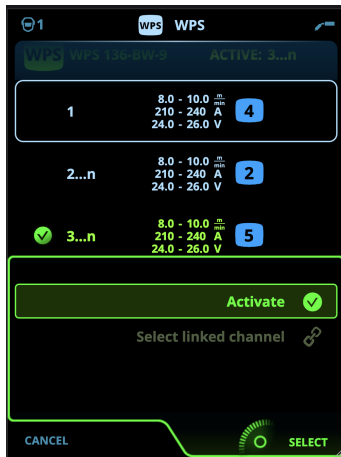
*ⓘ If a dWPS and weld pass have already before been linked to the active memory channel, the **WPS** view opens directly to that WPS. To open the list of available dWPSs, select 'Change WPS'.*

2. Select a weld pass on the dWPS by turning the right control knob and enter the actions menu by pressing the right control knob button.




>> The linked memory channel set as default is emphasized (in brighter blue) for each weld pass.

- If a memory channel has already been linked to the weld pass, you can activate the selected weld pass and the default memory channel by selecting 'Activate'.



- If a memory channel has not been linked to the weld pass previously, you can link the weld pass to an existing memory channel ('Select linked channel').

 A memory channel can also be linked to a weld pass on a dWPS through the **Memory channels view** by selecting 'Link to WPS' in the memory channel's actions menu.

Once a weld pass on a dWPS is activated, the default memory channel linked to it is automatically selected. This is indicated also in the home view and on screen during welding.

The welding parameters are still manually adjustable, but the adjustment ranges defined on the active WPS are indicated on the screen (1). If you adjust the welding parameters outside the WPS adjustment range, the control panel shows a warning (2) on the screen:

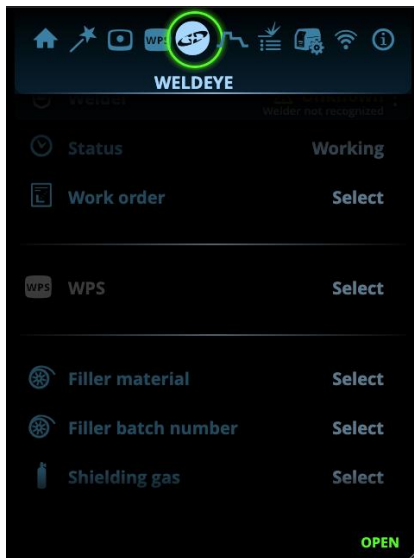


The active WPS can be deactivated by selecting 'Stop using' in the WPS's weld pass actions menu.

More feature descriptions here:

- >> "Digital Welding Procedure Specification (dWPS)" on page 161
- >> "WeldEye ArcVision" on page 162
- >> "WeldEye" on page 162

3.3.5 APC CONTROL PANEL: WELDEYE







This chapter is about the optional WeldEye feature in X5 APC wire feeder models.

The use of this WeldEye feature and cloud service require an up-to-date X5 FastMig equipment and a valid **Kemppi WeldEye Quality Management** subscription. For more information on WeldEye, refer to weldeye.com or contact your Kemppi representative.

The built-in WeldEye feature collects and passes on welding data, keeping it synchronized between the welding equipment and WeldEye cloud service. The WeldEye cloud service can be accessed using a desktop computer and an internet browser.

To take the WeldEye feature in use, the equipment must be connected to the internet via the built-in wireless connection (WLAN). Refer to "Wireless connection (WLAN)" on page 160 for instructions.

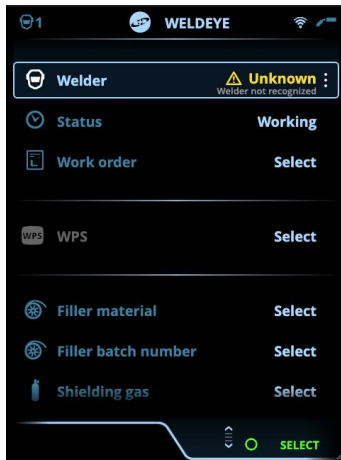
The welding equipment must also be added to your WeldEye account in the WeldEye cloud service. Once the equipment is connected to the internet and added into WeldEye, the equipment logs in to WeldEye automatically. For more information on using the WeldEye cloud service, refer to the WeldEye documentation in your organization's WeldEye cloud service.

-  *The selections in the WeldEye view are made beforehand for the weld or work in question. The weld data is then saved along with these selections in the WeldEye cloud service after the work has been completed.*
-  *If the welding equipment loses the internet connection during work, the weld data is saved locally and synchronized with the WeldEye cloud service once the connection has been restored.*
-  *If the WPS referred to in the selected work order is specified for another welding mode (e.g., TIG) than what is currently selected (e.g., MIG), it is indicated in the WeldEye view as a welding mode change recommendation. Also, the WPS referred to is not available in the WPS selection menu until the welding mode is changed to correspond with the WPS process.*
-  *WeldEye is a highly configurable welding management software. Depending on your WeldEye cloud service settings, some of the attributes or features mentioned here may be disabled or not used in your organization. Refer to your WeldEye administrator for more information.*

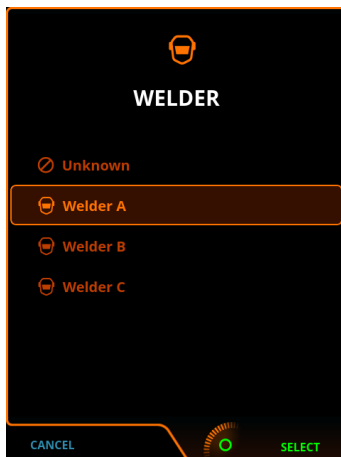
Selecting welder

The **WeldEye view** allows selecting the welder for the welding work at hand. The welders are predefined in the WeldEye cloud service.

1. Go to the WeldEye view and select "Welder" by turning and pressing the right control knob.



2. Select your name on the list.



If your name is not on the list, you can leave the welder unselected (unknown).

 *The WeldEye's welder selection is not linked with the user selection in the device settings.*

Selecting status

The welder's status can also be reported in the WeldEye view. This is used primarily for reporting when the actual welding work has been interrupted temporarily, typically due to maintenance or some other reason. The status options (reason codes) are specified in the WeldEye cloud service.

By default, the status is not defined, which is indicated by the text "Undefined".

1. In the WeldEye view, select "Status" by turning and pressing the right control knob.
2. Select the status from the menu.

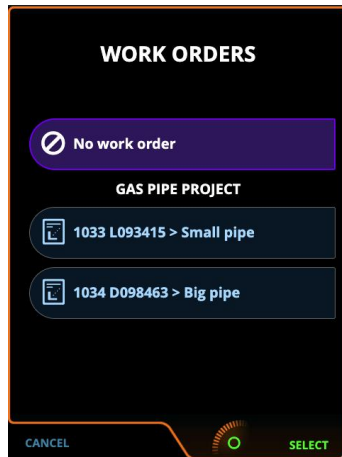
When the welding commences, the status is automatically reset to undefined.

Selecting work order and weld

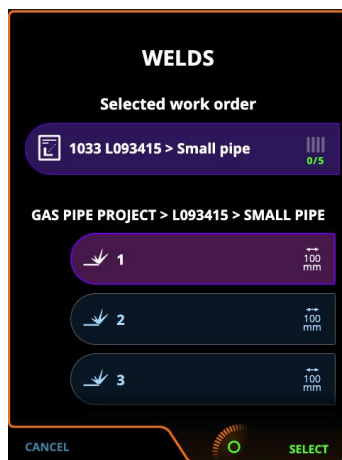
In the **WeldEye view** you can select digital work orders assigned to you in the Kemppi WeldEye cloud service. The work order feature is enabled by default.

i In case the use of work orders has been disabled in the WeldEye settings, welds are selected directly from a list (categorized by projects and/or weld lists), and welder-specific weld filtering is not applied.

1. In the WeldEye view, select "Work order" by turning and pressing the right control knob.
2. Select a work order from the list.



3. If the work order has more than one weld or weld pass included, select also the specific weld or weld pass to be welded.



The welds and weld passes on the work order can have digital WPSes (welding procedure specifications) attached to them. When a work order is selected, and it has a WPS or WPSes included, a WPS row is shown in the WeldEye view.

i A digital WPS may contain one or more requirements or recommendations for the welder's qualification and the filler material and gas to be used. If the welder or the materials selected do not meet the criteria on the work order, it is indicated with a caution symbol.

Applying digital WPS

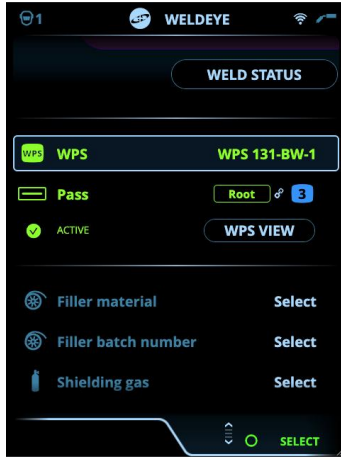
If the selected weld on the work order includes a digital WPS that has already been linked to a memory channel, that memory channel is automatically activated. For more information on digital WPSes on the X5 equipment, refer to "APC control panel: WPS view" on page 125.

i If the device-level user is changed in the device settings, also the saved memory channels change. Therefore, the digital WPS linking with memory channels must be established for each device-level user separately.

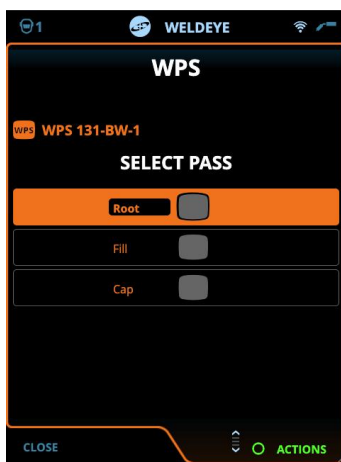
If no WPS is selected, you can go to the WPS row in the WeldEye view, and select an available WPS.

Also WPS linking or re-linking can be accomplished directly from the WeldEye view. To link or re-link WPS:

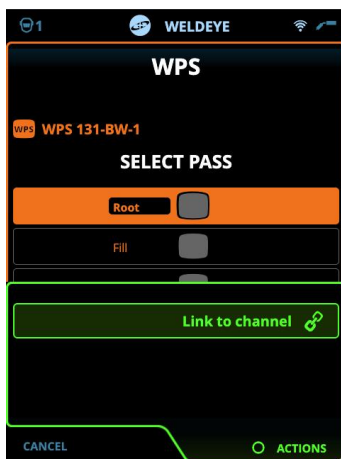
1. In the WeldEye view, select the weld and weld pass below the WPS row by turning and pressing the right control knob.



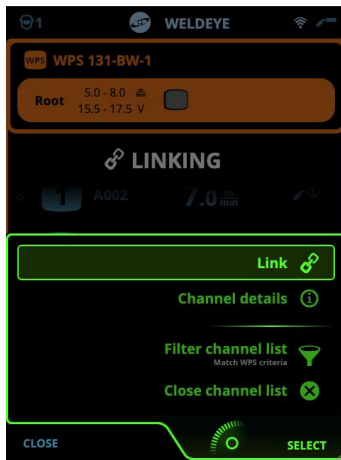
2. In the menu that opens, select the weld pass and WPS linking you want to edit.



3. Open the actions menu and select "Link to channel".



4. In the memory channel list, select the memory channel you want to link the WPS with.
>> If needed, select "Filter channel list" to filter memory channels based on the WPS specifications.






You can access the weld pass selection of the active WPS by selecting the weld pass row in the WeldEye view. In the selection dialog that opens, all of the weld passes are listed and each of them can be linked to a memory channel.

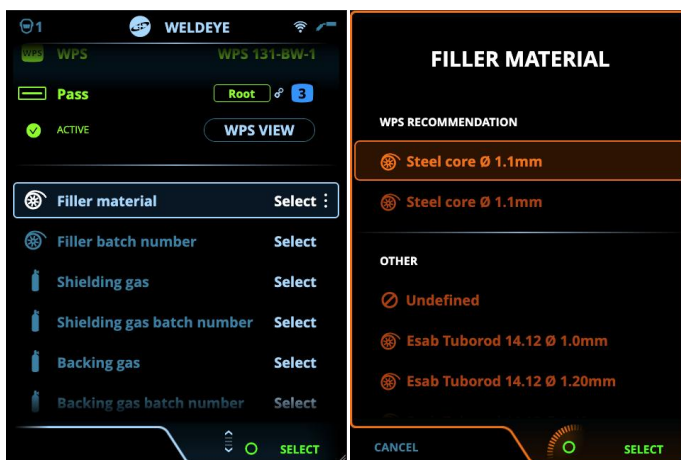
When a WPS is linked to a memory channel, that channel is automatically applied.

Entering material information

The lower section of the WeldEye view shows the filler wire material and gas information including their batch identification (if and as required).

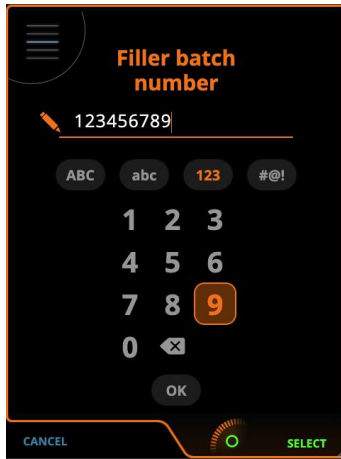
-  *The material information filled in the WeldEye view should always match with the filler material and gas used in welding (i.e., what is installed in the welding equipment).*
-  *A digital WPS may include several recommendations for filler material and gases. You can check and change the recommended materials in the WeldEye view.*
-  *A digital WPS may contain one or more requirements or recommendations for the welder's qualification and/or the filler material and gas to be used. If the welder or the materials selected do not meet the criteria, it is indicated with a caution symbol.*

1. Select the filler material and gas in the corresponding menus by turning and pressing the right control knob.



2. Select or enter also the batch information if/as required with the right control knob.

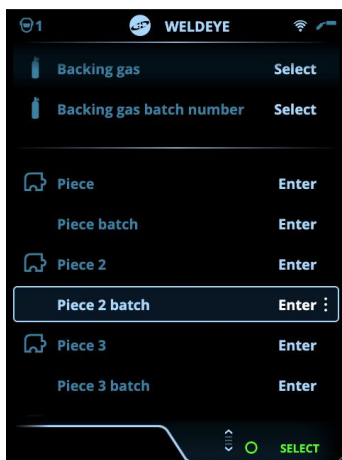
>> A virtual keyboard is used for entering the filler or gas batch identification manually, if the correct batch identification is not already on the list. Once the batch identification information has been entered for the first time, it becomes available as a pre-filled list option for later use.



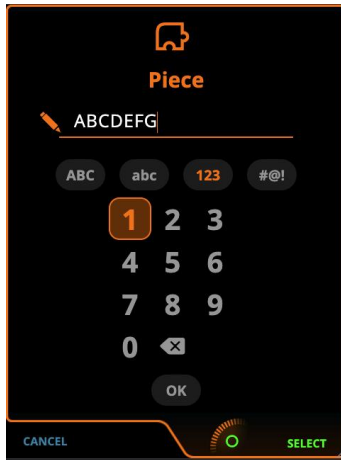
3. Ensure that the selected filler material and gas are installed and ready for welding.

Selecting work piece

Also the work piece information can be used and saved in WeldEye. If this feature is enabled in the WeldEye cloud service settings, the work piece selection is available in the WeldEye view.



1. Select the work piece by turning and pressing the right control knob.
2. Enter the work piece information using the virtual keyboard with the right control knob.

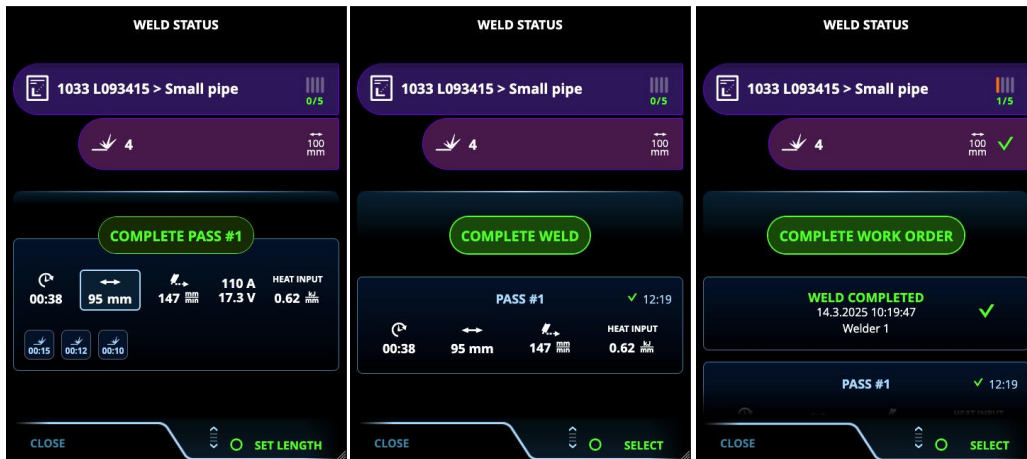


Completing work

Once work (work order, weld, weld pass) has been completed, it can be confirmed in the weld status view that opens right after finishing a weld. This view also replaces the standard weld data view in WeldEye use.

If the work has not been marked as completed right after finishing the weld, it can be done also in the WeldEye view:

1. Go to the work you finished, and select "Weld status" by turning and pressing the right control knob.
2. In the weld status dialog, select "Complete pass", "Complete weld" or "Complete work order", depending on which work stage you're finishing.



When completing a weld pass, the weld length can be entered in the weld status view by selecting the length symbol and "Set length" with the right control knob button.



- i Even if all of the individual welds are marked as completed, the work order itself must also be completed in the WeldEye view.
- i It is possible to mark welds and work orders completed even if they would contain incomplete weld passes and/or welds. Make sure that all of the welding work has been completed as required before completing welds or work orders in WeldEye.

More related feature descriptions here:

- >> "Digital Welding Procedure Specification (dWPS)" on page 161
- >> "WeldEye ArcVision" on page 162
- >> "WeldEye" on page 162
- >> "WeldEye with DCM" on page 163

3.3.6 AP/APC CONTROL PANEL: WELDING PARAMETERS

The Welding parameters view includes a start and stop curve for visualizing and adjusting the most essential parameters for a weld. The bottom section of the view lists the available adjustments for the selected welding process. The welding process selection is based on the active memory channel and its settings.

- i Many of the welding parameters are welding process specific and are visible and available for adjustment accordingly.



Adjusting welding parameters

1. Turn the right control knob to highlight the desired welding parameter.
2. Press the right control knob to select the welding parameter for adjustment.
3. Turn the right control knob to adjust welding parameter value.
 - >> Depending on the parameter to be adjusted, refer also to the Welding parameters table below for more details.
4. Confirm the new value / selection and close the adjustment view by pressing the right control knob.

Saving welding parameters for later use

A work channel is automatically created for the changed welding parameters. To save the set welding parameters on a memory channel, do one of the following:

- Quick active channel option: Keep the Channels shortcut button pressed for approximately 2 seconds.
 - >> This will save the parameter settings onto the currently active channel replacing its previous parameter settings.
- Channels view option: Go to the Channels view and save the parameter settings onto a new channel.
 - >> Refer to "AP/APC control panel: Channels" on page 123 for more information.

Welding parameters and feature descriptions

MIG and 1-MIG welding parameters

The parameters listed here are available for adjustment with the MIG and 1-MIG processes.

Parameter	Parameter value	Description
Process	MIG, 1-MIG, Pulse, DPulse, WiseRoot+, WiseThin+, MAX Cool, MAX Speed, MAX Position	This MIG welding process selection depends on the active welding program as well as the equipment type used. For more information on the additional processes, refer to "Additional guidance to functions and features" on page 151.

Trigger logic	2T, 4T	Welding guns can have several alternative trigger operation modes (trigger logics). Most common are 2T and 4T. In 2T mode you hold the trigger down while welding. In 4T mode you press and release the trigger to start or to stop welding. For more information, refer to "Trigger logic functions" on page 151.
Cycle timer	ON/OFF Default = OFF	Cycle timer is a welding function that automatically produces a weld or welds of predefined duration. For more information, refer to "Cycle timer" on page 167.
- Cycle arc time	0.0 ... 60.0 s Default = 2.0 s	
- Cycle pause	ON/OFF Default = OFF	
- Cycle pause time	0.1 ... 3.0 s, step 0.1 s Default = 0.1 s	
Pre gas	0.0 ... 9.9 s, Auto, step 0.1 0.0 = OFF	Welding function that starts the shielding gas flow before the arc ignites. This ensures that the metal does not come into contact with air at the start of the weld. Time value is preset by the user. Used for all metals, but especially for stainless steel, aluminum and titanium.
Creep start	10...90 %, Auto, step 1	The Creep start function defines the wire feed speed before the welding arc ignites, that is, before the filler wire comes in contact with the workpiece. When the arc ignites, the wire feed speed is automatically switched to the normal user-set speed. The Creep start function is always on.
Touch Sense Ignition	AUTO/ON/OFF	Touch Sense Ignition (TSI) delivers minimum spatter and stabilizes the arc immediately after ignition.
Wire feed speed	0.50 ... 25 m/min, step 0.05 or 0.1 Default = 5.00 m/min	Wire feed speed adjustment. When the wire feed speed is less than 5 m/min, the adjustment step is 0.05 and when the wire feed speed is 5 m/min or more, the adjustment step is 0.1.
Wire feed speed min	Min/Max = 0.5 ... 25 m/min, step 0.1 Default = 0.5 m/min	Minimum and maximum limits for the wire feed speed adjustment.
Wire feed speed max	Min/Max = 0.5 ... 25 m/min, step 0.1 Default = 25 m/min	

Voltage	Min/Max = According to welding equipment specifications, step 0.1	Welding voltage adjustment and the minimum and maximum limits for the welding voltage adjustment. These parameters are available for adjustment in MIG only. In 1-MIG the voltage is defined by welding program.
Dynamics	-10.0 ... +10.0, step 0.2 Default = 0	Controls the short circuit behavior of the arc. The lower the value the softer the arc, the higher the value the rougher the arc. (Not available with WiseRoot+, MAX Cool and MAX Speed.)
Crater fill	ON/OFF	When welding with high power, a crater is usually formed at the end of the weld. The Crater fill function decreases the welding power / wire feed speed at the end of the welding job so that the crater can be filled using a lower power level. With manual MIG process, Crater fill duration, wire feed speed and voltage are preset by the user.
- Crater fill time	0.0 ... 10.0 s, Auto, step 0.1 Default = 1.0 s	When the wire feed speed is less than 5 m/min, the adjustment step is 0.05 and when the wire feed speed is 5 m/min or more, the adjustment step is 0.1.
- Crater fill wire feed speed	0.5 ... 25.0 m/min, Auto, step 0.05 or 0.1 Default = 5 m/min	For more information, refer to "Hot start and crater fill functions" on page 152. For other processes, refer to the parameter tables below.
- Crater fill voltage	400A: 8 ... 45 V, Auto 500A: 8 ... 50 V, Auto Step 0.1 V Default = 18 V	
Post current	-30 ... +30	Post current setting affects the wire length at the weld end, for example to prevent the wire from stopping too close to the weld pool. This also enables the optimum wire length for the start of the next weld.
Wire feed end step (WF end step)	OFF/ON Default = OFF	Wire feed end step feature prevents the filler wire from sticking to the contact tip when the welding ends.
Post gas	0.0 ... 9.9 s, Auto, step 0.1 0.0 = OFF	Welding function that continues the shielding gas flow after the arc has extinguished. This ensures that the hot weld does not come into contact with air after the arc is extinguished, protecting the weld and also the electrode. Used for all metals. Especially stainless steel and titanium require longer post gas times.

1-MIG welding parameters

The parameters listed here are available for adjustment with the 1-MIG process.

Parameter	Parameter value	Description
Trigger logic	2T, 4T, Powerlog (2 levels or 3 levels)	Welding guns can have several alternative trigger operation modes (trigger logics). Most common are 2T and 4T. In 2T mode you hold the trigger down while welding. In 4T mode you press and release the trigger to start or to stop welding. Note that enabling Powerlog opens additional Powerlog settings in the Welding parameters view. For more information, refer to "Trigger logic functions" on page 151.
Upslope	ON/OFF	Upslope is a welding function that determines the time, during which the welding current gradually increases to the desired welding current level at the start of the weld. The upslope start level and time are preset by the user.
- Upslope start level	10 ... 100 %, Auto, step 1 Default = 50	
- Upslope time	0.1 ... 5 s, Auto, step 0.1 Default = 0.10	
Hot start	ON/OFF	Welding function that uses higher or lower wire feed speed and welding current at the start of the weld. After the Hot start period the current changes to normal welding current level. This facilitates the start of the weld especially with aluminum materials. The Hot start slope time adjustment sets the transition time from the Hot start phase to the normal welding current level. The Hot start level and time are adjustable in 2T trigger logic only. Hot start fine tuning (voltage) is adjustable with 1-MIG, Pulse, DPulse, WiseThin+ and MAX Speed processes. For more information, refer to "Hot start and crater fill functions" on page 152.
- Hot start level	-50 ... +200 %, Auto, step 1 Default = 40	
- Hot start fine tuning	-10.0 ... +10.0, step 0.1 Default = 0.0	
- Hot start time	0.1 ... 9.9 s, Auto, step 0.1 Default = 1.2 s	
- Hot start slope time	0.0 ... 10.0 s, step 0.1 s Default = 0.0 s	
Wise feature	None, WiseFusion, WisePenetration, WiseSteel	

Fine tuning	Example: -10.0 ... +10.0 V * Step 0.1 V	Fine tuning of the welding voltage. * The voltage range for fine tuning is defined by the active welding program.
Crater fill	OFF/ON/TIMER	When welding with high power, a crater is usually formed at the end of the weld. The Crater fill function decreases the welding power / wire feed speed at the end of the welding job so that the crater can be filled using a lower power level. Crater fill's timer option is available in 4T trigger logic only. It allows setting a fixed duration for the end level. Crater fill fine tuning (voltage) is adjustable with 1-MIG, Pulse, DPulse, WiseThin+ and MaxSpeed processes. For more information, refer to "Hot start and crater fill functions" on page 152.
- Crater fill start level	10 ... 150 %, Auto, step 1 Default = 100	
- Crater fill time	0.1 ... 10.0 s, Auto, step 0.1 Default = 1.0 s	
- Crater fill end level	10 ... 150 %, Auto, step 1 Default = 30	
- Crater fill end level time	OFF ... 10.0 s, step 0.1 Default = OFF	
- Crater fill fine tuning	-10.0 ... +10.0, step 0.1 Default = 0.0	
Current	10 ... machine size A, step 1 Default = 50 A	Welding current adjustment with WisePenetration+ only.

Pulse/DPulse welding parameters

The parameters listed here are available for adjustment in addition to the MIG and 1-MIG welding parameters when an X5 pulse power source is connected. DPulse = Double pulse process.

Parameter	Parameter value	Description
Pulse current %	-10 ... +15 %, step 1	The pulse current fine tuning relative to the current with Pulse and DPulse welding processes.
DPulse ratio	10 ... 90 %, step 1	This adjusts the double pulse time percentage, i.e. how long the double pulse is at the first pulse level. The second pulse level is determined in relation to the first level setting.
DPulse frequency	0.4 ... 8.0 Hz, Auto, step 0.1	This adjusts the double pulse frequency. How long it takes from the start of 1st level to the end of 2nd level.
DPulse level 1: Wire feed speed	0.50 ... 25 m/min, step 0.05 or 0.1	First double pulse level wire feed speed (and minimum / maximum values for wire feed speed). When the wire feed speed is less than 5 m/min, the adjustment step is 0.05 and when the wire feed speed is 5 m/min or more, the adjustment step is 0.1.
DPulse level 1: Fine tuning	-10 ... +10, step 1	Fine tuning of the welding voltage.

DPulse level 1: Dynamics	-10.0 ... +10.0, step 0.2 Default = 0	Controls the short circuit behavior of the arc. The lower the value the softer the arc, the higher the value the rougher the arc.
DPulse level 2: Wire feed speed	0.50 ... 25 m/min, step 0.05 or 0.1	Second double pulse level wire feed speed. The DPulse level 2 wire feed speed changes automatically when the DPulse level 1 wire feed speed setting is adjusted. When the wire feed speed is less than 5 m/min, the adjustment step is 0.05 and when the wire feed speed is 5 m/min or more, the adjustment step is 0.1.
DPulse level 2: Fine tuning	-10 ... +10, step 1	Fine tuning of the welding voltage.
DPulse level 2: Dynamics	-10.0 ... +10.0, step 0.2 Default = 0	Controls the short circuit behavior of the arc. The lower the value the softer the arc, the higher the value the rougher the arc.

MAX Speed parameters

The parameters listed here are MAX Speed process specific.

Parameter	Parameter value	Description
MAX Speed frequency	100 ... 800 Hz, Auto step 10	MAX Speed frequency setting.

MAX Position parameters

The parameters listed here are MAX Position process specific.

Parameter	Parameter value	Description
MAX Position frequency	-0.5 ... +0.5 Hz, step 0.1 Default = 0	MAX Position frequency fine tuning.
Pulse current %	-10 ... 15 %, step 1 Default = 0	MAX Position pulse current adjustment.
Plate thickness	3.0 ... 12.0 mm	MAX Position plate thickness setting.

TIG welding parameters

The parameters listed here are available for adjustment with the TIG process.

Parameter	Parameter value	Description
Trigger logic	2T, 4T	Welding guns can have several alternative trigger operation modes (trigger logics). Most common are 2T and 4T. In 2T mode you hold the trigger down while welding. In 4T mode you press and release the trigger to start or to stop welding.

Post gas	0.0 ... 30.0 s, step 0.1 0.0 = OFF	Welding function that continues the shielding gas flow after the arc has extinguished. This ensures that the hot weld does not come into contact with air after the arc is extinguished, protecting the weld and also the electrode. Used for all metals. Especially stainless steel and titanium require longer post gas times.
Current	10 ... machine size A, step 1 Default = 50 A	Welding current adjustment.
Current limit min	Min/Max = 10 ... machine size A, step 1 Default = 10 A	Minimum and maximum limits for the current adjustment.
Current limit max	Min/Max = 10 ... machine size A, step 1 Default = 10 A	

MMA welding parameters

The parameters listed here are available for adjustment with the MMA process.

Parameter	Parameter value	Description
Dynamics	-10.0 ... +10.0, step 0.2 Default = 0	Controls the short circuit behavior of the arc. The lower the value the softer the arc, the higher the value the rougher the arc.
Hot start level	-30 ... +30 Default = 0	Welding function that uses higher or lower welding current at the start of the weld. After the Hot start period the current changes to normal welding current level. This facilitates the start of the weld especially with aluminum materials. In MMA the Hot start level is preset by the user.
Current	10 ... machine size A, step 1 Default = 50 A	Welding current adjustment.
Current limit min	Min/Max = 10 ... machine size A, step 1 Default = 10 A	Minimum and maximum limits for the current adjustment.
Current limit max	Min/Max = 10 ... machine size A, step 1 Default = 10 A	
Arc break	OFF, 30...60 V, step 1 Default = OFF	Determines the point where the arc is extinguished in relation to the arc length in MMA welding.

Gouging parameters

The parameters listed here are available for adjustment with the gouging process.

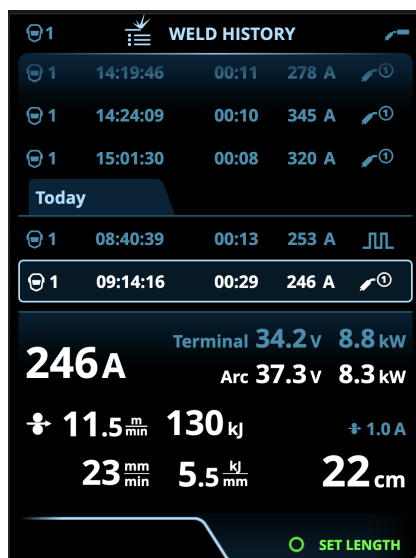
Parameter	Parameter value	Description
-----------	-----------------	-------------

Current	10 ... machine size A, step 1 Default = 50 A	Current adjustment.
Current limit min	Min/Max = 10 ... machine size A, step 1 Default = 10 A	Minimum and maximum limits for the current adjustment.
Current limit max	Min/Max = 10 ... machine size A, step 1 Default = 10 A	
Hot start level	-30 ... +30 Default = 0	Welding function that uses higher or lower current at the start of the pro- cess.

For more information on the additional welding features and functions, refer to "Additional guidance to functions and features" on page 151.

3.3.7 AP/APC CONTROL PANEL: WELD HISTORY

The Weld history view collects the information of the past welds (the last 10) into one view for later checking. To change how the weld data averages are calculated (with or without slope phases) refer to "AP/APC control panel: Device settings" on the next page.



Heat input calculation in weld history view

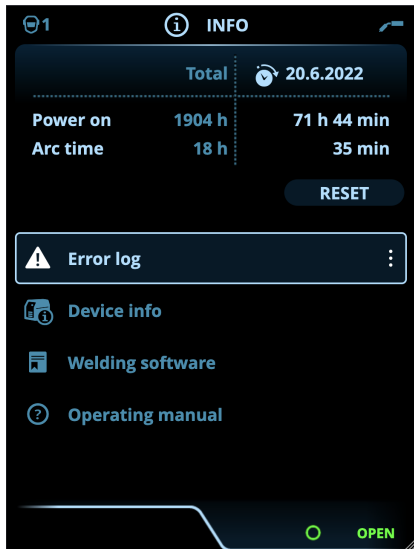
The heat input of a weld can be calculated by entering the weld length into the weld's history entry.

1. Select 'Set length' by pressing the right control knob button.
2. Set the weld length by turning the right control knob.
3. Confirm the weld length for calculation by pressing the control knob button.

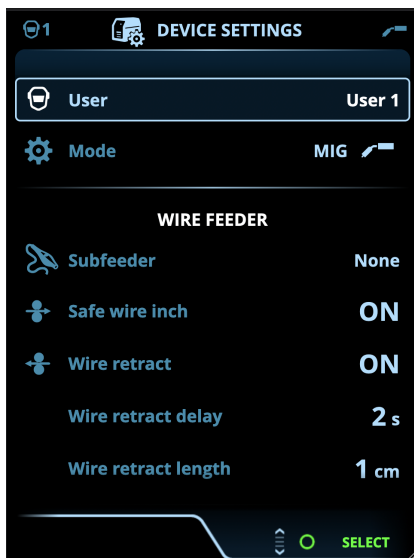
3.3.8 AP/APC CONTROL PANEL: INFO VIEW

The **Info** view shows information on the device usage.

Through this view it is also possible to access the error logs, list of installed welding programs, processes and features as well as additional operating information and device info, such as the software version and equipment serial numbers.



3.3.9 AP/APC CONTROL PANEL: DEVICE SETTINGS



Changing settings

1. Turn the right control knob to highlight the desired settings parameter.
2. Press the right control knob to select the settings parameter for adjustment.
3. Turn the right control knob to select the settings value.

>> Depending on the settings parameter to be adjusted, refer also to the Settings table below for more details.

4. Confirm the new value / selection and close the adjustment view by pressing the right control knob.

Users

The system settings can be customized for up to 10 different users. In addition to the system settings, the memory channels are user-specific. Each user can have up to 100 MIG channels, 10 TIG channels, 10 MMA channels and 10 gouging channels. The memory channel and system settings are saved automatically for the logged-in user.

Settings

Parameter	Parameter value	Description
User	Current user	There is always a logged-in user in the system. When a new user logs in, the previous user is automatically logged out. In case of a mixed double wire feeder installation where the other wire feeder is a Manual model, user 1 is automatically applied and user change is disabled.
Mode	MIG/TIG/MMA/Gouging	Note: For TIG welding the polarity (+/-) must be switched. For more information, refer to "Installing cables (X5 WF 200, X5 WF 300, X5 WF HD300)" on page 66.
Demo time	OFF/ON	The demo time feature allows you to try out optional welding features and functions without a license for a limited time. The total available demo time is 3 hours. The demo time passes only when welding using a welding feature you don't have a license for. When the demo time is set to ON, the remaining time is shown on the display.
Settings lock	Not in use / Unlocked / Locked	Settings lock is used to restrict changes to a predefined set of welding parameters and device settings. When this feature is turned on, the settings can be locked and unlocked in the device settings. A PIN code can be set for the settings lock. For more information, refer to "Settings lock" on page 168.
Remote control	OFF / Hand remote / Gun remote Default = OFF	If remote controller is not connected, this selection is not available. Note: This setting does not affect and is not affected by the HR55 remote control.

Remote mode (with 1-knob remote control)	Wire feed speed or current / Channel	This determines what is changed with the remote, welding parameter or memory channel (available channels: 1...5). The parameters are process-specific. If remote controller is not connected and remote not selected, this selection is not available.
Remote mode (with 2-knob remote control)	Welding parameters / Channel	Note (2-knob remote): When the remote mode is set to 'Channel', only the left remote control knob is in use. Note: If the HR55 remote control is also connected, the parameter that is selected here cannot be adjusted with the HR55 remote control.
Subfeeder (in MIG mode and with X5 Wire Feeder 300/HD300 only)	Subfeeder model / None Default = None	If a compatible subfeeder is connected, select the subfeeder from the list. Compatible subfeeders: <i>SuperSnake GTX (10m, 15m, 20m, 25m), Binzel PP401D, Binzel PP36D.</i>
Safe wire inch (with MIG only)	OFF/ON	When ON, and the arc doesn't ignite, the filler wire is fed 5 cm When OFF, 5 m of filler wire is fed.
Wire retract	OFF/ON	This is an automatic wire retract feature. Once the arc is extinguished, the wire is retracted for additional safety. The user can change the wire retract delay and length settings. Note: Wire retract function is disabled if a subfeeder is connected.
- Wire retract delay	2...10 s, step 1 Default = 5 s	
- Wire retract length	1...10 cm, step 1 Default = 2 cm	
Language	Available languages	This allows the user to select the control panel language from a list of available languages.
Weld data time	0...30 s, step 1 0 = OFF Default = 5 s	This defines if and how long the weld data summary is shown after each weld.
Weld data average	Without slopes / Entire weld Default = Without slopes	This feature allows the user to change how the weld data averages are calculated: with or without the slope phases in the beginning and in the end of the weld. This setting affects the calculation of the averages for the following: welding voltage (terminal and arc voltage), welding current, welding power and wire feed speed.

Brightness	1...10	The control panel display brightness.
Date	Current date	Date setting.
Time (24h)	Current time	Time setting in 24h format.
Screensaver	OFF/1...120 min, step 1 Default = 5 min	The screensaver image is shown on display after the set time period. By default, the Kemppi logo is shown. To change the screensaver image, refer to "USB update" on page 165.
Display off	OFF/1...120 min, step 1 Default = 5 min	The control panel display is turned off after the set time period. The right control knob light is lit when the display is off.
Cable calibration (with MIG only)	Start/Cancel	The date and time and the calibration information of the previous calibration is also shown. Refer to "Calibrating welding cable" on page 110 for cable calibration.
Water cooling	OFF/Auto/ON Default = Auto	When ON is selected, the coolant is circulated continuously, and when Auto is selected, the coolant is circulated only during welding.
Gas guard	OFF/ON Default = OFF	Gas guard prevents welding without shielding gas. This setting is not available if the gas guard is not installed.
VRD (with MMA and gouging only)	OFF/12V/24V Default = OFF	Voltage reduction device (VRD) reduces the open-circuit voltage to maintain below a certain voltage value.
Backup	(Selection)	This allows the settings to be saved on a connected USB memory stick.
Restore	(Selection)	This allows the settings to be restored from a connected USB memory stick.
Factory reset	Start/Cancel Default = Cancel	This resets the equipment to factory settings.

3.3.10 AP/APC CONTROL PANEL: APPLYING WELDING PROGRAMS

To select and apply a MIG welding process and program, a corresponding memory channel must be created.

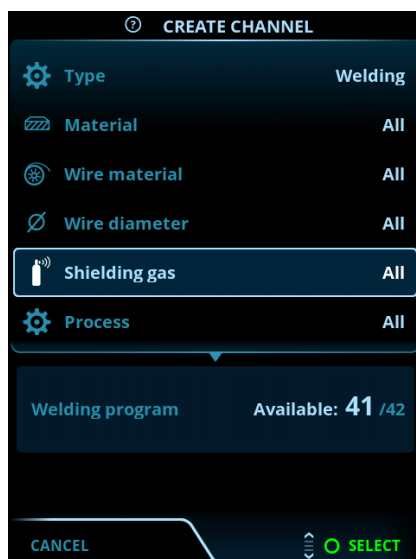
When creating the memory channel for a particular MIG welding process, the selection of welding programs can be narrowed down based on the available MIG welding processes: Manual, 1-MIG, MAX Speed (optional), MAX Position (optional), MAX Cool (optional), WiseRoot+ (optional) and WiseThin+ (optional).

- i** The use of additional welding programs and Wise and MAX features is possible with the X5 FastMig Auto equipment in MIG operation mode. Pulse power source is required for the MAX Position (optional) process and Pulse+ power source for the WiseRoot+ (optional) and WiseThin+ (optional) processes.

Use the welding program that is in accordance with your welding setup (e.g. welding wire and gas properties).

1. Go to the Memory channels view. (Refer to "AP/APC control panel: Channels" on page 123 for more information.)
2. Enter the actions menu.
3. Select **Create channel**.

>> A filter view opens:



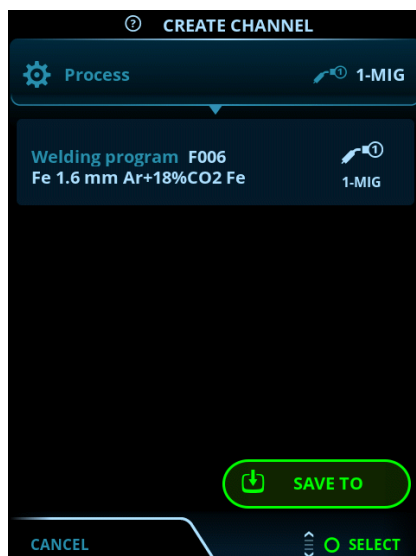
4. Use the filter options (e.g. material, wire material or wire diameter) to find the welding programs best suited for the purpose.

- i** The operation mode set in the panel [Settings](#) determines for which main welding process the programs here are shown. In MIG mode, the process selection in the Create channel view allows to narrow down the search more specifically to different MIG processes.
- i** If manual MIG is selected as the process, other filter and welding program selections are disabled.

- Once ready, go to the **Welding program** selection at the bottom to view the suitable welding programs.



- Select a welding program.
>> The selected welding program is now shown in the filter view.
- To save, scroll down to **Save to** and select it.



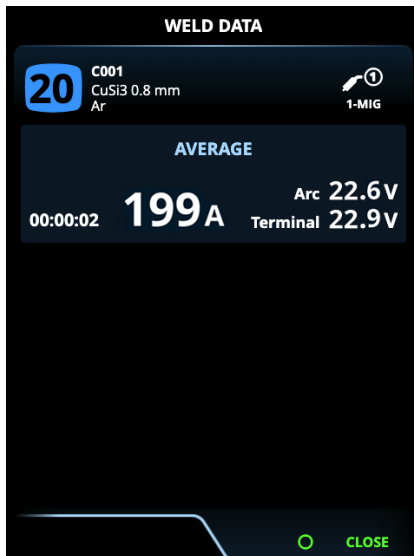
- Select the memory channel slot for saving and confirm.

Once ready, you can continue to the Welding parameters view to adjust the welding settings for the new channel, create a new channel or go back to the Channels view.

Tip: It is also possible to create new channels based on all of the unused welding programs available for the selected operation mode by selecting **Create all** in the Channel view's actions menu. This option uses the available memory channel slots.

3.3.11 AP/APC CONTROL PANEL: WELD DATA VIEW

After each weld, a weld summary is displayed briefly. To change the weld data view duration or how the weld data averages are calculated (with or without slope phases) refer to "AP/APC control panel: Device settings" on page 144.



3.4 ADDITIONAL GUIDANCE TO FUNCTIONS AND FEATURES

This section describes the advanced X5 FastMig functions and features and how to use them.



Many of the features described here are optional and available with the X5 FastMig Auto and Pulse system configurations only (see "General" on page 5). Refer to the feature-specific descriptions for more information on each feature and function.

When the feature is device model or equipment configuration specific, the emphasized X5 equipment information in the beginning of the section tells its availability: X5 example .

3.4.1 TRIGGER LOGIC FUNCTIONS

With X5 Manual wire feeder models you can select the trigger logic by pressing the trigger logic selection button in the control panel ("Using X5 Manual control panel" on page 111).

With X5 AP/APC wire feeder models you can select the trigger logic in the Welding parameters view ("AP/APC control panel: Welding parameters" on page 135).

2T

In 2T, pressing the trigger ignites the arc. If pre gas is set, pressing the trigger starts the shielding gas flow before the arc ignites. Releasing the trigger switches the arc off and starts post gas (if set).



>> For 2T trigger logic with Hot Start and Crater fill, refer to "Hot start and crater fill functions" on the next page.

4T

In 4T, pressing the trigger starts the pre gas, and releasing the trigger ignites the arc. Pressing the trigger again switches the arc off. Releasing the trigger ends the gas flow via the post gas phase (if set).



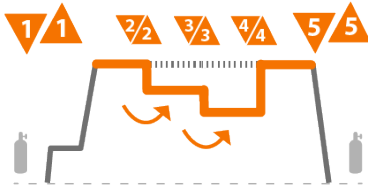
>> For 4T trigger logic with Hot Start and Crater fill, refer to "Hot start and crater fill functions" on the next page.

Powerlog

X5 WF AP/APC

Powerlog trigger logic function allows the user to switch between two or three different power levels. In Powerlog, pressing the trigger starts the pre gas, and releasing the trigger ignites the arc. A quick press of

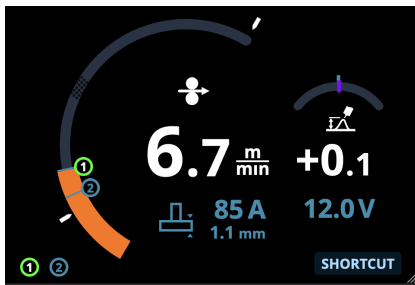
the trigger during welding switches between levels (after the last defined power level the first level is selected). Long-pressing the trigger at any of the levels during welding switches the arc off.





To take Powerlog into use, go to the control panel's [Welding parameters view](#) and select Powerlog as the trigger logic. Once selected, choose whether 2 or 3 power levels are used. Still in the Welding parameters view, set up the power levels for this function. The parameters available for adjustment are:







- Wire feed speed and its minimum and maximum values
- Voltage / Fine tuning
- Dynamics (not available with MAX Cool).

The wire feed speed of each level can also be adjusted in the Home view. Pressing the left control knob button changes between levels. Green color indicates the selected Powerlog level:



-  Powerlog trigger logic is not available together with WiseSteel feature or with manual MIG, MAX Speed, MAX Position or DPulse processes.
-  Powerlog trigger logic cannot be used together with a remote control. If a Powerlog memory channel is selected when a remote control is in use, the trigger logic is automatically switched to 4T.

Symbols:

	Function		Trigger press (down)
	Creep start		Trigger release (up)
	Set duration		Pre gas / post gas

3.4.2 HOT START AND CRATER FILL FUNCTIONS

With X5 Manual wire feeder models you can use the Crater fill function and adjust its parameters by pressing the Settings menu button in the control panel ("Using X5 Manual control panel" on page 111).

With X5 AP/APC wire feeder models you can use the Hot start and Crater fill functions and adjust their parameters in the Welding parameters view ("AP/APC control panel: Welding parameters" on page 135).

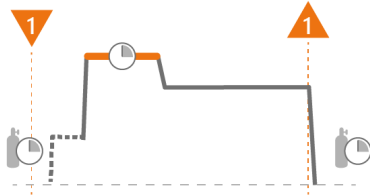
For the trigger logic functions in general, refer to "Trigger logic functions" on the previous page.

Hot start

When you use the Hot start function, welding starts with parameter values that are different from the values used for the rest of the welding job. The functionality can be used, for example, when welding thick materials, where using extra power (heat) at the start helps ensure the high quality of the weld.

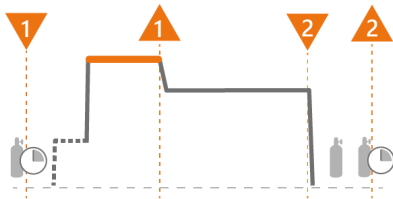
When the 2T trigger logic is in use, Hot start lasts for the predefined period of time.

Hot start with 2T:



When the 4T trigger logic is in use, Hot start starts when the trigger is pressed and welding starts, and lasts until the trigger is released.

Hot start with 4T:



Additional notes:

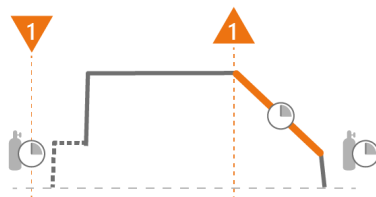
- Hot start slope time adjustment sets the transition time from the Hot start phase to the normal welding current level.
- Hot start level and time are adjustable in 2T trigger logic only.
- Hot start fine tuning (voltage) is adjustable with 1-MIG, Pulse, DPulse, WiseThin+ and MAX Speed processes.

Crater fill

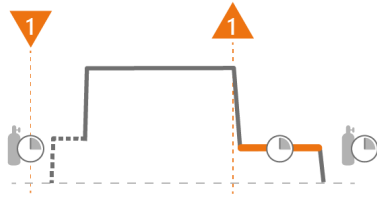
When welding with high power, a crater is usually formed at the end of the weld. The Crater fill function gradually decreases the welding power / wire feed speed at the end of the welding job so that the crater can be filled using a lower power level.

When the 2T trigger logic is in use, releasing the trigger launches the Crater fill sequence. Crater fill lasts for the predefined period of time.

Crater fill with automatic/synergic MIG processes and 2T:

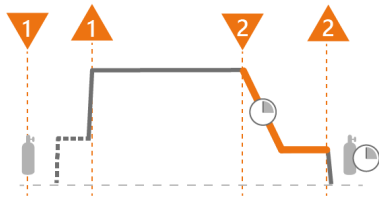


Crater fill with manual MIG process and 2T:



When the 4T trigger logic is in use, pressing the trigger during the welding launches the Crater fill sequence. The system stays on the Crater fill finishing level until the trigger is released. Releasing the trigger immediately finishes the Crater fill sequence.

Crater fill with 4T:

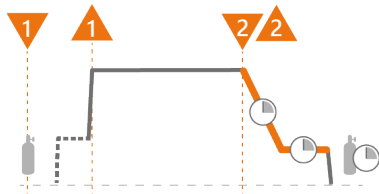


Additional notes:

- Crater fill fine tuning (voltage) is adjustable with 1-MIG, Pulse, DPulse, WiseThin+ and MaxSpeed processes.
- In manual MIG process, the Crater fill time, wire feed speed and voltage can be adjusted, but the Crater fill level settings are not available.
- In automatic/synergic MIG processes, the Crater fill fine tuning, time and level settings can be adjusted, but the Crater fill wire feed speed and voltage settings are not available.

Crater fill with timer

Crater fill's timer option is available with 4T trigger logic and in automatic/synergic MIG processes only. It allows setting a fixed duration for the Crater fill end level. When the Crater fill function with timer is selected and the Crater fill end level time is set, the Crater fill sequence will stop after the preset duration even if the trigger is kept pressed.









In the timer mode, the *Crater fill end level time* parameter affects the duration of the end level and the *Crater fill time* parameter affects the slope time (the duration of the transition from the welding level or Crater fill start level to the end level).

If the trigger is released and then pressed again during the Crater fill sequence, the Crater fill is stopped.

Additional notes:

- In automatic/synergic MIG processes, the Crater fill fine tuning, time and level settings can be adjusted, but the Crater fill wire feed speed and voltage settings are not available.
- Crater fill fine tuning (voltage) is adjustable with 1-MIG, Pulse, DPulse, WiseThin+ and MaxSpeed processes.

Symbols:

	Function		Trigger press (down)
	Creep start		Trigger release (up)
	Set duration		Pre gas / post gas


3.4.3 1-MIG

X5 WF AP/APC

1-MIG or "Auto" is a MIG/MAG welding process where the welding voltage is defined automatically when you adjust the wire feed speed. The voltage is calculated based on the welding program in use. The process is suitable for all materials, shielding gases and welding positions. 1-MIG supports WiseSteel, WisePenetration and WiseFusion features, as well as various optimized welding programs.

- >> To take 1-MIG into use, go to the [Memory channels view](#) and select an existing memory channel with 1-MIG process.

If there aren't any 1-MIG memory channels available, create a new one for 1-MIG process by selecting an available 1-MIG welding program for the channel. Follow the instructions in "AP/APC control panel: Applying welding programs" on page 147 (AP/APC).

 *When the X5 equipment is in MIG mode, the '0' memory channel is always reserved for the manual MIG process. All other memory channels are available for any process.*

3.4.4 WISEFUSION FEATURE



X5 WF AP/APC

The WiseFusion welding feature enables adaptive arc length control, which keeps the arc optimally short and focused. WiseFusion increases the welding speed and penetration and decreases heat input. WiseFusion can be used throughout the power range (short arc, globular arc and spray arc). WiseFusion is compatible with 1-MIG and pulsed MIG welding processes. (Not available with WiseRoot+, WiseThin+, MAX Cool, MAX Speed and MAX Position.)

- >> To take WiseFusion into use, go to the control panel's **Welding parameters view** and apply the WiseFusion feature.
- >> To adjust the welding power/wire feed speed, in the control panel's **Home view**, turn the left control knob.
- >> To fine-tune the heat output while welding, in the control panel's **Home view**, turn the right control knob.

For more information on Wise products, visit www.kemppi.com.

3.4.5 WISEPENETRATION FEATURE



X5 WF AP/APC

In standard MIG/MAG welding, changes in stick-out length cause welding current to fluctuate. WisePenetration feature maintains constant welding current by controlling the wire feed speed according to the stick-out length. This ensures stable and effective penetration and prevents burn through. WisePenetration also adjusts the voltage adaptively, which keeps the arc focused and optimally short. WisePenetration enables welding with Reduced Gap Technology (RGT) and is compatible with 1-MIG welding process. (Not available with WiseRoot+, WiseThin+, MAX Cool, MAX Speed and MAX Position.)

- >> To take WisePenetration into use, go to the control panel's **Welding parameters view** and apply the WisePenetration+ feature.
- >> To adjust the welding current while welding, in the control panel's **Home view**, turn the left control knob.
- >> To fine-tune the heat output while welding, in the control panel's **Home view**, turn the right control knob.

For more information on Wise products, visit www.kemppi.com.

3.4.6 WISESTEEL FEATURE



X5 WF AP/APC

The WiseSteel welding feature is based on modifying the conventional MIG/MAG arcs to enable higher quality of welds. WiseSteel improves the arc control, reduces spatter and helps create an optimally-formed weld pool. WiseSteel feature is available with selected welding programs. (Not available with WiseRoot+, WiseThin+, MAX Cool, MAX Speed and MAX Position.)

- >> To take WiseSteel into use, go to the control panel's **Welding parameters view** and apply the WiseSteel feature.
- >> To adjust the welding power/wire feed speed while welding, in the control panel's **Home view**, turn the left control knob.
- >> To fine-tune the heat output while welding, in the control panel's **Home view**, turn the right control knob.

When using WiseSteel, different adjustment methods are applied at different power ranges (different arcs). The wire feed speed / current indicator shows the arc range: Short arc — Globular arc — Spray arc.

Short arc range:

- WiseSteel is based on adaptive short arc control; that is, the process adjusts the short circuit ratio. This creates an easily-adjustable arc and less spatter. Within the short arc range, the shape of the current is similar to the traditional short arc welding. When a short arc is used in vertical up welding where weaving motion is applied, WiseSteel ensures good quality through adapting to the changes in the stick-out length.

Globular arc range:

- Globular arc means that WiseSteel fluctuates the power between short arc and spray arc at a low frequency, so that the average power stays within the globular arc range. This results in less spatter than conventional globular arc welding, and a welding pool that enables excellent structural durability.

Spray arc range:

- Within the spray arc range, WiseSteel is based on adaptive arc length control, which keeps the arc optimally short. WiseSteel also utilizes micro-pulsed welding current. This creates a well-formed weld pool that enables excellent bead geometry and optimal penetration with smooth and durable joints, and speeds up the work. The pulsing is not noticeable to the welder. The shape and control of the current are close to the conventional spray arc welding.

For more information on Wise products, visit www.kemppi.com.

3.4.7 PULSE WELDING

X5 PS Pulse/Pulse+ X5 WF AP/APC

The advantages of pulse welding are a higher welding speed and deposition rate compared to short-arc welding, lower heat input compared to spray-arc welding, a spatter-free globular arc and smooth appearance of the weld. Pulse is suitable for all position welding. It is excellent for welding aluminum and stainless steel, especially when the material thickness is small.

Pulse



Pulse is a synergic MIG/MAG welding process where the current is pulsed between the base current and the pulse current.

- >> To take Pulse welding process into use, go to **Memory channels** view and select an available Pulse channel.

If there aren't any Pulse memory channels available, create a new one for Pulse process by selecting an available Pulse welding program for the channel. Follow the instructions in "AP/APC control panel: Applying welding programs" on page 147.

- >> Once selected, the corresponding Pulse welding process parameters become available for adjustment in the **Welding parameters** view. For more information, refer to the pulse welding parameters in "AP/APC control panel: Welding parameters" on page 135.

DPulse



DPulse is a double-pulse MIG/MAG welding process with two separate power levels. The welding power varies between these two levels. With X5 FastMig, the parameters of each level are controlled independently.

- >> To take DPulse welding process into use, go to **Memory channels** view and select an available DPulse channel.

If there aren't any DPulse memory channels available, create a new one for DPulse process by selecting an available DPulse welding program for the channel. Follow the instructions in "AP/APC control panel: Applying welding programs" on page 147.

- >> Once selected, the corresponding DPulse welding process parameters become available for adjustment in the **Welding parameters** view. For more information, refer to the pulse welding parameters in "AP/APC control panel: Welding parameters" on page 135.

3.4.8 WISEROOT+ PROCESS

X5 PS Pulse+ X5 WF 300/HD300 AP/APC

The additional voltage sensing cable is required.

The WiseRoot+ welding process improves the quality of root pass welds. WiseRoot+ is based on accurate measurement of arc voltage.

Before welding, attach the voltage sensing cable to the workpiece. For optimal voltage measurement, connect the earth return cable and the voltage sensing cable close to each other and away from the other welding units' cables.

WiseRoot+ is a synergic MIG/MAG process optimized for open-gap root pass welding. The process is based on precise measurement of voltage between the welding gun nozzle and the workpiece. The measurement

data serves as input for the current control. The process is suitable for root pass welding in all positions, and provides a smooth and spatter-free arc.

- >> To take WiseRoot+ into use, go to the control panel's **Welding parameters view** and apply WiseRoot+. Optionally, go to the **Memory channels view** and create a new memory channel with WiseRoot+ process.
- >> To adjust the wire feed speed, turn the left knob when in the main welding view (Home view).
- >> To fine-tune the heat output while welding, turn the right knob when in the main welding view (Home view).

3.4.9 WISETHIN+ PROCESS

X5 PS Pulse+ X5 WF 300/HD300 AP/APC

The additional voltage sensing cable is required.

WiseThin+ is a synergic MIG/MAG process whose short-arc features are optimal for welding sheet metals (plate thickness 0.8 - 3.0 mm). It is based on precise measurement of voltage between the welding gun nozzle and the workpiece.

Before welding, attach the voltage sensing cable to the workpiece. For optimal voltage measurement, connect the earth return cable and the voltage sensing cable close to each other and away from the other welding units' cables.

The measurement data serves as input for the voltage control. The process reduces heat input, deformation and spatter. WiseThin+ is also optimal for position welding with thicker plates.

- >> To take WiseThin+ into use, go to the control panel's **Welding parameters view** and apply WiseThin+. Optionally, go to the **Memory channels view** and create a new memory channel with WiseThin+ process.
- >> To adjust the wire feed speed, turn the left knob when in the main welding view (Home view).
- >> To fine-tune the heat output while welding, turn the right knob when in the main welding view (Home view).

3.4.10 MAX COOL PROCESS

X5 WF AP/APC

MAX Cool is a synergic MIG/MAG welding process that is designed for root pass welds and sheet metal applications. MAX Cool is suitable for all welding positions and provides a smooth arc, reducing spatter.

- >> To take MAX Cool into use, go to the control panel's **Welding parameters view** and apply MAX Cool. Optionally, go to the **Memory channels view** and create a new memory channel with MAX Cool process.
- >> To adjust the wire feed speed while welding, or in the control panel's **Home view**, turn the left control knob. The adjustment's effect on the plate thickness is also shown.
- >> To fine-tune the heat output while welding, or in the control panel's **Home view**, turn the right control knob.

MAX Cool supports these filler wire and shielding gas combinations:

- Fe solid & Ar + 8...25 % CO₂ (1.0 mm, 1.2 mm)
- Fe solid & CO₂ (1.0 mm, 1.2 mm)
- Ss solid & Ar + 2 % CO₂ (1.0 mm, 1.2 mm)
- CuSi3 & Ar (1.0 mm)
- CuAl8 & Ar (1.0 mm).

3.4.11 MAX POSITION PROCESS

X5 PS Pulse/Pulse+ X5 WF AP/APC

MAX Position is a synergic MIG/MAG welding process optimized for vertical fillet welds (position: PF). MAX Position automatically switches between two separate power levels. The two power levels can use the same welding process or two different welding processes.

- >> To take MAX Position into use, go to the control panel's **Welding parameters view** and apply MAX Position. Optionally, go to the **Memory channels view** and create a new memory channel with MAX Position process.
- >> In **Welding parameters view**, MAX Position frequency can be adjusted and the optional WiseFusion feature can be applied. The ratio of the two power levels is preset.
- >> To adjust the average wire feed speed while welding, or in the control panel's **Home view**, turn the left control knob. The adjustment's effect on the plate thickness is also shown.
- >> To fine-tune the welding voltage while welding, or in the control panel's **Home view**, turn the right control knob.

MAX Position supports these filler wire and shielding gas combinations:

- Fe solid & Ar + 18% CO₂ (1.0 mm, 1.2 mm)
- Fe solid & Ar + 8% CO₂ (1.0 mm, 1.2 mm)
- Fe MC & Ar + 18% CO₂ (1.2 mm)
- Ss solid & Ar + 2% CO₂ (1.0 mm, 1.2 mm)
- AlMg & Ar (1.0 mm, 1.2 mm)

MAX Position supports these plate thicknesses:

- 3...12 mm

MAX Position utilizes also other welding processes, depending on the material and equipment type:

- Fe & Fe MC: 1-MIG (with low power) and Pulse MIG (with high power)
- Ss & Al: Pulse MIG (throughout the power range).

3.4.12 MAX SPEED PROCESS

X5 WF AP/APC

MAX Speed is a synergic pulsed MIG/MAG welding process. It is designed to maximize the welding speed and to minimize the heat input by modifying the conventional MIG/MAG arcs. MAX Speed is designed for steel and stainless steel welding applications mainly in the PA and PB positions. It is suitable for plate thicknesses above 2.5 mm, the ideal maximum plate thickness being approximately 6 mm.

MAX Speed operates within the spray arc range. Welding current is pulsed with constant frequency and amplitude. Arc length is controlled with the normal voltage control. MAX Speed's low-amplitude pulsing enables an effective transfer mode with lower wire feed speed than with conventional MIG/MAG arc. The pulsing is not noticeable to the welder.

- >> To take MAX Speed into use, go to the control panel's **Welding parameters view** and apply MAX Speed. Optionally, go to the **Memory channels view** and create a new memory channel with MAX Speed process.
- >> To adjust the wire feed speed while welding, or in the control panel's **Home view**, turn the left control knob. The adjustment's effect on the plate thickness is also shown.
- >> To fine-tune the welding voltage while welding, or in the control panel's **Home view**, turn the right control knob.

MAX Speed supports these filler wire and shielding gas combinations:

- Fe solid & Ar + 18% CO₂ (1.0 mm, 1.2 mm)
- Fe solid & Ar + 8% CO₂ (1.0 mm, 1.2 mm)
- Fe MC & Ar + 18% CO₂ (1.2 mm)

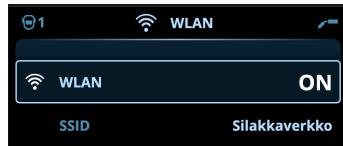
- Ss solid & Ar + 2% CO₂ (1.0 mm, 1.2 mm).

3.4.13 WIRELESS CONNECTION (WLAN)

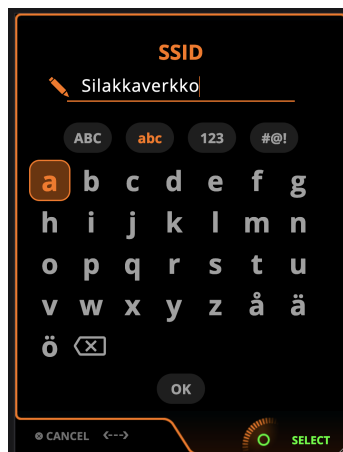
X5 WF APC

To connect the welding equipment to your local wireless network:

1. On the control panel, go to the **WLAN view**.
2. Turn the WLAN feature on by turning and pressing the right control knob.

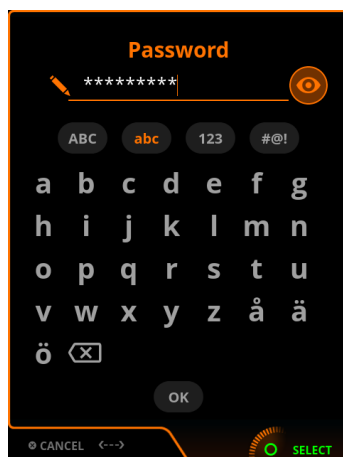


3. Enter your local wireless network's SSID (Service Set Identifier), i.e. the name of your WLAN network.



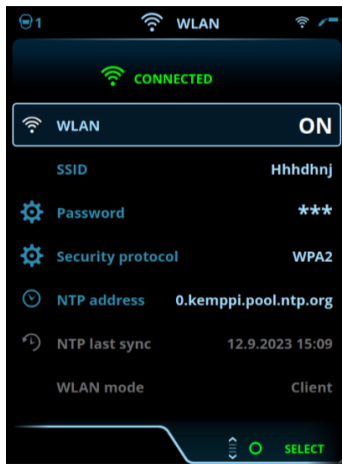
>> Use the right control knob to select letters.


4. Enter your WLAN password.



>> Use the right control knob to select letters.

When connected, the WLAN status information is shown.



 The WLAN mode is set to 'Client' by default and it cannot be changed.

Network Time Protocol (NTP)

When connected, the welding equipment synchronizes the clock between networks automatically. By default, X5 FastMig uses a Network Time Protocol (NTP) service defined by Kemppi. On some occasions, depending on your local network settings, this may have to be changed. Contact your local IT support or network provider to acquire a new NTP address.

To change the NTP service address:

1. In the **WLAN view**, ensure that the WLAN is turned on and connected.
2. Go to NTP address setting and replace the default NTP address with the preferred address for your network and location.

The last synchronization time is shown with the WLAN status information.

3.4.14 DIGITAL WELDING PROCEDURE SPECIFICATION (DWPS)

X5 WF APC

The use of digital WPS (Welding Procedure Specification, dWPS) and WeldEye cloud service require X5 FastMig with X5 APC wire feeder and a valid Kemppi WeldEye subscription with the Welding Procedures module. The X5 equipment includes a link to a free trial registration – featuring also a free trial option for WeldEye ArcVision. For more information on WeldEye, refer to weldeye.com or contact your Kemppi representative.

Digital Welding Procedure Specification (dWPS) is a WPS in digital format that can be set to observe the welding parameters of the supported X5 FastMig equipment. The **WPS view** shows the digital WPSs with one or more weld passes assigned to the welder or welding station in the Kemppi WeldEye cloud service.

The WPSes can be read on the control panel display and/or a memory channel can be linked with a WPS. X5 APC wire feeder's control panel provides a couple of ways to do this:

- >> In the main **WPS view**: Follow the more detailed steps in "APC control panel: WPS view" on page 125.
- >> In the **Memory channels view** via activating an existing memory channel: Open the memory channel 'Actions' and choose to link it with a WPS. In the view that opens, select the WPS and weld pass information to be linked with the memory channel. More detailed information on memory channels is in "AP/APC control panel: Channels" on page 123.

Once a WPS is linked to a memory channel, the welding parameters are still manually adjustable, but the adjustment ranges defined on the active WPS are indicated on the screen.

3.4.15 WELDEYE

X5 WF APC

The use of this WeldEye feature and cloud service require an up-to-date X5 FastMig equipment with X5 APC wire feeder and a valid **Kemppi WeldEye Quality Management** subscription. For more information on WeldEye, refer to weldeye.com or contact your Kemppi representative.

The WeldEye feature in the X5 FastMig equipment with APC wire feeder is designed to be used in welding quality management. This includes cloud-based tracking of the welding operations carried out with the welding equipment.

Some of the feature highlights:

- Work orders
- Work completion and heat input reporting
- WPS (Welding Procedure Specification) compliance verification
- Welder qualification verification.

The built-in WeldEye feature collects and passes on welding data, keeping it synchronized between the welding equipment and WeldEye cloud service. The WeldEye cloud service can be accessed using a desktop computer and an internet browser.

- >> To take the WeldEye feature in use, the equipment must be connected to the internet via the built-in wireless connection (WLAN). Refer to "Wireless connection (WLAN)" on page 160 for instructions.
- >> To use the WeldEye feature on the X5 APC wire feeder, refer to "APC control panel: WeldEye" on page 128.

Other WeldEye options with the X5 equipment:

- >> "Digital Welding Procedure Specification (dWPS)" on the previous page
- >> "WeldEye ArcVision" below
- >> "WeldEye with DCM" on the next page.

3.4.16 WELDEYE ARCVISION

X5 WF APC

The use of this WeldEye feature requires X5 FastMig with X5 APC wire feeder and a valid Kemppi WeldEye subscription. The X5 equipment includes a link to a free trial registration – featuring also a free trial option for WeldEye ArcVision. For more information on WeldEye, refer to weldeye.com or contact your Kemppi representative.



The WeldEye's ArcVision module (optional) is intended for cloud-based tracking of the welding operations carried out with the welding equipment. The ArcVision on the welding device itself is a connection feature for connecting to the WeldEye cloud service. The actual welding information gathered by the welding equipment is passed on to the WeldEye cloud where it can be accessed using a desktop computer and an internet browser.

To take the WeldEye ArcVision feature in use, the equipment must be connected to the internet via the built-in wireless connection (WLAN). Refer to "Wireless connection (WLAN)" on page 160 for instructions.

The X5 FastMig with X5 APC wire feeder comes preinstalled with a trial license for ArcVision. The trial license can be activated by following these steps:

1. On the X5 APC control panel, go to the **WPS view**.
2. Use a QR code reader on your mobile device to open the WeldEye web link or navigate to 'https://register.weldeye.io/weldeye' on your web browser.



3. Complete the registration process as instructed on the registration page. Once finished, the equipment is connected to WeldEye ArcVision.
 -  You will be required to fill in the serial number and four-digit security pin of your X5 power source. These can be found on the power source rating plate.
 -  The free trial registration includes both the WeldEye Welding Procedures and WeldEye ArcVision modules.

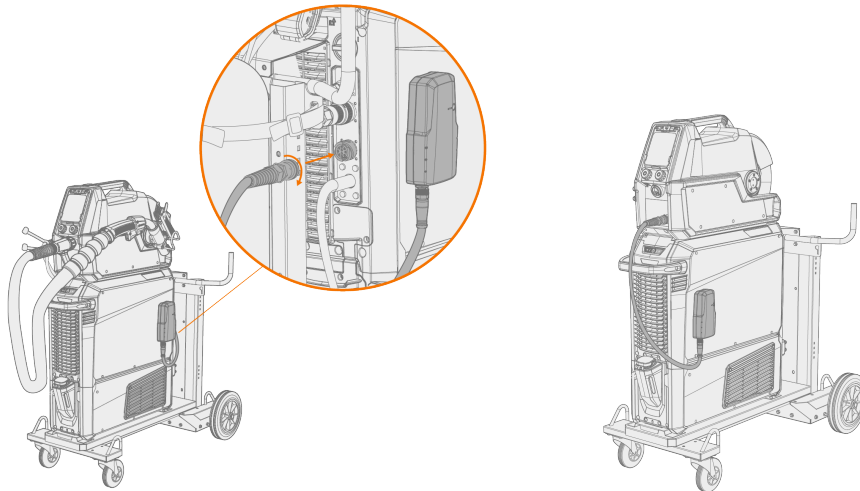
3.4.17 WELDEYE WITH DCM

The use of this WeldEye feature and cloud service require a Digital Connectivity Module (DCM) connected to the welding equipment and a valid **Kemppi WeldEye** subscription. For more information on WeldEye, refer to weldeye.com or contact your Kemppi representative.

X5 FastMig with X5 APC wire feeder, the WeldEye connection option is built-in (refer to "WeldEye" on the previous page for more information).

With other X5 FastMig models, an additional Digital Connectivity Module (DCM) device is required. DCM is connected directly to the X5 FastMig's control connection with the cables and adapters delivered with the DCM device.

DCM can be connected either to the wire feeder's or to the power source's control connection. Together with WeldEye App, it collects and synchronizes welding data and adds tools to the workflow management, for example, in the form of work orders and welding procedure specifications (WPS). The welding data collected with DCM is synchronized with the WeldEye welding management software cloud via WeldEye App.



For more information on installing and using the DCM device, refer to userdoc.kemppi.com (DCM/WeldEye).

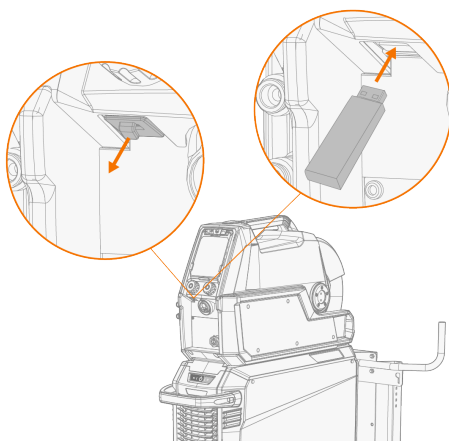
3.4.18 USB BACKUP AND RESTORE

X5 WF AP/APC

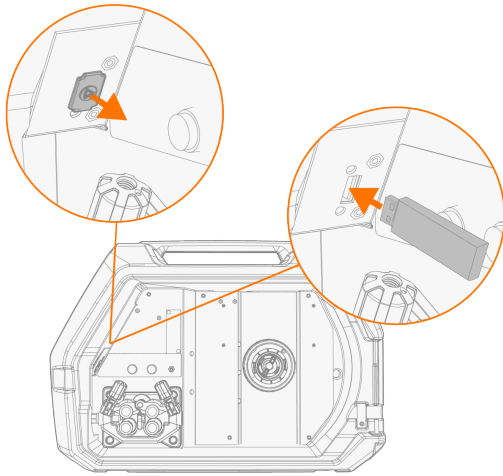
This feature allows the current welding parameters, memory channels and other settings to be backed up on a USB memory stick. These can be restored later on the same welding equipment or other compatible X5 FastMig equipment.

1. Turn the welding equipment on.
2. If creating a backup, go to the device settings and select **Backup**.
3. If restoring from a backup, go to the device settings and select **Restore**.
4. Open the USB connector cover and connect the USB memory stick to the X5 control panel.

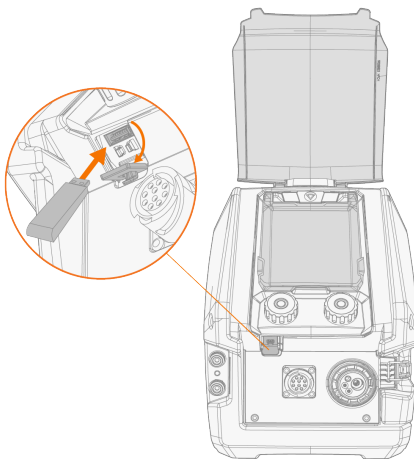
>> X5 Wire Feeder 300:



>> X5 Wire Feeder HD300:





>> X5 Wire Feeder HD200:



5. Follow the steps on the control panel screen to complete the backup/restore operation.

3.4.19 USB UPDATE

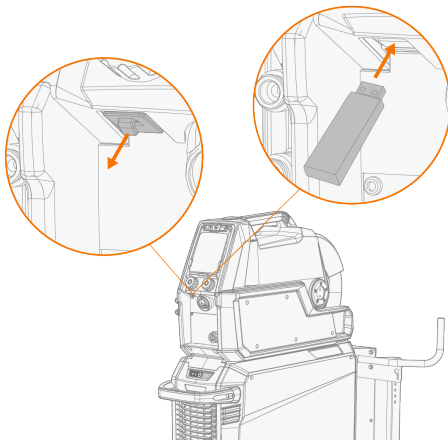
The USB update feature allows the firmware to be updated as well as welding programs, processes and features to be installed using a USB memory stick.

-  *There can be only one ZIP file on the USB memory stick inserted into the welding system at once. This can be either a dedicated firmware pack for this welding system or a welding program and license pack (matching the power source serial number). For more information on the available software and compatibility, contact your local Kemppi representative.*
-  *In a double wire feeder setup, the update must be performed on both wire feeders separately.*

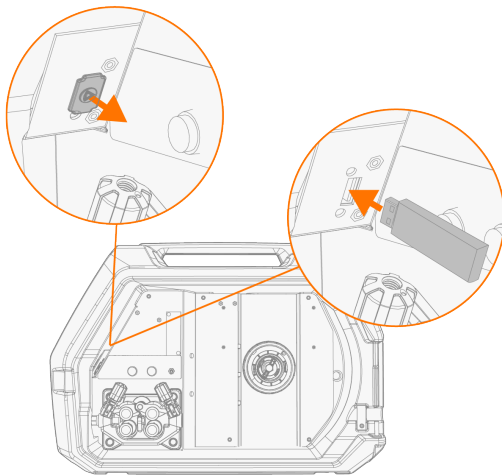
Firmware and welding software

1. Ensure you have the correct firmware/software ZIP package saved on your computer for the welding equipment in question.
2. Connect the USB memory stick to the computer.
3. Prepare the USB memory stick by copying the firmware/software ZIP file into the root folder of the memory stick.
4. Turn the welding equipment on.
5. Open the USB connector cover and connect the USB memory stick to the X5 wire feeder.

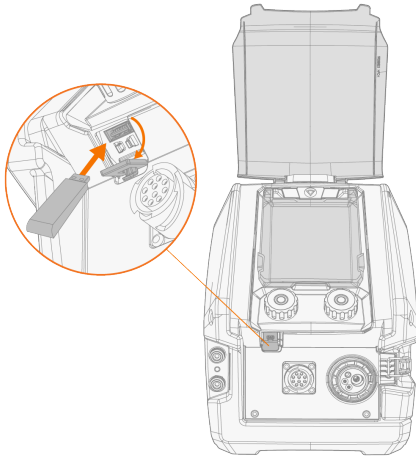
>> X5 Wire Feeder 300:



>> X5 Wire Feeder HD300:



>> X5 Wire Feeder HD200:



6. The update process starts automatically. Follow the on-screen instructions.

Custom screensaver image

X5 WF AP/APC

This screensaver feature is available with X5 Wire Feeder 300 AP/APC and X5 Wire Feeder HD300 AP/APC.

The custom screensaver image must first be prepared at <https://kemp.cc/screensaver> and then copied onto the USB memory stick. The supported image file formats are JPG, PNG and GIF.

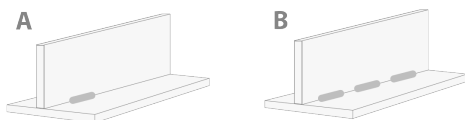
1. On your computer web browser, go to <https://kemp.cc/screensaver>.
2. Following the on-screen instructions, upload, edit and download the new screen saver image onto a USB memory stick.
3. Connect the USB memory stick to the X5 control panel following the same principle than with the software updates (previous chapter) and the on-screen instructions.

The screensaver image is shown during start-up and when the control panel has been idle for a predefined time. The screensaver settings can be adjusted in "AP/APC control panel: Device settings" on page 144.

3.4.20 CYCLE TIMER

X5 WF AP/APC

Cycle timer is a welding function that automatically produces a single weld or multiple welds of predefined duration with a press of the welding gun trigger. For example, this can be used to maintain weld consistency when creating a single weld (A) or an intermittent weld (B), or to easily create clean tack welds with low heat input.



- >> To take Cycle timer in use, go to the **Welding parameters view** and set Cycle timer to ON.
- >> Once Cycle timer is turned on, the Cycle arc time (the duration of the weld) can be adjusted.

When only the Cycle arc time is set, only one single weld is created. The intermittent weld feature is enabled by setting also the Cycle pause time.

- >> To turn the Cycle timer's intermittent weld feature on, go to the **Welding parameters view** and set Cycle timer to ON, set also Cycle pause to ON and adjust the Cycle pause time (the pause duration before the next weld).

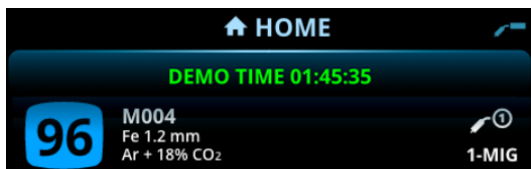
With Cycle timer, the weld start and stop features such as pre gas, post gas, upslope, hot start, creep start and crater fill, are available for adjustment according to the selected welding process. Note that using these features with Cycle timer also has an effect on the actual weld duration and that the Cycle arc time setting does not include these.

3.4.21 DEMO TIME

X5 WF AP/APC

The demo time feature allows a free test evaluation of MAX and Wise welding software. Demo time is available (starting from October 2023) in all new X5 Wire Feeder AP/APC and X5 Power Source 400/500 equipment with welding program work pack installed.

The total available demo time is 3 hours. The demo time passes only when welding using a welding feature you don't have a license for. When the demo time is set to ON, the remaining time is shown on the display.



 Note that different equipment requirements apply to the different Wise and MAX welding software.

Available for test evaluation are:

- **WisePenetration**
>> Requires X5 Wire Feeder AP/APC. For more information, refer to "WisePenetration feature" on page 155.
- **WiseRoot+**
>> Requires X5 Wire Feeder AP/APC and X5 Power Source 400/500 Pulse+. For more information, refer to "WiseRoot+ process" on page 157.
- **WiseThin+**
>> Requires X5 Wire Feeder AP/APC and X5 Power Source 400/500 Pulse+. For more information, refer to "WiseThin+ process" on page 158.
- **MAX Cool**
>> Requires X5 Wire Feeder AP/APC. For more information, refer to "MAX Cool process" on page 158.
- **MAX Speed**
>> Requires X5 Wire Feeder AP/APC. For more information, refer to "MAX Speed process" on page 159.
- **MAX Position**
>> Requires X5 Wire Feeder AP/APC and X5 Power Source 400/500 Pulse or Pulse+. For more information, refer to "MAX Position process" on page 159.

The demo time feature can be turned on and off in "AP/APC control panel: Device settings" on page 144. By default, the demo time is set to OFF.

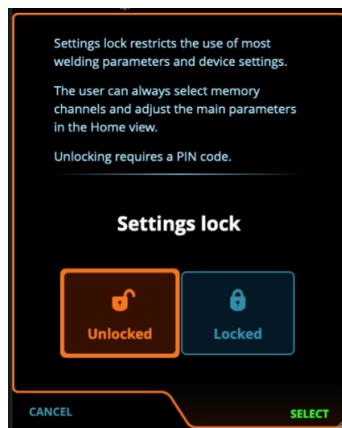
When the demo time expires, the features without a license cannot be used anymore. To continue using the optional features, you must buy licenses for them.

3.4.22 SETTINGS LOCK

X5 WF AP/APC

Settings lock is used to restrict changes to a predefined set of welding parameters and device settings. A PIN code is defined for the settings lock.

- >> To take the settings lock feature in use the first time, go to the **Device settings view**, select 'Settings lock' and enable the lock by defining a PIN code for it: Select 'Define PIN' and enter a 4-digit PIN code.
- >> To lock/unlock, select settings lock in the **Device settings view**. When unlocking, enter also the defined settings lock PIN code when requested.

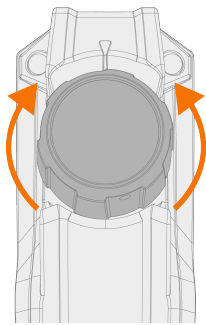


Some of the basic welding parameters and user-specific device settings always remain unlocked and available for adjustment.

3.5 USING REMOTE CONTROL HR40/HR43

The HR40 or HR43 remote controls are taken into use in the control panel settings ("Manual control panel: Settings" on page 113 or "AP/APC control panel: Device settings" on page 144).

Remote control HR43

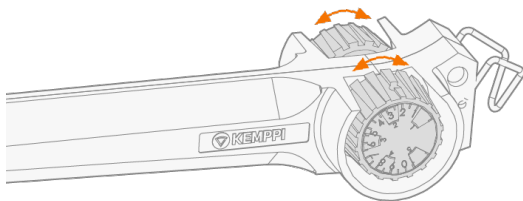


The HR43 control knob function is defined by the selected welding process and reflects the adjustment of the control panel's left control knob.

To adjust the welding parameter, turn the knob on the remote control.



In MIG/MAG: With HR43 and X5 AP/APC equipment the adjusted parameter can be selected between wire feed speed and memory channel in the control panel settings.

Remote control HR40



The HR40 control knob functions are defined by the selected welding process and reflect the adjustments of the control panel's two control knobs.

In MIG/MAG: With HR40 and X5 AP/APC equipment the adjusted parameter can be selected between wire feed speed and memory channel in the control panel settings. When the remote mode is set to 'channel', only the left remote control knob is in use.

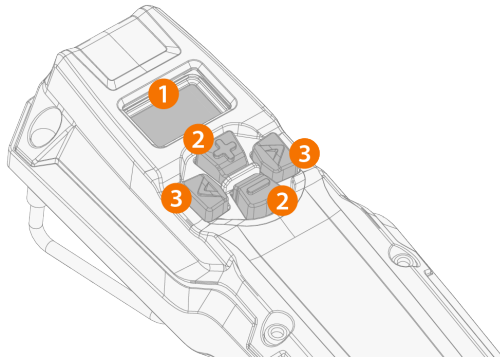
-  *With HR40/HR43 remote control, the minimum and maximum values affect also the resolution of the remote control adjustment.*
-  *For the HR40 remote control, welding equipment firmware version 1.30 or newer is required. Check the currently installed version in the AP/APC control panel's **Info** view (select 'Device info') or in the Manual control panel's advanced settings (select 'Info'). For more information on firmware updates, contact your local Kemppi dealer.*

3.6 USING REMOTE CONTROL HR55

When connected, the HR55 remote control is automatically in use.

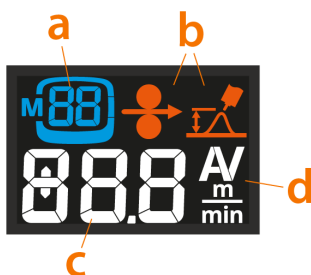
With the optional digital remote control HR55, you can select memory channels and adjust wire feed speed, welding current, welding voltage or voltage fine tuning depending on the welding process and the features supported by the connected X5 FastMig equipment.

In a double wire feeder setup, the remote-controlled wire feeder can be selected directly from the remote without moving the cable.



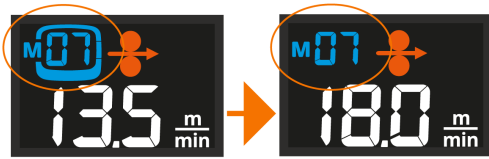
1. Custom LCD display
 - >> Displays the adjusted parameter and notifies if there is an error ("Err") in the welding system.
2. Plus/minus (+/-) buttons
 - >> Changes the parameter value.
3. Left/right arrow buttons
 - >> Changes between adjustable parameters/views.

Remote control display items



- a. Process and/or selected memory channel information (process is indicated with a single letter: M = MIG/MAG, S = MMA, G = Gouging, t = TIG)
- b. MIG/MAG: Wire feed speed and fine tuning symbols
- c. Adjusted parameter value (or error indicator)
- d. Adjusted parameter unit

When the parameter is adjusted with the remote and the parameter value doesn't reflect the one saved on the selected memory channel anymore, this is indicated on the display by showing only the memory channel number without the channel box around it (MIG/MAG only):



Remote control views and operation

Change between the views by pressing the left/right arrow buttons.



- **Memory channel view (MIG/MAG only):** The memory channel is changed by pressing the +/- buttons. Long press of a +/- button scrolls the parameter values faster.
- **Process selection view:** This allows selecting between MIG/MAG welding, MMA welding and gouging.
- **Welding power view:** Depending on the used welding process, wire feed speed or current is adjusted by pressing the +/- buttons. Long press of a +/- button scrolls the parameter values faster.
- **Voltage/Fine tuning view:** Depending on the welding process used, voltage or welding process specific parameter is adjusted by pressing the +/- buttons. Long press of the +/- button scrolls the parameter values faster. Long press of the right arrow button switches between different parameter sets, as applicable.
- **Wire feeder selection view (double wire feeder setup only):** The remote-controlled wire feeder is changed by pressing the +/- buttons.
- **Safety lock:** By pressing the left/right arrow buttons simultaneously for 2 seconds, the equipment safety lock can be enabled and disabled.

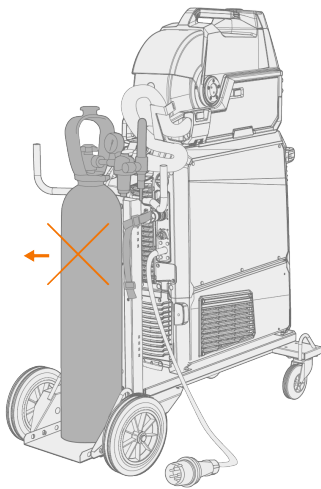
Long press of the left arrow button saves the adjusted parameters on the currently selected channel.

- ⓘ *When a MIG welding torch remote control is used to select a memory channel or adjust the wire feed speed, the corresponding function is disabled in the HR55 remote control.*
- ⓘ *In a double wire feeder setup, changing the remote-controlled wire feeder directly from the remote takes approximately 20 seconds. The remaining time is indicated in the remote control display.*

3.7 LIFTING EQUIPMENT

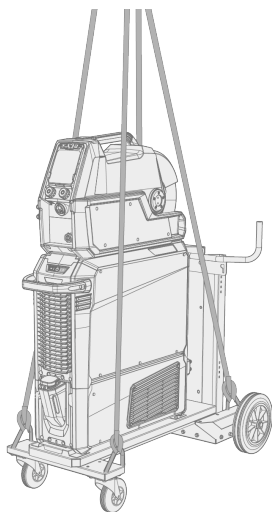
If you need to lift X5 FastMig equipment, pay special attention to the safety measures. Also follow the local regulations. The X5 FastMig equipment can be lifted with a mechanical hoist as a whole only when the equipment is installed securely on a dedicated transport unit.

-  **DO NOT attempt to lift the equipment with a hoist from the handle.**
-  **If a gas bottle is installed on cart, DO NOT attempt to lift the cart with the gas bottle in place.**



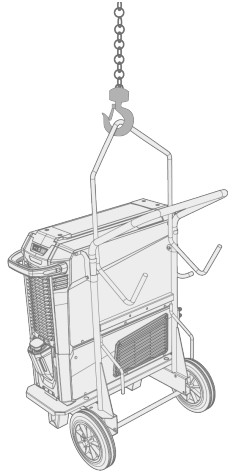
4 wheel cart:

1. Ensure that the welding equipment is properly secured to the cart.
2. Connect the 4-legged chain or straps from the hoist hook to the four lifting points on the cart on both sides of the welding equipment.



2 wheel cart:

1. Ensure that the welding equipment is properly secured to the cart.
2. Connect the hoist hook to the lifting handle on the cart.



3.8 TROUBLESHOOTING

i *The problems listed and the possible causes are not definitive, but suggest some typical situations that may turn up during normal use of the welding system.*

Welding system:

Problem	Recommended actions
The welding system does not power up	Check that the mains cable is plugged in properly.
	Check that the mains switch of the power source is at the ON position.
	Check that the mains power distribution is on.
	Check the mains fuse and/or the circuit breaker.
	Check that the interconnection cable between the power source and the wire feeder is intact and properly attached.
	Check that the earth return cable is connected.
The welding system stops working	Gas-cooled gun may have overheated. Wait for it to cool down.
	Check that none of the cables is loose.
	The wire feeder may have overheated. Wait for it to cool down and see that the welding current cable is properly attached.
	The power source may have overheated. Wait for it to cool down and see that the cooling fans work properly and the air flow is unobstructed.

Wire feeder:

Problem	Recommended actions
The filler wire on the spool unravels	Check that the spool locking cover is closed.
The wire feeder does not feed the filler wire	Check that the filler wire has not run out.
	Check that the filler wire is properly routed through the feed rolls to the wire liner.
	Check that the pressure handle is properly closed.
	Check that the feed roll pressure is adjusted correctly for the filler wire.
	Check that the welding cable is properly connected to the wire feeder.
	Blow compressed air through the wire liner to check that it is not blocked.

Weld quality:

Problem	Recommended actions
---------	---------------------

Dirty and/or poor quality weld	Check that the shielding gas has not run out.
	Check that the shielding gas flow is unobstructed.
	Check that the gas type is correct for the application.
	Check the polarity of the gun/electrode.
	Check that the welding procedure is correct for the application.
Varying welding performance	Check that the wire feed mechanism is adjusted properly.
	Blow compressed air through the wire liner to check that it is not blocked.
	Check that the wire liner is correct for the selected wire size and type.
	Check the welding gun contact tip's size, type and wear.
	Check that the welding gun is not overheating.
	Check that the earth return clamp is properly attached to a clean surface of the workpiece.
High spatter volume	Check the welding parameter values and welding procedure.
	Check the gas type and flow.
	Check the polarity of the gun/electrode.
	Check that the filler wire is correct for the current application.

"Error codes" on the next page

3.9 ERROR CODES

In error situations, the control panel displays the number and title of the error. The X5 Wire Feeder 300 AP/APC control panel also shows the possible cause and a proposed action to fix the issue.

Error			
Code	Title	Possible cause	Proposed action
1	Power source not calibrated	Power source calibration has been lost.	Restart the power source. If problem persists, contact Kemppi service.
2	Too low mains voltage	Voltage in mains network is too low.	Restart the power source. If problem persists, contact Kemppi service.
3	Too high mains voltage	Voltage in mains network is too high.	Restart the power source. If problem persists, contact Kemppi service.
4	Power source is overheated	Too long welding session with high power.	Do not shut down, let the fans cool the machine. If fans are not running, contact Kemppi service
5	Internal 24V voltage is too low	Power source contains an inoperative 24V power supply unit .	Restart the power source. If problem persists, contact Kemppi service.
7	Wire feeder not found	Wire feeder is not connected to power source or connection is faulty.	Check the control cable and its connectors.
8	Initialization error in FPGA card	Control card is faulty or software fails in power source.	Restart the power source. If problem persists, contact Kemppi service.
9	Measurement cable failure	Voltage sensing cable is not connected to the work piece or measurement cable connection is faulty.	Connect voltage sensing cable to the work piece and check the measurement cable and its connectors.
11	FET unit failure	Power source contains an inoperative FET unit.	Restart the power source. If problem persists, contact Kemppi service.
12	Welding cable failure	Plus and minus cables are connected together.	Check the connections of welding cable and earth return cable.
13	IGBT over-current	Inoperative mains transformer in power source.	Restart the power source. If problem persists, contact Kemppi service.
14	IGBT overheated	Too long welding session with high power or high ambient temperature.	Do not shut down, let the fans cool the machine. If fans are not running, contact Kemppi service.
17	Phase is missing from mains supply	One or more phases are missing from the mains supply.	Check the mains cable and its connectors. Check the voltage of mains supply.
20	Power source cooling failure	Cooling capacity is reduced in the power source.	Clean the filters and clear any dirt from the cooling channel. Check that the cooling fans are running. If not, contact Kemppi service.
24	Cooling liquid overheated	Too long welding session with high power or high ambient temperature.	Do not turn off the cooler. Let the liquid circulate until the fans cool it down. If fans are not running, contact Kemppi service.
26	Cooling liquid not circulating	No cooling liquid or circulation is blocked.	Check the liquid level in the cooler. Check hoses and connectors for blockage.

27	Cooler not found	Cooling is turned on in the settings menu, but cooler is not connected to power source or cabling is faulty.	Check the cooler connections. Ensure that the cooling is turned off in the settings menu, if the cooler is not in use.
33	Welding cable calibration failure	Welding cable calibration failed.	Check the welding system cables and their connections.
40	VRD error	Open circuit voltage exceeds the VRD limit.	Restart the power source. If problem persists, contact Kemppi service.
42	High current in wire feeder motor	There may be too much pressure in the wire feed rolls or dirt in the wire line.	Adjust the feed roll pressure. Clean the wire line. Change worn parts in the welding gun.
43	Overcurrent in wire feeder motor	There may be too much pressure in the wire feed rolls or dirt in the wire line.	Adjust the feed roll pressure. Clean the wire line. Change worn parts in the welding gun.
44	Wire speed measurement is missing	Faulty sensor or wiring in wire feeder.	Restart the welding system. If problem persists, contact Kemppi service.
50	License error	License for the selected feature is missing.	To continue using the feature, please install the license.
61	Operation not allowed	Subfeeder is connected, but it has not been selected in the system settings.	Go to the system settings menu on the control panel and select your subfeeder model and type.
62	Power source not found	No power source is connected to the wire feeder, or connection is faulty.	Check the control cable and its connectors.
64	Robot control device lost	Wire feeder lost connection to the robot control device.	Check the robot control device and inter-connection cables. If problem persists, contact Kemppi service.
65	Subfeeder not allowed	Use of subfeeder is not allowed with selected welding process.	Remove the subfeeder or change the welding process.
81	Welding program data missing	Welding program data has been lost.	Restart the power source. If problem persists, contact Kemppi service.
103	Empty memory channel	Robot tried to start welding using a nonexistent memory channel.	Check the memory channel selected by the robot.
132	Robot not responding	There is a communication problem between robot and the RCM.	Check fieldbus cabling, connectors and the fieldbus module.
238	Power source serial number is missing	Communication to serial number card failed.	Restart welding system. If problem persists, contact Kemppi service.
244	Internal memory failure	Initialization failed (%sub:%device).	Restart welding system. If problem persists, contact Kemppi service.
245	Demo time left: %min min	When the demo time expires, the features without a license cannot be used anymore.	To continue using the optional features, you must buy licenses for them.
246	Demo time has expired	Features without a license cannot be used anymore.	To continue using the optional features, you must buy licenses for them.
250	Internal memory failure	Memory communication failed (%sub:%device).	Restart welding system. If problem persists, contact Kemppi service.

4. MAINTENANCE






4.1 DAILY, PERIODIC AND ANNUAL MAINTENANCE

When considering and planning routine maintenance, consider the operating frequency of the welding system and the working environment.

Correct operation of the welding machine, regular maintenance, and the use of original Kemppi spare parts and consumables help you avoid unnecessary downtime and equipment failure, while also maximizing the equipment's service life.

Use pre-mixed coolant solution in the cooling unit. The mixing ratio should be 20...50% as standard. Use only ethylene or propylene glycol mixture intended for welding cooling systems, for example Kemppi cooling liquid. Do not add water to the pre-mixed coolant solution. Do not use automotive cooling solutions or ethanol-based mixtures.

For repairs, find your closest Kemppi service workshop at www.kemppi.com or contact your dealer.

-  *Only an authorized electrician is allowed to carry out electrical work.*
-  *Only qualified service personnel is allowed to carry out periodic and annual maintenance.*
-  *Disconnect the power source from the mains before handling electrical cables and connectors.*
-  *Do not use pressure washing devices.*
-  *Where applicable, use the correct tension torque when fastening loose parts.*

Daily maintenance

Welding equipment's daily maintenance:

- Check that all covers and components are intact.
- Check all the cables, hoses and connectors. Do not use them if they are damaged.
- Ensure that the connectors are correctly fastened. Loose connectors can impair welding performance and damage connectors.
- Check the wire feeder's feed rolls and the pressure handle mechanism. Clean and lubricate with a small quantity of light machine oil if needed.

Cooling unit's daily maintenance (in addition):

- Check the cooling liquid level. Add cooling liquid if needed. Note: Use the correct coolant solution (see above).
- Check the cooling unit surroundings for cooling liquid leakages. If there are signs of significant leakage, contact Kemppi service.
- Check and test the cooling liquid pump operation by circulating the cooling liquid.

Weekly maintenance

Welding equipment's weekly maintenance:

- Clean the outside parts of the units from dust and dirt, for example, with a soft brush and vacuum cleaner.
- Clean the ventilation grills. Do not use compressed air, there is a risk that the dirt will compact even more tightly into the gaps of the cooling profiles.
- If air filters are used, remove them and clean them by blowing with compressed air.

Periodic maintenance

Welding equipment's periodic maintenance, every 1–6 months:

- Check the electrical connectors of the equipment at least every 6 months. Clean oxidized parts and tighten loose connectors.
- Update the welding system to the latest firmware and software versions, as applicable.

Cooling unit's periodic maintenance, every 1–6 months (in addition):

- Check the cooling liquid quality at least once a month. Ensure that the liquid is clear and free of any visible impurities.
- Replace the cooling liquid every 6 months. Note: Use the correct coolant solution (see above).

Annual maintenance

The annual maintenance must be carried out by an authorized Kemppi service workshop. Kemppi service workshops complete the welding system maintenance according to your Kemppi service agreement. Find your closest service workshop at www.kemppi.com.


Welding equipment's annual maintenance program includes:

- Cleaning the equipment.
- Maintenance of the welding tools.
- Checking the connectors and switches.
- Checking all electrical connections.
- Checking the power source mains cable and plug.
- Repairing defective parts and replacing defective components.
- Maintenance test.
- Testing the operation and calibrating the performance values when needed.
- Updating the welding system to the latest firmware and software versions, and installing new welding software.
- If a cooling unit is used: Checking and cleaning the cooling liquid pump. The pump is dismantled and cleaned thoroughly, and if there has been any leakage in the pump's axle seal point, the axle seal is replaced. The axle seal is subject to wear and may need replacement periodically to maintain proper sealing.

For Kemppi welding torch maintenance, refer to your welding torch's instructions (available also at user-doc.kemppi.com).

4.2 INSTALLING AND CLEANING POWER SOURCE AIR FILTER

An optional power source air filter can be purchased separately. The air filter comes with a fixed casing designed to be mounted directly onto the power source air intake.

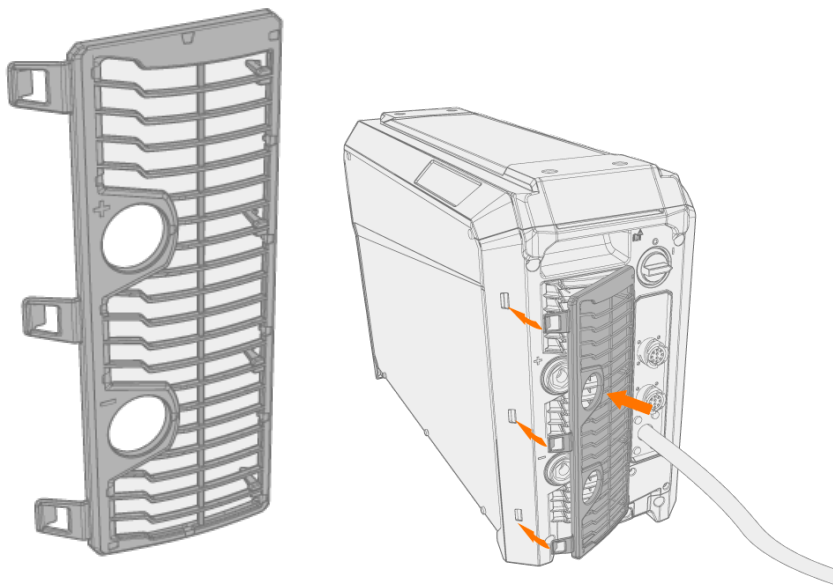
 *Using the optional air filter decreases the rated power levels of the power source as follows (output 40 °C): 60% >>> 45% and 100% >>> 100%-20A. This is due to the slightly reduced cooling air intake.*

Tools needed:



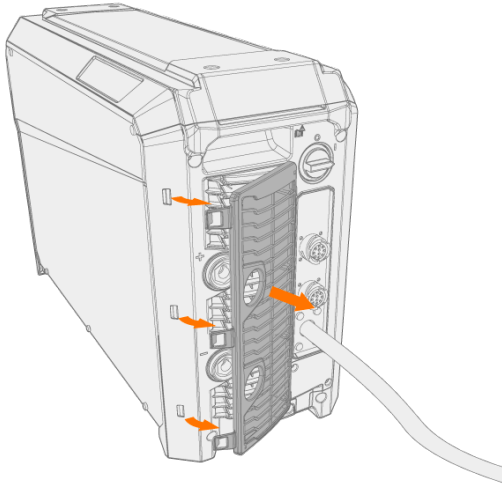
Installation and replacement

1. Place the air filter assembly onto the power source air intake, and lock it in place with the clips on the edge of the casing.

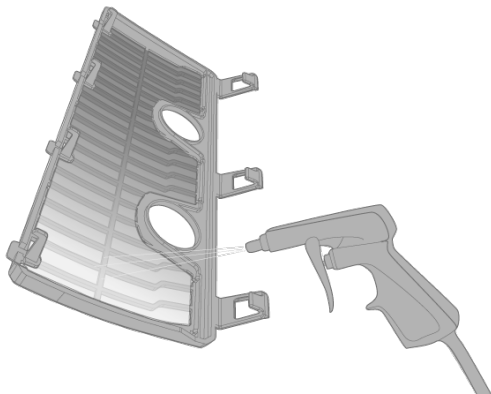


Cleansing

1. Remove the air filter from the power source by releasing the clips on the edge of the air filter casing.



2. Blow the air filter clean with compressed air.



4.3 DISPOSAL



Do not dispose of any electrical equipment with normal waste!

In observance of WEEE Directive 2012/19/EU on waste of electrical and electronic equipment and European Directive 2011/65/EU on the restriction of the use of certain hazardous substances in electrical and electronic equipment, and their implementation in accordance with national law, electrical equipment that has reached the end of its life must be collected separately and taken to an appropriate environmentally responsible recycling facility. The owner of the equipment is obliged to deliver a decommissioned unit to a regional collection center, as per the instructions of local authorities or a Kemppli representative. By applying these European Directives you improve the environment and human health.

For more information:



5. TECHNICAL DATA

Technical data:

- For X5 power source technical data, refer to "X5 power sources" on the next page.
- For X5 wire feeder technical data, refer to "X5 wire feeders" on page 197.
- For X5 cooling unit technical data, refer to "X5 cooling units" on page 207.

Additional information:

- For ordering information, refer to "X5 ordering info" on page 209.

5.1 X5 POWER SOURCES

X5 Power Source 400

X5 Power Source 400		
Feature		Value
Mains connection voltage		380...460 V \pm 10 %
Mains connection phases		3~50/60 Hz
Mains connection cable type		H07RN-F
Mains connection cable size		4 mm ²
Rated maximum input power [S_{1max}]		20 kVA
Mains fuse		25 A
Idle state power consumption [P_{idle}]		30 W
No-load state power consumption (MMA), power save		30 W
No-load state power consumption (MMA), fans ON		175 W
No-load voltage [U_0]		52...67 V
Open circuit voltage [U_{av}]		52...67 V
Effective supply current [I_{leff}]		24...21 A
Maximum supply current [I_{1max}]		28...24 A
Output at +40 °C, 60% MIG		400 A
Output at +40 °C, 100% MIG		350 A
Output range, MIG welding current/voltage		15 A / 12 V ... 400 A / 42 V
Output range, TIG welding current/voltage		15 A / 1 V ... 400 A / 42 V
Output range, MMA welding current/voltage		15 A / 10 V ... 400 A / 42 V
Voltage adjustment range (MIG)		8...45 V
Power factor at rated maximum current	λ	0.88
Efficiency at rated maximum current	η	90 %
Minimum short-circuit power of supply network [S_{SC}]		5.8 MVA
Voltage supply for auxiliary devices		12 V, 48 V
Voltage supply for cooling unit		24 V, 380...460 V
Wired communication type		CAN bus
Operating temperature range		-20...40 °C
Storage temperature range		-40...60 °C
Recommended minimum generator power [S_{gen}]		25 kVA
EMC class		A
Degree of protection		IP23S
External dimensions	$L \times W \times H$	750 x 263 x 456 mm

Weight without accessories	39 kg
Standards	IEC 60974-1, -10

X5 Power Source 400 MV

X5 Power Source 400 MV WP		
Feature		Value
Mains connection voltage		380...460 V \pm 10 %
Mains connection voltage	MV low range	220...230 V \pm 10 %
Mains connection phases		3~50/60 Hz
Mains connection cable type		H07RN-F
Mains connection cable size		6 mm ²
Rated maximum input power [S_{1max}]		19 kVA
Mains fuse		25 A
Mains fuse	@MV low range	32 A
Idle state power consumption [P_{idle}]		30 W
No-load voltage [U_0]		52...67 V
No-load voltage [U_0]	@MV low range	51 V
Open circuit voltage [U_{av}]		52...67 V
Effective supply current [I_{1eff}]		19...23 A
Effective supply current [I_{1eff}]	@MV low range	29 A
Maximum supply current [I_{1max}]		24...28 A
Maximum supply current [I_{1max}]	@MV low range	47 A
Output at +40 °C, 60% MIG		400 A
Output at +40 °C, 100% MIG		350 A
Output, duty cycle % at rated max current, MIG	@MV low range	40 %
Output at +40 °C, rated max current, MIG	@MV low range	400 A
Output at +40 °C, 100% MIG	@MV low range	300 A
Output range, MIG welding current/voltage		15 A / 12 V ... 400 A / 42 V
Output range, TIG welding current/voltage		15 A / 1 V ... 400 A / 42 V
Output range, MMA welding current/voltage		15 A / 10 V ... 400 A / 42 V
Voltage adjustment range (MIG)		8...45 V
Power factor at rated maximum current	λ	0.89
Efficiency at rated maximum current	η	90 %
Minimum short-circuit power of supply network [S_{SC}]		5.8 MVA
Voltage supply for auxiliary devices		12 V, 48 V
Voltage supply for cooling unit		24 V, 380...460 V
Voltage supply for cooling unit	@MV low range	220...230 V, 24 V
Wired communication type		CAN bus
Operating temperature range		-20...40 °C
Storage temperature range		-40...60 °C

Recommended minimum generator power [S_{gen}]	25 kVA
EMC class	A
Degree of protection	IP23
External dimensions <i>L x W x H</i>	750 x 263 x 456 mm
Weight without accessories	43.5 kg
Standards	IEC 60974-1, -10

X5 Power Source 400 Pulse

X5 Power Source 400 Pulse		
Feature		Value
Mains connection voltage		380...460 V \pm 10 %
Mains connection phases		3~50/60 Hz
Mains connection cable type		H07RN-F
Mains connection cable size		4 mm ²
Rated maximum input power [S_{1max}]		20 kVA
Mains fuse		25 A
Idle state power consumption [P_{idle}]		31 W
No-load state power consumption (MMA), power save		32 W
No-load state power consumption (MMA), fans ON		230 W
No-load voltage [U_0]		76...94 V
Open circuit voltage [U_{av}]		76...94 V
Effective supply current [I_{eff}]		24...22 A
Maximum supply current [I_{1max}]		28...26 A
Output at +40 °C, 60% MIG		400 A
Output at +40 °C, 100% MIG		350 A
Output range, MIG welding current/voltage		15 A / 10 V ... 400 A / 50 V
Output range, TIG welding current/voltage		15 A / 1 V ... 400 A / 50 V
Output range, MMA welding current/voltage		15 A / 10 V ... 400 A / 50 V
Voltage adjustment range (MIG)		8...50 V
Power factor at rated maximum current	λ	0.85
Efficiency at rated maximum current	η	89 %
Minimum short-circuit power of supply network [S_{SC}]		6.3 MVA
Voltage supply for auxiliary devices		12 V, 48 V
Voltage supply for cooling unit		24 V, 380...460 V
Wired communication type		CAN bus
Operating temperature range		-20...40 °C
Storage temperature range		-40...60 °C
Recommended minimum generator power [S_{gen}]		25 kVA
EMC class		A
Degree of protection		IP23S
External dimensions	$L \times W \times H$	750 x 263 x 456 mm
Weight without accessories		39.5 kg
Standards		IEC 60974-1, -10

X5 Power Source 400 Pulse+

X5 Power Source 400 Pulse+		
Feature		Value
Mains connection voltage		380...460 V \pm 10 %
Mains connection phases		3~50/60 Hz
Mains connection cable type		H07RN-F
Mains connection cable size		4 mm ²
Rated maximum input power [S_{1max}]		20 kVA
Mains fuse		25 A
Idle state power consumption [P_{idle}]		33 W
No-load state power consumption (MMA), power save		34 W
No-load state power consumption (MMA), fans ON		230 W
No-load voltage [U_0]		76...94 V
Open circuit voltage [U_{av}]		76...94 V
Effective supply current [I_{eff}]		24...22 A
Maximum supply current [I_{1max}]		28...26 A
Output at +40 °C, 60% MIG		400 A
Output at +40 °C, 100% MIG		350 A
Output range, MIG welding current/voltage		15 A / 10 V ... 400 A / 50 V
Output range, TIG welding current/voltage		15 A / 1 V ... 400 A / 50 V
Output range, MMA welding current/voltage		15 A / 10 V ... 400 A / 50 V
Voltage adjustment range (MIG)		8...50 V
Power factor at rated maximum current	λ	0.86
Efficiency at rated maximum current	η	89 %
Minimum short-circuit power of supply network [S_{SC}]		6.3 MVA
Voltage supply for auxiliary devices		12 V, 48 V
Voltage supply for cooling unit		24 V, 380...460 V
Wired communication type		CAN bus
Operating temperature range		-20...40 °C
Storage temperature range		-40...60 °C
Recommended minimum generator power [S_{gen}]		25 kVA
EMC class		A
Degree of protection		IP23S
External dimensions	$L \times W \times H$	750 x 263 x 456 mm
Weight without accessories		39.5 kg
Standards		IEC 60974-1, -10

X5 Power Source 400 MV Pulse+

X5 Power Source 400 MV Pulse+		
Feature		Value
Mains connection voltage		380...460 V \pm 10 %
Mains connection voltage	MV low range	220...230 V \pm 10 %
Mains connection phases		3~50/60 Hz
Mains connection cable type		H07RN-F
Mains connection cable size		6 mm ²
Rated maximum input power [S_{1max}]		19 kVA
Mains fuse		25 A
Mains fuse	@MV low range	32 A
Idle state power consumption [P_{idle}]		33 W
No-load state power consumption (MMA), power save		34 W
No-load state power consumption (MMA), fans ON		230 W
No-load voltage [U_0]		76...94 V
No-load voltage [U_0]	@MV low range	72 V
Open circuit voltage [U_{av}]		76...94 V
Effective supply current [I_{1eff}]		22...19 A
Effective supply current [I_{1eff}]	@MV low range	29 A
Maximum supply current [I_{1max}]		28...24 A
Maximum supply current [I_{1max}]	@MV low range	47 A
Output at +40 °C, 60% MIG		400 A
Output at +40 °C, 100% MIG		350 A
Output, duty cycle % at rated max current, MIG	@MV low range	40 %
Output at +40 °C, rated max current, MIG	@MV low range	400 A
Output range, MIG welding current/voltage		15 A / 10 V ... 400 A / 45 V
Output range, TIG welding current/voltage		15 A / 1 V ... 400 A / 45 V
Output range, MMA welding current/voltage		15 A / 10 V ... 400 A / 45 V
Voltage adjustment range (MIG)		8...45 V
Power factor at rated maximum current	λ	0.89
Efficiency at rated maximum current	η	89 %
Minimum short-circuit power of supply network [S_{SC}]		5.3 MVA
Voltage supply for auxiliary devices		12 V, 48 V
Voltage supply for cooling unit		24 V, 380...460 V
Voltage supply for cooling unit	@MV low range	220...230 V, 24 V
Wired communication type		CAN bus

Operating temperature range		-20...40 °C
Storage temperature range		-40...60 °C
Recommended minimum generator power [S_{gen}]		25 kVA
EMC class		A
Degree of protection		IP23S
External dimensions	<i>L x W x H</i>	750 x 263 x 456 mm
Weight without accessories		43.5 kg
Standards		IEC 60974-1, -10

X5 Power Source 500

X5 Power Source 500		
Feature		Value
Mains connection voltage		380...460 V \pm 10 %
Mains connection phases		3~50/60 Hz
Mains connection cable type		H07RN-F
Mains connection cable size		6 mm ²
Rated maximum input power [S_{1max}]		27 kVA
Mains fuse		32 A
Idle state power consumption [P_{idle}]		30 W
No-load state power consumption (MMA), power save		30 W
No-load state power consumption (MMA), fans ON		195 W
No-load voltage [U_0]		59...75 V
Open circuit voltage [U_{av}]		59...75 V
Effective supply current [I_{eff}]		31...27 A
Maximum supply current [I_{1max}]		38...33 A
Output at +40 °C, 60% MIG		500 A
Output at +40 °C, 100% MIG		430 A
Output range, MIG welding current/voltage		15 A / 10 V ... 500 A / 47 V
Output range, TIG welding current/voltage		15 A / 1 V ... 500 A / 47 V
Output range, MMA welding current/voltage		15 A / 10 V ... 500 A / 47 V
Voltage adjustment range (MIG)		8...50 V
Power factor at rated maximum current	λ	0.88
Efficiency at rated maximum current	η	90 %
Minimum short-circuit power of supply network [S_{SC}]		6.4 MVA
Voltage supply for auxiliary devices		12 V, 48 V
Voltage supply for cooling unit		24 V, 380...460 V
Wired communication type		CAN bus
Operating temperature range		-20...40 °C
Storage temperature range		-40...60 °C
Recommended minimum generator power [S_{gen}]		35 kVA
EMC class		A
Degree of protection		IP23S
External dimensions	$L \times W \times H$	750 x 263 x 456 mm
Weight without accessories		39.5 kg
Standards		IEC 60974-1, -10

X5 Power Source 500 Pulse

X5 Power Source 500 Pulse		
Feature		Value
Mains connection voltage		380...460 V \pm 10 %
Mains connection phases		3~50/60 Hz
Mains connection cable type		H07RN-F
Mains connection cable size		6 mm ²
Rated maximum input power [S_{1max}]		27 kVA
Mains fuse		32 A
Idle state power consumption [P_{idle}]		31 W
No-load state power consumption (MMA), power save		32 W
No-load state power consumption (MMA), fans ON		240 W
No-load voltage [U_0]		76...94 V
Open circuit voltage [U_{av}]		76...94 V
Effective supply current [I_{leff}]		30...27 A
Maximum supply current [I_{1max}]		39...34 A
Output at +40 °C, 60% MIG		500 A
Output at +40 °C, 100% MIG		400 A
Output range, MIG welding current/voltage		15 A / 10 V ... 500 A / 50 V
Output range, TIG welding current/voltage		15 A / 1 V ... 500 A / 50 V
Output range, MMA welding current/voltage		15 A / 10 V ... 500 A / 50 V
Voltage adjustment range (MIG)		8...50 V
Power factor at rated maximum current	λ	0.89
Efficiency at rated maximum current	η	89 %
Minimum short-circuit power of supply network [S_{SC}]		6.7 MVA
Voltage supply for auxiliary devices		12 V, 48 V
Voltage supply for cooling unit		24 V, 380...460 V
Wired communication type		CAN bus
Operating temperature range		-20...40 °C
Storage temperature range		-40...60 °C
Recommended minimum generator power [S_{gen}]		35 kVA
EMC class		A
Degree of protection		IP23S
External dimensions	$L \times W \times H$	750 x 263 x 456 mm
Weight without accessories		39.5 kg
Standards		IEC 60974-1, -10

X5 Power Source 500 Pulse+

X5 Power Source 500 Pulse+		
Feature		Value
Mains connection voltage		380...460 V \pm 10 %
Mains connection phases		3~50/60 Hz
Mains connection cable type		H07RN-F
Mains connection cable size		6 mm ²
Rated maximum input power [S_{1max}]		27 kVA
Mains fuse		32 A
Idle state power consumption [P_{idle}]		33 W
No-load state power consumption (MMA), power save		34 W
No-load state power consumption (MMA), fans ON		240 W
No-load voltage [U_0]		76...94 V
Open circuit voltage [U_{av}]		76...94 V
Effective supply current [I_{eff}]		30...27 A
Maximum supply current [I_{1max}]		39...34 A
Output at +40 °C, 60% MIG		500 A
Output at +40 °C, 100% MIG		400 A
Output range, MIG welding current/voltage		15 A / 10 V ... 500 A / 50 V
Output range, TIG welding current/voltage		15 A / 1 V ... 500 A / 50 V
Output range, MMA welding current/voltage		15 A / 10 V ... 500 A / 50 V
Voltage adjustment range (MIG)		8...50 V
Power factor at rated maximum current	λ	0.89
Efficiency at rated maximum current	η	88 %
Minimum short-circuit power of supply network [S_{SC}]		6.7 MVA
Voltage supply for auxiliary devices		12 V, 48 V
Voltage supply for cooling unit		24 V, 380...460 V
Wired communication type		CAN bus
Operating temperature range		-20...40 °C
Storage temperature range		-40...60 °C
Recommended minimum generator power [S_{gen}]		35 kVA
EMC class		A
Degree of protection		IP23S
External dimensions	$L \times W \times H$	750 x 263 x 456 mm
Weight without accessories		39.5 kg
Standards		IEC 60974-1, -10

5.2 X5 WIRE FEEDERS

X5 Wire Feeder 200 Manual

X5 Wire Feeder 200 Manual	
Feature	Value
Supply voltage	48 V
Supply current at maximum load	6.3 A
Idle power	6 W
Idle power with cabinet heater	30 W
Welding current 60%	500 A
Welding current 100%	430 A
Welding connection type	Euro
Wire feed mechanism	4-roll, Single-motor
Diameter of feed rolls	32 mm
Filler wire diameter, Fe	0.8...1.6 mm
Filler wire diameter, Ss	0.8...1.6 mm
Filler wire diameter, MC/FC	0.8...2 mm
Filler wire diameter, Al	0.8...2.4 mm
Wire feed speed	0.5...25 m/min
Maximum wire spool weight	5 kg
Maximum wire spool diameter	200 mm
Maximum shielding gas pressure	0.5 MPa
Control panel, model	X5 Feeder Panel 200R
Control panel, display	B/W OLED
Control panel, controls	2 control knobs, Push buttons
Control panel, type of installation	Built-in
Control panel, input voltage (DC)	12 V
Control panel, input current (DC)	100 mA
Wired communication type	CAN bus
Operating temperature range	-20...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23S
External dimensions	<i>L x W x H</i>
	565 x 218 x 339 mm
Weight without accessories	9.7 kg
Standards	IEC 60974-5, 10

X5 Wire Feeder HD200 Manual

X5 Wire Feeder HD200 M

Feature	Value
Supply voltage	48 V
Supply current at maximum load	6.3 A
Idle power	6 W
Welding current 60%	500 A
Welding current 100%	430 A
Welding connection type	Euro
Wire feed mechanism	4-roll
Diameter of feed rolls	32 mm
Filler wire diameter, Fe	0.8...1.6 mm
Filler wire diameter, Ss	0.8...1.6 mm
Filler wire diameter, MC/FC	0.8...2 mm
Filler wire diameter, Al	0.8...2.4 mm
Wire feed speed	0.5...25 m/min
Maximum wire spool weight	5 kg
Maximum wire spool diameter	200 mm
Maximum shielding gas pressure	0.5 MPa
Control panel, model	X5 Feeder Panel 300R
Control panel, controls	2 control knobs, Push buttons
Control panel, type of installation	Built-in
Wired communication type	CAN bus
Operating temperature range	-20...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23
External dimensions	<i>L x W x H</i> 560 x 235 x 325 mm
Weight without accessories	10.2 kg
Standards	IEC 60974-5, 10

X5 Wire Feeder HD200 AP

X5 Wire Feeder HD200 AP	
Feature	Value
Supply voltage	48 V
Supply current at maximum load	6.3 A
Idle power	6 W
Welding current 60%	500 A
Welding current 100%	430 A
Welding connection type	Euro
Wire feed mechanism	4-roll

Diameter of feed rolls	32 mm
Filler wire diameter, Fe	0.8...1.6 mm
Filler wire diameter, Ss	0.8...1.6 mm
Filler wire diameter, MC/FC	0.8...1.6 mm
Filler wire diameter, Al	0.8...2.4 mm
Wire feed speed	0.5...25 m/min
Maximum wire spool weight	5 kg
Maximum wire spool diameter	200 mm
Maximum shielding gas pressure	0.5 MPa
Control panel, model	X5 Feeder Panel 300 AP
Control panel, controls	2 control knobs, Push buttons
Control panel, type of installation	Built-in
Wired communication type	CAN bus
Operating temperature range	-20...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23
External dimensions	<i>L x W x H</i> 560 x 235 x 325 mm
Weight without accessories	10.2 kg
Standards	IEC 60974-5, 10

X5 Wire Feeder HD200 APC

X5 Wire Feeder HD200 APC	
Feature	Value
Supply voltage	48 V
Supply current at maximum load	6.3 A
Idle power	6 W
Welding current 60%	500 A
Welding current 100%	430 A
Welding connection type	Euro
Wire feed mechanism	4-roll
Diameter of feed rolls	32 mm
Filler wire diameter, Fe	0.8...1.6 mm
Filler wire diameter, Ss	0.8...1.6 mm
Filler wire diameter, MC/FC	0.8...2 mm
Filler wire diameter, Al	0.8...2.4 mm
Wire feed speed	0.5...25 m/min
Maximum wire spool weight	5 kg
Maximum wire spool diameter	200 mm

Maximum shielding gas pressure	0.5 MPa
Control panel, model	X5 Feeder Panel 300 APC
Control panel, controls	2 control knobs, Push buttons
Control panel, type of installation	Built-in
Wired communication type	CAN bus
Wireless communication type	WUBT-236ACN(BT)
Bluetooth type	4.2 (LE)
Transmitter frequency and power, Bluetooth	2.4 GHz; 4 dBm
WLAN type	IEEE 802.11 ac/a/b/g/n
Transmitter frequency and power, WLAN	2.4 GHz: 2.412...2.484 GHz; 5.1 GHz: 5.150...5.240 GHz, 5.250...5.350 GHz, 5.470...5.725 GHz; 9...16 dBm
Operating temperature range	-20...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23
External dimensions	<i>L x W x H</i> 560 x 235 x 325 mm
Weight without accessories	10.2 kg
Standards	IEC 60974-5, 10

X5 Wire Feeder 300 Manual

X5 Wire Feeder 300 Manual	
Feature	Value
Supply voltage	48 V
Supply current at maximum load	6.3 A
Idle power	6 W
Idle power with cabinet heater	30 W
Welding current 60%	500 A
Welding current 100%	430 A
Welding connection type	Euro
Wire feed mechanism	4-roll, Single-motor
Diameter of feed rolls	32 mm
Filler wire diameter, Fe	0.8...2 mm
Filler wire diameter, Ss	0.8...2 mm
Filler wire diameter, MC/FC	0.8...2.4 mm
Filler wire diameter, Al	0.8...2.4 mm
Wire feed speed	0.5...25 m/min
Maximum wire spool weight	20 kg
Maximum wire spool diameter	300 mm

Maximum shielding gas pressure	0.5 MPa
Control panel, model	X5 Feeder Panel 300R
Control panel, display	B/W OLED
Control panel, controls	2 control knobs, Push buttons
Control panel, type of installation	Built-in
Control panel, input voltage (DC)	12 V
Control panel, input current (DC)	100 mA
Wired communication type	CAN bus
Operating temperature range	-20...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23S
External dimensions	<i>L x W x H</i> 650 x 230 x 410 mm
Weight without accessories	10.9 kg
Standards	IEC 60974-5, 10

X5 Wire Feeder 300 AP

X5 Wire Feeder 300 AP	
Feature	Value
Supply voltage	48 V
Supply current at maximum load	6.3 A
Idle power	6 W
Idle power with cabinet heater	30 W
Welding current 60%	500 A
Welding current 100%	430 A
Welding connection type	Euro
Wire feed mechanism	4-roll, Single-motor
Diameter of feed rolls	32 mm
Filler wire diameter, Fe	0.8...2 mm
Filler wire diameter, Ss	0.8...2 mm
Filler wire diameter, MC/FC	0.8...2.4 mm
Filler wire diameter, Al	0.8...2.4 mm
Wire feed speed	0.5...25 m/min
Maximum wire spool weight	20 kg
Maximum wire spool diameter	300 mm
Maximum shielding gas pressure	0.5 MPa
Control panel, model	X5 Feeder Panel 300 AP
Control panel, display	5.7" LCD
Control panel, controls	2 control knobs, Push buttons

Control panel, type of installation	Built-in
Control panel, input voltage (DC)	12 V
Wired communication type	CAN bus
Operating temperature range	-20...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23S
External dimensions	<i>L x W x H</i> 650 x 230 x 410 mm
Weight without accessories	10.9 kg
Standards	IEC 60974-5, 10

X5 Wire Feeder 300 APC

X5 Wire Feeder 300 APC	
Feature	Value
Supply voltage	48 V
Supply current at maximum load	6.3 A
Idle power	6 W
Idle power with cabinet heater	30 W
Welding current 60%	500 A
Welding current 100%	430 A
Welding connection type	Euro
Wire feed mechanism	4-roll, Single-motor
Diameter of feed rolls	32 mm
Filler wire diameter, Fe	0.8...2 mm
Filler wire diameter, Ss	0.8...2 mm
Filler wire diameter, MC/FC	0.8...2.4 mm
Filler wire diameter, Al	0.8...2.4 mm
Wire feed speed	0.5...25 m/min
Maximum wire spool weight	20 kg
Maximum wire spool diameter	300 mm
Maximum shielding gas pressure	0.5 MPa
Control panel, model	X5 Feeder Panel 300 APC
Control panel, display	5.7" LCD
Control panel, controls	2 control knobs, Push buttons
Control panel, type of installation	Built-in
Control panel, input voltage (DC)	12 V
Wired communication type	CAN bus
Wireless communication type	WUBT-236ACN(BT)
Bluetooth type	4.2 (LE)

Transmitter frequency and power, Bluetooth	2.4 GHz; 4 dBm
WLAN type	IEEE 802.11 ac/a/b/g/n
Transmitter frequency and power, WLAN	2.4 GHz: 2.412...2.484 GHz; 5.1 GHz: 5.150...5.240 GHz, 5.250...5.350 GHz, 5.470...5.725 GHz; 9...16 dBm
Operating temperature range	-20...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23S
External dimensions	<i>L x W x H</i> 650 x 230 x 410 mm
Weight without accessories	10.9 kg
Standards	IEC 60974-5, 10

X5 Wire Feeder HD300 AP

X5 Wire Feeder HD300 AP	
Feature	Value
Supply voltage	48 V
Supply current at maximum load	6.3 A
Idle power	6 W
Idle power with cabinet heater	11 W
Welding current 60%	500 A
Welding current 100%	430 A
Welding connection type	Euro
Wire feed mechanism	4-roll, Single-motor
Diameter of feed rolls	32 mm
Filler wire diameter, Fe	0.8...2 mm
Filler wire diameter, Ss	0.8...2 mm
Filler wire diameter, MC/FC	0.8...2.4 mm
Filler wire diameter, Al	0.8...2.4 mm
Wire feed speed	0.5...25 m/min
Maximum wire spool weight	20 kg
Maximum wire spool diameter	300 mm
Maximum shielding gas pressure	0.5 MPa
Control panel, model	X5 Feeder Panel 300 AP
Control panel, display	5.7" LCD
Control panel, controls	2 control knobs, Push buttons
Control panel, type of installation	Built-in
Control panel, input voltage (DC)	12 V
Wired communication type	CAN bus

LED battery type and voltage	Built-in, rechargeable: LG CHEM (ICR18650HE4; Li-ion, 3.6 V, 2500 mAh), Samsung SDI (INR18650-26J; Li-ion, 3.6 V, 2600 mAh)
Operating temperature range	-20...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23S
External dimensions	<i>L x W x H</i> 670 x 240 x 465 mm
Weight without accessories	14.4 kg
Standards	IEC 60974-5, 10

X5 Wire Feeder HD300 APC

X5 Wire Feeder HD300 APC	
Feature	Value
Supply voltage	48 V
Supply current at maximum load	6.3 A
Idle power	6 W
Idle power with cabinet heater	11 W
Welding current 60%	500 A
Welding current 100%	430 A
Welding connection type	Euro
Wire feed mechanism	4-roll, Single-motor
Diameter of feed rolls	32 mm
Filler wire diameter, Fe	0.8...2 mm
Filler wire diameter, Ss	0.8...2 mm
Filler wire diameter, MC/FC	0.8...2.4 mm
Filler wire diameter, Al	0.8...2.4 mm
Wire feed speed	0.5...25 m/min
Maximum wire spool weight	20 kg
Maximum wire spool diameter	300 mm
Maximum shielding gas pressure	0.5 MPa
Control panel, model	X5 Feeder Panel 300 APC
Control panel, display	5.7" LCD
Control panel, controls	2 control knobs, Push buttons
Control panel, type of installation	Built-in
Control panel, input voltage (DC)	12 V
Wired communication type	CAN bus
Wireless communication type	WUBT-236ACN(BT)
Bluetooth type	4.2 (LE)

Transmitter frequency and power, Bluetooth	2.4 GHz; 4 dBm
WLAN type	IEEE 802.11 ac/a/b/g/n
Transmitter frequency and power, WLAN	2.4 GHz: 2.412...2.484 GHz; 5.1 GHz: 5.150...5.240 GHz, 5.250...5.350 GHz, 5.470...5.725 GHz; 9...16 dBm
LED battery type and voltage	Built-in, rechargeable: LG CHEM (ICR18650HE4; Li-ion, 3.6 V, 2500 mAh), Samsung SDI (INR18650-26J; Li-ion, 3.6 V, 2600 mAh)
Operating temperature range	-20...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23S
External dimensions	<i>L x W x H</i> 670 x 240 x 465 mm
Weight without accessories	14.4 kg
Standards	IEC 60974-5, 10

X5 Wire Feeder HD300 M

X5 Wire Feeder HD300 M	
Feature	Value
Supply voltage	48 V
Supply current at maximum load	6.3 A
Idle power	6 W
Idle power with cabinet heater	11 W
Welding current 60%	500 A
Welding current 100%	430 A
Welding connection type	Euro
Wire feed mechanism	4-roll, Single-motor
Diameter of feed rolls	32 mm
Filler wire diameter, Fe	0.8...2 mm
Filler wire diameter, Ss	0.8...2 mm
Filler wire diameter, MC/FC	0.8...2.4 mm
Filler wire diameter, Al	0.8...2.4 mm
Wire feed speed	0.5...25 m/min
Maximum wire spool weight	20 kg
Maximum wire spool diameter	300 mm
Maximum shielding gas pressure	0.5 MPa
Control panel, model	X5 Feeder Panel 300R
Control panel, display	B/W OLED
Control panel, controls	2 control knobs, Push buttons

Control panel, type of installation	Built-in
Control panel, input voltage (DC)	12 V
Control panel, input current (DC)	100 mA
Wired communication type	CAN bus
LED battery type and voltage	Built-in, rechargeable: LG CHEM (ICR18650HE4; Li-ion, 3.6 V, 2500 mAh), Samsung SDI (INR18650-26J; Li-ion, 3.6 V, 2600 mAh)
Operating temperature range	-20...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23S
External dimensions	<i>L x W x H</i> 670 x 240 x 465 mm
Weight without accessories	14.4 kg
Standards	IEC 60974-5, 10

5.3 X5 COOLING UNITS

X5 Cooler

X5 Cooler	
Feature	Value
Supply voltage	380...460 V \pm 10 %
Idle state power consumption [P_{idle}]	3 W
Maximum supply current [I_{max}]	0.7 A
Cooling power at 1 l/min	1.1 kW
Maximum coolant pressure	4 Bar
Recommended coolant	Kemppi MGP 4456
Operating temperature range	-10...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23S
Tank volume	3 l
External dimensions	<i>L x W x H</i> 730 x 263 x 288 mm
Weight without accessories	14.3 kg
Standards	IEC 60974-2, -10

X5 Cooler MV

X5 Cooler MV	
Feature	Value
Supply voltage	380...460 V \pm 10 %
Supply voltage	MV low range 220...230 V \pm 10 %
Idle state power consumption [P_{idle}]	5 W
Maximum supply current [I_{max}]	0.7 A
Maximum supply current [I_{max}]	@MV low range 1 A
Cooling power at 1 l/min	1 kW
Maximum coolant pressure	4 Bar
Recommended coolant	Kemppi MGP 4456
Operating temperature range	-10...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23S
Tank volume	3 l
External dimensions	<i>L x W x H</i> 730 x 263 x 288 mm
Weight without accessories	15.7 kg
Standards	IEC 60974-2, -10

X5 Cooler 1400

X5 Cooler 1400	
Feature	Value
Supply voltage	380...460 V \pm 10 %
Maximum supply current [I_{max}]	0.7 A
Cooling power at 1 l/min	1.4 kW
Maximum coolant pressure	0.4 MPa
Recommended coolant	MGP 4456
Operating temperature range	-10...40 °C
Storage temperature range	-40...60 °C
EMC class	A
Degree of protection	IP23S
Tank volume	3 l
External dimensions	<i>L x W x H</i> 730 x 263 x 288 mm
Weight without accessories	15 kg
Standards	IEC 60974-2, -10

5.4 X5 ORDERING INFO

For X5 FastMig ordering information and optional accessories, refer to [Kemppi.com](https://www.kemppi.com).

5.5 WIRE FEEDER CONSUMABLES

This section lists the feed rolls and wire guide tubes available both separately and in consumable kits. The consumable kits contain recommended feed roll and wire guide tube combinations for selected filler wire materials and diameters. The wire feeder consumables can be ordered in [Configurator.kemppi.com](https://configurator.kemppi.com).

In the tables, *standard* refers to plastic feed rolls and *heavy-duty* refers to metal feed rolls. The materials mentioned first refer to primary suitability and the materials mentioned inside brackets refer to secondary suitability.

Wire feeder consumable kits

The table below lists the recommended consumable kits for selected filler wire materials and diameters.

Wire feeder consumable kits				
Filler wire material	Feed roll profile	Filler wire diameter (mm)	Consumable kit code, standard	Consumable kit code, heavy-duty
Fe (MC/FC)	V-groove	0.8–0.9	F000488	F000492
		1.0	F000489	F000493
		1.2	F000490	F000494
		1.6	F000491	F000495
Ss (Fe, Cu)	V-groove	0.8–0.9	F000455	-
		1.0	F000456	-
		1.2	F000457	-
		1.4	F000496	-
		1.6	F000497	-
Ss (Fe)	V-groove	0.8–0.9	-	F000458
		1.0	-	F000459
		1.2	-	F000460
		1.6	-	F000498
MC/FC	V-groove, knurled	1.0	F000499	F000502
		1.2	F000500	F000503
		1.4–1.6	F000501	F000504
		2.0	-	F000505
Al	U-groove	1.0	F000461	-
		1.2	F000462	-
		1.6	F000506	-

Wire guide tubes

The table below lists the wire guide tubes available.










Wire guide tubes					
Filler wire material	Filler wire diameter (mm)	Feed roll identification	Inlet tube	Middle tube	Outlet tube

Al, Ss (Fe, MC, FC)	0.6		SP007293	SP007273	SP016608
	0.8–0.9		SP007294	SP007274	SP011440
	1.0		SP007295	SP007275	SP011441
	1.2		SP007296	SP007276	SP011442
	1.4		SP007297	SP007277	SP016609
	1.6		SP007298	SP007278	SP016610
	2.0		SP007299	SP007279	SP016611
	2.4		SP007300	SP007280	SP016612
Fe, MC, FC	0.6		(SP007293)	(SP007273)	SP016613
	0.8–0.9		SP007536	(SP007274)	SP016614
	1.0		SP007537	(SP007275)	SP016615
	1.2		SP007538	(SP007276)	SP016616
	1.4		(SP007297)	(SP007277)	SP016617
	1.4–1.6		SP007539	(SP007278)	SP016618
	2.0		SP007540	(SP007279)	SP016619
	2.4		SP007541	(SP007280)	SP016620

Feed rolls

The table below lists the standard feed rolls available.

Wire feed rolls, standard					
Filler wire material	Feed roll profile	Filler wire diameter (mm)	Feed roll identification	Drive roll code	Pressure roll code
Fe, Ss, Cu (Al, MC/FC)	V-groove V	0.6		W001045	W001046
		0.8–0.9		W001047	W001048
		1.0		W000675	W000676
		1.2		W000960	W000961
		1.4		W001049	W001050
		1.6		W001051	W001052
		2.0		W001053	W001054
		2.4		W001055	W001056

MC/FC (Fe)	V-groove, knurled V≡	1.0		W001057	W001058
		1.2		W001059	W001060
		1.4-1.6		W001061	W001062
		2.0		W001063	W001064
		2.4		W001065	W001066
Al (MC/FC, Ss, Fe, Cu)	U-groove U	1.0		W001067	W001068
		1.2		W001069	W001070
		1.4		W008974	W008975
		1.6		W001071	W001072

The table below lists the heavy-duty feed rolls available.

Wire feed rolls, heavy-duty				
Filler wire material	Feed roll profile	Filler wire diameter (mm)	Drive roll code	Pressure roll code
Fe, Ss (MC/FC)	V-groove V	0.8-0.9	W006074	W006075
		1.0	W006076	W006077
		1.2	W004754	W004753
		1.6	W006078	W006079
MC/FC (Fe)	V-groove, knurled V≡	1.0	W006080	W006081
		1.2	W006082	W006083
		1.4-1.6	W006084	W006085
		2.0	W006086	W006087
(MC/FC, Ss, Fe)	U-groove U	1.0	W006088	W006089
		1.2	W006090	W006091
		1.6	W006092	W006093

5.6 WELDING PROGRAM WORK PACKS

Welding program work packs include a set of standard welding programs to allow welding with e.g. automatic 1-MIG and pulse processes. For more information on the available X5 FastMig welding program options and installing the welding programs or software updates, contact your local Kemppi dealer or go to Kemppi.com.

1-MIG work pack:

Welding program	Process	Wire material	Wire diameter	Shielding gas	Description
A01	1-MIG	AlMg5	1.0	Ar	Standard
A02	1-MIG	AlMg5	1.2	Ar	Standard
A11	1-MIG	AlSi5	1.0	Ar	Standard
A12	1-MIG	AlSi5	1.2	Ar	Standard
C01	1-MIG	CuSi3	0.8	Ar	Standard: Brazing
C03	1-MIG	CuSi3	1.0	Ar	Standard: Brazing
C11	1-MIG	CuAl8	0.8	Ar	Standard: Brazing
C13	1-MIG	CuAl8	1.0	Ar	Standard: Brazing
F01	1-MIG	Fe	0.8	Ar+18%CO2	Standard
F02	1-MIG	Fe	0.9	Ar+18%CO2	Standard
F03	1-MIG	Fe	1.0	Ar+18%CO2	Standard
F04	1-MIG	Fe	1.2	Ar+18%CO2	Standard
F06	1-MIG	Fe	1.6	Ar+18%CO2	Standard
F11	1-MIG	Fe	0.8	Ar+8%CO2	Standard
F12	1-MIG	Fe	0.9	Ar+8%CO2	Standard
F13	1-MIG	Fe	1.0	Ar+8%CO2	Standard
F14	1-MIG	Fe	1.2	Ar+8%CO2	Standard
F21	1-MIG	Fe	0.8	CO2	Standard
F22	1-MIG	Fe	0.9	CO2	Standard
F23	1-MIG	Fe	1	CO2	Standard
F24	1-MIG	Fe	1.2	CO2	Standard
F26	1-MIG	Fe	1.6	CO2	Standard
M04	1-MIG	Fe Metal	1.2	Ar+18%CO2	Standard
M06	1-MIG	Fe Metal	1.6	Ar+18%CO2	Standard
R04	1-MIG	Fe Rutil	1.2	Ar+18%CO2	Standard
R06	1-MIG	Fe Rutil	1.6	Ar+18%CO2	Standard
R14	1-MIG	Fe Rutil	1.2	CO2	Standard
S01	1-MIG	Ss	0.8	Ar+2%CO2	Standard
S02	1-MIG	Ss	0.9	Ar+2%CO2	Standard
S03	1-MIG	Ss	1.0	Ar+2%CO2	Standard
S04	1-MIG	Ss	1.2	Ar+2%CO2	Standard

S82	1-MIG	FC-CrNiMo	0.9	Ar+18%CO2	Standard
S84	1-MIG	FC-CrNiMo	1.2	Ar+18%CO2	Standard

Pulse work pack:

The Pulse work pack includes also all 1-MIG work pack welding programs.

Welding program	Process	Wire material	Wire diameter	Shielding gas	Description
A01	Pulse	AlMg5	1.0	Ar	Standard
A02	Pulse	AlMg5	1.2	Ar	Standard
A11	Pulse	AlSi5	1.0	Ar	Standard
A12	Pulse	AlSi5	1.2	Ar	Standard
C01	Pulse	CuSi3	0.8	Ar	Standard: Brazing
C03	Pulse	CuSi3	1.0	Ar	Standard: Brazing
C11	Pulse	CuAl8	0.8	Ar	Standard: Brazing
C13	Pulse	CuAl8	1.0	Ar	Standard: Brazing
F01	Pulse	Fe	0.8	Ar+18%CO2	Standard
F02	Pulse	Fe	0.9	Ar+18%CO2	Standard
F03	Pulse	Fe	1.0	Ar+18%CO2	Standard
F04	Pulse	Fe	1.2	Ar+18%CO2	Standard
F11	Pulse	Fe	0.8	Ar+8%CO2	Standard
F12	Pulse	Fe	0.9	Ar+8%CO2	Standard
F13	Pulse	Fe	1.0	Ar+8%CO2	Standard
F14	Pulse	Fe	1.2	Ar+8%CO2	Standard
M04	Pulse	Fe Metal	1.2	Ar+18%CO2	Standard
S01	Pulse	Ss	0.8	Ar+2%CO2	Standard
S02	Pulse	Ss	0.9	Ar+2%CO2	Standard
S03	Pulse	Ss	1.0	Ar+2%CO2	Standard
S04	Pulse	Ss	1.2	Ar+2%CO2	Standard