



PipeWorx 400 FAQ's

Can the PipeWorx be used to weld plate?

The Welding Processes in the PipeWorx were Developed and Optimized for all-position, Pipe Welding Applications using Filler Metals and Shielding Gases that are commonly used by customers that manufacture welded spool assemblies in a shop environment. During our development and testing, we have found that the PipeWorx Welding processes are very robust. As a result, it is highly likely that users will be able to find settings that produce High Quality Welds on Plate Applications.

Can the PipeWorx be used on 208-volt power input?

The PipeWorx was not designed to operate on 208-volt. We typically (but not always) receive the request when a demo is planned at a distributor location. The power source will operate on a minimum 208-volt input. A degradation of weld performance will occur below 208-volt input and above 500 ipm wire feed speed.

Can the PipeWorx Run on Single Phase Power?

The PipeWorx 400 is designed to run **only** on 3 phase power. If 3 phase power is not available, it is possible to use a phase converter to power the PipeWorx 400.

Can the PipeWorx be used to weld aluminum?

The PipeWorx System was not designed to weld aluminum because this was a negligible requirement in a pipe shop.

Does the suitcase feeder operate on the PipeWorx System?

There is not a suitcase feeder available for the PipeWorx 400 System. The PipeWorx System was not designed for field applications. Pipe shops require higher amperages for roll welding, less environmental protection and operate on single voltages, while field applications require more portability (less amperage), environmental protection and need to operate on various voltages (auto line). The PipeWorx 350 FieldPro system was designed to bring the benefits of the PipeWorx into the Field.

Can we provide a complete system with ground cables, gas hoses and regulators – like AMS?

The weld package 951381 has been ordered by most customers. This package comes with a dual feeder. We have completed a dual feeder accessory package 300568, which includes a work cable and clamp, two gas hoses and two regulators. This is shown on the spec sheet. If the customer has a bulk gas system, two hoses and regulators are not required.



What TIG Torches do we recommend with PipeWorx?

We designed PipeWorx to be used with standard Weldcraft Torches in Miller Parts Department. These are identified in the spec sheet. We have even provided the small gas hose from the torch to the power source. It is included with the power source. The small water hose from the torch to the power source is provided with the cooler, so we didn't have to create custom torch numbers. Our customers in this market are not standardized on a particular model of water or air cooled torch.

Do you have basic recommended parameters?

The PipeWorx comes preprogrammed from the factory with recommended parameters for all welding process conditions. For example, each combination of material, wire diameter and gas for RMD is preprogrammed with parameters. You can default to the factory settings on a single memory slot by first selecting the welding processes you would like to restore to default and then push and hold that memory slot button. To reset the entire system, push and hold the number 1 and number 4 memory slot at the same time.

How do I set-up Trigger Select?

Push the program button 1 and push trigger select to turn on trigger select for program 1.

Push the program button 2 and push trigger select to turn on trigger select for program 2.

Push the program button 3 and push trigger select to turn on trigger select for program 3.

Push the program button 4 and push trigger select to turn on trigger select for program 4.

You can trigger select through up to four programs. See **OM**.

Do I need to connect the volt sense lead?

We **always** suggest using the volt sense lead for the RMD and Pulse processes. However, there are some situations when trying to STICK or Wire weld with DCEN polarity that you would need to disconnect the volt sense lead. Volt sense lead connections vary based on the age of the machine as explained in the table below (Software 1.11 required): See Owner's Manual for proper volt sense lead configurations.

	Electrode Negative Stick	Electrode Negative Wire
Power sources prior to S/N MA470021G	Disconnect the volt sense lead	Disconnect volt sense lead from the left feeder drive housing
Power sources including and after S/N MA470021G	Disconnect the volt sense lead	Volt sense lead needs to be connected