

Aquafuse

Supply low.

The supply voltage is less than 95 volts ac **or** the supply frequency is less than 40Hz. Check the supply.

Supply high.

The supply voltage is more than 150 volts ac **or** the supply frequency is greater than 70Hz. Check the supply.

Voltage low (constant voltage modes only).

The output voltage was less than 180 volts for 6 seconds.

Voltage high (constant voltage modes only).

The output voltage was greater than 290 volts for 6 seconds.

Current low.

The output current has decreased to 12.5% of the nominal value for 6 seconds.

Current high (constant current modes only).

The output current has exceeded either;

- 25% of the nominal value for 1 second,
- 12.5% of the nominal value for 2 seconds,
- 6.25% of the nominal value for 4 seconds,
- 1.5% of the nominal value for 6 seconds.

Faulty temp.

The ambient temperature measured is outside the working temperature limits of the equipment. Less than -40°C or greater than +70°C.

Proxima

E00 Good weld

E01 Supply voltage low.

The supply voltage is more than 20% lower than the nominal value. Check the supply.

E02 Supply voltage high.

The supply voltage is more than 20% higher than the nominal value. Check the supply.

E03 Supply frequency low.

The supply frequency is less than 40 Hz. Check the supply.

E04 Supply frequency high.

The supply frequency is greater than 70 Hz. Check the supply.

E05 Output voltage low.

The output voltage is more than 1½% lower than the nominal value. Check the power supply to the welding unit has sufficient capacity.

E06 Output voltage high.

The output voltage is more than 1½% higher than the nominal value. Possible fault within the welding unit.

E07 Excessive output voltage.

The output voltage is more than 6% higher than the nominal value. Possible fault within the welding unit.

E08 Fitting connection fault.

An open circuit in the output has been detected while a weld is in progress. Check the fitting and output leads.

E09 Output current low.

The output current is less than 2 amps. Check the fitting and the output lead connections.

E10 Case temperature too high.

The case temperature is too high. Disconnect the unit from the supply and allow it to cool down before reconnecting it.

E11 Operator stop.

The operator has interrupted the welding process by pressing the Stop button.

E12 Self test error – Stuck button.

During the power up self test, the unit has detected that a button was pressed or is stuck in.

E13 Self test error – Output fault.

During the power up self test, the unit has detected a voltage on the output terminals. This indicates a fault within the unit.

E14 Self test error – Calibration error.

During the power up self test, the unit has detected that the unit requires calibration.

E15 Internal temperature error.

The internal temperature of the unit is too high. Disconnect the unit from the supply and allow it to cool down before reconnecting it.

E16 Power relay error.

The power relays have not activated. This indicates a fault within the unit.

E17 Current surge.

The output current has increased over time indicating a fault with the fitting.

E18 USB memory disc full.

The USB memory disc has not got sufficient free space for the records held in the control unit to be downloaded.

E127 Loss of supply.

The supply has been lost during the fusion cycle.

Note: this will only be recorded on the fusion joint record.