

Title (en)

TWO STAGE WELDER AND METHOD OF OPERATING SAME

Title (de)

ZWEISTUFIGE SCHWEISSVORRICHTUNG UND VERFAHREN ZU DEREN BETRIEB

Title (fr)

MACHINE A SOUDER A DEUX ETAGES ET PROCEDE DE FONCTIONNEMENT

Publication

**EP 1490194 A1 20041229 (EN)**

Application

**EP 03744094 A 20030106**

Priority

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Abstract (en)

[origin: WO03076114A1] An electric arc GMAW welder (A) is provided, which welder (A) includes a high speed switching power supply (10) with a controller (130) for creating a first or second weld process across the gap between a workpiece (W) and a welding wire (E) advanced toward the workpiece (W). The first process uses a first current waveform and the second process uses a second current waveform. A circuit is provided for shifting between the first and second weld processes. The shifting circuit includes a counter (212) for counting the waveforms in the first and second processes and a circuit (190) to shift from the process being processed to the other weld process when the waveform count of the weld process being processed reaches a preselected number for such weld process.

IPC 1-7

**B23K 9/09**

IPC 8 full level

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