



ProHeat Rolling Inductor FAQ

Q: How do I access the program setup screen for the Rolling Inductor?

A: To view the system setup screen for the Rolling Inductor, simultaneously press the **Parameters** and **Program** buttons. The following settings are available:

- Deg Units Displayed (°F or °C)
- Tolerance (±5 to 99)
- Travel Detect (On or Off)
- Control Mode (Manual, Temp, Time or Remote)
- Max Output (1 Kw to 35 Kw)
- System Lock (Yes or No)

(For more information on the setup screen, please consult the Rolling Inductor Owner's Manual)

Q: Can I get a full 35 kW of output power with the Rolling Inductor?

A: No, the Rolling Inductor is limited to 300 amps which results in about 20 kW of output power. If 35 kW at 100% duty cycle is desired, a two rolling inductor arrangement is required. The external cooler heat exchanger (300993) is recommended for two Rolling Inductor arrangements. *(See owner's manual for additional information on this topic)*

Q: If I already own a ProHeat 35, will the Rolling Inductor work with my system?

A: Yes, all ProHeat 35 systems are capable of running the Rolling Inductor, but if the system was purchased before August 2014 (serial number prior to ME320092G) a software update is required to run the Rolling Inductor and a hardware update is required to run the Travel Detect System (301183). If an update is needed, call Miller's service department at 920-735-4001 for more information on how to update your systems software.

Q: Will the Rolling Inductor work with the Intellifire 250 or other induction power sources?

A: No. The ProHeat 35 is the only power source that works with the Rolling Inductor.



Q: Can I use the recorder to document heating with the Rolling Inductor?

A: Yes. If the Rolling Inductor is used with compatible temperature measurement devices (customer supplied) you can record heating temperatures. Measurements should be taken within two inches of the Rolling Inductor.

Q: What happens if I run the Rolling Inductor without rolling the pipe or moving the induction head?

A: Depending on output, material type and material thickness, if the Rolling Inductor remains stationary for too long it can overheat the work piece and cause irreversible damage to the work piece and Rolling Inductor. For this reason it is extremely important to ensure that either the work piece or Rolling Inductor is moving at all times. Using the Travel Detect System (301183) helps minimize the chance of overheating a stationary, object by constantly sending feedback to the power source and limiting output if limited or no motion is detected.

Q: What's the difference between the mounting arm and mounting stand that Miller offers?

A: The mounting arm (301119) allows heating from the top side of the pipe and will provide the most amount of flexibility and configurability. The mounting stand (301258) is ideal for heating from the bottom of the pipe.

Q: How fast can I expect my part to reach its target temperature?

A: There are many variables that affect the time to temperature of the part being heated; the thickness of the part, amount of surface area, travel speed and type of material being heated.

Example: A carbon steel pipe with a diameter of 12" and a wall thickness of $\frac{3}{4}$ ", traveling at 34 ipm, took under 4 minutes in our lab testing to reach 400°F on the entire interior of the pipe.



Q: How do I determine a travel speed for optimal heating?

A: A larger diameter part should be rolled faster because it will dissipate heat quickly between passes of the induction head. A smaller part can be rolled slower because it will dissipate less heat between passes of the induction head. Speeds below 15 ipm will take longer to heat because the power ramp rate is limited. Below 30 ipm maximum output is limited to about 1 kW per ipm of travel speed.

Q: Do all four Rolling Inductor wheels need to be in contact with the work piece at all times?

A: Power coupling to the part decreases as the distance to the part increases. Maintaining constant distance between the rolling inductor and the work piece will ensure consistent heating, using the wheels is the best way to maintain a constant distance. The wheels should be the only part to contact the work piece, if any other part of the rolling inductor stays in contact with the work piece damage can occur.

Q: Does it matter which way I roll the pipe/work piece when using the Rolling Inductor?

A: When using the Rolling Inductor always roll away from the power cable. (Clockwise when the cable is exiting left and counterclockwise when the cable is exiting right)

Q: What applications are best suited for the Rolling Inductor?

A: While there is no set configuration for the Rolling Inductor, primary applications include preheating fabricated pipe sections, preheating tower bases and preheating longitudinal submerged arc welding passes.

Q: Who can I contact for additional support or information about the Rolling Inductor?

A: For more information regarding setup, troubleshooting, or operation of the Rolling Inductor contact Miller's service department at 920-735-4001