



REM POWER®

Rheinland Elektro Maschinen

**OWNER'S MANUAL
BEDIENUNGSANLEITUNG
NAVODILA ZA UPORABO
UPUTE ZA UPOTREBU
УПАТСТВО ЗА КОРИСТЕЊЕ**

WMEm MIG 400/500 cc/cv

WMEm MIG 401/501 cc/cv



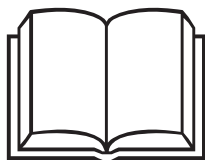
EN Power Source

CRO Izvor napajanja

D Schweißstromquellen

МК Извор за напојување

SLO Varilna transformatorja



Please read these safety instructions prior to the initial use of your appliance and act accordingly.

Lesen Sie vor der ersten Benutzung Ihres Gerätes diese Sicherheitshinweise und handeln Sie danach.

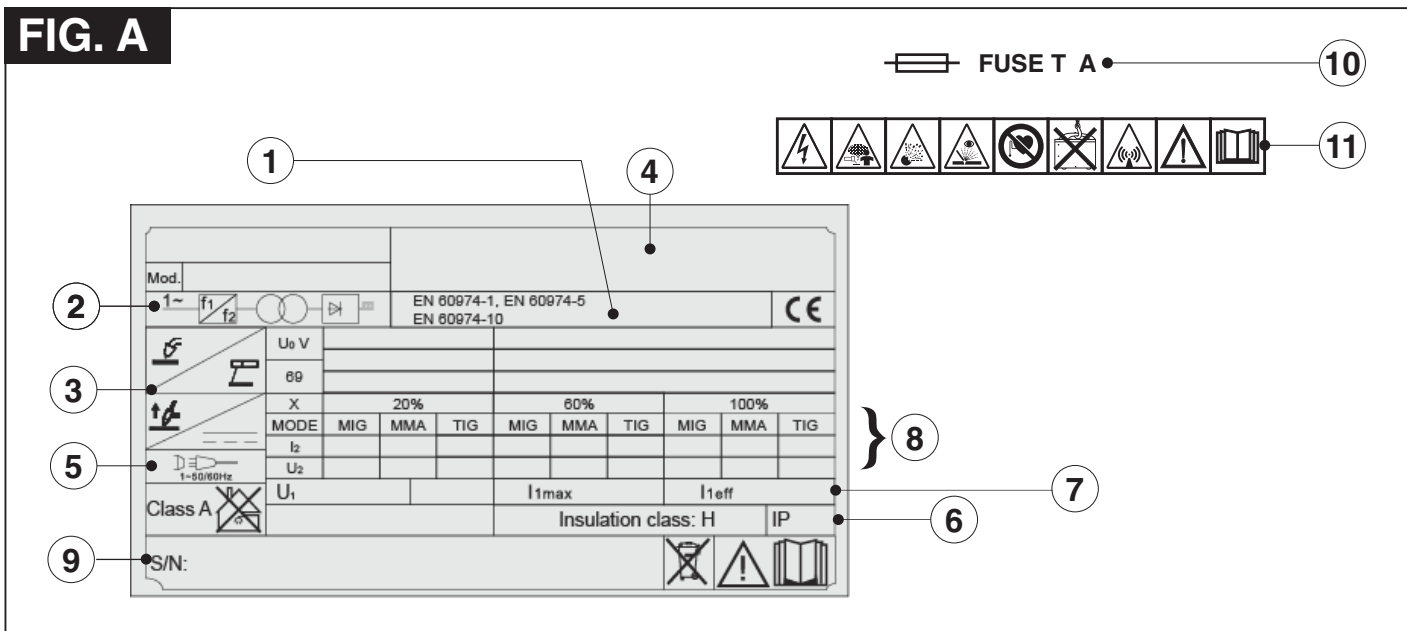
Pred prvo uporabo Vaše naprave preberite te varnostne napotke in ravnajte v skladu z njimi.

Prije prve uporabe Vašeg uređaja pročitajte ove sigurnosne naputke i postupajte prema njima.

Пред прва употреба на вашиот апарат за заварување, прочитајте го упатството и следете ги препораките

EN	The right is reserved to technical and color alterations, errors and misprints
D	Technische Änderungen, Irrtümer, Druckfehler und farbliche Abweichungen bleiben vorbehalten
SLO	Tehnične spremembe, zmote, napake v tisku in barvna odstopanja so pridržani
CRO	Pridržavamo pravo tehničkih izmjena, zabuna, tiskarskih pogrešaka i odstupanja u boji.
SRB	Zadržavamo pravo na tehničke izmene, zabune, štamparske greške i odstupanja u boji
MK	Го задржуваме правото за технички промени, грешки, печатни грешки и отстапувања.
BG	Запазва се правото на технически и цетови промени, грешки и печатни грешки
CZ	Technické změny, omyly, tiskové chyby a barevné odchylky vyhrazeny
SK	Technické zmeny, chyby, tlačové chyby a farebné odchýlky sú vyhradené
DK	Tekniske ændringer, fejl, bliver trykfejl og farveafvigelser forbeholdes
ES	Los cambios técnicos, errores, errata y el color desviaciones son reservados
TR	Teknik değışiklik, hatalar, baskı hatası ve renk sapmaları saklıdır
RU	Технические изменения, ошибки, опечатки и отклонения цвета зарезервированы
SWE	Tekniska ändringar, fel, tryckfel och färgavvikelser är reserverade
NOR	Tekniske endringer, feil, trykkfeil og fargeavvik er reservert
LVA	Tehniskās izmaiņas, kļūdas, drukas kļūda un krāsu novirzes ir aizsargātas
IT	Modifiche tecniche, errori, errori di stampa e colori le deviazioni sono riservati

FIG. A



TAB. 1



**TECHNICAL DATA - TECHNISCHE DATEN - TEHNIČNI PODATKI
TEHNIČKI PODACI - ТЕХНИЧКИ ИНФОРМАЦИИ**

I ₂ max (A)	400V	400V	mm ²	kg	dB(A)
400/401	T32A	26.2A	35	44	<85
500/501	T32A	26.4A	55	45	<85

FIG.B1



FIG.B2



FIG. C1

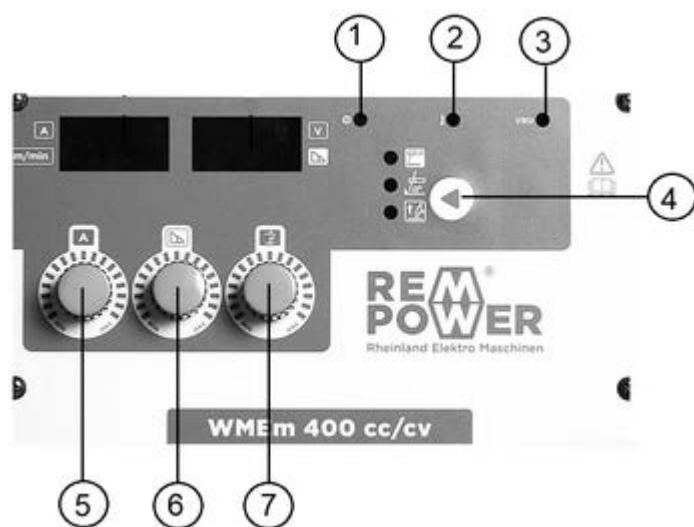


FIG. C2

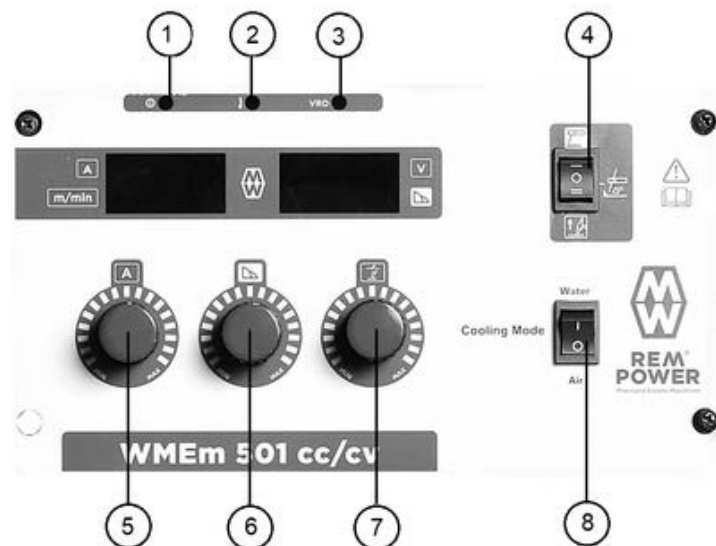
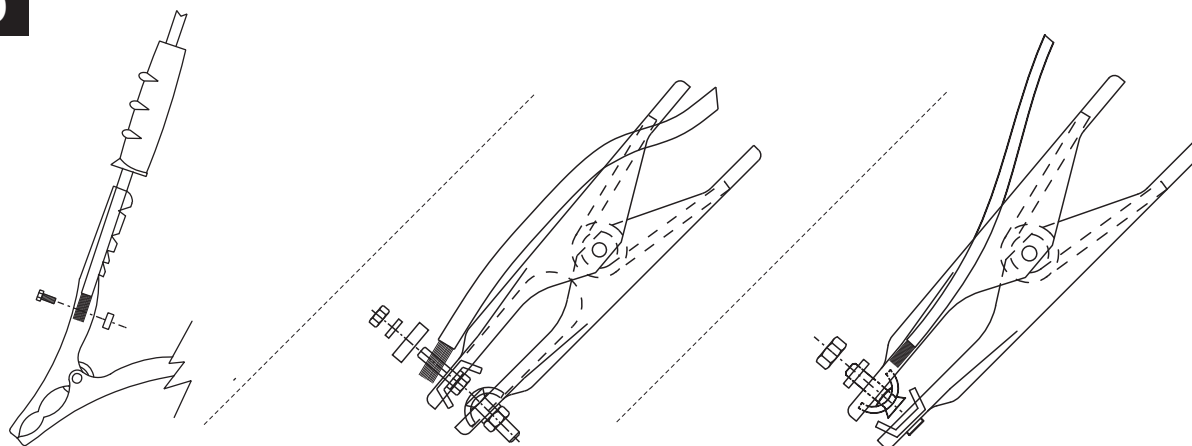


FIG. D



- EN** EXPLANATION OF DANGER, MANDATORY AND PROHIBITION SIGNS.
- D** LEGENDE DER GEFAHREN-, GEBOTS- UND VERBOTSZEICHEN.
- SLO** LEGENDA SIGNALOV ZA NEVARNOST, ZA PREDPISANO IN PREPOVEDANO.
- CRO** LEGENDA OZNAKA OPASNOSTI, OBAVEZA I ZABRANA.
- МК** ОПАСНОСТИ, ЗАДОЛЖИТЕЛНИ ПОСТАПКИ И ЗАБРАНИ.

	(EN) DANGER OF ELECTRIC SHOCK (DE) STROMSCHLAGGEFAHR (SLO) NEVARNOST ELEKTRIČNEGA UDARA (CRO) OPASNOST STRUJNOG UDARA (МК) ОПАСНОСТ ОД ЕЛЕКТРИЧЕН УДАР
	(EN) DANGER OF WELDING FUMES (DE) GEFAHR DER ENTWICKLUNG VON RAUCHGASEN BEIM SCHWEISSEN (SLO) NEVARNOST VARILNEGA DIMA (CRO) OPASNOST OD DIMA PRILIKOM VARENJA (МК) ОПАСНОСТ ОД ГАСОВИ ОД ЗАВАРУВАЊЕ
	(EN) DANGER OF EXPLOSION (DE) EXPLOSIONSGEFAHR (SLO) NEVARNOST EKSPLOZIJE (CRO) OPASNOST OD EKSPLOZIJE (МК) ОПАСНОСТ ОД ЕКСПЛОЗИЈА
	(EN) WEARING PROTECTIVE CLOTHING IS COMPULSORY (DE) DAS TRAGEN VON SCHUTZKLEIDUNG IST PFLICHT (SLO) OBVEZNO OBLECITE ZAŠČITNA OBLAČILA (CRO) OBAVEZNO KORIŠTENJE ZAŠTITNE ODJEĆE (МК) ЗАДОЛЖИТЕЛНО НОСЕЊЕ ЗА ШТИТНА ОБЛЕКА
	(EN) WEARING PROTECTIVE GLOVES IS COMPULSORY (DE) DAS TRAGEN VON SCHUTZHANDSCHUHEN IST PFLICHT (SLO) OBVEZNO NADENITE ZAŠČITNE ROKAVICE (МК) ЗАДОЛЖИТЕЛНО НОСЕЊЕ ЗАШТИТНИ РАКАВИЦИ
	(EN) DANGER OF ULTRAVIOLET RADIATION FROM WELDING (DE) GEFAHR ULTRAVIOLETTER STRAHLUNGEN BEIM SCHWEISSEN (SLO) NEVARNOST SEVANJA ULTRAVIJOLIČNIH ŽARKOV ZARADI VARJENJA (CRO) OPASNOST OD ULTRALJUBIČASTIH ZRAKA PRILIKOM VARENJA (МК) ОПАСНОСТ ОД УВ ЗРАЦИ ПРИ ЗАВАРУВАЊЕ
	(EN) DANGER OF FIRE (DE) BRANDGEFAHR (SLO) NEVARNOST POŽARA (CRO) OPASNOST OD POŽARA (МК) ОПАСНОСТ ОД ОГАН
	(EN) DANGER OF BURNS (DE) VERBRENNUNGSGEFAHR (SLO) NEVARNOST OPEKLIN (CRO) OPASNOST OD OPEKLINA (МК) ОПАСНОСТ ОД ИЗГОРЕНИЦИ

	(EN) DANGER OF NON-IONISING RADIATION (DE) GEFÄHR NICHT IONISIERENDER STRAHLUNGEN (SLO) NEVARNOST NEJONIZIRANEGA SEVANJA (CRO) OPASNOST NEJONIZIRAJUĆIH ZRAKA (MK) ОПАСНОСТ ОД НЕЈОНИЗИРАЧКО ЗАРАЧЕЊЕ
	(EN) GENERAL HAZARD (DE) GEFÄHR ALLGEMEINER ART (SLO) SPLOŠNA NEVARNOST (CRO) OPĆA OPASNOST (MK) ОПШТА ОПАСНОСТ
	(EN) DO NOT USE THE HANDLE TO HANG THE WELDING MACHINE (DE) ES IST UNTERSAGT, DEN GRIFF ALS MITTEL ZUM AUFHÄNGEN DER SCHWEISSMASCHINE ZU BENUTZEN (SLO) ROČAJA NE SMETE UPORABLJATI ZA OBEŠANJE VARILNEGA APARATA (CRO) ZABRANJENO JE UPOTREBLJAVATI RUČKU ZA PODIZANJE STROJA ZA VARENJE (MK) АПАРАТОТ ЗА ЗАВАРУВАЊЕ НЕ СМЕЕ ДА СЕ ОБЕСУВА НА РАЧКАТА
	(EN) WARNING: MOVING PARTS (DE) VORSICHT BEWEGUNGSELEMENTE (SLO) POZOR, NAPRAVE DELUJEJO (CRO) POZOR DIJELOVI U POKRETU (MK) ВНИМАНИЕ: ПОДВИЖНИ ДЕЛОВИ
	(EN) MIND YOUR HANDS, MOVING PARTS (DE) AUF DIE HÄNDE ACHTEN, BEWEGUNGSELEMENTE (SLO) PAZITE NA ROKE, NAPRAVE DELUJEJO (CRO) POZOR SA RUKAMA, DIJELOVI U POKRETU (MK) ВНИМАВАЈТЕ НА РАЦЕТЕ, ПОДВИЖНИ ДЕЛОВИ
	(EN) EYE PROTECTIONS MUST BE WORN (DE) DAS TRAGEN EINER SCHUTZBRILLE IST PFLICHT (SLO) OBVEZNA UPORABA ZAŠČITNIH OČAL (CRO) OBAVEZNA UPOTREBA ZAŠTITNIH NAOČALA (MK) ЗАДОЛЖИТЕЛНО НОСЕЊЕ ЗАШТИТНИ ОЧИЛА
	(EN) NO ENTRY FOR UNAUTHORISED PERSONNEL (DE) UNBEGUTEN PERSONEN IST DER ZUTRITT VERBOTEN (SLO) DOSTOP PREPOVEDAN NEPOOBLAŠČENIM OSEBAM (CRO) ZABRANA PRISTUPA NEOVLAŠTENIM OSOBAMA (MK) ЗАБРАНЕТ ВЛЕЗ ЗА НЕОВЛАТЕНИ ЛИЦА
	(EN) WEARING A PROTECTIVE MASK IS COMPULSORY (DE) DER GEBRAUCH EINER SCHUTZMASKE IST PFLICHT (SLO) OBVEZNOST UPORABI ZAŠČITNE MASKE (CRO) OBAVEZNO KORIŠTENJE ZAŠTITNE MASKE (MK) ЗАДОЛЖИТЕЛНО НОСЕЊЕ ЗАШТИТНА МАСКА
	(EN) USERS OF VITAL ELECTRICAL AND ELECTRONIC APPARATUS MUST NEVER USE THE MACHINE (DE) TRÄGERN LEBENSERHALTENDER ELEKTRISCHER UND ELEKTRONISCHER GERÄTE IST DER GEBRAUCH DER MASCHINE UNTERSAGT (SLO) PREPOVEDANA UPORABA STROJA ZA UPORABNIKE ŽIVLJENJSKO POMEMBNIH ELEKTRIČNIH IN ELEKTRONSKIH NAPRAV (CRO) ZABRANJENO JE UPOTREBLJAVATI STROJ OSOBAMA KOJE IMAJU UGRAĐENE VITALNE ELEKTRIČNE ILI ELEKTRONIČKE UREĐAJE (MK) ЗАБРАНЕТО КОРИСТЕЊЕ НА АПАРАТОТ ЗА ЗАВАРУВАЊЕ ОД ЛИЦА КОИ ИМААТ ВГРАДЕНИ ВИТАЛНИ ЕЛЕКТРИЧНИ И ЕЛЕКТРОНСКИ УРЕДИ
	(EN) PEOPLE WITH METAL PROSTHESES ARE NOT ALLOWED TO USE THE MACHINE (DE) TRÄGERN VON METALLPROTHESEN IST DER UMGANG MIT DER MASCHINE VERBOTEN (SLO) PREPOVEDANA UPORABA STROJA ZA NOSILCE KOVINSKIH PROTEZ (CRO) ZABRANJENA UPOTREBA STROJA OSOBAMA KOJE NOSE METALNE PROTEZE (MK) ЗАБРАНЕТА УПОТРЕБА НА АПАРАТОТ ЗА ЗАВАРУВАЊЕ ОД ЛИЦА СО ВГРАДЕНИ МЕТАЛНИ ПРОТЕЗИ

	(EN) DO NOT WEAR OR CARRY METAL OBJECTS, WATCHES OR MAGNETISED CARDS (DE) DAS TRAGEN VON METALLOBJEKTEN, UHREN UND MAGNETKARTEN IST VERBOTEN (SLO) PREPOVEDANO NOŠENJE KOVINSKIH PREDMETOV, UR IN MAGNETNIH KARTIC (CRO) ZABRANJENO NOŠENJE METALNIH PREDMETA, SATOVA I MAGNETSKIH ČIROVA (MK) НЕ НОСЕТЕ МЕТАЛНИ ПРЕДМЕТИ, ЧАСОВНИЦИ И МАГНЕТНИ КАРТИЧКИ
	(EN) NOT TO BE USED BY UNAUTHORISED PERSONNEL (DE) DER GEBRAUCH DURCH UNBEFUGTE PERSONEN IST VERBOTEN (SLO) NEPOOBLAŠČENIM OSEBAM UPORABA PREPOVEDANA (CRO) ZABRANJENA UPOTREBA NEOVLAŠTENIM OSOBAMA (MK) ЗАБРАНЕТА УПОТРЕБА ОД НЕОВЛАСТЕНИ ЛИЦА
	(EN) Symbol indicating separation of electrical and electronic appliances for refuse collection. The user is not allowed to dispose of these appliances as solid, mixed urban refuse, and must do it through authorised refuse collection centres. (DE) Symbol für die getrennte Erfassung elektrischer und elektronischer Geräte. Der Benutzer hat pflichtgemäß dafür zu sorgen, daß dieses Gerät nicht mit dem gemischt erfaßten festen Siedlungsabfall entsorgt wird. Stattdessen muß er eine der autorisierten Entsorgungsstellen einschalten. (SLO) Simbol, ki označuje ločeno zbiranje električnih in elektronskih aparatov. Uporabnik tega aparata ne sme zavreči kot navaden gospodinjski trden odpadek, ampak se mora obrniti na pooblašcene centre za zbiranje. (CRO) Simbol koji označava posebno sakupljanje električnih i elektronskih aparata. Korisnik ne smije odložiti ovaj aparat kao običan kruti otpad, već se mora obratiti ovlaštenim centrima za sakupljanje. (MK) Симбол кој означува посебно собирање електрични и електронски апарати. Корисникот не смее да ги фрла апаратите како цврст, мешан отпад, туку мора да ги отстранува преку овластени центри за отпад.

OWNER'S MANUAL

POWER SOURCE

EN



WARNING:
BEFORE USING THE POWER SOURCE READ THE INSTRUCTION MANUAL CAREFULLY.

CONTINUOUS WIRE WELDING MACHINE FOR MIG/MAG AND FLUX ARC WELDING DESIGNED FOR INDUSTRIAL AND PROFESSIONAL USE.

Note: In the following text the term "power source" will be used.

1. GENERAL SAFETY CONSIDERATIONS FOR ARC WELDING

The operator should be properly trained to use the power source safely and should be informed about the risks related to arc welding procedures, the associated protection measures and emergency procedures.

(Please refer to the applicable standard "EN 60974-9: Arc welding equipment. Part 9: Installation and Use).



- Avoid direct contact with the welding circuit: the no-load voltage supplied by the power source can be dangerous under certain circumstances.
- When the welding cables are being connected or checks and repairs are carried out the power source should be switched off and disconnected from the power supply outlet.
- Switch off the power source and disconnect it from the power supply outlet before replacing consumable torch parts.
- Make the electrical connections and installation according to the safety rules and legislation in force.
- The welding machine should be connected only and exclusively to a power source with the neutral lead connected to earth.
- Make sure that the power supply plug is correctly connected to the earth protection outlet.
- Do not use the power source in damp or wet places and do not weld in the rain.
- Do not use cables with worn insulation or loose connections.



- Do not weld on containers or piping that contains or has contained flammable liquid or gaseous products.
- Do not operate on materials cleaned with chlorinated solvents or near such substances.
- Do not weld on containers under pressure.
- Remove all flammable materials (e.g. wood, paper, rags etc.) from the working area.
- Provide adequate ventilation or facilities for the removal of welding fumes near the arc; a systematic approach is needed in evaluating the exposure limits for the welding fumes, which will depend on their composition, concentration and the length of exposure itself.
- Keep the gas bottle (if used) away from heat sources, including direct sunlight.



- Use electric insulation that is suitable for the torch, the workpiece and any metal parts that may be placed on the ground and nearby (accessible).
This can normally be done by wearing gloves, footwear, head protection and clothing that are suitable for the purpose and by using insulating boards or mats.
- Always protect your eyes with the relative filters, which must comply with UNI EN 169 or UNI EN 379, mounted on masks or use helmets that comply with UNI EN 175.
Use the relative fire-resistant clothing (compliant with UNI EN 11611) and welding gloves (compliant with UNI EN 12477) without exposing the skin to the ultraviolet and infrared rays produced by the arc; the protection must extend to other people who are near the arc by way of screens or non-reflective sheets.
- Noise: If the daily personal noise exposure (LEPd) is equal

to or higher than 85 dB(A) because of particularly intensive welding operations, suitable personal protective means must be used (Tab. 1).



- The flow of the welding current generates electromagnetic fields (EMF) around the welding circuit.

Electromagnetic fields can interfere with certain medical equipment (e.g. Pace-makers, respiratory equipment, metallic prostheses etc.).

Adequate protective measures must be adopted for persons with these types of medical apparatus. For example, they must be forbidden access to the area in which welding machines are in operation.

This power source conforms to technical product standards for exclusive use in an industrial environment for professional purposes. It does not assure compliance with the basic limits relative to human exposure to electromagnetic fields in the domestic environment.

The operator must adopt the following procedures in order to reduce exposure to electromagnetic fields:

- Fasten the two welding cables as close together as possible.
- Keep head and trunk as far away as possible from the welding circuit.
- Never wind welding cables around the body.
- Avoid welding with the body within the welding circuit. Keep both cables on the same side of the body.
- Connect the welding current return cable to the piece being welded, as close as possible to the welding joint.
- Do not weld while close to, sitting on or leaning against the power source (keep at least 50 cm away from it).
- Do not leave objects in ferromagnetic material in proximity of the welding circuit.
- Minimum distance $d = 20$ cm.



- Class A equipment:

This power source conforms to technical product standards for exclusive use in an industrial environment and for professional purposes. It does not assure compliance with electromagnetic compatibility in domestic dwellings and in premises directly connected to a low-voltage power supply system feeding buildings for domestic use.



EXTRA PRECAUTIONS

- WELDING OPERATIONS:

- In environments with increased risk of electric shock; - In confined spaces;
- In the presence of flammable or explosive materials; MUST BE evaluated in advance by an "Expert supervisor" and must always be carried out in the presence of other people trained to intervene in emergencies.
All protective technical measures MUST be taken as provided in 7.10; A.8; A.10 of the applicable standard EN 60974-9: Arc welding equipment. Part 9: Installation and Use".

- Welding MUST NOT be allowed if the welding machine or wire feeder is supported by the operator (e.g. using belts).
- The operator MUST NOT BE ALLOWED to weld in raised positions unless safety platforms are used.

- VOLTAGE BETWEEN ELECTRODE HOLDERS OR TORCHES:

working with more than one welding machine on a single piece or on pieces that are connected electrically may generate a dangerous accumulation of no-load voltage between two different electrode holders or torches, the value of which may reach double the allowed limit.

An expert coordinator must be designated to measuring the apparatus to determine if any risks subsist and suitable protection measures can be adopted, as foreseen by section 7.9 of the applicable standard "EN 60974-9: Arc welding equipment. Part 9: Installation and Use".



RESIDUAL RISKS

- **OVERTURNING:** position the power source on a horizontal surface that is able to support the weight: otherwise (e.g. inclined or uneven floors etc.) there is danger of overturning.
- **IMPROPER USE:** it is hazardous to use the power source for any work other than that for which it was designed (e.g. de-icing mains water pipes).
- **MOVING THE POWER SOURCE:** Always secure the gas bottle, taking suitable precautions so that it cannot fall accidentally (if used).
- Do not use the handle to hang the power source.



The safety guards and moving parts of the covering of the power source and of the wire feeder should be in their proper positions before connecting the power source to the power supply.



WARNING! Any manual operation carried out on the moving parts of the wire feeder, for example:

- Replacing rollers and/or the wire guide;
- Inserting wire in the rollers;
- Loading the wire reel;
- Cleaning the rollers, the gears and the area underneath them; - Lubricating the gears.

SHOULD BE CARRIED OUT WITH THE POWER SOURCE SWITCHED OFF AND DISCONNECTED FROM THE POWER SUPPLY OUTLET.

2. INTRODUCTION AND GENERAL DESCRIPTION

The inverter power source WME 400/500/401/501 CC/CV multimatic is the solution for Industrial Multi-process application. WME 400/500/401/501 CC/CV multimatic inverter welding-type semi-automatic welding machine is an inverter DC semi-automatic welding machine, which is widely used in automation, metal furniture manufacturing, shipyard, pressure container manufacturing and steel construction industries. With modular and compact design this welding set is easy to move around site. Transport is trouble free thanks to the lower weight of the design.

STANDARD ACCESSORIES

- return cable complete with earth clamp 3m
- gas hose Ø5.5 x 8 0.75m
- clamp Ø7
- operator's manual
- robust trolley

SPECIFICATIONS AND DIMENSIONS

Description		Specification	
Model		400/401	500/501
Mains Voltage V		400±15%	500±15%
Frequency Hz		50/60	50/60
Primary current I_{max}		32 A	41.8 A
No-load voltage V		65	73
Rated working voltage V		16-24	16-26.5
MIG welding current A		15~400	15~500
Permissible loads			
MIG	60%Duty cycle	400 A/34 V	500A/39V
	100%Duty cycle	271A/27.6V	387A/33.4V
MMA	60%Duty cycle	350A/34V	490A/39.6V
	100%Duty cycle	270A/30.8V	380A/35.2V
TIG	60%Duty cycle	350A/24V	490A/29.6V
	100%Duty cycle	271A/20.8V	380A/25.2V
Efficiency η		85%	85%
Power factor at maximum current Cosφ		0.75	0.75
Insulation class		H	H
Enclosure protection IP		21S	21S
Cooling type		Fan cooled	Fan cooled
Dimensions cm L×W×H		65x40x82	65x40x82
Weight kg		44	45

3. TECHNICAL DATA

DATA PLATE

The most important data regarding use and performance of the power source are summarised on the rating plate and have the following meaning:

Fig. A

- 1- EUROPEAN standard of reference, for safety and construction of arc welding machines.
- 2- Symbol for internal structure of the welding machine.
- 3- Symbol for welding procedure provided.
- 4- Manufacturer
- 5- Symbol for power supply line:
1~ : single phase alternating voltage;
3~ : 3-phase alternating voltage.
- 6- Protection rating of the covering.
- 7- Technical specifications for power supply line:
 - U_1 : Alternating voltage and power supply frequency of welding machine (allowed limit ±10%).
 - I_{1max} : Maximum current absorbed by the lin
 - I_{1eff} : effective current supplied.e.

8- Performance of the welding circuit:

- U_0 : maximum no-load voltage (open welding circuit).
 - I_2/U_2 : current and corresponding normalised voltage that the welding machine can supply during welding.
 - **X** : Duty cycle: indicates the time for which the welding machine can supply the corresponding current (same column). It is expressed as %, based on a 10 min. cycle (e.g. 60% = 6 minutes working, 4 minutes pause, and so on).
If the usage factors (on the plate, referring to a 40°C environment) are exceeded, the thermal safeguard will trigger (the welding machine will remain in standby until its temperature returns within the allowed limits).
 - **A/V-A/V** : shows the range of adjustment for the welding current (minimum maximum) at the corresponding arc voltage.
- 9- Manufacturer's serial number for welding machine identification (indispensable for technical assistance, requesting spare parts, discovering product origin).
- 10-  : Size of delayed action fuses to be used to protect the power line.
- 11- Symbols referring to safety regulations, whose meaning is given in chapter 1 "General safety considerations for arc welding".

Note: The data plate shown above is an example to give the meaning of the symbols and numbers; the exact values of technical data for the welding machine in your possession must be checked directly on the data plate of the welding machine itself.

OTHER TECHNICAL DATA

- **POWER SOURCE:** see table 1 (TAB.1)

4. DESCRIPTION OF THE POWER SOURCE

CONTROL DEVICES: ADJUSTMENT AND CONNECTION.

POWER SOURCE WME MIG 400/500 CC/CV (Fig. B1)

At the front:

- 1- Control panel (see description).
- 2- Positive terminal (+)
- 3- Negative terminal (-)
- 4- Control Receptacle
- 5- Toolbox (optional)

At the back:

- 6- Main ON/OFF switch.
- 7- Power supply cable
- 8- Heat power socket
- 9- Control fuse
- 10- Cooler Power Supply Socket (optional for water cooling)
- 11- Cooler Power lead (optional for water cooling)
- 12- Quick Connect Coupling: Coolant outlet (optional for water cooling)
- 13- Quick Connect Coupling: Coolant inlet (optional for water cooling)

POWER SOURCE WME MIG 401/501 CC/CV (Fig. B2)

At the front:

- 1- Control panel (see description).
- 2- Positive terminal (+)
- 3- Negative terminal (-)
- 4- Control Receptacle
- 5- Toolbox (optional)

At the back:

- 6- Main ON/OFF switch.
- 7- Power supply cable
- 8- Flow sensore
- 9- Flow sensore
- 10- Cooler Power Supply Socket (optional for water cooling)
- 11- Cooler Power lead (optional for water cooling)
- 12- Quick Connect Coupling: Coolant outlet (optional for water cooling)
- 13- Quick Connect Coupling: Coolant inlet (optional for water cooling)

POWER SOURCE CONTROL PANEL

WME MIG 400/500 CC/CV (Fig. C1)

1. Main power indicator (Green)
2. Protection indicator (red)
3. Working indicator (red)
4. Welding process button: MMA, MIG/MAG, SYN
5. Current adjust knob
6. Voltage adjust knob
7. Inductance adjust knob

POWER SOURCE CONTROL PANEL

WME MIG 401/501 CC/CV (Fig. C2)

1. Main power indicator
2. Protection indicator
3. Working indicator
4. Welding process selector
5. Current adjustment knob
6. Voltage adjustment knob
7. Inductance adjust knob
8. Cooling mode (optional)

5. INSTALLATION



WARNING! ALL INSTALLATION OPERATIONS AND ELECTRICAL CONNECTIONS MUST ALWAYS BE CARRIED OUT WITH THE POWER SOURCE SWITCHED OFF AND DISCONNECTED FROM THE POWER SUPPLY. THE ELECTRIC CONNECTIONS MUST ONLY BE CARRIED OUT BY EXPERT OR QUALIFIED TECHNICIANS.

Return cable-clamp assembly Fig. D

POSITIONING THE POWER SOURCE

Choose the place where the power source is to be installed so that there are no obstructions to the cooling air inlets and outlets; at the same time make sure that conductive dust, corrosive vapours, humidity etc. cannot be drawn into the machine. Leave at least 250 mm of free space all around the power source.



WARNING! Position the power source on a level surface with sufficient load-bearing capacity, so that it cannot be tipped over or shift dangerously.

CONNECTION TO THE MAIN POWER SUPPLY

- Before making any electrical connection, check the rating plate data on the power source to make sure they correspond to the voltage and frequency of the available power supply where the machine is to be installed.
- The power source must be connected only and exclusively to a power supply with the neutral conductor connected to earth.
- To guarantee protection against indirect contact use the following types of residual current devices: - A type () for single-phase machines.
- In order to satisfy the requirements of the EN 61000-3-11 (Flicker) standard we recommend connecting the power source to the interface points of the main power supply that have an impedance of less than $Z_{max} = 0.15 \text{ ohm}$.
- The IEC/EN 61000-3-12 Standard does not apply to the power source.
If the power source is connected to an electrical grid, the installer or user must make sure that the machine can indeed be connected (if necessary, consult the company that manages the electrical grid).

Plug and outlet

Connect the power supply plug to a mains socket fitted with fuses or an automatic circuit-breaker; the corresponding earth terminal should be connected to the (yellow-green) earth conductor of the power supply. Table 1 (TAB. 1) shows the recommended delayed fuse sizes, in amps, for the main supply, which have been chosen according to the maximum rated current output from the welding machine, and to the nominal power supply voltage.



WARNING! Non-compliance with the above regulations renders the manufacturer's safety system (class I) inefficient, with resulting serious risks to people (e.g. electric shock) and things (e.g. fire).

WELDING CIRCUIT CONNECTIONS



WARNING! BEFORE CARRYING OUT THE FOLLOWING CONNECTIONS MAKE SURE THAT THE POWER SOURCE IS SWITCHED OFF AND DISCONNECTED FROM THE POWER SUPPLY.

Table 1 (TAB. 1) shows the recommended sizes of the welding cables (in mm²), according to the maximum current output from the welding machine.

WELDING CABLES CONNECTIONS

Insert the plug of the work lead into the socket (B3). The other end of this lead connects to the work piece with the work clamp.

Connect the wire feeder to the power source: Insert the positive welding cable into the output socket (B2). Insert the wire feeder control cable into the socket (B4).

WATER COOLER CONNECTIONS

1. Turn off the power source and disconnect input plug.
2. Remove the cap from the Water Cooler Supply Socket (B10).
3. Insert the water cooler power lead (B11) into the Water Cooler Power Supply Socket (B10).
4. Connect water cooling lines (B12) and (B13) to wire feeder sockets.

OPERATION

MMA welding process:

1. Turn on the power source.
2. Determine the electrode polarity for the electrode to be used.
3. Connect the work lead to output socket of power source.
4. Connect the work lead to the welding piece with the earth clamp.
5. Turn on the input power
6. On control panel (B1) choose the MMA process on button (C4).
Regulate the current and voltage on button (C5) and (C6)
7. The welding machine is now ready.

Electrode diameter (mm) : 1,6 - 4

TIG welding process:

1. Turn on the power source.
2. Determine the electrode polarity for the electrode to be used.
3. Connect the work lead to output socket of power source.
4. Connect the work lead to the welding piece with the earth clamp.
5. Turn on the input power
6. On control panel (B1) choose the TIG process on button (C4).
7. The welding machine is now ready.

9. MAINTENANCE



WARNING! BEFORE CARRYING OUT MAINTENANCE OPERATIONS MAKE SURE THE POWER SOURCE IS SWITCHED OFF AND DISCONNECTED FROM THE MAIN POWER SUPPLY.

**ROUTINE MAINTENANCE:
ROUTINE MAINTENANCE OPERATIONS CAN BE CARRIED OUT BY THE OPERATOR.**

Routine maintenance (everyday)

- Check condition of insulation and connections of the work leads and insulation of power lead. If any insulation damage exists replace the lead immediately.
- Remove the spatters from the welding gun nozzle. Spatters could interfere with the shielding gas flow to the arc.
- Check the welding gun condition: replace it, if necessary.
- Check condition and operation of the cooling fan. Keep clean its airflow slots.

Periodic maintenance (every 200 working hours but at list once every year) Perform the routine maintenance and, in addition:

- Keep the machine clean. Using a dry (and low pressure) airflow, remove the dust from the external case and from the cabinet inside.
- If it is required, clean and tighten all weld terminals.

The frequency of the maintenance operations may vary in accordance with the working environment where the machine is placed.

EXTRAORDINARY MAINTENANCE

EXTRAORDINARY MAINTENANCE MUST ONLY BE CARRIED OUT BY TECHNICIANS WHO ARE EXPERT OR QUALIFIED IN THE ELECTRIC-MECHANICAL FIELD, AND IN FULL RESPECT OF THE IEC/EN 60974-4 TECHNICAL DIRECTIVE.



WARNING! BEFORE REMOVING THE POWER SOURCE PANELS AND WORKING INSIDE THE MACHINE MAKE SURE THE POWER SOURCE IS SWITCHED OFF AND DISCONNECTED FROM THE MAIN POWER SUPPLY OUTLET. If checks are made inside the welding machine while it is live, this may cause serious electric shock due to direct contact with live parts and/or injury due to direct contact with moving parts.

- Inspect the power source regularly, with a frequency depending on use and the dustiness of the environment, and remove the dust deposited on the transformer, reactance and rectifier using a jet of dry compressed air (max. 10 bar).
- Do not direct the jet of compressed air on the electronic boards; these can be cleaned with a very soft brush or suitable solvents.
- At the same time make sure the electrical connections are tight and check the wiring for damage to the insulation.
- At the end of these operations re-assemble the panels of the power source and screw the fastening screws right down.
- Never, ever carry out welding operations while the power source is open.
- After having carried out maintenance or repairs, restore the connections and wiring as they were before, making sure they do not come into contact with moving parts or parts that can reach high temperatures. Tie all the wires as they were before, being careful to keep the high voltage connections of the primary transformer separate from the low voltage ones of the secondary transformer. Use all the original washers and screws when closing the casing.



D EU Konformitäts Erklärung
EN EU declaration of Conformity
FR Déclaration EU de Conformité
IT Dichiarazione EU di Conformità
NL EU verklaring van overeenstemming
SE EU försäkran om överensstämmelse

SI EU izjava o skladnosti
HR EU izjava o sukladnosti
SRB EU izjava o usaglašenosti
MK EU изјава за сообразност
RO EU Declarație de Conformitate
BG EU декларация за съответствие

HU EU megfelelési nyilatkozat
CZ EU prohlášení o shodě
SK EU Vyhlásenie o zhode
PL Deklaracja zgodności EU
TR EU Uygunluk Beyanı
ES EU Declaración de Conformidad

Rheinland Elektro maschinen Group d.o.o.
PC Komenda, Pod lipami 10
SI – 1218 Komenda – EU

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Schweißstromquellen- Power Source - Générateurs de soudage - Alimentatori di saldatura- Lasstroombonnen - Svetsströmkällor - Varilna transformatorja - Izvor napajanja-Извор за напајање - Извор за напојување - Alimentare pentru sudură - Захранващи източници- Napájací zdroje - Svařovací inverter - Źródła prądu- Prostownik spawalniczy - Kaynağı güç üniteleri

Typ - Type - Type - Modelo - Type - Typ - Tip - Tip - Tip - Тип - Type - Тип - Típus - Typ - Typ - Typ - Tip - Tipo:

WME MIG 400/500 cc/cv - WME MIG 4 01/501 cc/cv

(2014/35/EU) , (2014/30/EU)

(EN 60974-1:2012); (EN 60974-10:2014)

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Boštjan Prebil

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Komenda, 13.09.2017

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