

PROCESS WELDING SYSTEMS, INC.

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DT-400

The PWS DT-400 is a four-channel weld process controller that replaces the PWS DT-100, and shares many of its attributes with many improvements.

The DT-400 has four fully isolated 0 – 10V analog outputs, ideal to control:

- Arc Weld Current
- Rotation or Linear Travel Speed
- Wire Feed Speed
- Arc Voltage AVC, ALC

Each of these four channels are isolated from the control system and each other by means of a precision, wide bandwidth 3-port isolation amplifier. This ensures a channel's pulsed output waveform to be crisp and accurate from 1Hz to 1kHz. A high degree of signal filtration exists on every I/O line and power input wiring as well. This filtration system keeps noise on the outside of the DT-400 main enclosure. Connection boxes attached to the outside of the DT-400 main enclosure allow custom signal/wiring integration for different styles of weld power supplies, motor drivers, wire feeders, and AVCs. One connector is available to connect various DT-400 input functions to a remote pendant or for automation connections to a PLC or other controller system. All discrete I/O signals are optically isolated for use with nominal 24V DC controls.

| Weld Schedule | | | |
|--------------------------|-----------------------|--|------|
| Weld Schedule Number | 1 - 50 | <input type="text"/> | A |
| CONFIG | | <input type="button" value="Browse..."/> | |
| Full Scale Amps | AMPS | <input type="text"/> | A |
| Amperage Offset | AMPS | <input type="text"/> | A |
| Chained Schedule | 0 - 50 | <input type="text" value="0"/> | |
| Number of Main Intervals | 1 - 10 | <input type="text" value="10"/> | |
| Pulsing Frequency | HZ | <input type="text" value="1000.0"/> | Hz |
| Pulsing Duty Cycle | % On | <input type="text" value="50.0"/> | % |
| PREFLOW | | | |
| Preflow Time | Seconds 0.0 - 99.9 | <input type="text" value="0.0"/> | S |
| Preflow CH 2 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Preflow CH 2 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Preflow CH 3 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Preflow CH 3 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Preflow CH 4 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Preflow CH 4 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Preflow BITS | | <input type="text" value="1111"/> | BITS |
| INITIAL | | | |
| Initial Time | Seconds 0.0 - 600.0 | <input type="text" value="0.0"/> | S |
| Initial Peak Amps | Amps 0.0 to Fullscale | <input type="text" value="0.0"/> | A |
| Initial Background Amps | Amps 0.0 to Fullscale | <input type="text" value="0.0"/> | A |
| Initial CH2 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Initial CH2 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Initial CH3 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Initial CH3 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Initial CH4 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Initial CH4 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Initial BITS | | <input type="text" value="1111"/> | BITS |

| Main 1 | | | |
|------------------------|-----------------------|-----------------------------------|------|
| Main 1 Slope Time | Seconds 0.0 - 20.0 | <input type="text" value="0.0"/> | S |
| Main 1 Time | Seconds 0.0 - 600.0 | <input type="text" value="0.0"/> | S |
| Main 1 Peak Amps | Amps 0.0 to Fullscale | <input type="text" value="0.0"/> | A |
| Main 1 Background Amps | Amps 0.0 to Fullscale | <input type="text" value="0.0"/> | A |
| Main 1 CH2 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Main 1 CH2 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Main 1 CH3 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Main 1 CH3 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Main 1 CH4 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Main 1 CH4 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Main 1 BITS | | <input type="text" value="1111"/> | BITS |
| Main 2 | | | |
| Main 2 Slope Time | Seconds 0.0 - 20.0 | <input type="text" value="0.0"/> | S |
| Main 2 Time | Seconds 0.0 - 600.0 | <input type="text" value="0.0"/> | S |
| Main 2 Peak Amps | Amps 0.0 to Fullscale | <input type="text" value="0.0"/> | A |
| Main 2 Background Amps | Amps 0.0 to Fullscale | <input type="text" value="0.0"/> | A |
| Main 2 CH2 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Main 2 CH2 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Main 2 CH3 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Main 2 CH3 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Main 2 CH4 Peak | 0-100% | <input type="text" value="0.0"/> | % |
| Main 2 CH4 Background | 0-100% | <input type="text" value="0.0"/> | % |
| Main 2 BITS | | <input type="text" value="1111"/> | BITS |

With up to 10 main welding intervals with sloping from interval to interval.