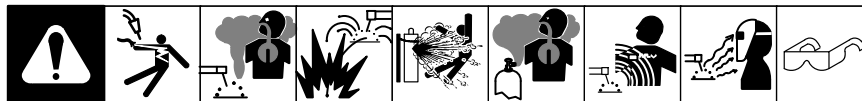


Tracking Software Revisions In

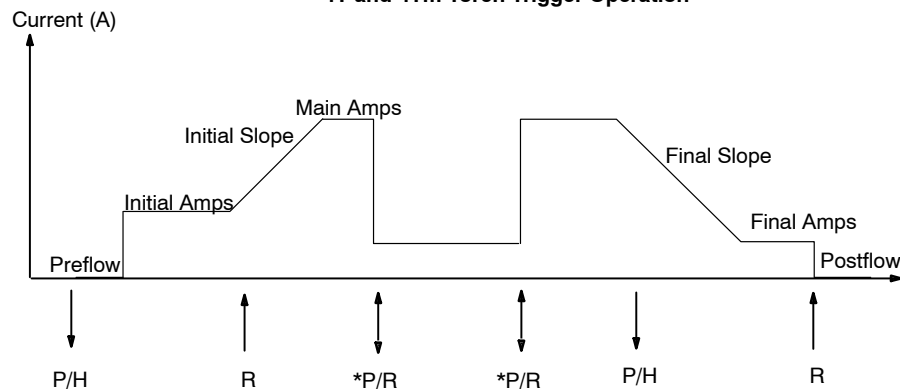
Dynasty® 210 And Maxstar® 210 And Maxstar® 210 Red-D-Arc Models

The data contained in this supplement is either in addition to or takes exception to data appearing later in this manual.

1. 4T, 4Tm And 4TL Specific Trigger Method (Eff /w 2017-02-21 Software Update 301153S)



4T and 4Tm Torch Trigger Operation



P/H = Push and hold trigger; R = Release trigger;

*4T only: P/R = Push trigger and release in less than 0.75 seconds

4T and 4Tm Application:

Use 4T and 4Tm (modified) trigger methods when the functions of a remote current control are desired, but only a remote on/off control is available.

4T* allows the operator to toggle between weld current and final current.

When a remote switch is connected to the welding power source, use the remote switch to control the weld cycle. Amperage is controlled by the welding power source.

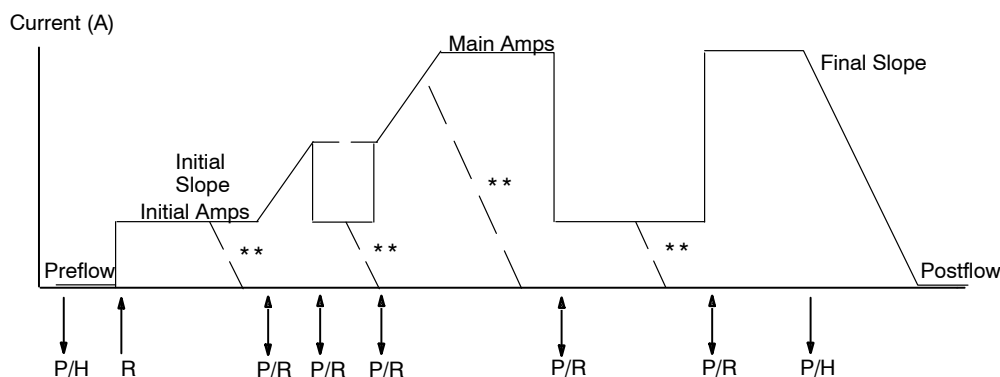
4TL Application:

The ability to change current levels without either initial slope or final slope, gives the operator the opportunity to adjust filler metal without breaking the arc.

4TL (mini logic) allows the operator to toggle between initial slope or main amps and initial amps. Final Amperage is not available. Final slope always slopes to minimum amperage and ends the cycle.

When a remote switch is connected to the welding power source, use the remote switch to control the weld cycle. Amperage is controlled by the welding power source.











4TL Torch Trigger Operation



P/H = Push and hold trigger; R = Release trigger; P/R = Push trigger and release in less than 0.75 seconds

** = Arc can be extinguished at final slope rate at any time by pushing and holding trigger

2. Control Panel Menu: AC And DC Stick's DIG selection (Eff /w 2017-04-27 Software Update 301153U)



DIG











30%

[DIG]* Arc Force Control:

Controls the amount of additional amperage at low voltage (short arc length) conditions. Adjust the force of the arc for different joint configurations and electrodes. Range is OFF to 100% PRO-Set values available for both 6010 and 7018 electrodes.

CARBon ARC Gouging can be selected at one step above DIG's 100%.

3. Voltmeter/Ammeter Display Messages (Eff /w 2017-04-27 Software Update 301153U)



WELD

CABL

[WELD] [CABL] Weld Cable: An error related to the weld cables has been sensed. Straighten out or shorten weld cables. If carbon arc gouging, adjust DIG setting to CARBOn ARC.