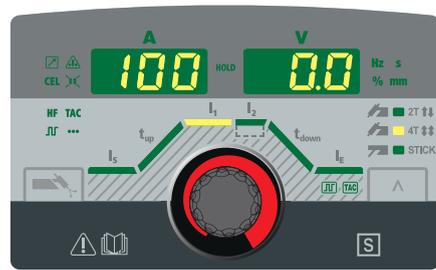


# TRANSTIG 170, TRANSTIG 210

## Control Panel Overview | Setting Welding Parameters



- To select the operating mode
- 2-step mode:  
Short weld seams
- 4-step mode:  
Longer weld seams
- SMAW
- Allow shielding gas to flow out for 30 seconds

### Adjustable welding parameters:

- $I_s$  Starting current
- $t_{up}$  UpSlope
- $I_1$  Main current (welding current)
- $I_2$  Reduced current
- $t_{down}$  DownSlope
- $I_E$  Final current
- Pulses
- Tacking

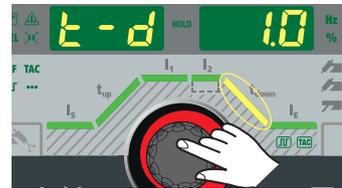
### Setting the welding parameters:



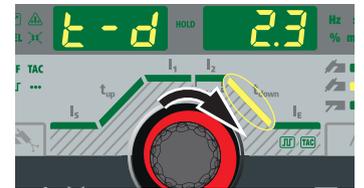
1. Press selection dial to enable parameter selection



2. Turn selection dial to select the desired parameter



3. Press selection dial to confirm the selected parameter



4. Turn selection dial to select the desired value



42,0426,0327,EA

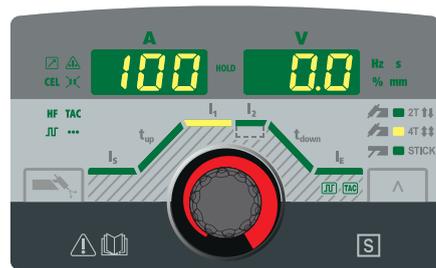
003-03082020

Operating Instructions:  
[www.fronius.com/transtig](http://www.fronius.com/transtig)



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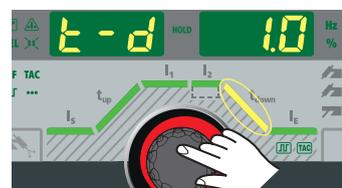
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1. Press selection dial to enable parameter selection



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42,0426,0327,EA

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Operating Instructions:  
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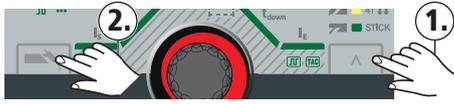


# TRANSTIG 170, TRANSTIG 210

## Description of Setup Parameters



### Accessing the Setup menu:



1. Press and hold
2. Press

### Exiting the Setup menu:



### Rod electrode Setup menu:

<b>HCU</b>	HotStart current
<b>HtI</b>	Starting current duration
<b>StR</b>	Start ramp
<b>F-P</b>	Pulse frequency
<b>ASt</b>	Anti-stick
<b>CEL</b>	CEL mode
<b>dYn</b>	Dynamic correction
<b>UCo</b>	Break voltage
<b>FAC</b>	Reset welding system
<b>2nd</b>	Setup Menu 2nd Level

### TIG Setup Menu, 1st Level:

<b>ELd</b>	Electrode diameter
<b>SPT</b>	Spot welding time/interval welding time
<b>SPb</b>	Interval pause time
<b>tAC</b>	Tacking
<b>F-P</b>	Pulse frequency
<b>dcY</b>	Duty cycle
<b>I-G</b>	Base current
<b>t-S</b>	Starting current time
<b>t-E</b>	Final current time
<b>GPp</b>	Gas pre-flow time
<b>GPo</b>	Gas post-flow time
<b>GPU</b>	Gas purging
<b>FAC</b>	Reset welding system
<b>2nd + tIG</b>	TIG Setup Menu, 2nd Level
<b>2nd</b>	Setup Menu 2nd Level

### TIG Setup Menu, 2nd Level:

<b>r</b>	Welding circuit resistance
<b>St1</b>	Slope time 1
<b>St2</b>	Slope time 2
<b>tT1</b>	Trigger mode
<b>tGn</b>	HF ignition
<b>Ptd</b>	Pulse TAC display
<b>tto</b>	Ignition time out
<b>ArC</b>	Arc break monitoring
<b>CSs</b>	Comfort Stop sensitivity
<b>UCo</b>	Break voltage
<b>ACS</b>	Main current changeover

### Setup Menu 2nd Level (TIG and SMAW):

<b>SAt</b>	System active time
<b>SoT</b>	System on time
<b>FUS</b>	Fuse
<b>SoF</b>	Software version
<b>tSd</b>	Automatic shutdown

### SAFETY



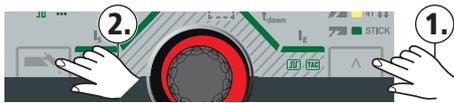
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# TRANSTIG 170, TRANSTIG 210

## Description of Setup Parameters



### Accessing the Setup menu:



1. Press and hold
2. Press

### Exiting the Setup menu:



### Rod electrode Setup menu:

<b>HCU</b>	HotStart current
<b>HtI</b>	Starting current duration
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<b>CEL</b>	CEL mode
<b>dYn</b>	Dynamic correction
<b>UCo</b>	Break voltage
<b>FAC</b>	Reset welding system
<b>2nd</b>	Setup Menu 2nd Level

### TIG Setup Menu, 1st Level:

<b>ELd</b>	Electrode diameter
<b>SPT</b>	Spot welding time/interval welding time
<b>SPb</b>	Interval pause time
<b>tAC</b>	Tacking
<b>F-P</b>	Pulse frequency
<b>dcY</b>	Duty cycle
<b>I-G</b>	Base current
<b>t-S</b>	Starting current time
<b>t-E</b>	Final current time
<b>GPp</b>	Gas pre-flow time
<b>GPo</b>	Gas post-flow time
<b>GPU</b>	Gas purging
<b>FAC</b>	Reset welding system
<b>2nd + tIG</b>	TIG Setup Menu, 2nd Level
<b>2nd</b>	Setup Menu 2nd Level

### TIG Setup Menu, 2nd Level:

<b>r</b>	Welding circuit resistance
<b>St1</b>	Slope time 1
<b>St2</b>	Slope time 2
<b>tT1</b>	Trigger mode
<b>tGn</b>	HF ignition
<b>Ptd</b>	Pulse TAC display
<b>tto</b>	Ignition time out
<b>ArC</b>	Arc break monitoring
<b>CSs</b>	Comfort Stop sensitivity
<b>UCo</b>	Break voltage
<b>ACS</b>	Main current changeover

### Setup Menu 2nd Level (TIG and SMAW):

<b>SAt</b>	System active time
<b>SoT</b>	System on time
<b>FUS</b>	Fuse
<b>SoF</b>	Software version
<b>tSd</b>	Automatic shutdown

### SAFETY



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