

# PipeWorx 400 Hidden Features

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The features described below are not apparent on the front panels of the system but are explained in detail in the owner's manual. These are identified with "OM". We strongly encourage you to review the manual.

**Weld program adjustments** – *All weld programs are set to optimized parameters based on welding process, material, wire diameter, and gas from the factory and do NOT require adjustment in most applications.*

- **Inductance control** – Available in MIG and FCAW Processes. Push and hold the Left or Right side feeder select buttons for at least 2 seconds to obtain this control. **OM**
- **Arc Control** – Controls arc width in RMD and Pulse Processes. Push and hold the Left or Right side feeder select buttons for at least 2 seconds to obtain this control. **OM**
- **Arc Length and Trim** – Arc Length replaces "Trim" on the PipeWorx. We changed the name because welders understand the term "arc length". We also changed the Arc Length units to +/- 3.0, so welders did not confuse the setting with voltage settings in the 15 to 40 volt range.
- **Adjustable DIG and Hot Start for Stick** – To adjust, push and hold the Stick button for 2 seconds to access the DIG setting (scale of 0-99, default of 40). Push the Stick button again to access the Hot Start setting (scale of 0.0-2.0, default of 0.0). **Software Version 1.11 or higher required.**  
**OM**
- **Timed Purge** – Press the "Purge" and "Trigger Hold" buttons at the same time and the purge will automatically purge for a preset length of time. When in the TIG mode this functionality works for the TIG gas. See OM for adjustment. **OM**
- **Post flow** – This can be adjusted by pressing and holding the purge button and then adjusting the wire feed speed control. Version 1.05 or higher Software is required.
- **Pre Flow** – This can be accessed from the Post Flow adjustment option. Push and hold the purge button, then use the Volt/Arc Length knob to cycle between Pre and Post Flow adjustments. Use the Wire Feed Speed knob to make the adjustment. **Software version 1.11 or higher required.** **OM**
- **Auto jog** - Press the "Jog" and "Trigger Hold" buttons at the same time and the wire will jog automatically for a preset length of wire. The display shows length of wire in feet. See OM for adjustment. **OM**
- **Display Remote Pre Set TIG Amperage** – Push and hold the TIG button to display the preset amperage when using a remote. Example, the machine is set to 200 amps and a remote hand control is set at 50%, the meter will display 100 amps. This allows the user to fine tune TIG amperage settings when using a remote hand control. **OM**
- **MIG Trigger Select/TIG Remote Select:** The PipeWorx System has the unique ability to switch between TIG and MIG by either pressing the gun trigger for MIG or the TIG Remote for TIG.
- **Arc Timer:** We have had requests to select and time TIG or MIG with a PLC for mechanized pipe welding applications. The MIG Trigger Select/TIG Select enables a PLC to control the processes through the trigger receptacle on the feeder or the TIG Remote Receptacle on the power source.

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## Welding Process Programs

- Standard carbon steel RMD & ProPulse programs will also work for:
  - Chrome Moly P11, P22 and P91
  - Carbon steel can be welded with 98% Argon/2% Oxygen, by selecting the carbon steel “C8-C15” gas type.
- Duplex stainless can be welded with the stainless pulse programs.

## Restoring Factory Settings

- **Machine default reset** – There are two methods to return the machine or program to a factory default setting.
  - Total reset – A full factory reset can be accomplished by pressing memory locations buttons 1 and 4 on the power source simultaneously for more than four seconds.
  - Single program reset – Pressing and holding a memory location button for more than 2 seconds will restore factory default settings for the current weld process to that particular memory location.

## Options Cards (instructions supplied with cards)

- Feature Cards – One card can activate feature in multiple machines
  - **New! VRD (301116) – The Voltage Reduction Device (VRD) reduces unloaded open circuit voltage across the output terminals for use in electrically hazardous conditions, or when required by jobsite specifications.**
  - **Trigger Select Enabled While Welding (301035)** – Allows end users to tap the trigger to select a different weld program memory slot while welding. **Software Version 1.11 or higher required**
  - **Program Locks (300460)** – Also called Range Locks, limits the window for parameters. **Software Version 1.05 or higher required**
  - **Calibration Memory Card (300557)** – Available as a free download or can be purchased
  - **Accu-Power (300667)** – Allows users to view heat input while welding per ASME Section IX code
- Custom Program Card – Card is required to stay in the machine
  - Inconel Pulse program (300536) – Custom program for .035 and .045 Inconel 75% Argon and 25% Helium gas
  - Carbon .052 wire dia RMD program (300675) – Custom RMD program for .052 dia carbon steel 75/25 gas