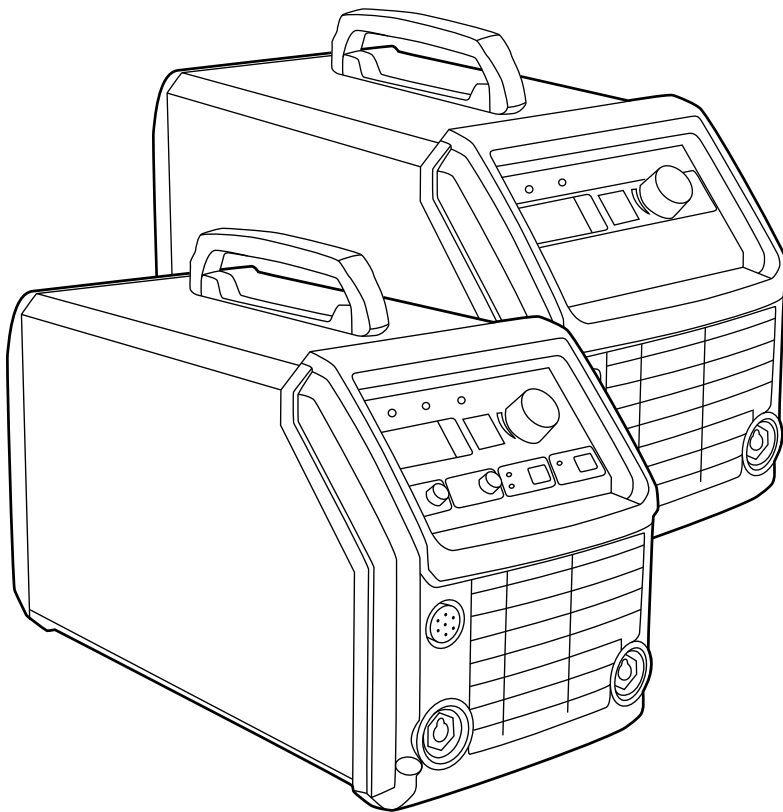


HiArc

S 400R, 400A



Operating manual *EN*

Manual de instrucciones *ES*

Manuel d'utilisation *FR*

Manual de utilização *PT*

Инструкции по эксплуатации *RU*

OPERATING MANUAL

English

CONTENTS

1.	Introduction	3
1.1	General	3
1.2	Product introduction	3
1.3	Machine introduction	4
2.	Installation	5
2.1	Before use	5
2.2	Positioning of the machine	5
2.3	Distribution network	6
2.4	Welding and earth return cable connections	6
2.4.1	Choosing welding polarity in MMA welding	6
2.4.2	Choosing welding polarity in TIG welding	6
2.4.3	Earthing	6
3.	Operation	6
3.1	Welding processes	6
3.1.1	MMA welding	6
3.1.2	TIG	6
3.2	Operation functions	6
3.2.1	Power source	6
3.2.2	Control panel and SETUP functions, HiArc S 400R	7
3.2.3	Activation and setup parameter adjustment, HiArc S 400R	7
3.2.4	Control panel and SETUP functions, HiArc S 400A	8
3.2.5	Activation and setup parameter adjustment, HiArc S 400A	9
3.3	MMA welding	10
3.3.1	Filler materials and equipment	10
3.3.2	Earth return cable and clamp	10
3.3.3	Manual metal arc welding (MMA)	10
3.3.4	Electrode welding parameter table	11
3.3.5	Arc force, HiArc S 400A	11
3.3.6	Hot start, HiArc S 400A	11
3.4	TIG welding	12
3.5	Carbon arc gouging	13
4.	Maintenance	13
4.1	Regular maintenance	13
4.1.1	Every six months	13
4.2	Service contract	13
4.3	Storage	13
4.4	Disposal of the machine	14
5.	Troubleshooting	14
5.1	Troubleshooting	14
5.2	Control panel error codes	15
6.	Ordering codes	15
7.	Technical data	16

EN

1. INTRODUCTION

1.1 General

Congratulations on choosing the HiArc series power source. Used correctly, Kemppi products can significantly increase the productivity of your welding, and provide years of economical service.

This operating manual contains important information on the use, maintenance and safety of your Kemppi product. The technical specifications of the device can be found at the end of the manual.

Please read the operating manual and the safety instructions booklet carefully before using the equipment for the first time. For your own safety and that of your working environment, pay particular attention to the safety instructions.

For more information on Kemppi products, contact Kemppi Oy, consult an authorised Kemppi dealer, or visit the Kemppi web site at www.kemppi.com.

The specifications presented in this manual are subject to change without prior notice.

Important notes

Items in the manual that require particular attention in order to minimise damage and personal harm are indicated with the '*NOTE!*' notation. Read these sections carefully and follow their instructions.

Disclaimer

While every effort has been made to ensure that the information contained in this guide is accurate and complete, no liability can be accepted for any errors or omissions. Kemppi reserves the right to change the specification of the product described at any time without prior notice. Do not copy, record, reproduce or transmit the contents of this guide without prior permission from Kemppi.

1.2 Product introduction

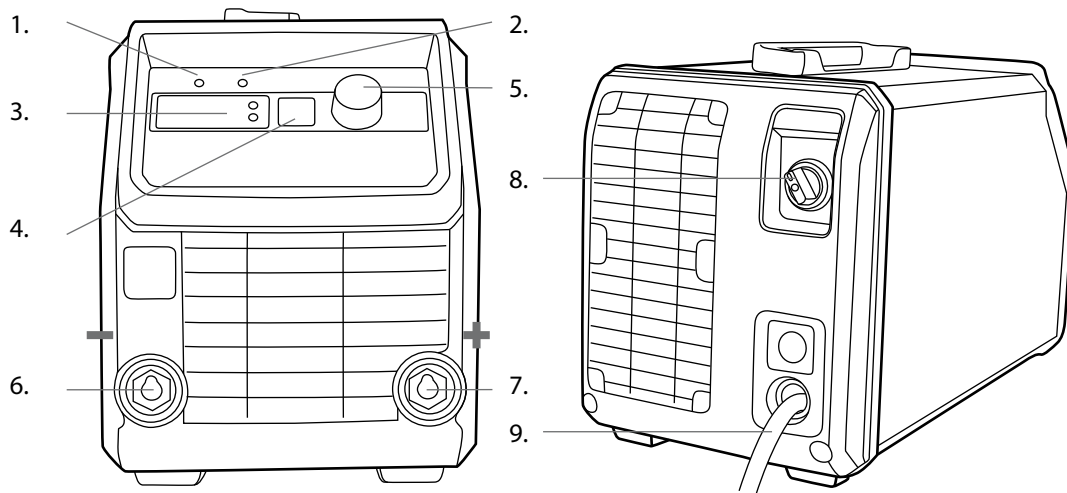
HiArc S model welding machines are designed for industrial use and for welding all kinds of covered electrodes.

Model 400R includes a regular control panel with the basic functions. Model 400A has also advanced functions like HotStart, ArcForce, TIG mode and remote control.

HiArc S 400A comes equipped with a voltage reduction device (VRD) for maintaining the open-circuit voltage (OCV) below 35 volts.

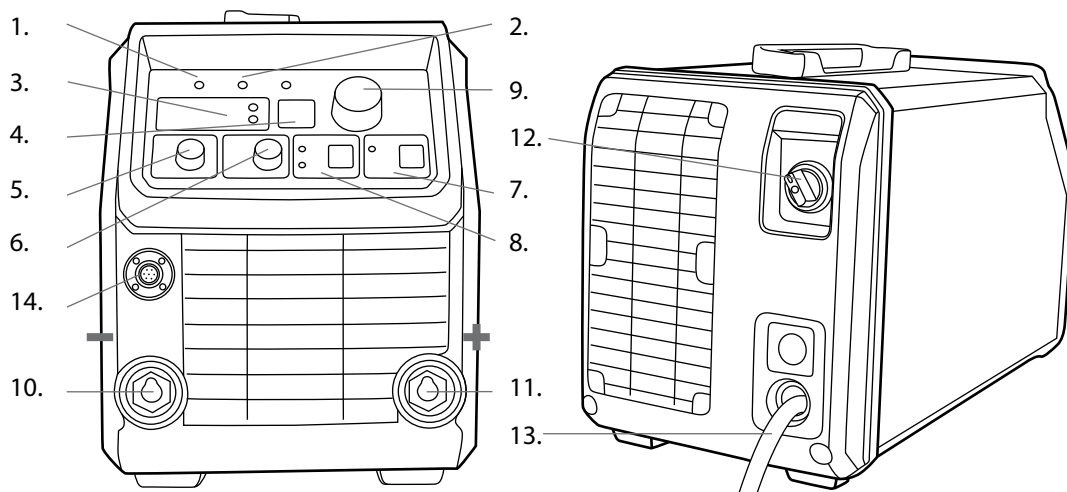
1.3 Machine introduction

HiArc S 400R



1. Power on pilot lamp
2. Overheating pilot lamp
3. Amperage/voltage meter display
4. Amperage/voltage meter display selection button
5. Welding current adjustment knob
6. Negative (-) pole connection socket (earth return cable)
7. Positive (+) pole connection socket (welding cable)
8. Main switch (ON/OFF)
9. Mains power cable

HiArc S 400A



1. Power on pilot lamp
2. Overheating pilot lamp
3. Amperage/voltage meter display
4. Amperage/voltage meter display selection button
5. ArcForce
6. HotStart

7. Remote Control
8. Welding Mode
9. Welding current adjustment knob
10. Negative (-) pole connection socket (earth return cable)
11. Positive (+) pole connection socket (welding cable)
12. Main switch (ON/OFF)
13. Mains power cable
14. Remote control connector

There is an optional display cover available to protect the panel from sparks, dust and scratches. See 'Ordering codes'.

2. INSTALLATION

2.1 Before use

The product is packed in cartons designed specifically for them. However, always make sure before use that the products have not been damaged during transportation.

Check also that you have received the components you ordered and the instruction manuals needed. Product packaging material is recyclable.

NOTE! When moving the welding machine, always lift it from the handle, never pull it from the welding or other cables.

Operating environment

This machine is suitable for both indoor and outdoor use. Always make sure that the air flow in the machine is unrestricted. The recommended operating temperature range is $-20 \dots +50$ °C.

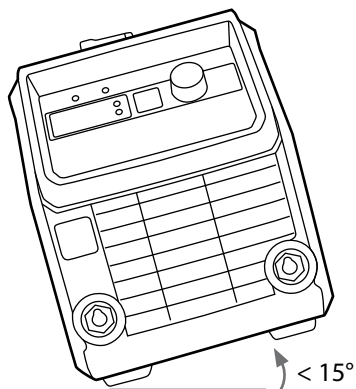
Please read also the Safety Instructions concerning the operating environment.

2.2 Positioning of the machine

Place the machine on a sturdy, level surface that is dry and does not allow dust or other impurities to enter the machine's cooling air flow. Preferably site the machine to a suitable carriage unit so it is above floor level.

Notes for positioning the machine

- The surface inclination may not exceed 15 degrees.



- Ensure the free circulation of the cooling air. There must be at least 20 cm of free space in front of and behind the machine for cooling air circulation.
- Protect the machine against heavy rain and direct sunshine.

The machine is not allowed to be operated in the rain as the protection class of the machine, IP23S, allows preserving and storing outside only.

NOTE! Never aim the spray of sparks from a grinding machine toward the equipment.

2.3 Distribution network

All regular electrical devices without special circuits generate harmonic currents into distribution network. High rates of harmonic current may cause losses and disturbance to some equipment.

2.4 Welding and earth return cable connections

2.4.1 Choosing welding polarity in MMA welding

You can change the welding polarity by choosing (+) or (-) cable connector. Typically, in MMA welding, the welding cable is connected to the positive (+) pole connection socket and the earth return cable to the negative (-) pole connection socket.

2.4.2 Choosing welding polarity in TIG welding

In TIG welding the welding cable must be connected to the negative (-) pole connection socket and the earth return cable to the positive (+) pole connection socket.

2.4.3 Earthing

If possible, always fasten the clamp of the earth return cable directly onto work piece.

1. Clean contact surface of the clamp from paint and rust.
2. Fasten the clamp properly, so that contact surface is as large as possible.
3. Check that the clamp is fastened firmly.

3. OPERATION

NOTE! Welding in places presenting an immediate fire or explosion hazard is forbidden! Welding fumes may cause injury, take care of sufficient ventilation during welding!

3.1 Welding processes

3.1.1 MMA welding

MMA welding, as well as carbon arc gouging, is possible with all HiArc S power sources. A separate HiArc S 400A model including cellulose kit is also available. See 'Ordering codes'.

3.1.2 TIG

For TIG welding with the A model a separate TIG-torch with gas valve is required. See 'Ordering codes'.

NOTE! TIG welding is not possible with R model.

3.2 Operation functions

3.2.1 Power source

NOTE! Always switch the machine on and off from main switch. Do not use the mains plug for switching!

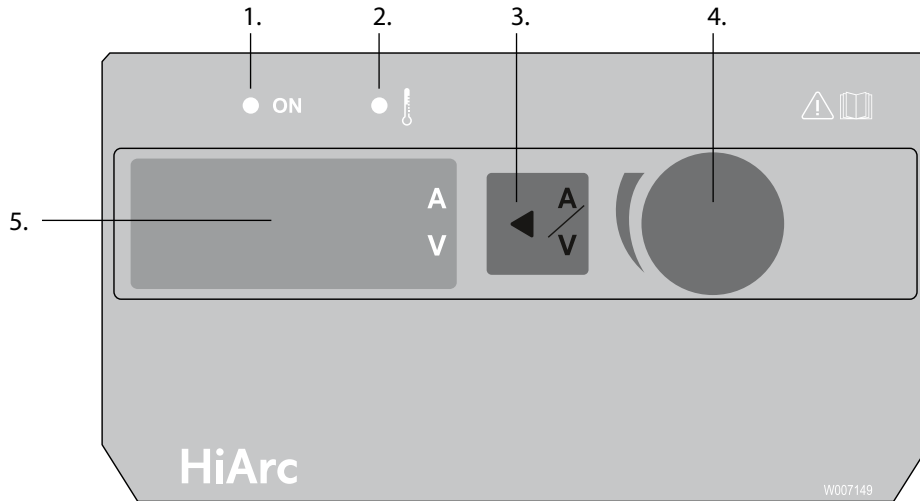
NOTE! Never watch the arc without a proper face shield designed for arc welding! Protect yourself and the surroundings against welding arc and hot spatters!

3.2.2 Control panel and SETUP functions, HiArc S 400R

WeldData

After welding has finished, the display shows the measured average current of the last weld. This weld data is only displayed if the welding cycle lasts for 5 seconds or more.

Regular control panel



1. The green ON light indicates that the power source is turned on.
2. Overheating indicator. Light indicates that the machine is overheated.
3. Amperage/voltage meter display selection button.
 - Short press to select either amperage or voltage values to the display. Values can be adjusted during welding.
 - Long press (> 5 s) activates setup function.
4. Welding current adjustment knob. Turn the knob to set the welding current value.
5. Amperage/voltage meter display. Shows used current/voltage values during welding and the set current value when not welding.

3.2.3 Activation and setup parameter adjustment, HiArc S 400R

1. Press A/V selection button (3) for at least 3 seconds, until the text "Set" appears on the screen.
2. Choose the needed parameter with the welding current adjustment knob (4).
3. To select the required parameter, press the A/V selection button (3). You can move from adjustment mode to selection mode with a new press of button (3).
4. Use the Welding current adjustment knob (4) to adjust the parameter value.
5. You can exit Setup mode with a long press of A/V selection button (3). Setup parameters are saved when you exit Setup.

Setup menu structure

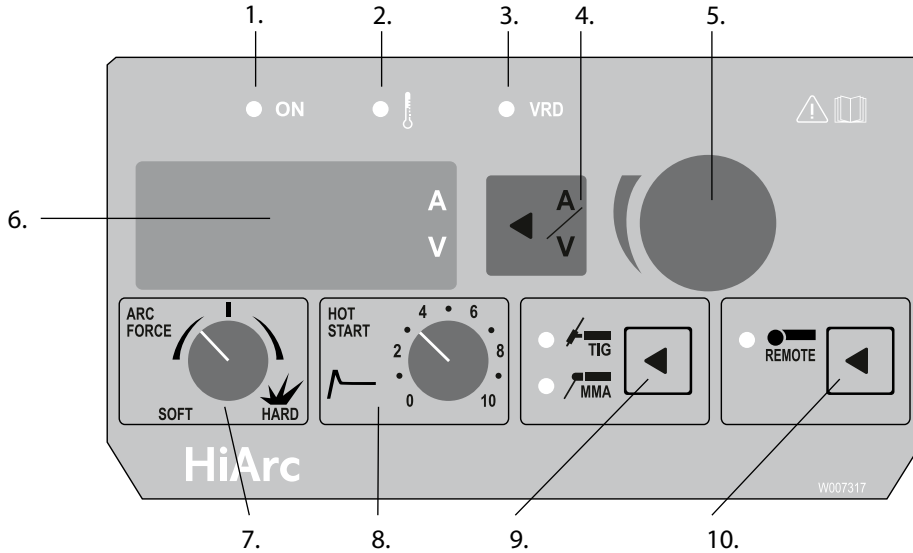
Regular control panel				
Name	Function	Description	Factory default	Adjustment range
Elt.	Electrode type	Selection of electrode type between basic and rutile electrodes	Rut	bAS/RUt
Hot.	HotStart selection		ON	ON/OFF
Cab.	Long cables	Long cable mode for welding circuits of 50 m and longer (max. 80 m).	OFF	ON/OFF
GEn	Generator	Generator mode	OFF	ON/OFF
Fac.	Restore factory settings		OFF	rES/OFF

3.2.4 Control panel and SETUP functions, HiArc S 400A

WeldData

After welding has finished, the display shows the measured average current of the last weld. This weld data is only displayed if the welding cycle lasts for 5 seconds or more.

Advanced control panel



1. The green ON light indicates that the power source is turned on.
2. Overheating indicator. Light indicates that the machine is overheated.
3. VRD indicator. Light indicates that VRD is set on.
 - Solid green light: VRD is set ON and OCV is under 35V.
 - Blinking red light: VRD is set ON and OCV is over 35 V.
4. Amperage/voltage meter display selection button.
 - Short press to select either amperage or voltage values to the display. Values can be adjusted during welding.
 - Long press (> 5 s) activates setup function.
5. Welding current adjustment knob. Turn the knob to set the welding current value.
6. Amperage/voltage meter display. Shows used current/voltage values during welding and the set current value when not welding.
7. ArcForce. The smaller the value, the softer the arc. When using a bigger value, the harder the arc gets. Factory setting in the middle.
8. HotStart. Factory setting in the middle. Adjust to value 0 = no HotStart, adjust to 10 = HotStartMax
9. Welding Mode. Press to select TIG or MMA mode. Light indicates the selection.
10. Remote Control. Press to select remote or panel control. Light indicates remote control.

3.2.5 Activation and setup parameter adjustment, HiArc S 400A

1. Press A/V selection button (3) for at least 3 seconds, until the text "Set" appears on the screen.
2. Choose the needed parameter with the welding current adjustment knob (4).
3. To select the required parameter, press the A/V selection button (3). You can move from adjustment mode to selection mode with a new press of button (3).
4. Use the Welding current adjustment knob (4) to adjust the parameter value.
5. You can exit Setup mode with a long press of A/V selection button (3). Setup parameters are saved when you exit Setup.

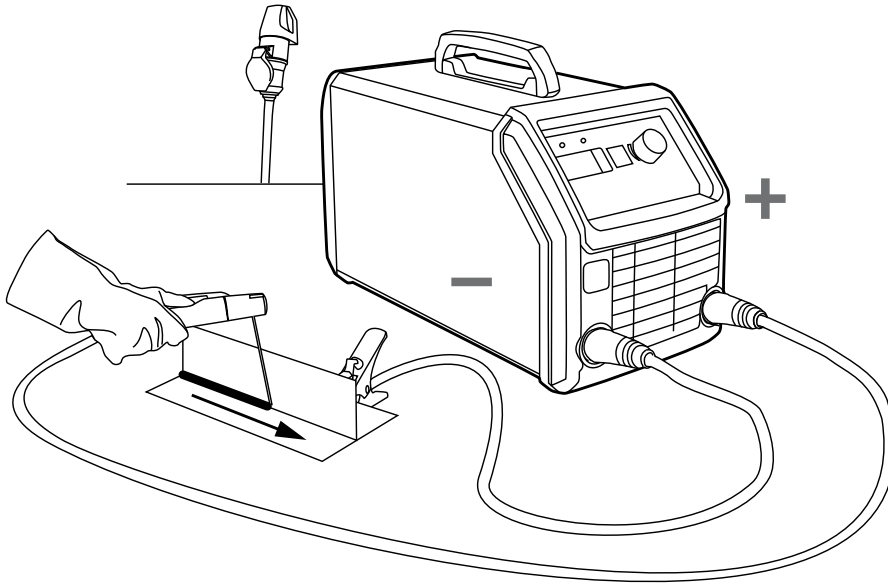
Setup menu structure

Advanced control panel				
Name	Function	Description	Factory default	Adjustment range
Cel.	Cellulosic	Cellulosic option selection. This selection must be On, if Cel kit is assembled.	On (device specific)	On/OFF
Ant.	Antifreeze	If Antifreeze selection is On, the machine cuts off the power and protects the electrode if sticking occurs during the welding	On	On/OFF
Cab.	Long cables	Long cable mode for welding circuits of 50 m and longer (max. 80 m)	OFF	On/OFF
Gen.	Generator	Generator mode for generator use and fluctuating mains networks	OFF	On/OFF
rcl	Remote Low Current limit	Limits the remote adjustment range. Allows more exact remote adjustment.	30	30-MAX
rch	Remote High Current limit	Limits the remote adjustment range. Allows more exact remote adjustment.	MAX	30-MAX
Urd	VRD selection	Reduces open circuit voltage below 35V	OFF (device specific)	On/OFF
Fac.	Restore Factory Settings	Restores setup and panel settings to factory default	OFF	rES/OFF

Voltage Reduction Device (VRD)

HiArc S 400A contains a voltage reduction device (VRD), which reduces the open-circuit voltage below 35 V. This reduces the risk of electric shock in particularly dangerous environments, such as closed or damp spaces. VRD is activated through the setup menu. VRD is a feature of HiArc S 400A model, not available on the R model.

3.3 MMA welding



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In manual metal arc welding (MMA), the filler material is melted from the electrode to the weld pool. The rate of welding current is selected on the basis of the electrode size and welding position. The arc forms between the electrode tip and work piece. The melting electrode coating forms a gas and slag shield, which protects the molten metal in transfer to the weld pool and during solidification. As the slag solidifies over the hot weld metal, it prevents weld metal from oxidation. This slag coating is removed after welding e.g. with a chipping hammer. When removing the slag coating, ensure you protect your eyes and face with suitable equipment.

For more info, visit www.kemppi.com > Welding ABC.

3.3.1 Filler materials and equipment

HiArc S series can be used with most of the common electrode types for DC welding. For welding with cellulosic electrodes, the optional kit should be fitted. Electrode sizes for the unit are listed in Technical data section later in this manual. Follow the welding specifications given on the electrode package.

1. Check that the welding cable and earth return cable connections are hand tight. If a cable connection is loose, it will result in a decrease of welding performance, overheating of the connection, and it may affect your product warranty cover.
2. Select and mount the correct electrode type firmly in holder.

3.3.2 Earth return cable and clamp

If possible, always fix the earth return cable and clamp directly to the welding work piece.

1. Clean the connection surface of the clamp from paint, dirt and rust.
2. Connect the clamp carefully so that contact surface is as large as possible.
3. Finally check that the clamp remains fastened.

3.3.3 Manual metal arc welding (MMA)

Select your required welding parameters according to the manufacturer's filler material recommendations and the joint to be welded.

1. Select the required polarity (+ or -) of welding current cable (normally +) and earth return cable (normally -) according to the filler material manufacturers recommendations.
2. Depending on the HiArc S series model, select MMA welding mode by pressing the process selection button on the control panel.

3. Select a suitable welding current by adjusting the current adjustment knob.
4. Make a small test weld to check the selections made.

Site your equipment in a suitable location, ensuring there is adequate cable length to complete the weld pass. Before you start welding, ensure you are comfortably positioned in front of the work piece, and that you are well balanced with your weight equally distributed. Ensure that the power source current setting is correct for the electrode size selected. Draw the welding face shield over your eyes. (Electronic welding face shields like Kemppi Beta 90X allow you to see the welding start point more accurately and better concentrate on the welding process. This reduces the possibility of arc flash).

NOTE! Ensure others in the welding area are aware that you're going to weld.

To establish the arc, scratch the electrode on the surface of the work piece.

As the arc starts, move the welding electrode at a pulling angle. The boundary of the slag formed is visible after the molten weld. It must be behind the molten weld. The distance of the slag boundary from the molten weld can be adjusted with the welding current and the angle of the electrode. Throughout the welding, concentrate on the length of the arc and keep it as short as possible. The length of the arc increases easily as the electrode decreases in length during the welding. End welding by moving the welding electrode slightly back to the completed weld and then lifting the electrode straight away from the work piece.

Your completed weld bead should be straight and of even width and bead height, consistent in its appearance. Travel too slowly during welding and the weld pool will get too big and may burn through the weld piece, too fast and the resulting weld will be too small and may have slag entrapments and/or poor strength. After welding, the solidified slag on the weld surface should easily remove with a chipping hammer. Ensure you wear eye and face protection when removing the slag from the weld surface.

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3.3.4 Electrode welding parameter table

Electrode diameter (mm)	Rutile E6013 (A)	Basic E7018 (A)
1.6	30–60	30–55
2.0	50–70	50–80
2.5	60–100	80–110
3.25	80–150	90–140
4.0	100–200	125–210
5.0	150–290	200–260
6.0	200–385	220–340
7.0		280–410

3.3.5 Arc force, HiArc S 400A

Adjusting arc force by turning the ArcForce knob will affect the roughness of the arc. Factory setting for all electrode types is in the middle. When the knob is turned counter-clockwise the arc is softened and the amount of spatter decreases when welding at the upper end of the recommended current range of the electrode. When the knob is turned clockwise the arc gets rougher.

3.3.6 Hot start, HiArc S 400A

HotStart increases the current for the arc ignition momentarily. With very thin work pieces hot start is generally not needed (depends on the electrode type).

The hot start value is selected between 0 and 10. Zero shuts HotStart off (no HotStart) and 10 sets it to HotStartMax. Factory setting is 5.

3.4 TIG welding

TIG welding is possible only with HiArc S 400A model, not with the R model.

NOTE! In TIG welding the welding cable must be connected to the negative (-) pole connection socket and the earth return cable to the positive (+) pole connection socket.

Select your required welding parameters according to the manufacturer's filler material recommendations and the joint to be welded.

1. Select the required polarity of welding current cable (-) and earth return cable (+) for TIG welding.
2. Select TIG welding mode by pressing the process selection button on the control panel.
3. Select a suitable welding current by adjusting the current adjustment knob.
4. Make a small test weld to check the selections made.

Shielding gas is used in DC TIG welding. Your dealer will give you advice on choosing gas and equipment.

You can start welding after having made the necessary selections. Open the gas valve on the TTM 15 V BC. When gas starts to flow, arc is lit by lightly scratching work piece with the tip of the tungsten electrode, or with the touch and lift method (see 'Ignition by Lift TIG'). When arc is lit, its length is regulated by holding the tip of the tungsten electrode at a suitable distance from the work piece. Suitable arc length is usually about half the diameter of the electrode core wire. Move the torch forwards from the starting point. If necessary, adjust current value.

The filler material, tungsten electrode and the welding current level are decided according to the base material type and thickness, joint form and welding position.

Stop welding by lifting the torch off the welding piece and by closing the gas valve on the torch.

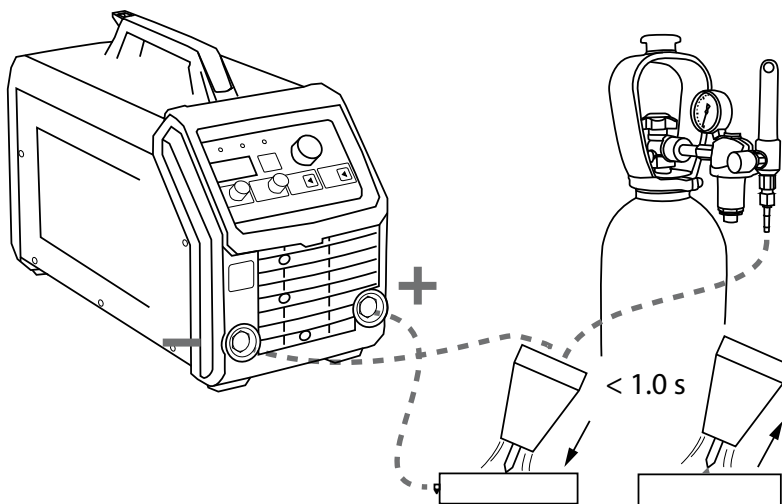
NOTE! The torch voltage will remain on.

NOTE! Always fix the gas cylinder so that it stays steadily in upright position either in specially made wall rack or cylinder trolley. Always close the cylinder valve after having finished welding.

Ignition by Lift TIG

You can ignite TIG arc with the Lift TIG method. Gently touch the work piece with the electrode and quickly lift the electrode from the work piece to a suitable welding distance to ignite the arc. If electrode contact with the work piece exceeds 1 second, the power source ignition will automatically shut off preventing damage to the electrode.

To stop welding, quickly pull the electrode away from the work piece.



Order information for the additional equipment (TIG torch) required for TIG welding can be found in 'Ordering codes' section later in this manual.

3.5 Carbon arc gouging

Refer to the table below for amperage settings for carbon arc gouging.

Electrode	Amperage (A)
6.35 mm (1/4")	170–330 A
8 mm (5/16")	230–450 A

4. MAINTENANCE

NOTE! Watch out for mains voltage when handling electric cables!

Degree and circumstances of machine utilisation should be taken into consideration when planning product maintenance. Careful use and preventive maintenance helps to avoid unnecessary production disturbances and breaks. Check the condition of the welding and connection cables daily. Do not use damaged cables.

4.1 Regular maintenance

4.1.1 Every six months

NOTE! Disconnect the plug of the machine from the mains socket and wait for about 2 minutes before removing the casing plate.

The following maintenance operations should be carried out at least every six months:

- Electric connections of the machine – clean any oxidised parts and tighten any loose ones.

NOTE! You must know the correct tension torques before you start repairing the connections.

- Clean the inner parts of the machine from dust and dirt e.g. with a soft brush and a vacuum cleaner. Do not use compressed air because there is the danger that the dirt is packed even more tightly in the gaps of the cooling profiles. Do not use a pressure washer.

NOTE! Only an authorised electrician may repair the machine.

NOTE! The machine and control panel are at mains current potential. DO NOT remove either the cover or control panel unless authorised to do so. Only authorised and trained personnel can carry out maintenance and repair processes.

4.2 Service contract

Kemppi service workshops make special service contracts with customers about regular maintenance. All parts are cleaned, checked and if necessary, repaired. Also the operation of welding machine is tested.

4.3 Storage

The machine must be stored in a clean and dry room. Protect the machine from rain and direct sunshine in places where temperature exceeds +25 °C.

4.4 Disposal of the machine



Do not dispose of electrical equipment with normal waste!

Electrical equipment that has reached the end of its life must be collected separately and taken to an appropriate environmentally responsible recycling facility.

The owner of the equipment is obliged to deliver a decommissioned unit to a regional collection centre, as per the instructions of local authorities or a Kemppi representative. By applying this you will improve the environment and human health.

5. TROUBLESHOOTING

The control panel will display any errors of the system. Error code numbers are shown in the display and can be compared to the table below.

5.1 Troubleshooting

Power On light is not illuminated.

There is no electrical power to the machine.

- Check the mains electrical supply is connected.
- Check the mains fuses, replace blown fuses.
- Check the mains cable and plug, replace defect parts.

The machine is not welding properly. Welding creates spatter. The weld joint is porous or power supply is insufficient.

- Check the welding parameter settings and adjust if needed. See welding parameter table on page 9.
- Check that the earth return clamp is properly fastened and that earth return cable has no defects. If necessary change the clamp location and replace defective parts.
- Check the welding cable and connector. Tighten the connection(s) and replace defective parts.

Power source overheating pilot lamp is illuminated.

Power source has exceeded the designed working temperature. Fans are running and the machine is in a cooling down cycle. The machine will reset automatically.

- Check that there is enough free space around the machine for cooling air circulation.
- In some cases when error occurs, the machine turns off. Then user must turn the main switch off and on again.
- Check that welding circuit is open.

5.2 Control panel error codes

Error 1 (E1)	Power source is not calibrated.	Calibrate power source.
Error 2 (E2)	Undervoltage	Check the mains network connection and fuses.
Error 3 (E3)	Overvoltage	Check the mains network connection and fuses.
Error 4 (E4)	Overheating. Also the overheating pilot lamp is on. Machine drops welding current for 30s. If error conditions still apply: Machine stops welding (model A) Machine shuts down (model R).	Ensure free air flow. Let the machine cool down.
Error 5 (E5)	---	
Error 6 (E6)	---	
Error 7 (E7)	NTC warning. (IGBT overheating). Machine drops welding current.	Ensure free air flow. Let the machine cool down. Check the environment temperature.
Error 8 (E8)	NTC error. (IGBT overheating). If error conditions (Err7) still apply: Machine stops welding (model A) Machine shuts down (model R).	Ensure free air flow. Let the machine cool down. Check the environment temperature.
Error 9 (E9)	Mains network phase alarm.	Check the mains network connection and fuses. If connected to generator check setup jumper Gen.
Error 10 (E10)	---	
Error 11 (E11)	VRD error.	
Error 12 (E12)	Power source is locked. Too long short circuit. Machine stops welding (model A) Machine shuts down (model R).	Avoid long short circuits (20s).
Error 13 (E13)	Wrong panel type (R-type control panel connected to A-type HiArc or vice versa).	R-type HiArc accepts only R-type (regular) control panel.
Error 14 (E14)	Current feedback is missing.	Contact Kemppi service representative.

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6. ORDERING CODES

HiArc S 400R		63114002
HiArc S 400A		63114001
HiArc S 400A	cellulose kit included	6311400101
Welding cable	50 mm ² , 5 m	6184501H
	70 mm ² , 5 m	6184701H
Earth return cable	50 mm ² , 5 m	6184511H
	70 mm ² , 5 m	6184711H
Display cover		SP006989
Slide bars		SP007023
R10H remote control for HiArc S 400A		6185431H
TTM 15 V BC	4 m	627143201

7. TECHNICAL DATA

		HiArc S 400R	HiArc S 400A
Connection voltage	3~50/60 Hz	380 – 440 V (-10...+10 %)	380 – 440 V (-10 %...+10 %)
Rated power at max. current	60 % ED	20 kVA	20kVA
Fuse (delayed)		25 A	25 A
Output at 40 °C	MMA 60 % ED	400 A / 36 V	400 A / 36 V
	MMA 100 % ED	310 A / 32.4 V	310 A / 32.4 V
	TIG 60 % ED	-	400 A / 26 V
	TIG 100 % ED	-	310 A / 22.4 V
Welding voltage (max)		400 A / 48 V	400 A / 48 V
Electrodes, \varnothing		1.6...7.0 mm	1.6...7.0 mm
Welding current control		stepless	stepless
Power factor at 100 %		0.90	0.90
Operating temperature range		-20...+50 °C	-20...+50 °C
Efficiency at 100 %		0.89	0.89
Degree of protection		IP23S	IP23S
EMC class		A	A
External dimensions	L x W x H	570 x 270 x 340 mm	570 x 270 x 340 mm
Weight		19.5 kg	20 kg

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