

INSTALLATION

OUTPUT CONNECTIONS

WELDING CABLE

Run electrode and ground cables of the appropriate size as shown in Table 4. To avoid excessive heat losses during welding, all output connections, lugs and cables should be secure and well insulated. Failure to use proper cable sizes contributes to lost efficiency of the power source and excessive consumption of electrical power.

The electrode and work leads have to be assembled using customer supplied welding cable and cable connectors. After the cables are assembled, connect the electrode lead to the negative (-) jack and the work lead to the positive (+) jack for straight polarity operation. For reverse polarity operation, the electrode lead is connected to the positive (+) jack and the work lead is connected to the negative (-) jack.

NOTE

LOCATE THE PowerCon UNIT SO THAT THE AIR FLOW INTO THE FRONT AND OUT OF THE BACK OF THE UNIT IS NOT OBSTRUCTED.

TABLE 4

RECOMMENDED COPPER WELDING CABLE SIZES BASED ON 60% DUTY CYCLE AND COMBINED LENGTH OF ELECTRODE GROUND CABLE*

6' to 150' (45.7M)	150' to 200' (51.8M)	200' to 250' (76.2M)
1/0	2/0	3/0

*Use of aluminum cable requires increase by two AWG sizes over recommended copper cable size. Recommended cable sizes for other duty cycles and output currents can be found in Volume 2, WELDING HANDBOOK, 7th Edition, published by the American Welding Society.

REMOTE CURRENT AND CONTACTOR CONTROL CONNECTIONS

Both the remote control device (hand and foot) come with a 14-pin connector plug which connects to the remote terminal on the rear panel of the PowerCon unit. The remote control devices come with a pre-wired plug and 10 1/2 feet (3.8 M) of cable. When a remote control device is plugged into the rear panel receptacle, certain front panel controls are overriden by the remote device.

To connect the remote control device, insert the 14-pin plug from the control cable of the device fully into the receptacle on the rear panel. Ensure that the plug keyways align with the receptacle keys. Rotate the plug keyways collar clockwise as far as possible into the receptacle threaded body to secure the plug in the receptacle.

WIREFEEDER CONTROL CABLE

The control cable for the wirefeeder and PowerCon SM interface comes with a 14 pin connector designed to mate with the remote receptacle on the rear panel. The wiring schematic for the control cable is shown in Figure 3.

NOTE

UNLESS OTHERWISE SPECIFIED, THE PowerCon SM IS SHIPPED FROM THE FACTORY WITH ON/OFF CONTROL RESPONSIVE TO CONTACT CLOSURE ONLY.

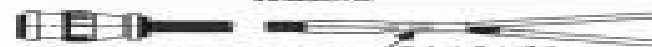
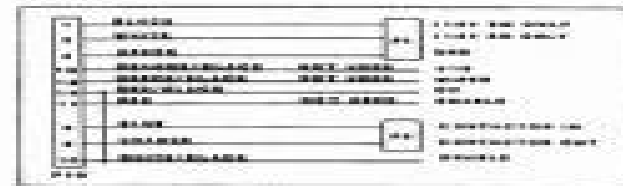


Figure 3, Wirefeeder Control Cable with Schematic

The wirefeeder control cable can be adapted for use with the PowerCon SM and any other manufacturer's wirefeeder. The specific pin numbers and individual wire colors are shown in Figure 3. A breakdown of the control cable is as follows:

Pins 1, 2, 3

The auxiliary power for the wirefeeder is provided via these connections.

NOTE

THE GREEN WIRE ON PIN #3 IS THE GROUND.

Pins 4, 5

These pins, with corresponding wires, are used to provide remote contactor control for a wirefeeder wired for contact closure as follows:

- Connect the wire from pin 4 (orange) to the return side of the wirefeeder.
- Connect the wire from pin 5 (blue) to the incoming terminal of the contactor.

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