



# Part Report

108392 - PickUp Carriage

62928242

# Part report summary

Part is OK

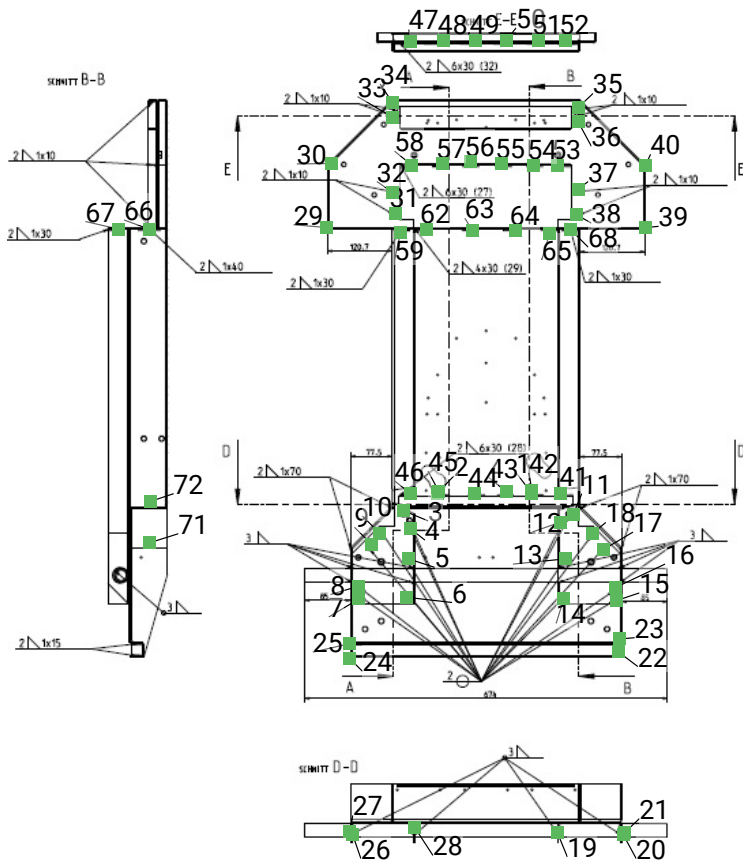
Part serial number 62928242  
 Part item number 108392  
 Part name Pickup Carriage  
 Start time 7/29/2019 2:11:30 PM

Configured processing steps 72

Number of welds 72  
 Number of OK welds 72  
 Number of welds with error 0  
 Number of missing welds 0  
 Number of multiple welds 0  
 Number of unconfigured welds 0

Arc time 149.9 s  
 Spot welding weld time 0 s  
 Process time 4 min 13 s

Number of limit violations 0



freigegeben

q	1	Artbezeichnung	625 x 3 x 675	62.0200.0973
3	1	Teile	2 x 605 x 638,8	32.0200.0368
2	1	Stange/Profile	2 x 55,2 x 620,8	32.0200.0368
1	1	Bolzen	M8x17,52x49,5	32.0200.0107

Pos.	26	Bezeichnung / Material	Abmessung	Art. Nr.
Ausgewähltes Material nach: DIN ISO 2768-M-K				
1	1	Stange/Profile	2 x 55,2 x 620,8	32.0200.0368
2	1	Stange/Profile	2 x 605 x 638,8	32.0200.0368
3	1	Teile	2 x 605 x 638,8	32.0200.0368
4	1	Teile	2 x 605 x 638,8	32.0200.0368
5	1	Teile	2 x 605 x 638,8	32.0200.0368
6	1	Teile	2 x 605 x 638,8	32.0200.0368
7	1	Teile	2 x 605 x 638,8	32.0200.0368
8	1	Teile	2 x 605 x 638,8	32.0200.0368
9	1	Teile	2 x 605 x 638,8	32.0200.0368
10	1	Teile	2 x 605 x 638,8	32.0200.0368
11	1	Teile	2 x 605 x 638,8	32.0200.0368
12	1	Teile	2 x 605 x 638,8	32.0200.0368
13	1	Teile	2 x 605 x 638,8	32.0200.0368
14	1	Teile	2 x 605 x 638,8	32.0200.0368
15	1	Teile	2 x 605 x 638,8	32.0200.0368
16	1	Teile	2 x 605 x 638,8	32.0200.0368
17	1	Teile	2 x 605 x 638,8	32.0200.0368
18	1	Teile	2 x 605 x 638,8	32.0200.0368
19	1	Teile	2 x 605 x 638,8	32.0200.0368
20	1	Teile	2 x 605 x 638,8	32.0200.0368
21	1	Teile	2 x 605 x 638,8	32.0200.0368
22	1	Teile	2 x 605 x 638,8	32.0200.0368
23	1	Teile	2 x 605 x 638,8	32.0200.0368
24	1	Teile	2 x 605 x 638,8	32.0200.0368
25	1	Teile	2 x 605 x 638,8	32.0200.0368
26	1	Teile	2 x 605 x 638,8	32.0200.0368
27	1	Teile	2 x 605 x 638,8	32.0200.0368
28	1	Teile	2 x 605 x 638,8	32.0200.0368
29	1	Teile	2 x 605 x 638,8	32.0200.0368
30	1	Teile	2 x 605 x 638,8	32.0200.0368
31	1	Teile	2 x 605 x 638,8	32.0200.0368
32	1	Teile	2 x 605 x 638,8	32.0200.0368
33	1	Teile	2 x 605 x 638,8	32.0200.0368
34	1	Teile	2 x 605 x 638,8	32.0200.0368
35	1	Teile	2 x 605 x 638,8	32.0200.0368
36	1	Teile	2 x 605 x 638,8	32.0200.0368
37	1	Teile	2 x 605 x 638,8	32.0200.0368
38	1	Teile	2 x 605 x 638,8	32.0200.0368
39	1	Teile	2 x 605 x 638,8	32.0200.0368
40	1	Teile	2 x 605 x 638,8	32.0200.0368
41	1	Teile	2 x 605 x 638,8	32.0200.0368
42	1	Teile	2 x 605 x 638,8	32.0200.0368
43	1	Teile	2 x 605 x 638,8	32.0200.0368
44	1	Teile	2 x 605 x 638,8	32.0200.0368
45	1	Teile	2 x 605 x 638,8	32.0200.0368
46	1	Teile	2 x 605 x 638,8	32.0200.0368
47	1	Teile	2 x 605 x 638,8	32.0200.0368
48	1	Teile	2 x 605 x 638,8	32.0200.0368
49	1	Teile	2 x 605 x 638,8	32.0200.0368
50	1	Teile	2 x 605 x 638,8	32.0200.0368
51	1	Teile	2 x 605 x 638,8	32.0200.0368
52	1	Teile	2 x 605 x 638,8	32.0200.0368
53	1	Teile	2 x 605 x 638,8	32.0200.0368
54	1	Teile	2 x 605 x 638,8	32.0200.0368
55	1	Teile	2 x 605 x 638,8	32.0200.0368
56	1	Teile	2 x 605 x 638,8	32.0200.0368
57	1	Teile	2 x 605 x 638,8	32.0200.0368
58	1	Teile	2 x 605 x 638,8	32.0200.0368
59	1	Teile	2 x 605 x 638,8	32.0200.0368
60	1	Teile	2 x 605 x 638,8	32.0200.0368
61	1	Teile	2 x 605 x 638,8	32.0200.0368
62	1	Teile	2 x 605 x 638,8	32.0200.0368
63	1	Teile	2 x 605 x 638,8	32.0200.0368
64	1	Teile	2 x 605 x 638,8	32.0200.0368
65	1	Teile	2 x 605 x 638,8	32.0200.0368
66	1	Teile	2 x 605 x 638,8	32.0200.0368
67	1	Teile	2 x 605 x 638,8	32.0200.0368
68	1	Teile	2 x 605 x 638,8	32.0200.0368
69	1	Teile	2 x 605 x 638,8	32.0200.0368
70	1	Teile	2 x 605 x 638,8	32.0200.0368
71	1	Teile	2 x 605 x 638,8	32.0200.0368
72	1	Teile	2 x 605 x 638,8	32.0200.0368

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:11:30 PM
Duration	0.8 s
Limit violations	None
Wire consumption (length)	0.029 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

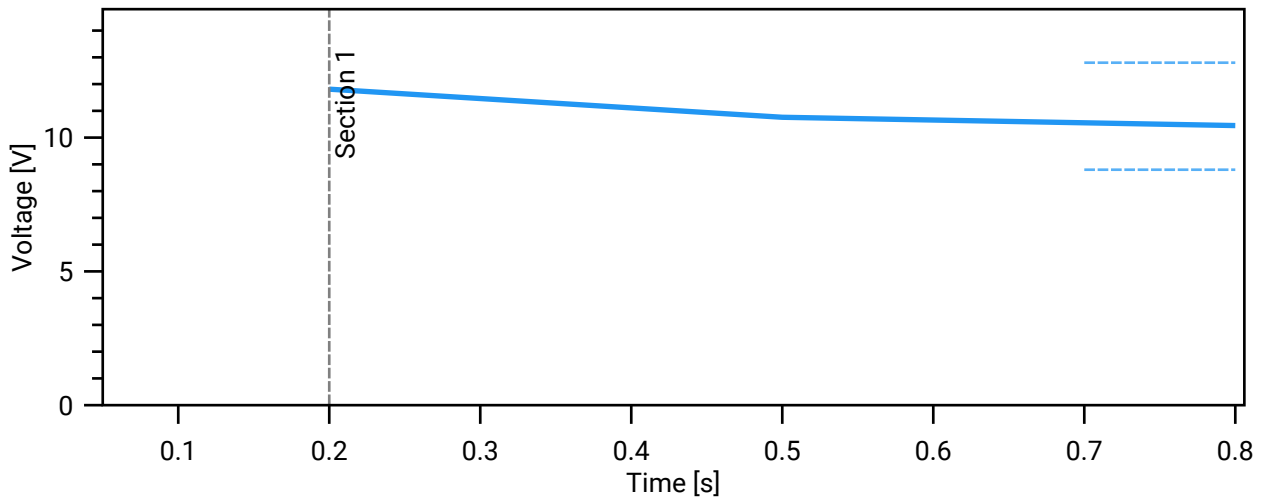
#### Section values

Welding mode	mig cmt
Duration	0.8 s
Job number	60
Arc gas consumption	0.2 l
Wire consumption (length)	0.029 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

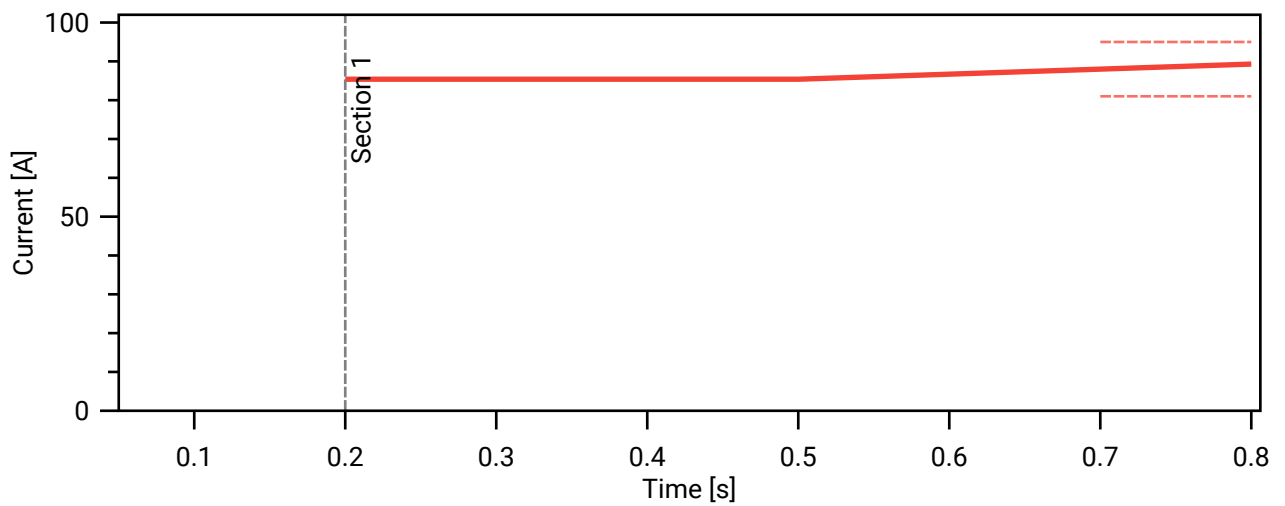
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

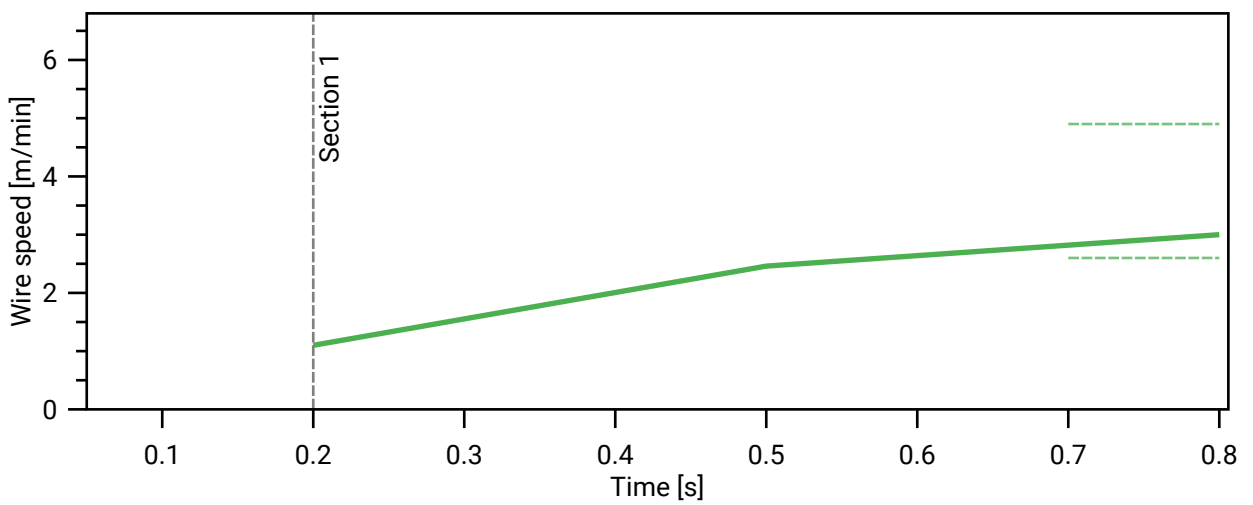
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:11:32 PM
Duration	0.8 s
Limit violations	None
Wire consumption (length)	0.042 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

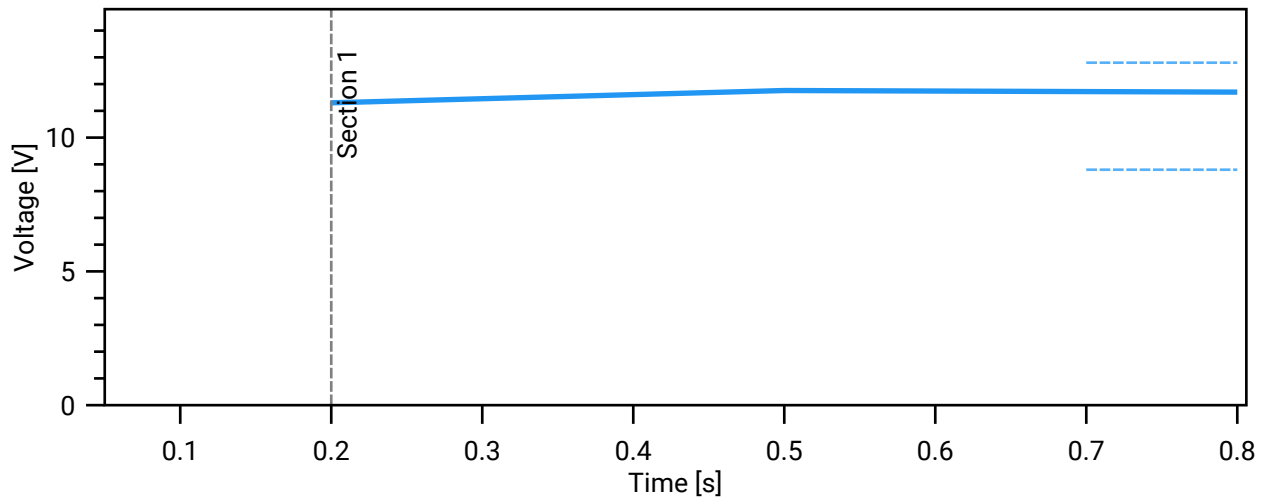
#### Section values

Welding mode	mig cmt
Duration	0.8 s
Job number	60
Arc gas consumption	0.3 l
Wire consumption (length)	0.042 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

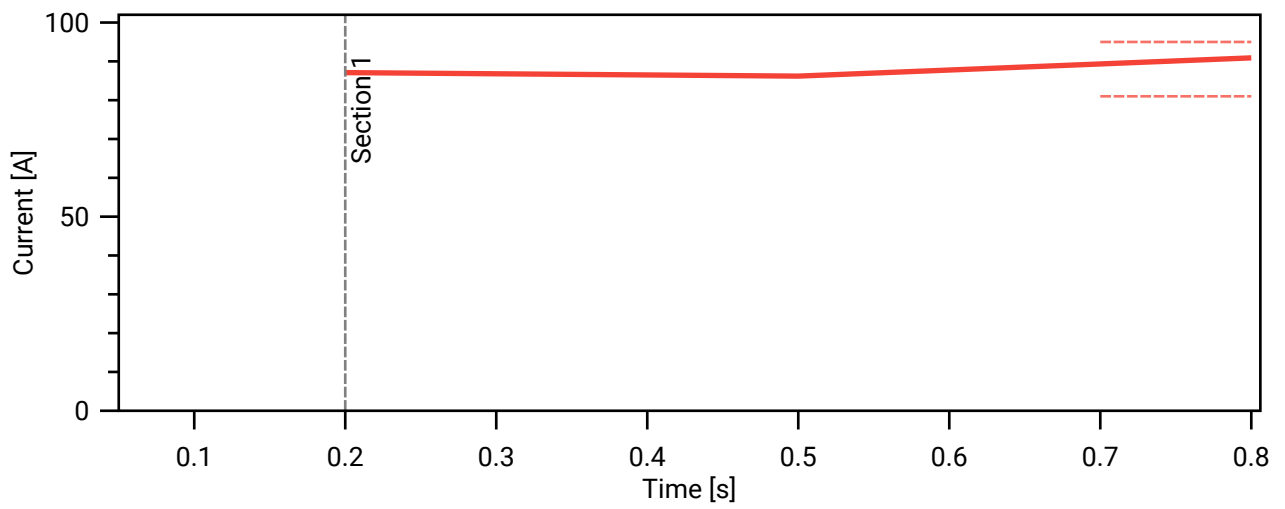
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

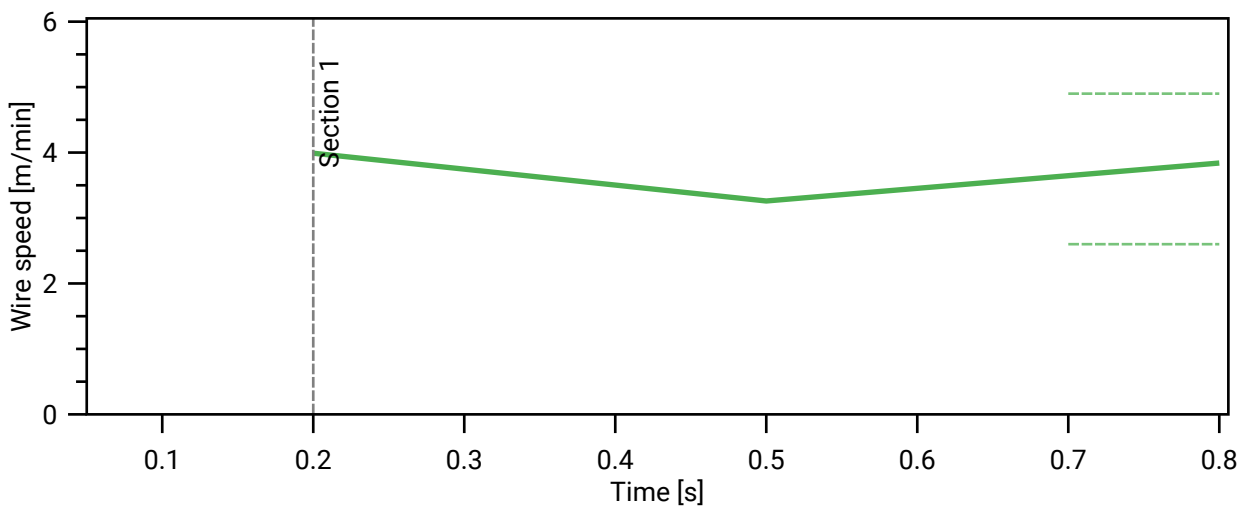
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:11:35 PM
Duration	2.3 s
Limit violations	None
Wire consumption (length)	0.133 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

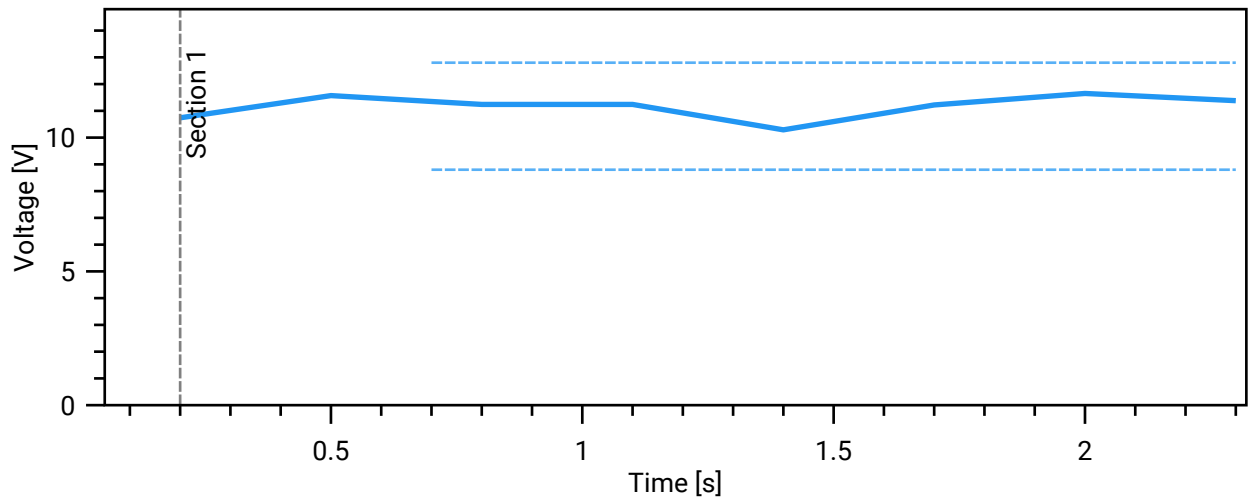
#### Section values

Welding mode	mig cmt
Duration	2.3 s
Job number	60
Arc gas consumption	0.6 l
Wire consumption (length)	0.133 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

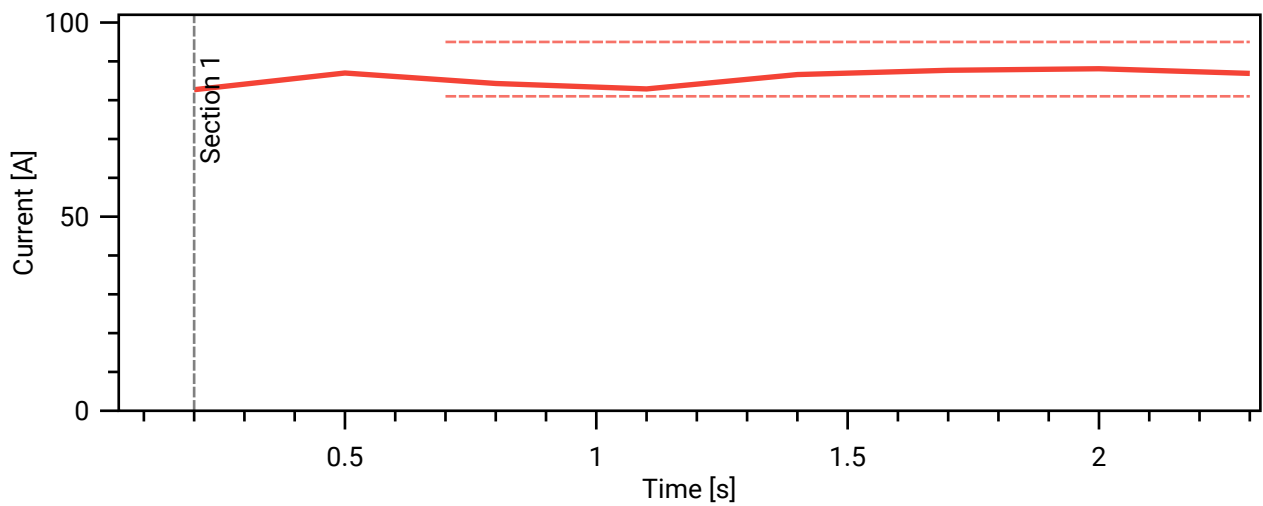
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

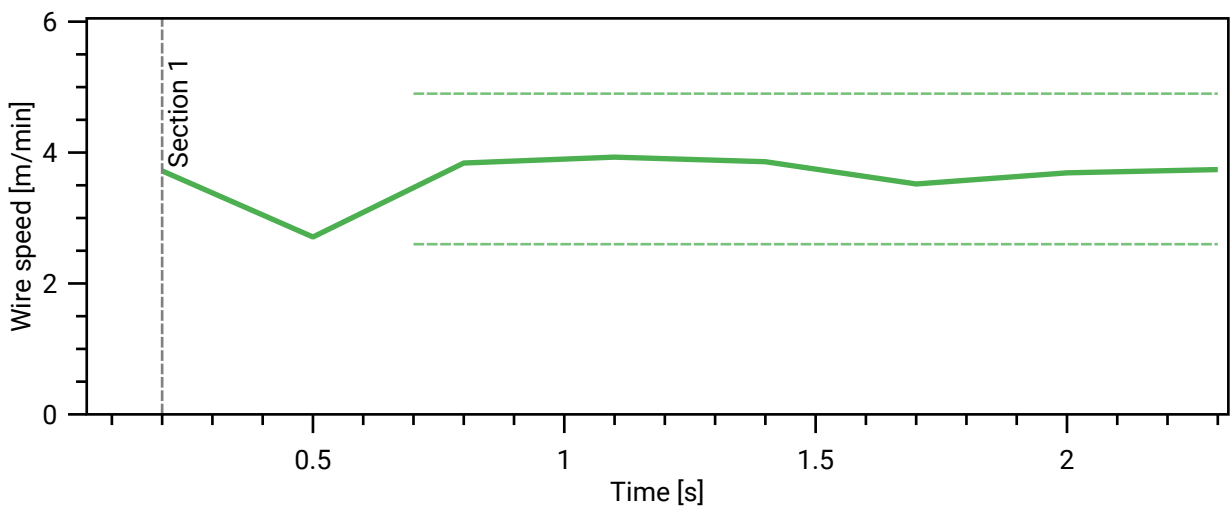
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:11:38 PM
Duration	1.7 s
Limit violations	None
Wire consumption (length)	0.09 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

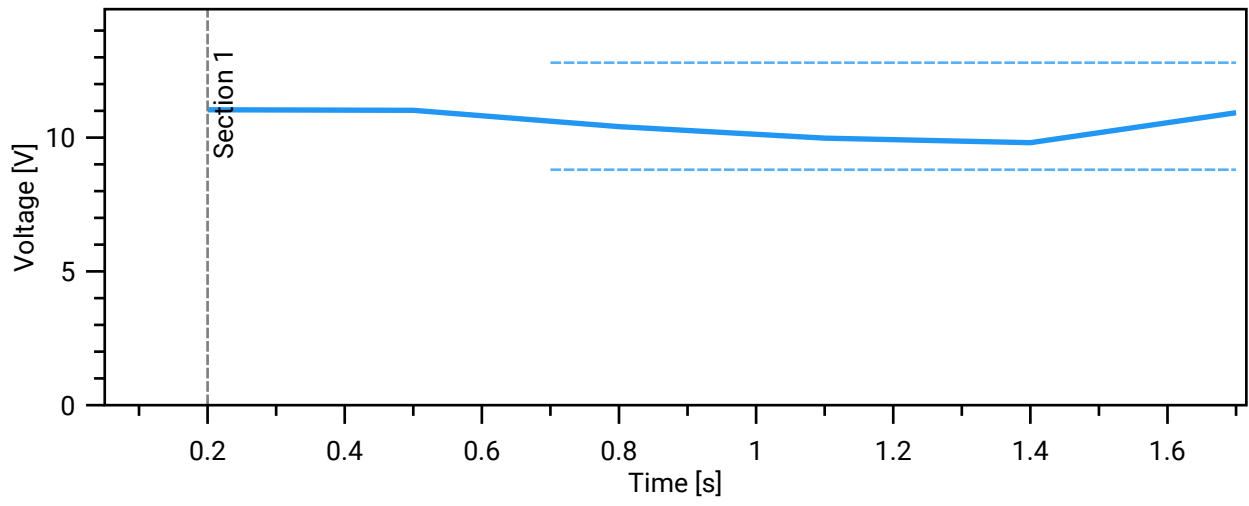
#### Section values

Welding mode	mig cmt
Duration	1.7 s
Job number	60
Arc gas consumption	0.5 l
Wire consumption (length)	0.09 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

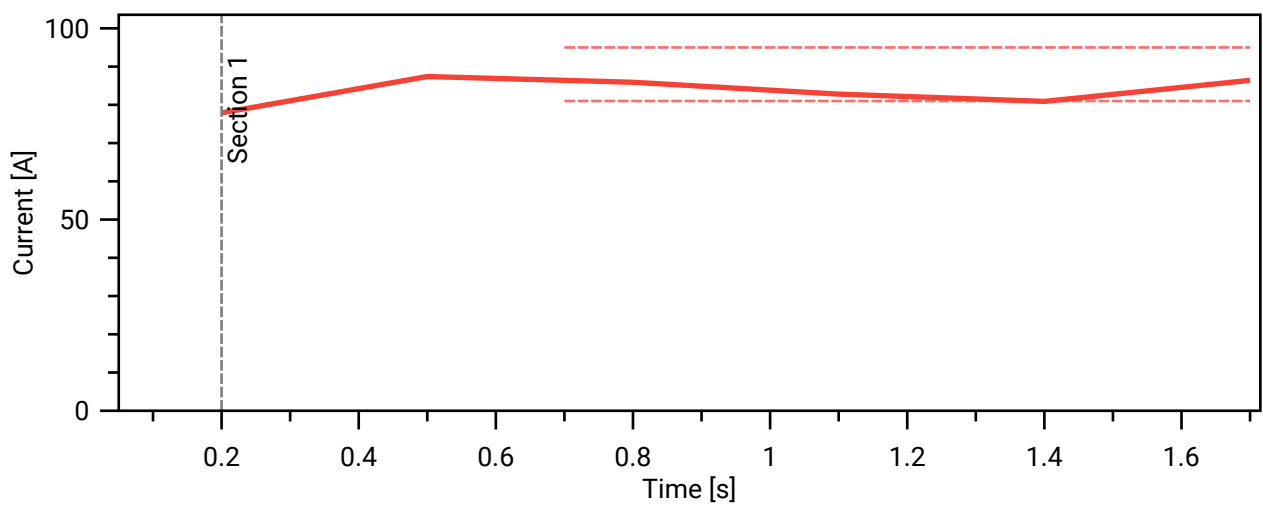
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

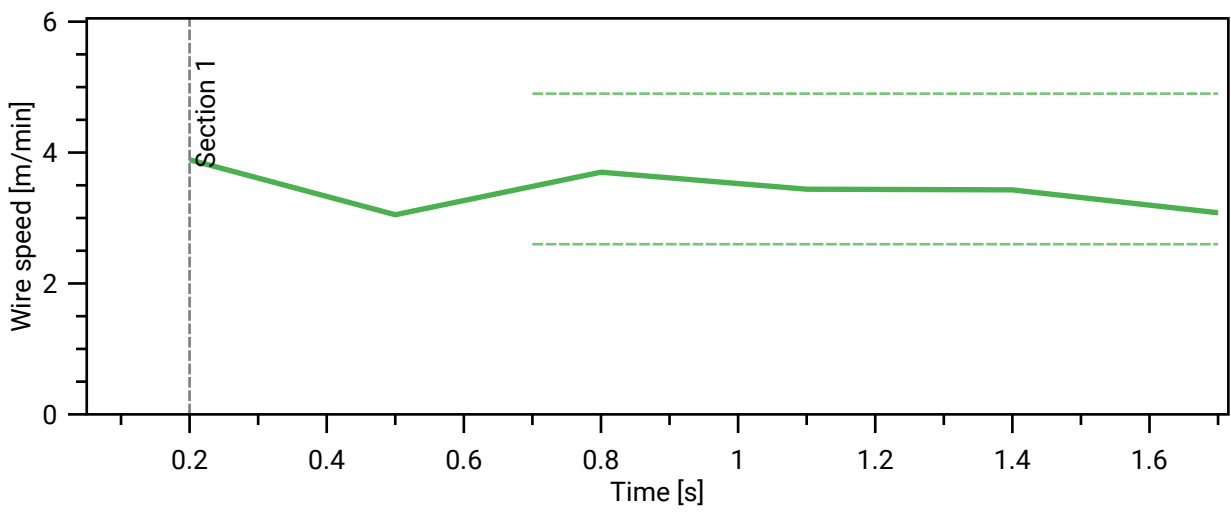
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:11:41 PM
Duration	2.3 s
Limit violations	None
Wire consumption (length)	0.12 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

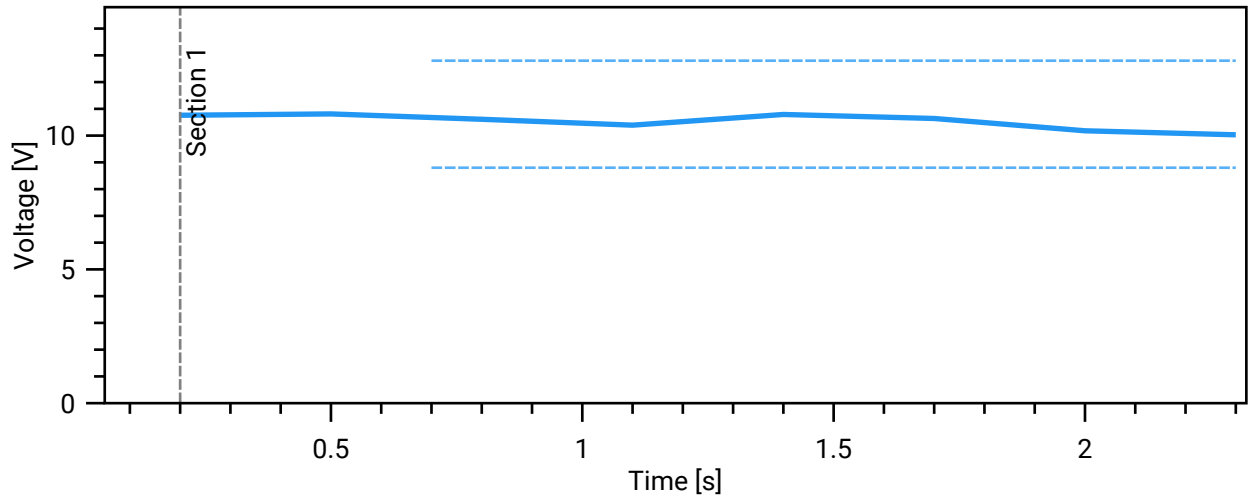
#### Section values

Welding mode	mig cmt
Duration	2.3 s
Job number	60
Arc gas consumption	0.6 l
Wire consumption (length)	0.12 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

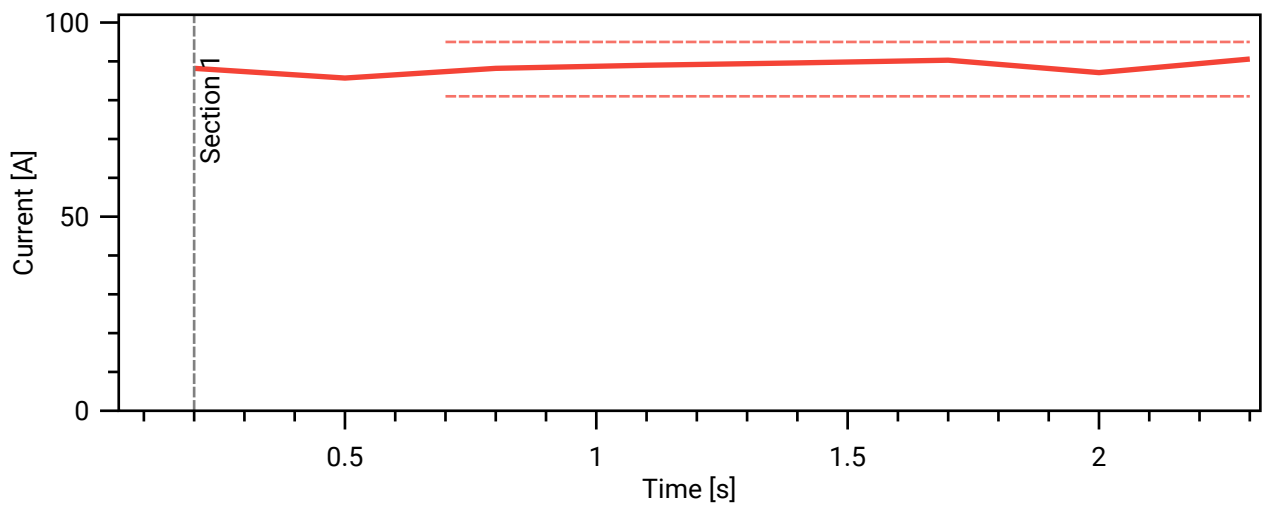
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

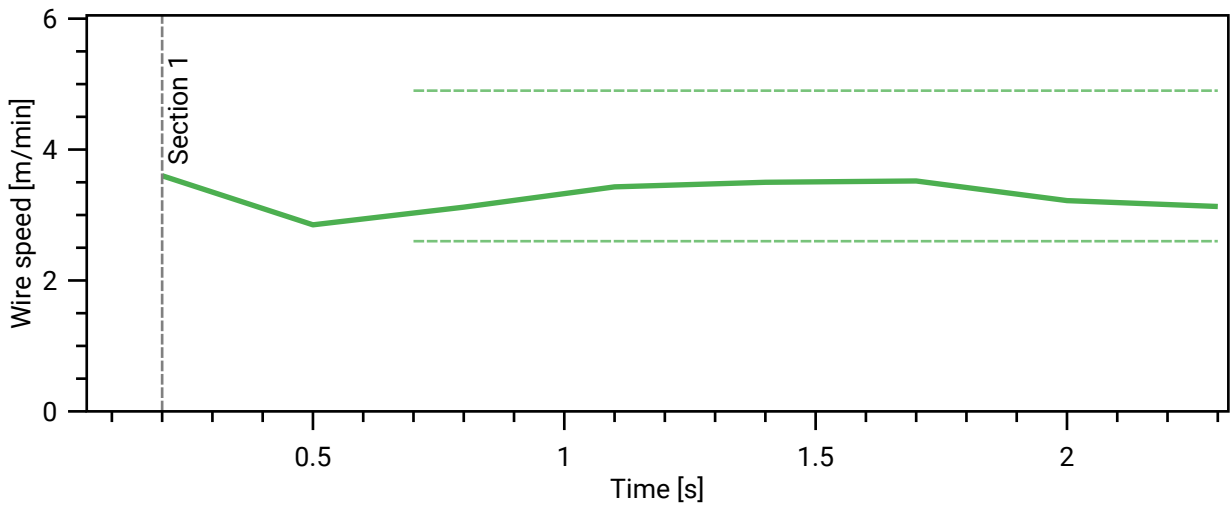
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:11:45 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.112 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

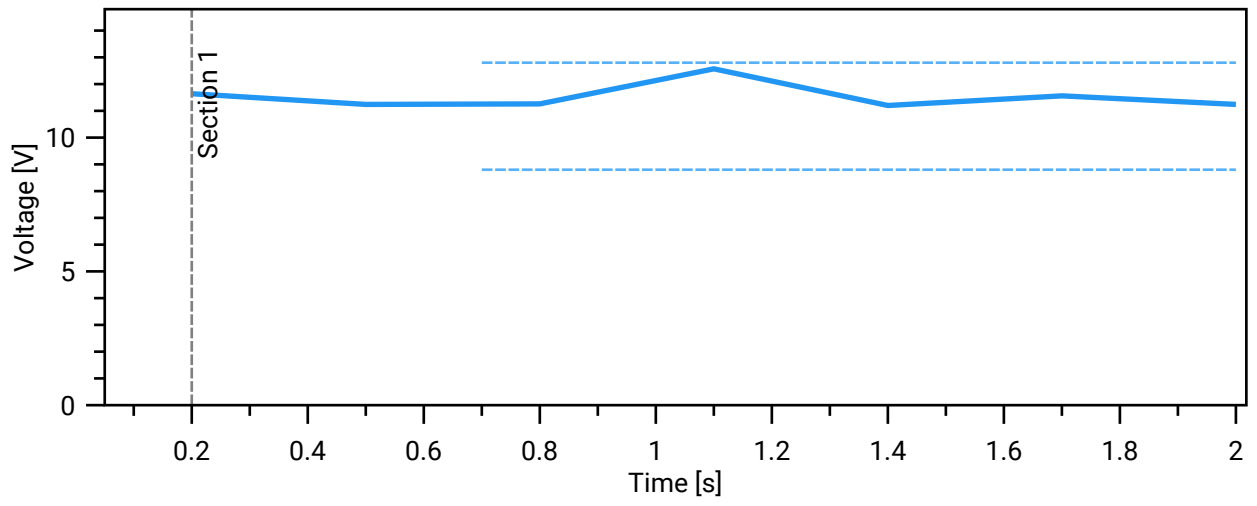
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	60
Arc gas consumption	0.6 l
Wire consumption (length)	0.112 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

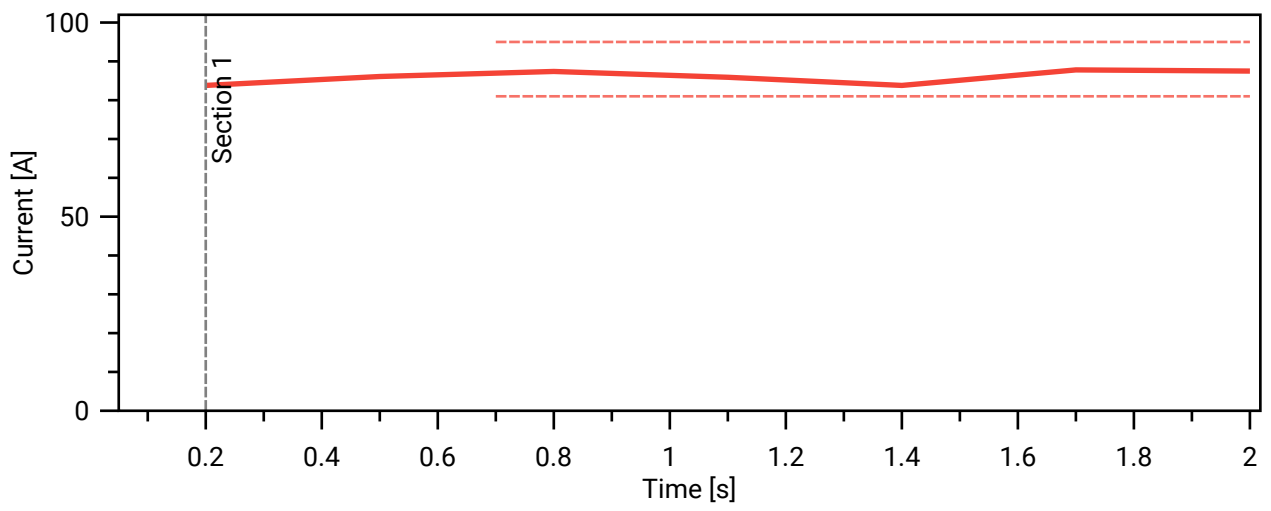
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

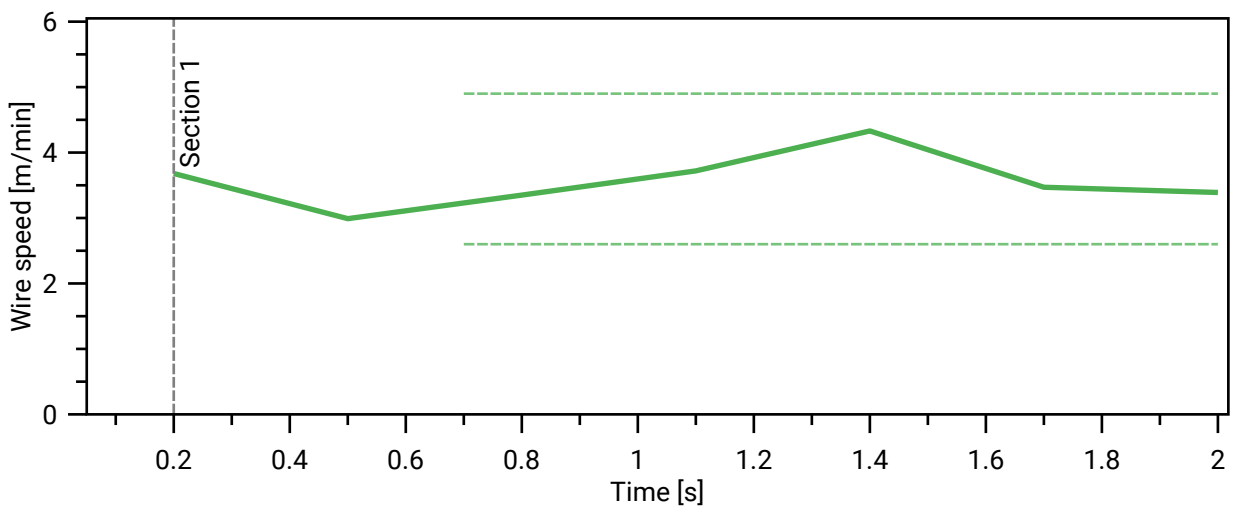
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:11:49 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.103 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

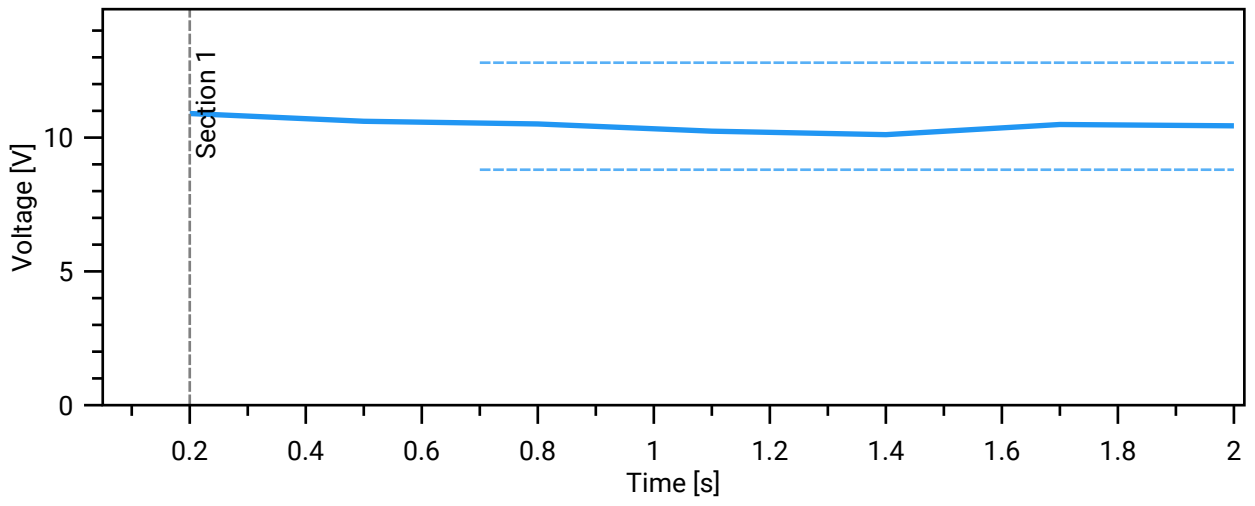
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	60
Arc gas consumption	0.6 l
Wire consumption (length)	0.103 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

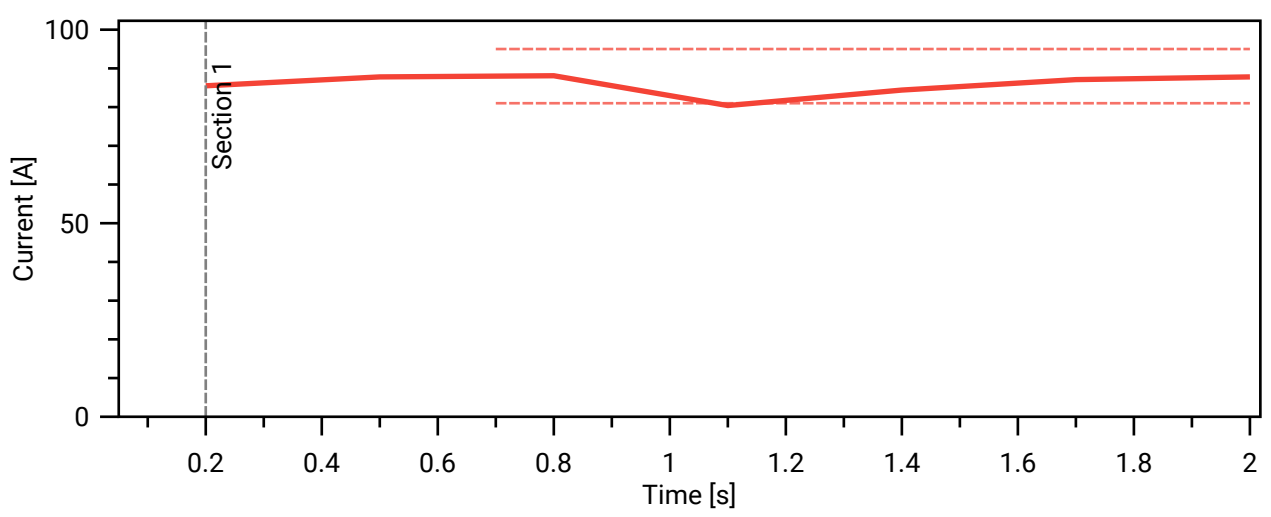
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

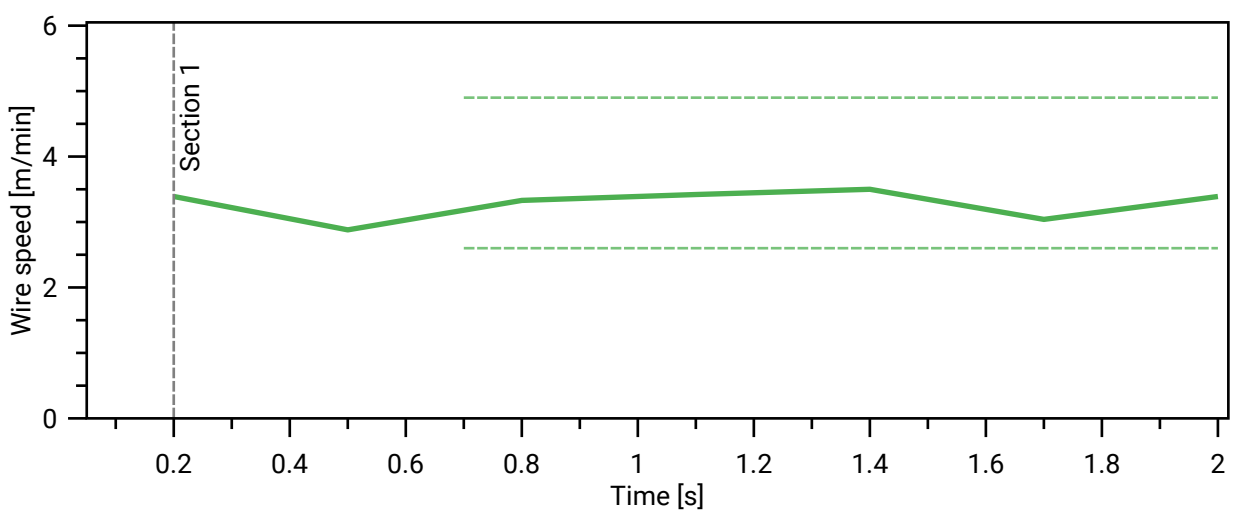
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:11:52 PM
Duration	1.1 s
Limit violations	None
Wire consumption (length)	0.051 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

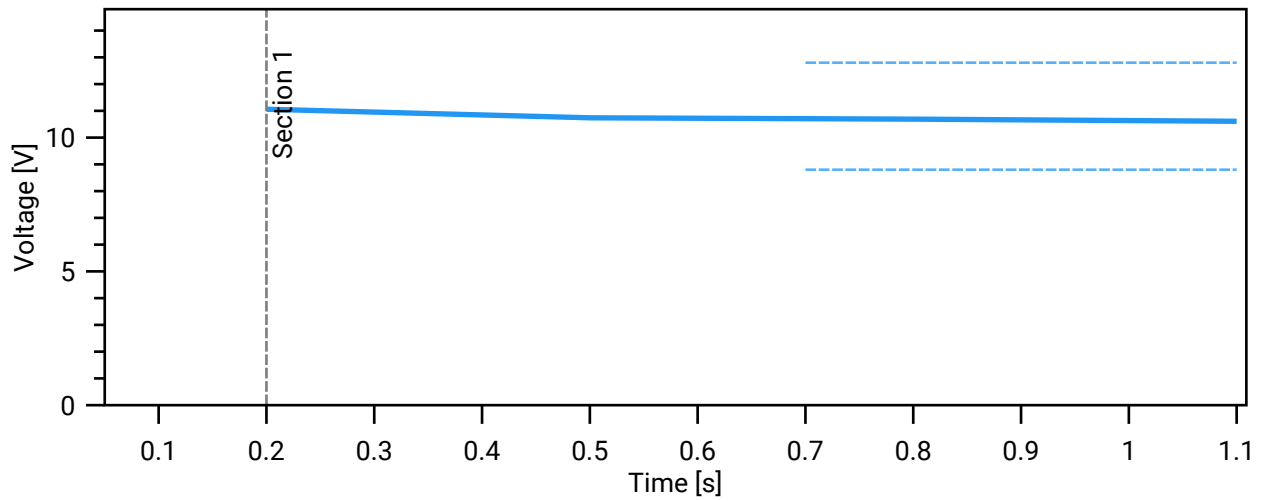
#### Section values

Welding mode	mig cmt
Duration	1.1 s
Job number	60
Arc gas consumption	0.3 l
Wire consumption (length)	0.051 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

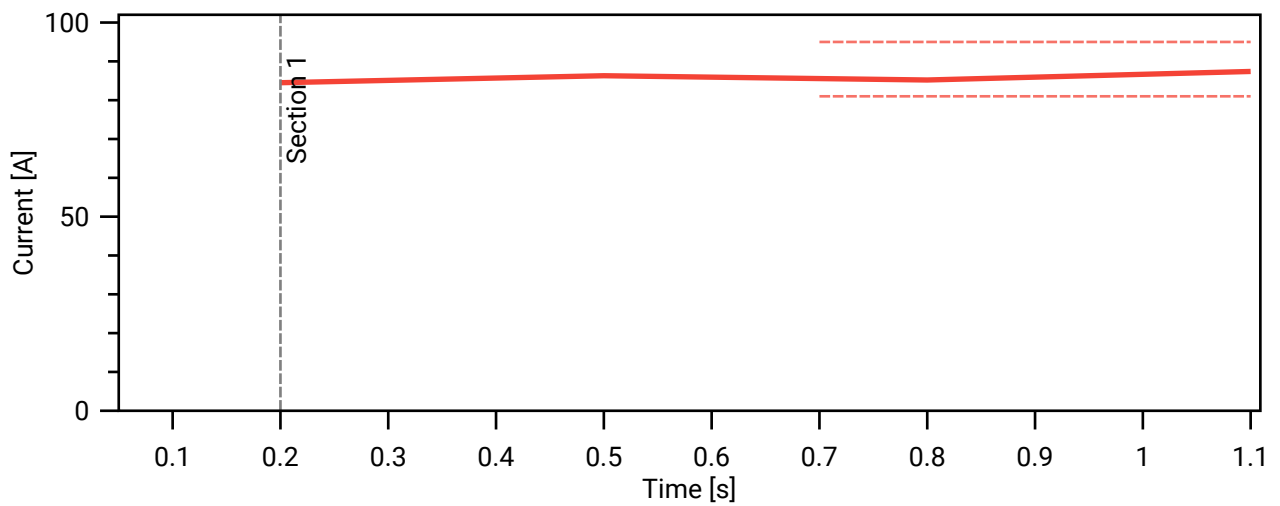
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

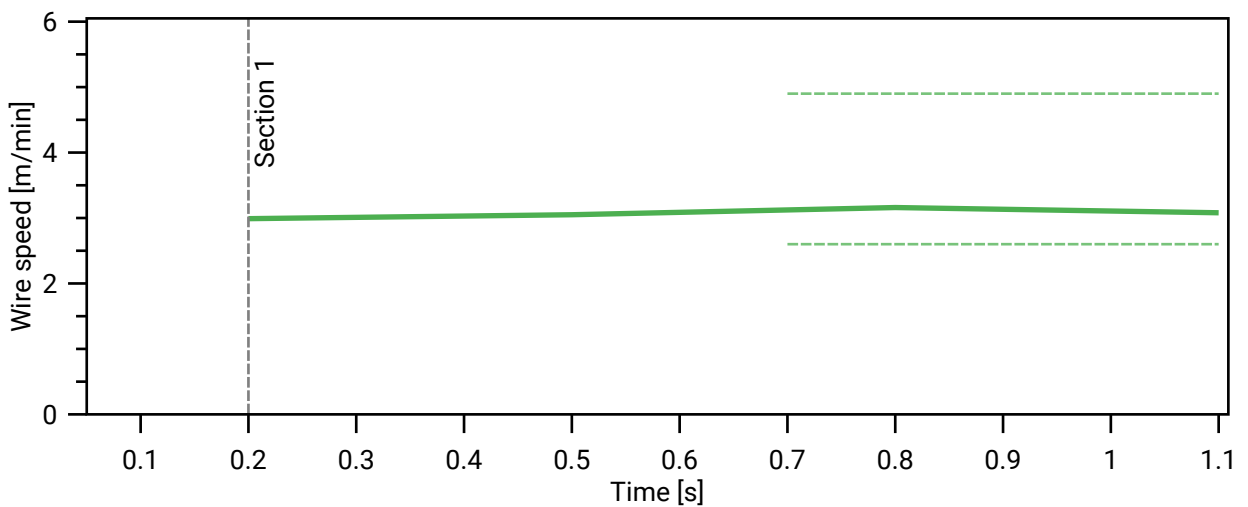
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:11:55 PM
Duration	2.3 s
Limit violations	None
Wire consumption (length)	0.129 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

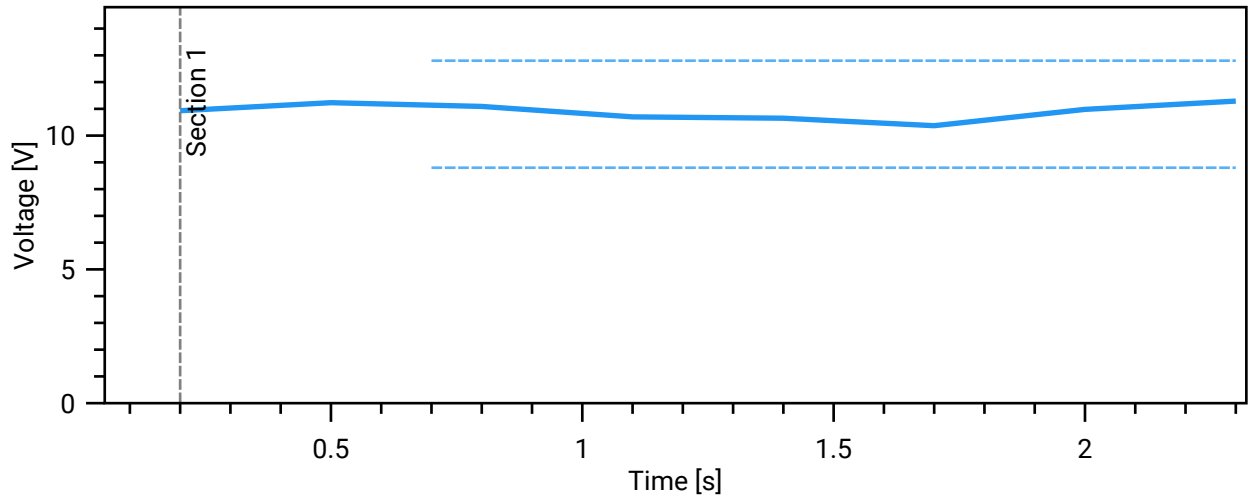
#### Section values

Welding mode	mig cmt
Duration	2.3 s
Job number	60
Arc gas consumption	0.5 l
Wire consumption (length)	0.129 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

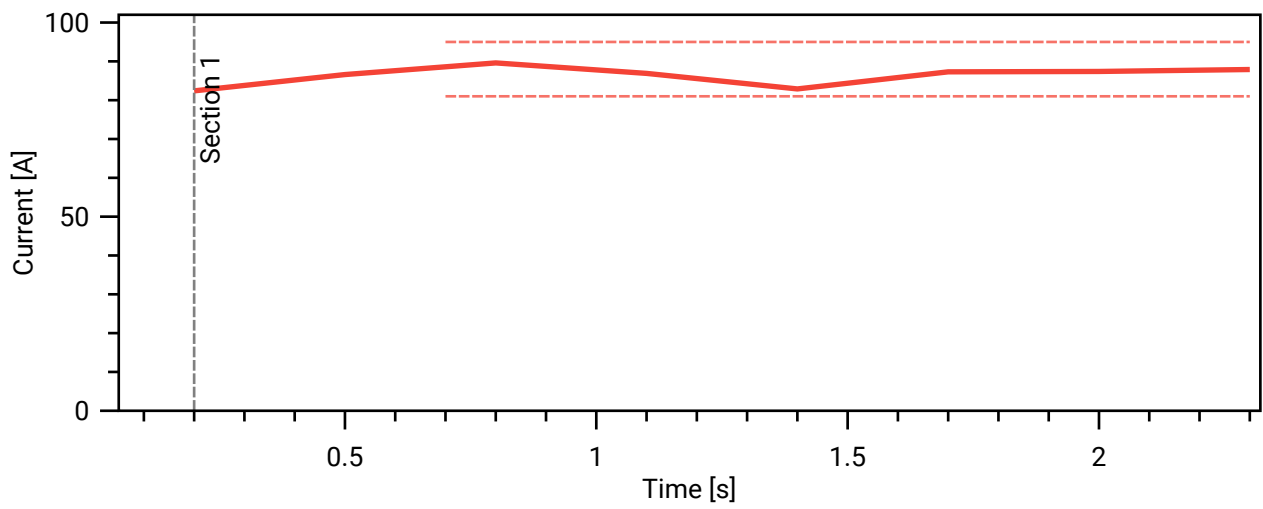
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

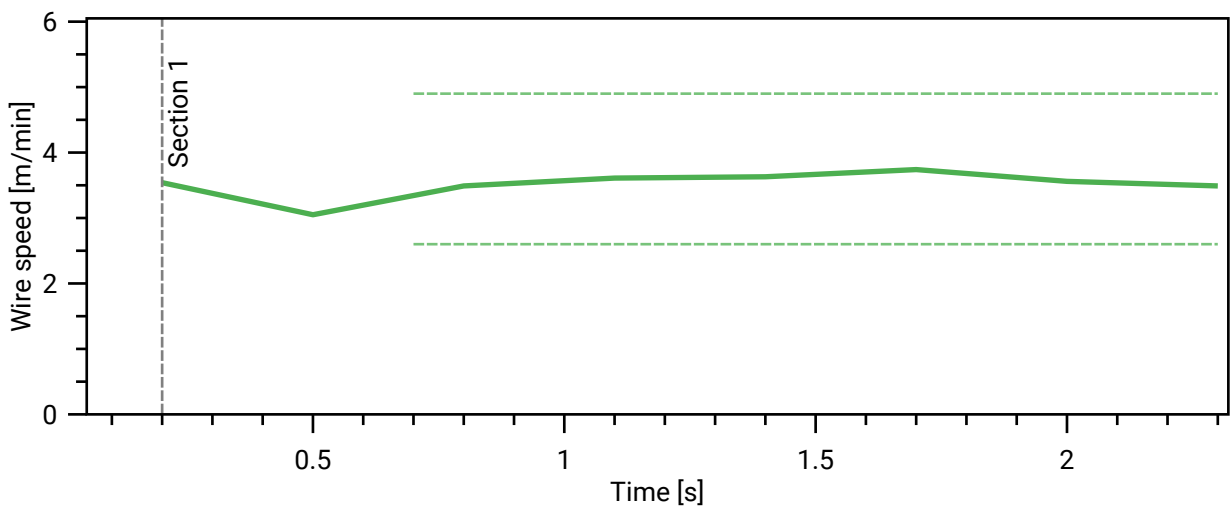
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:11:58 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.113 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

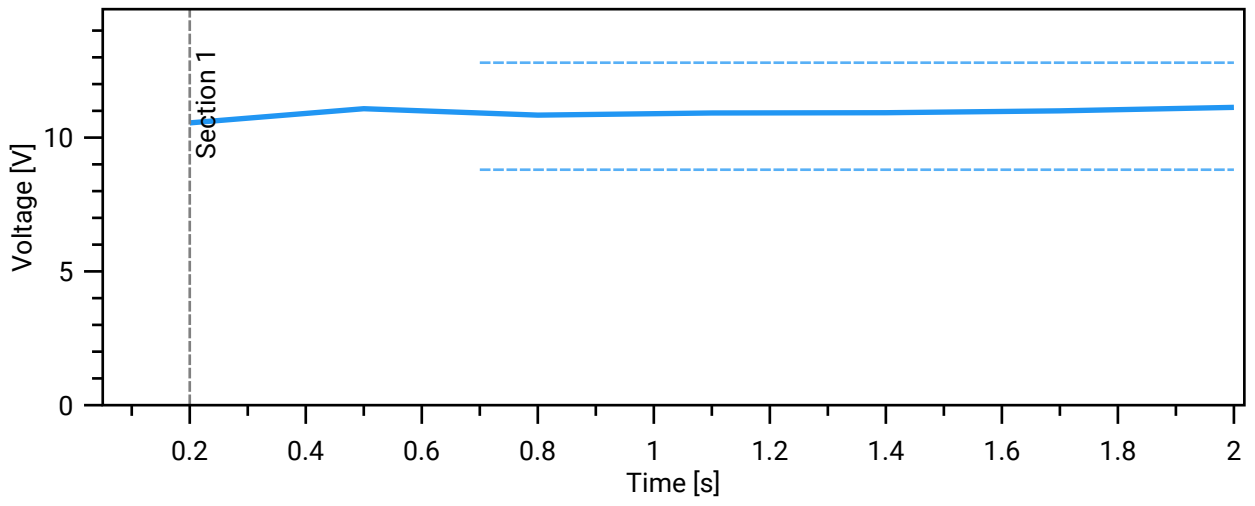
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	60
Arc gas consumption	0.6 l
Wire consumption (length)	0.113 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

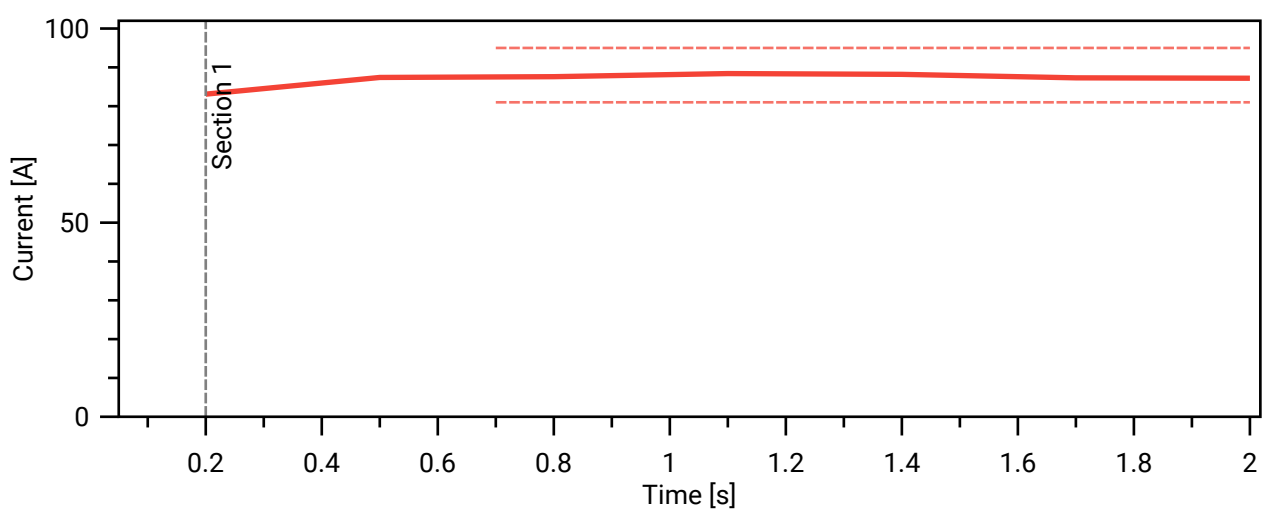
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

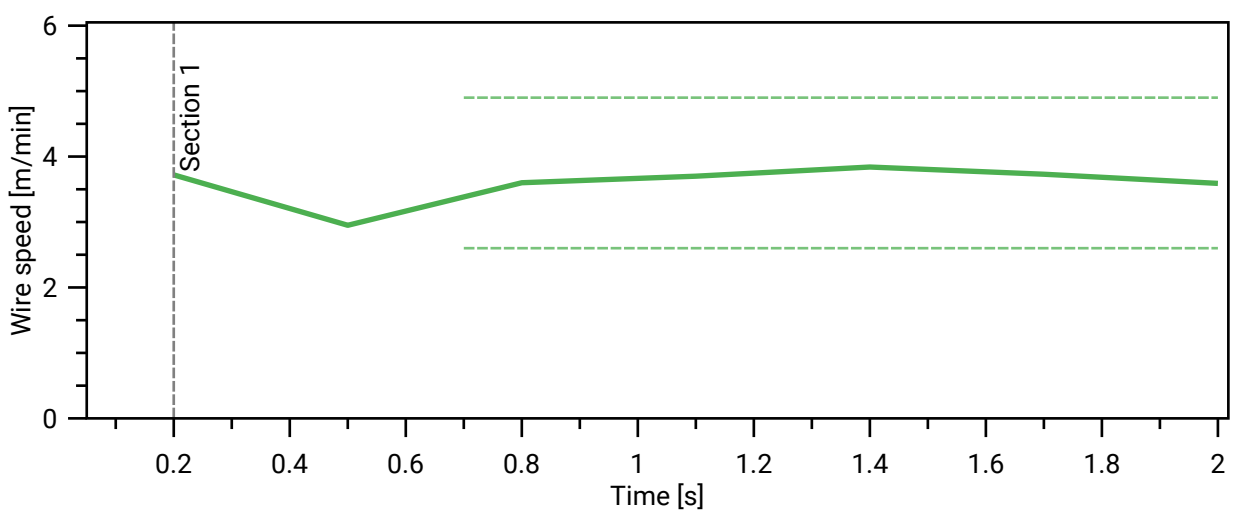
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:02 PM
Duration	2.3 s
Limit violations	None
Wire consumption (length)	0.122 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

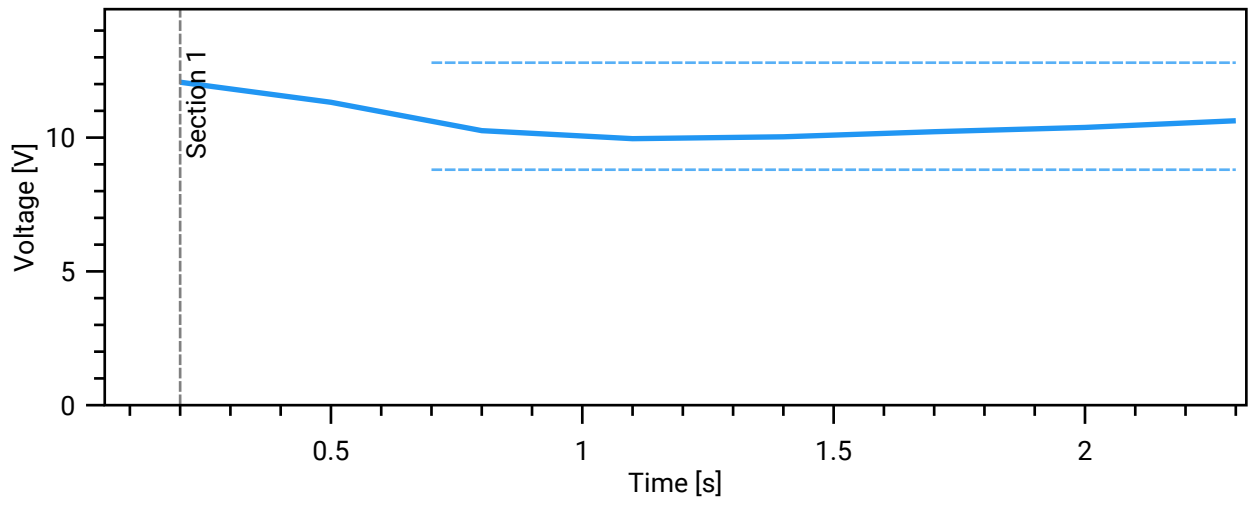
#### Section values

Welding mode	mig cmt
Duration	2.3 s
Job number	60
Arc gas consumption	0.6 l
Wire consumption (length)	0.122 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

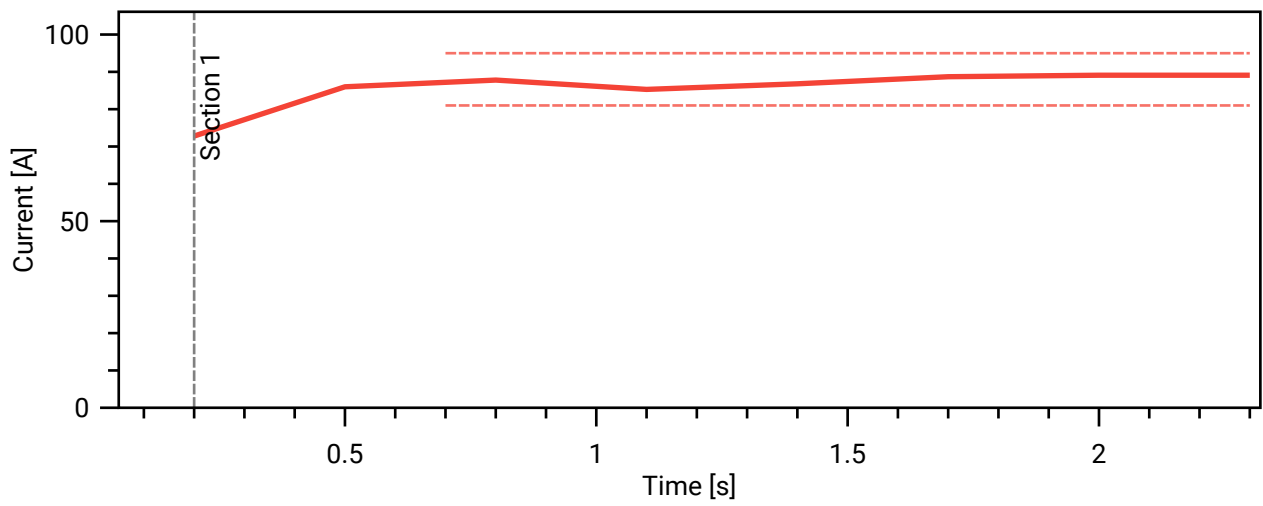
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

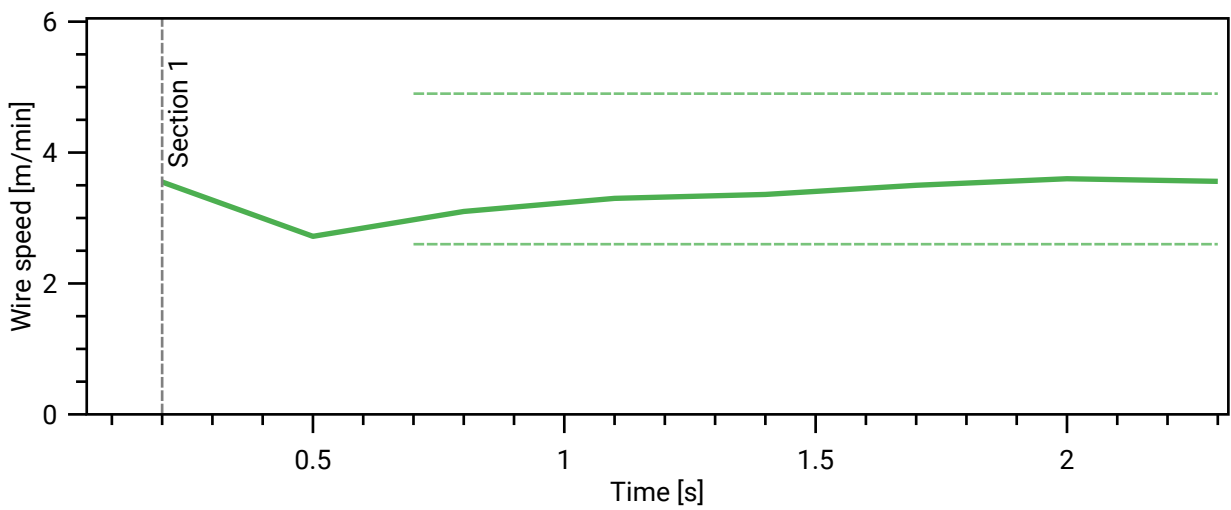
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:06 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.11 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

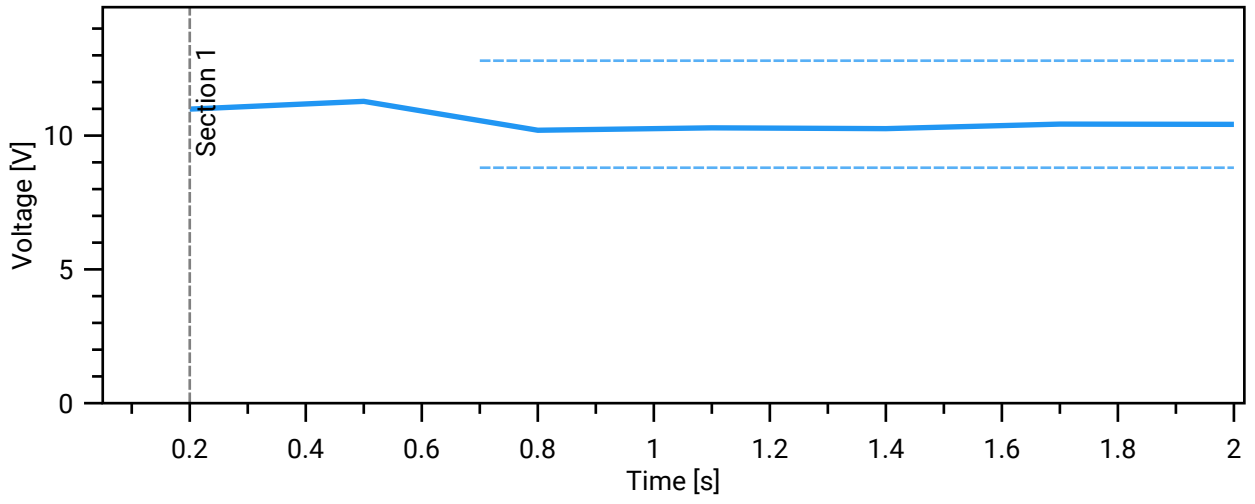
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	60
Arc gas consumption	0.5 l
Wire consumption (length)	0.11 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

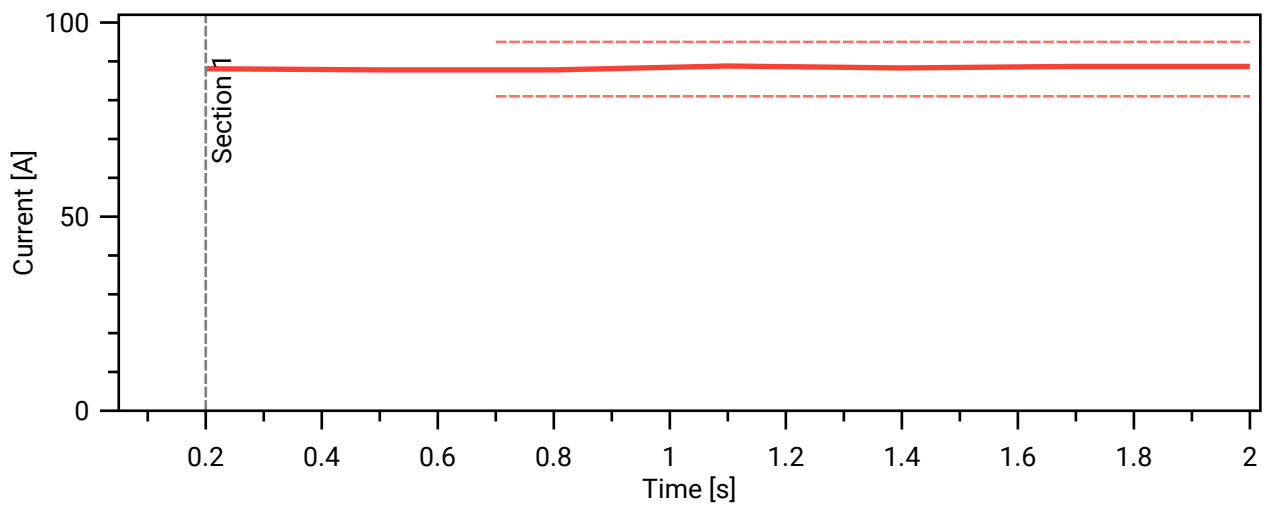
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

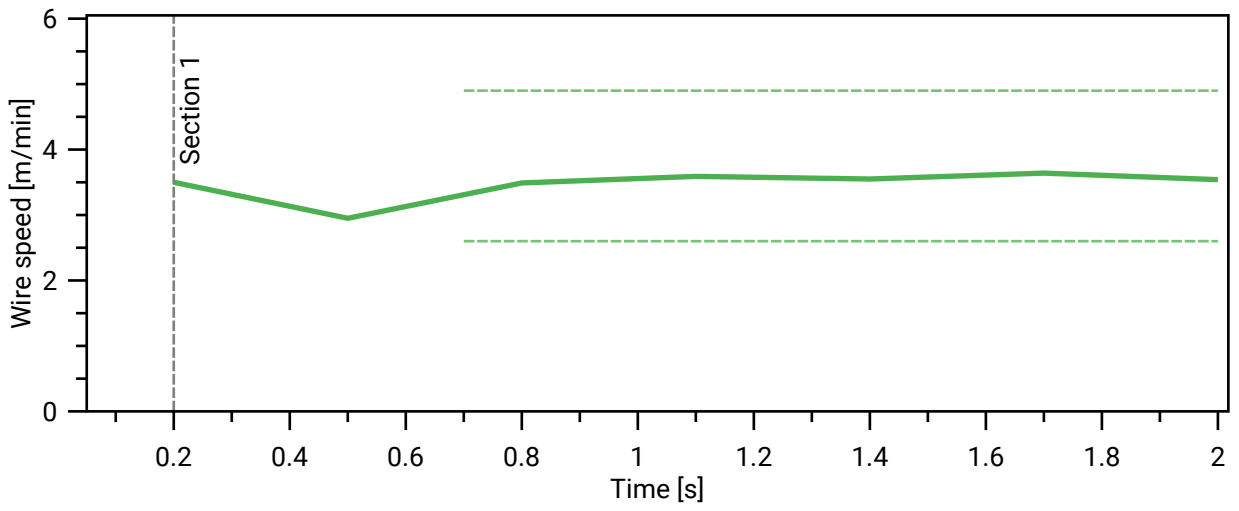
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:09 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.114 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

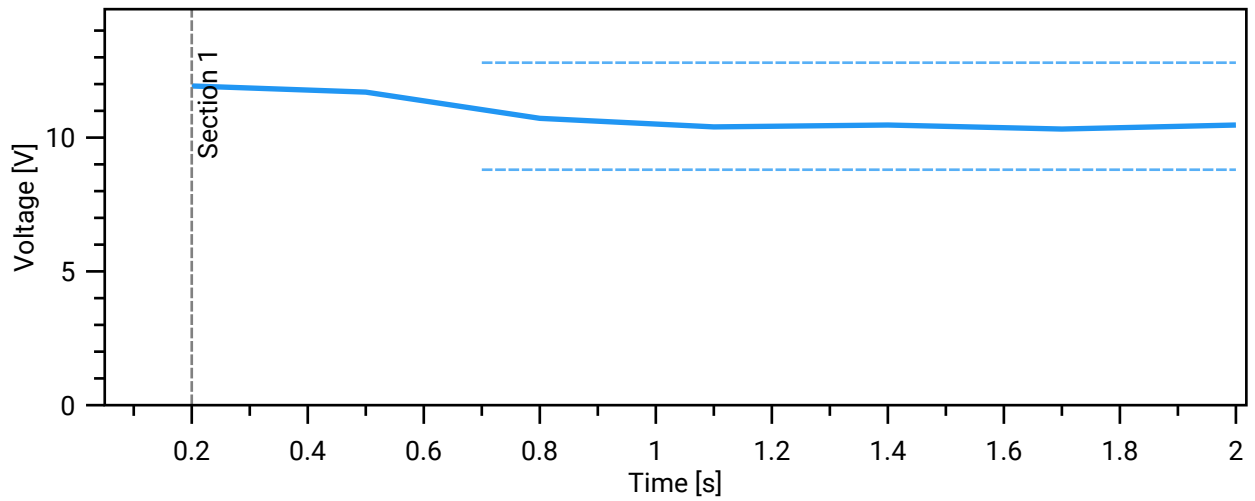
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	60
Arc gas consumption	0.6 l
Wire consumption (length)	0.114 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

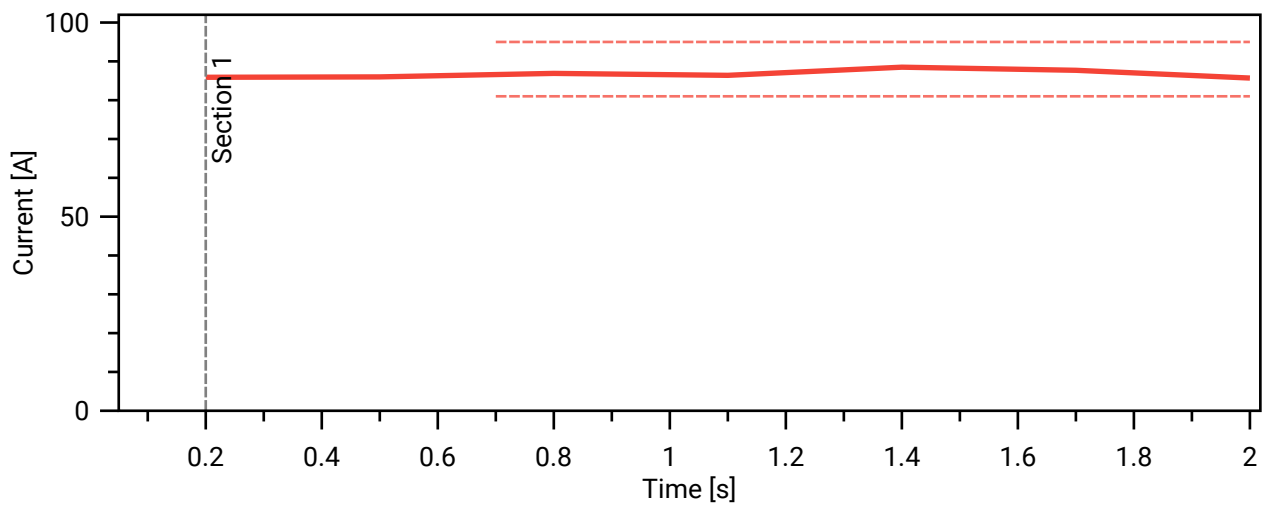
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

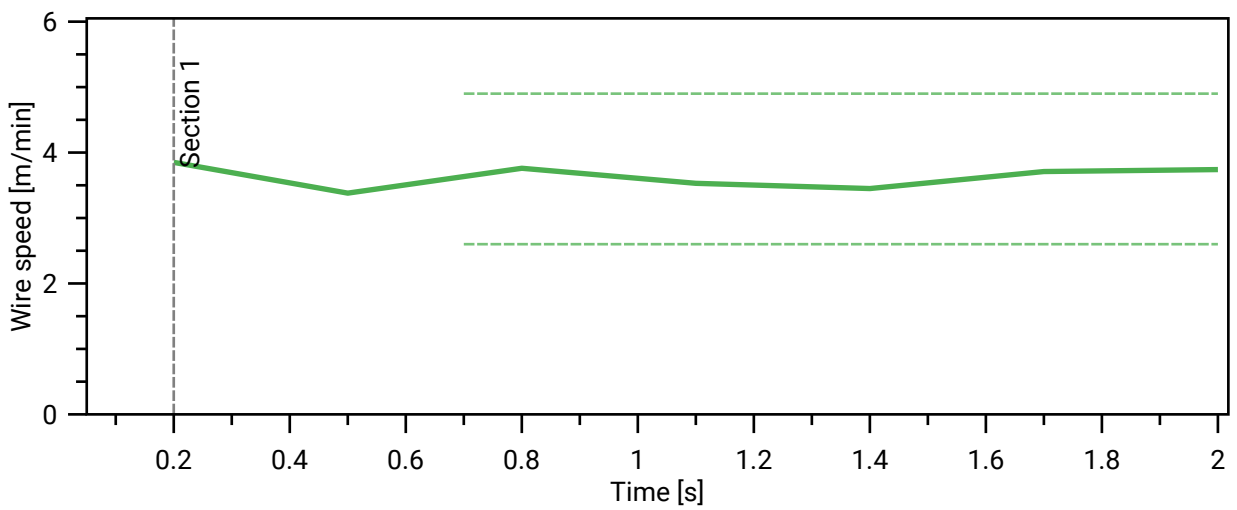
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:12 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.117 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

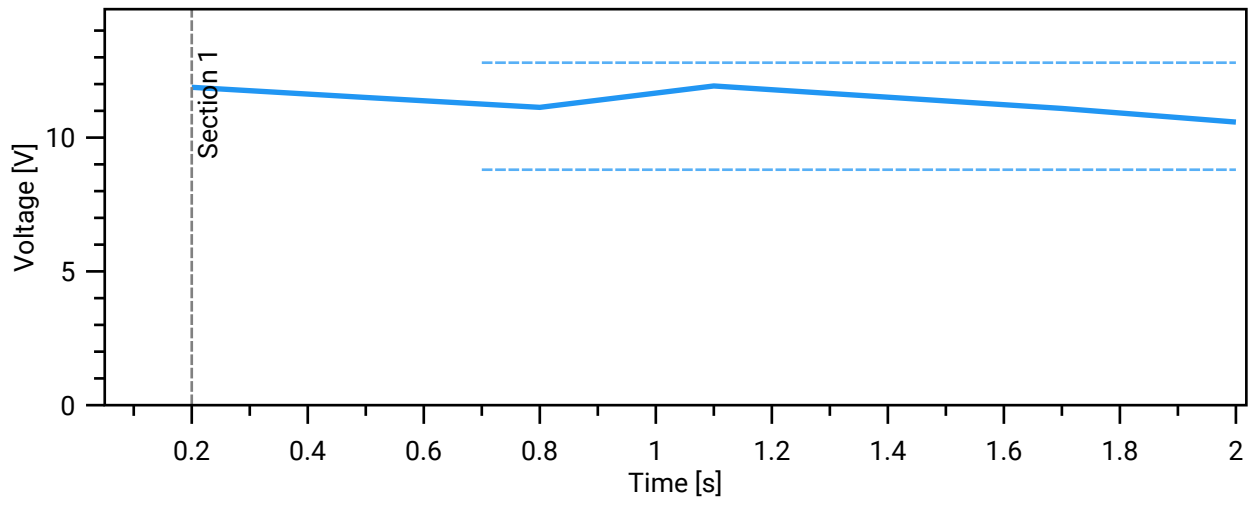
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	60
Arc gas consumption	0.6 l
Wire consumption (length)	0.117 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

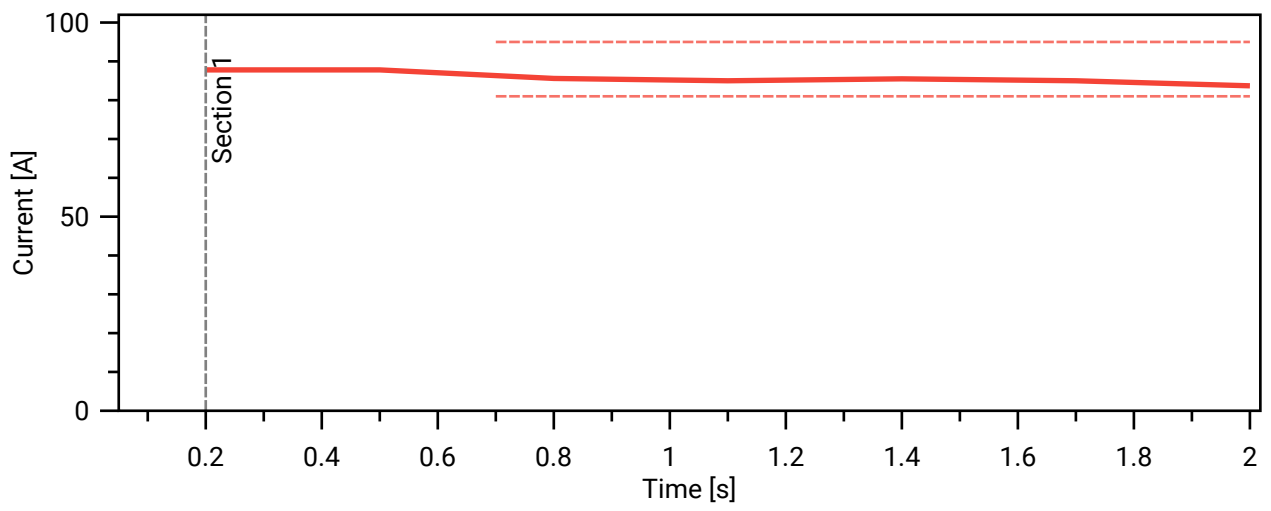
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

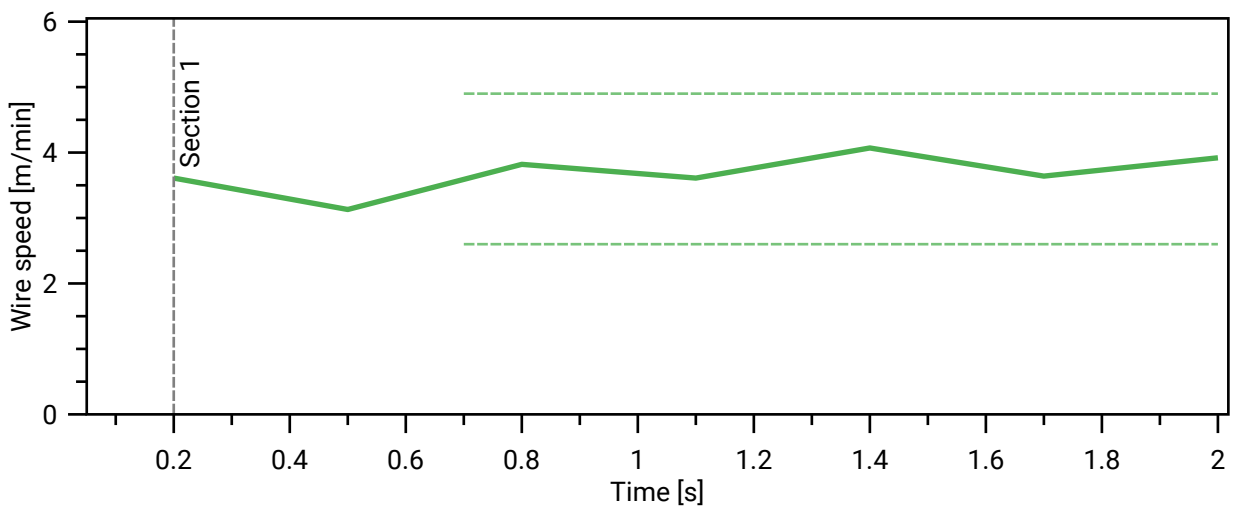
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:16 PM
Duration	1.4 s
Limit violations	None
Wire consumption (length)	0.074 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

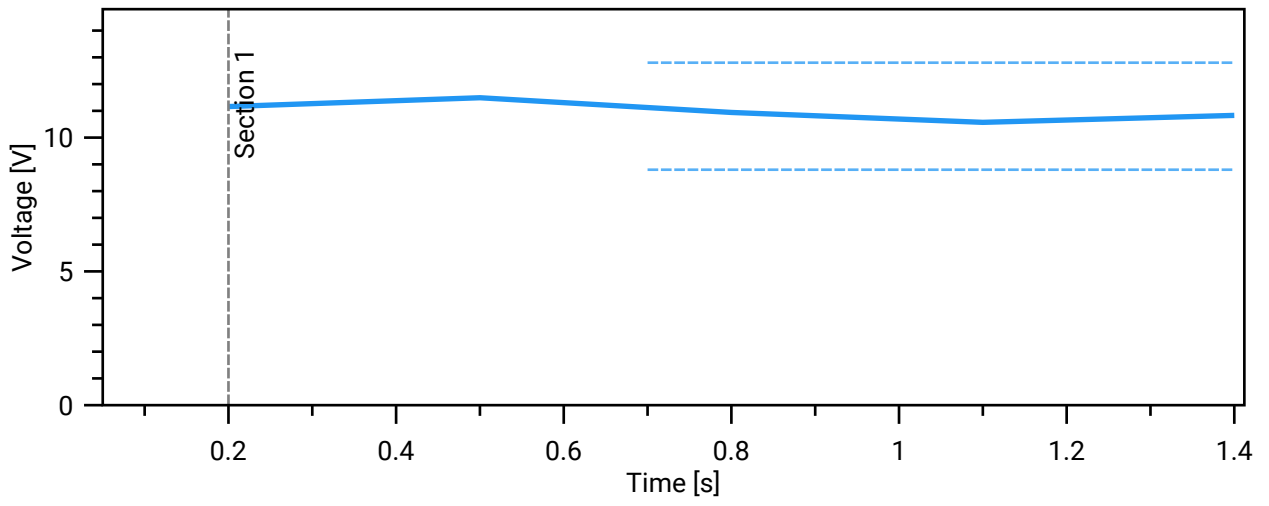
#### Section values

Welding mode	mig cmt
Duration	1.4 s
Job number	60
Arc gas consumption	0.4 l
Wire consumption (length)	0.074 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

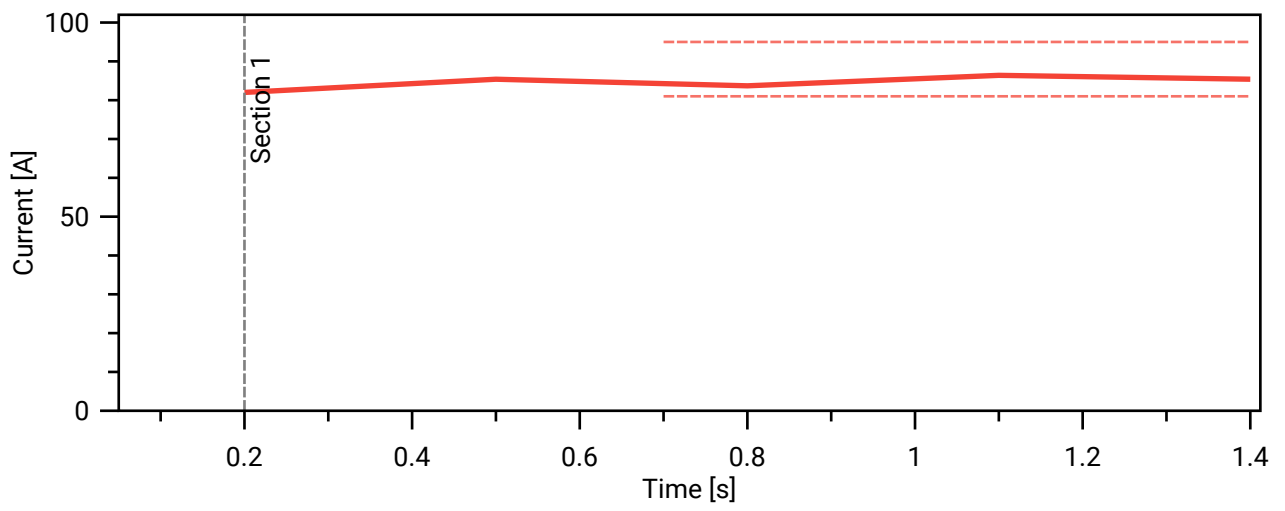
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

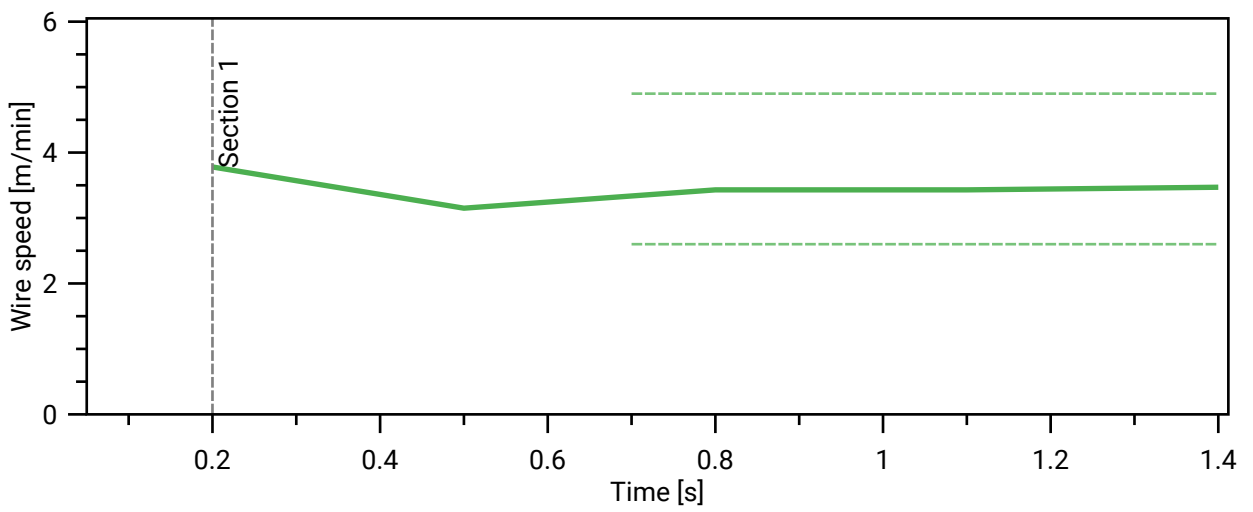
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:19 PM
Duration	1.1 s
Limit violations	None
Wire consumption (length)	0.06 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

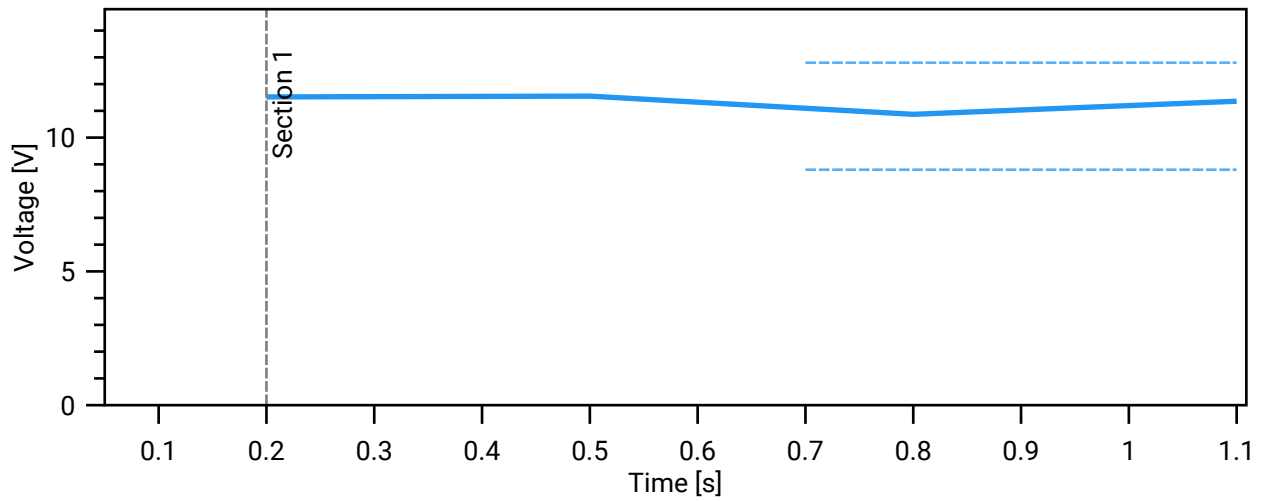
#### Section values

Welding mode	mig cmt
Duration	1.1 s
Job number	60
Arc gas consumption	0.4 l
Wire consumption (length)	0.06 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

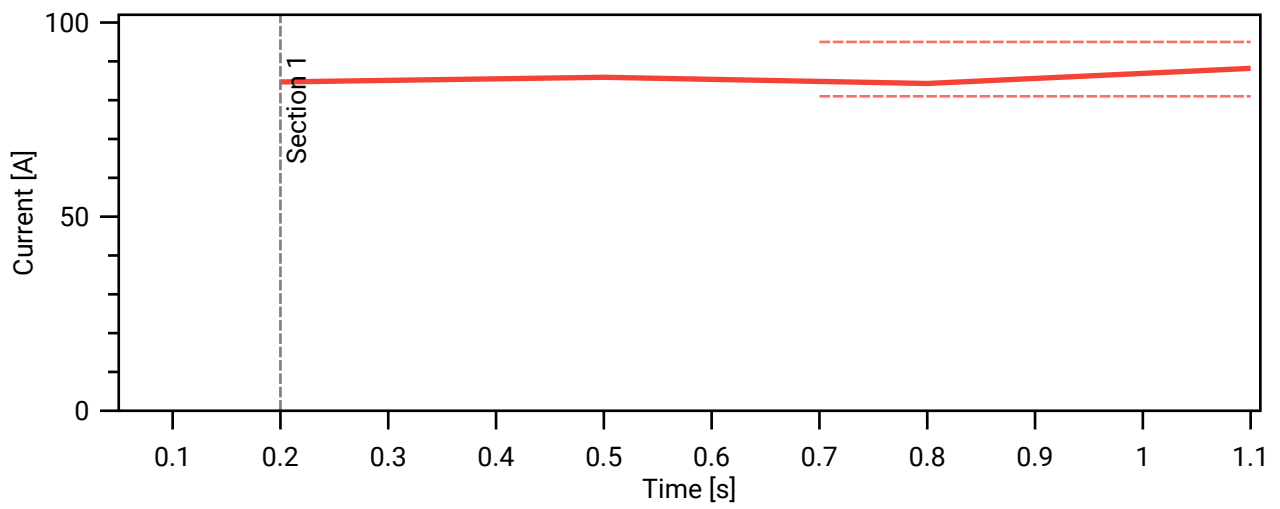
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

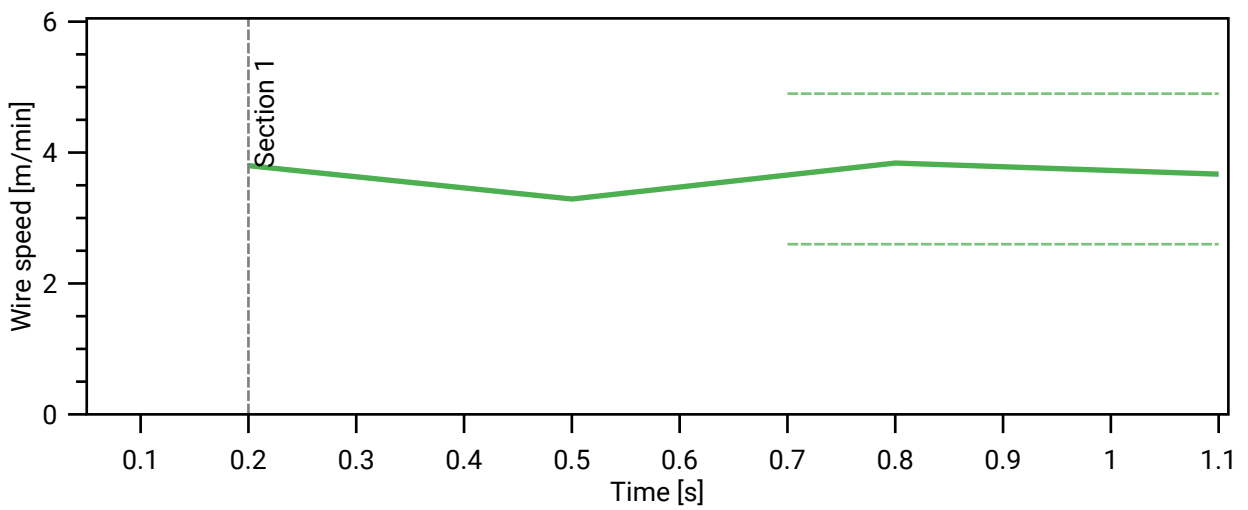
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:21 PM
Duration	2.3 s
Limit violations	None
Wire consumption (length)	0.138 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

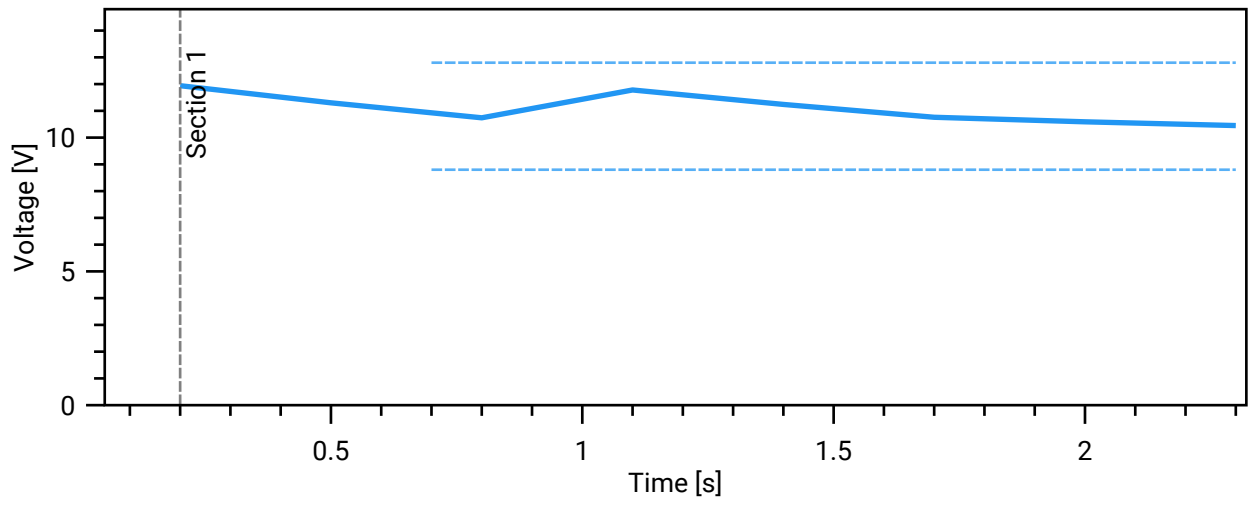
#### Section values

Welding mode	mig cmt
Duration	2.3 s
Job number	60
Arc gas consumption	0.6 l
Wire consumption (length)	0.138 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

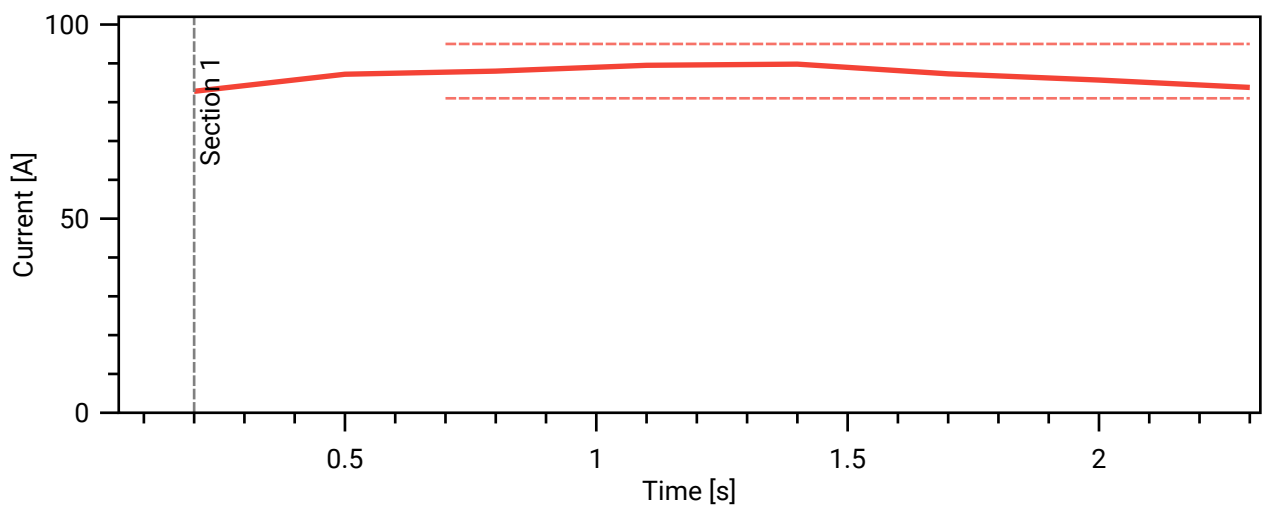
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

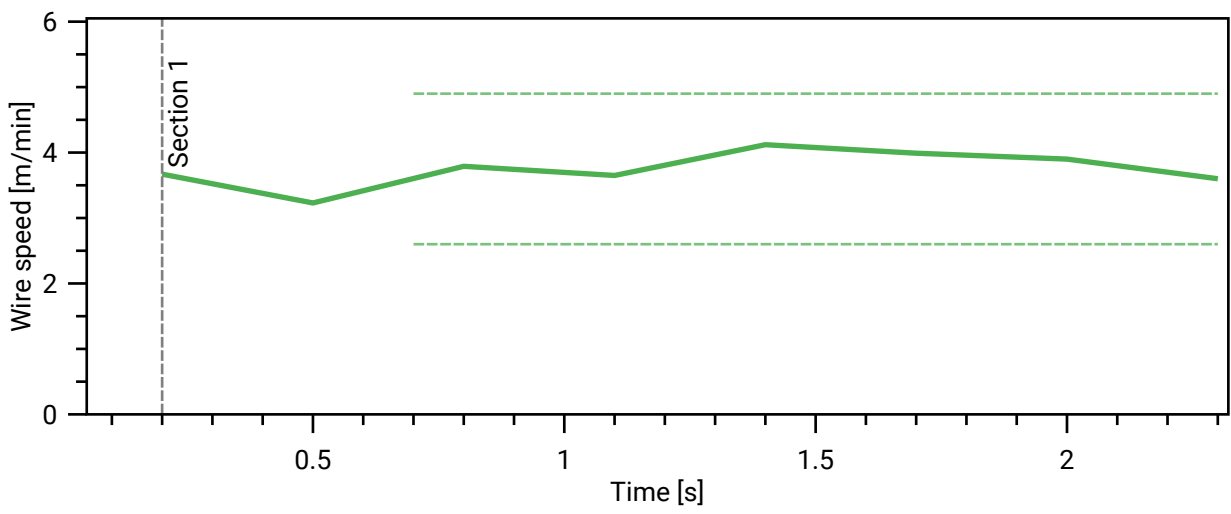
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:25 PM
Duration	2.3 s
Limit violations	None
Wire consumption (length)	0.14 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

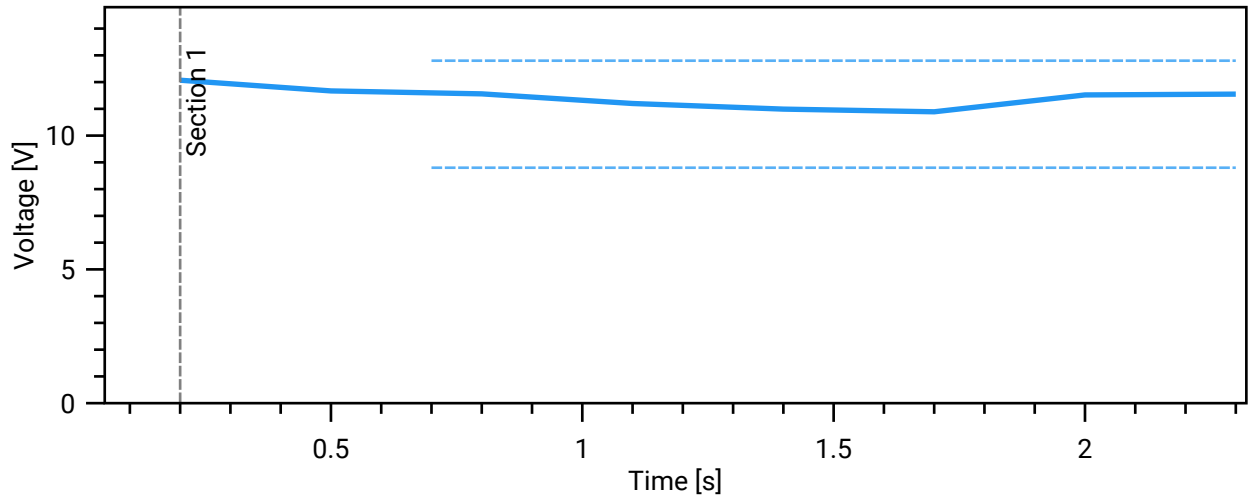
#### Section values

Welding mode	mig cmt
Duration	2.3 s
Job number	60
Arc gas consumption	0.6 l
Wire consumption (length)	0.14 m
Reference number of weld characteristic	1053
Wire speed	3.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	10.05 V
I approximately	90.5 A
Spatter free ignition	Off
SynchroPulse	Off

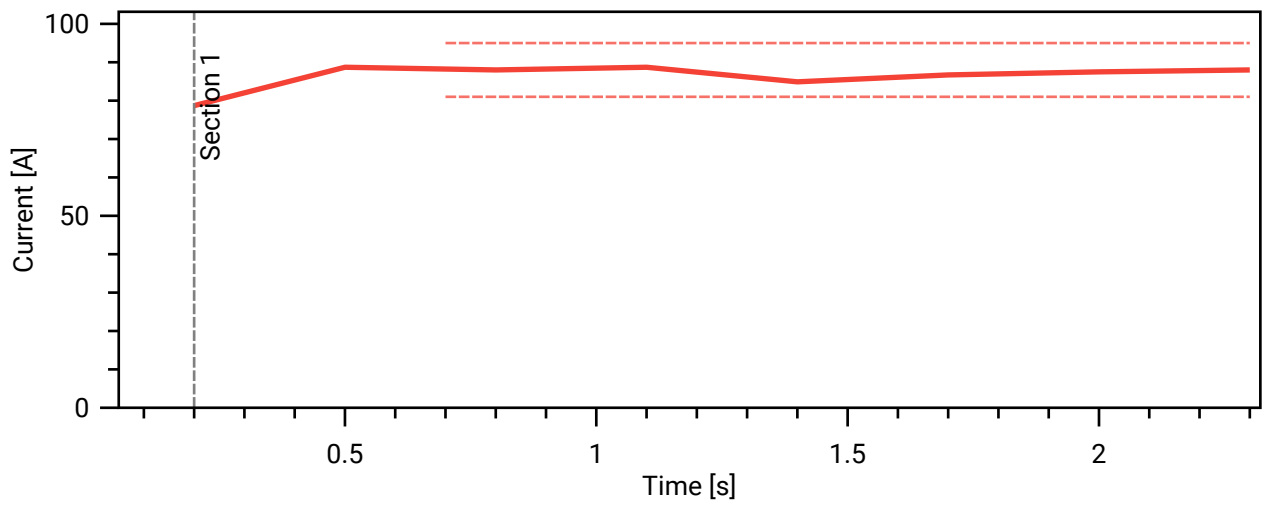
#### QMaster

Welding current command value	88 A (7 A / -7 A)
Voltage command value	10.8 V (2.0 V / -2.0 V)
Wire speed command value	3.5 m/min (1.4 m/min / -0.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

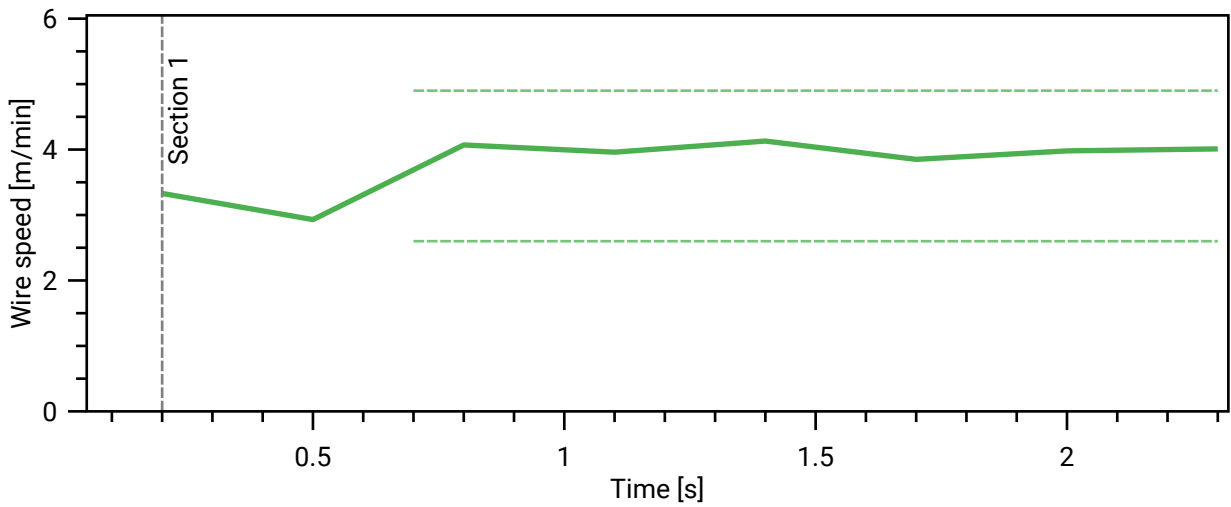
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:29 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.197 m

## Machine

Name	<a href="#">TPS5000CMT Second Line</a>
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

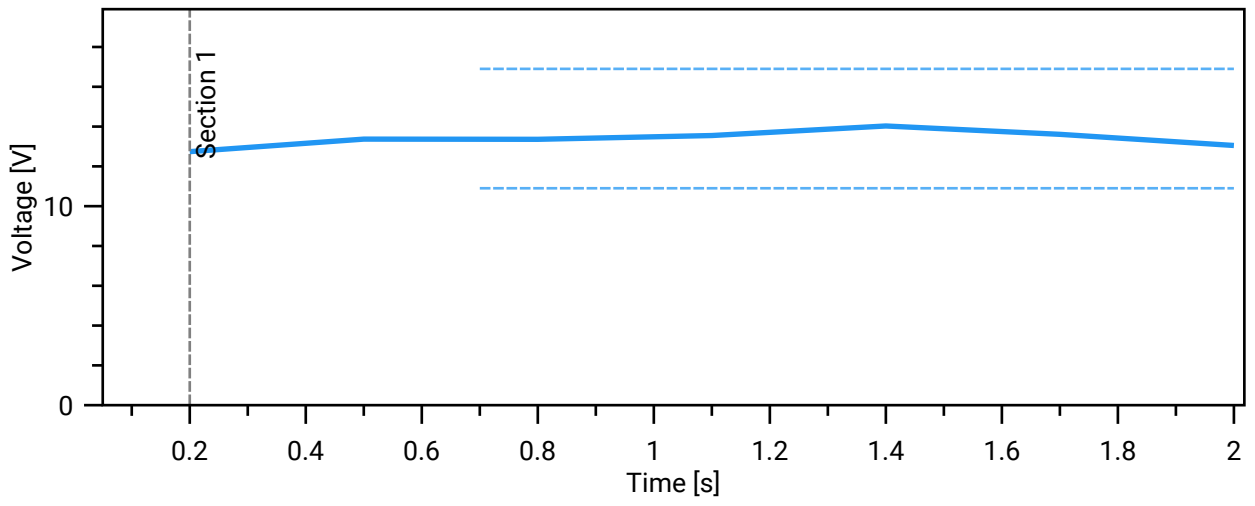
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	61
Arc gas consumption	0.6 l
Wire consumption (length)	0.197 m
Reference number of weld characteristic	1053
Wire speed	7 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	12.79 V
I approximately	169.8 A
Spatter free ignition	Off
SynchroPulse	Off

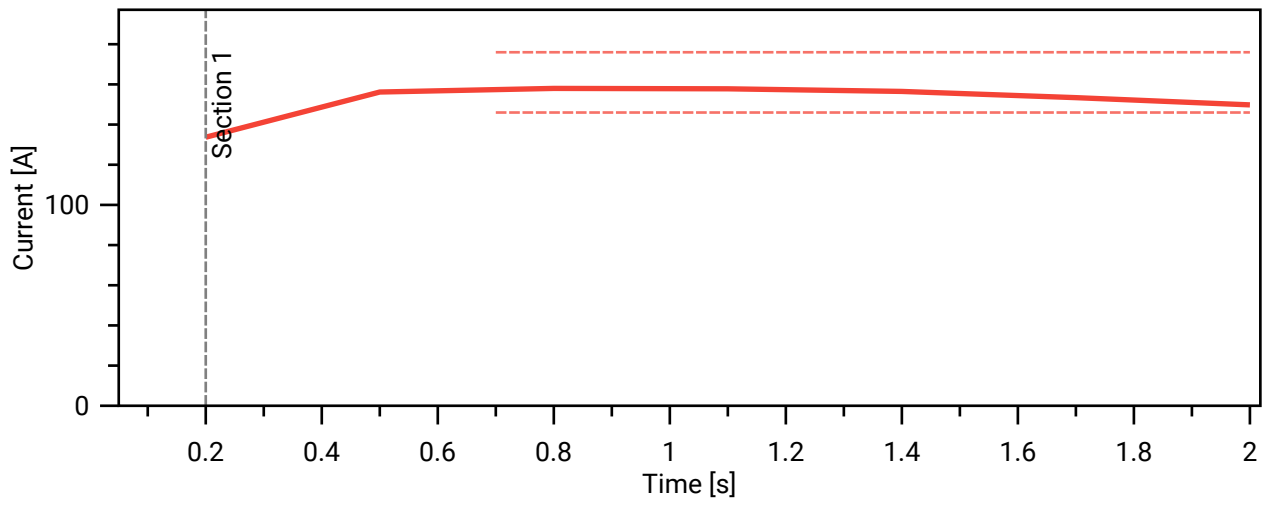
#### QMaster

Welding current command value	161 A (15 A / -15 A)
Voltage command value	13.9 V (3.0 V / -3.0 V)
Wire speed command value	7.0 m/min (2.3 m/min / -2.1 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

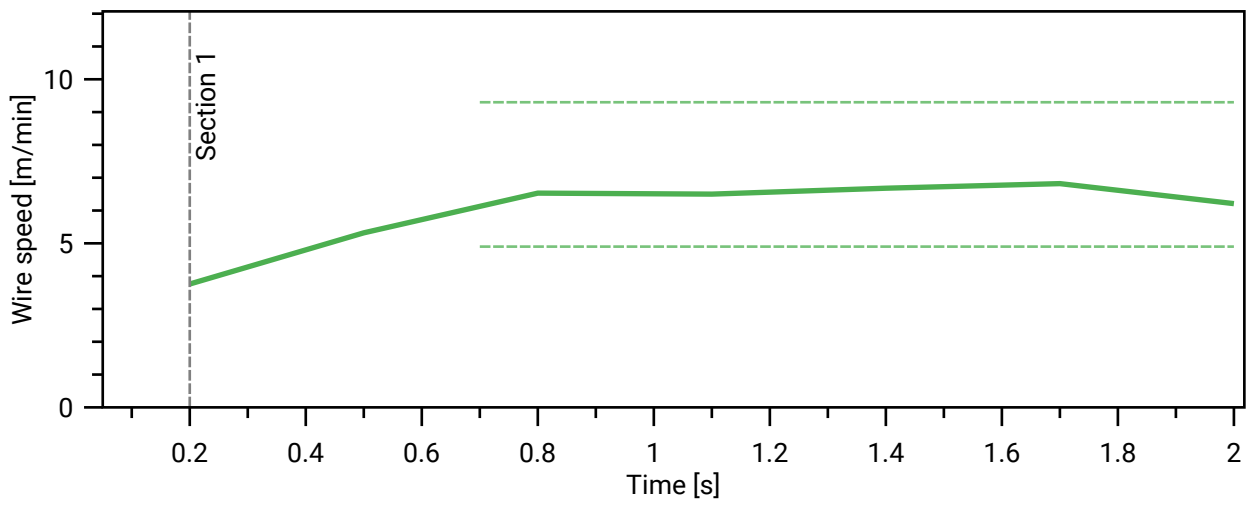
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:32 PM
Duration	2.6 s
Limit violations	None
Wire consumption (length)	0.295 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

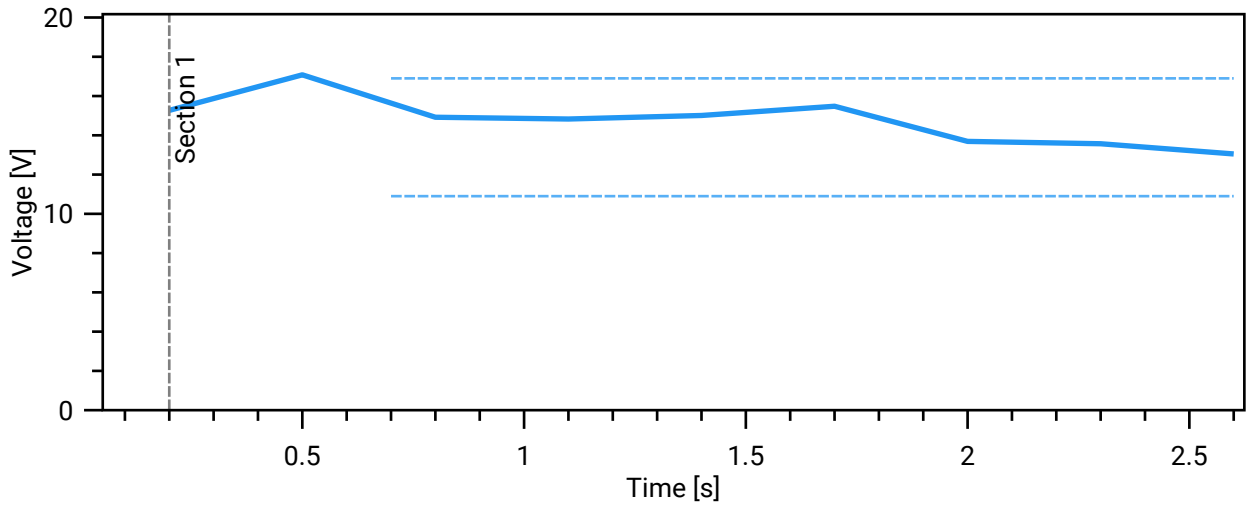
#### Section values

Welding mode	mig cmt
Duration	2.6 s
Job number	61
Arc gas consumption	0.7 l
Wire consumption (length)	0.295 m
Reference number of weld characteristic	1053
Wire speed	7 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	12.79 V
I approximately	169.8 A
Spatter free ignition	Off
SynchroPulse	Off

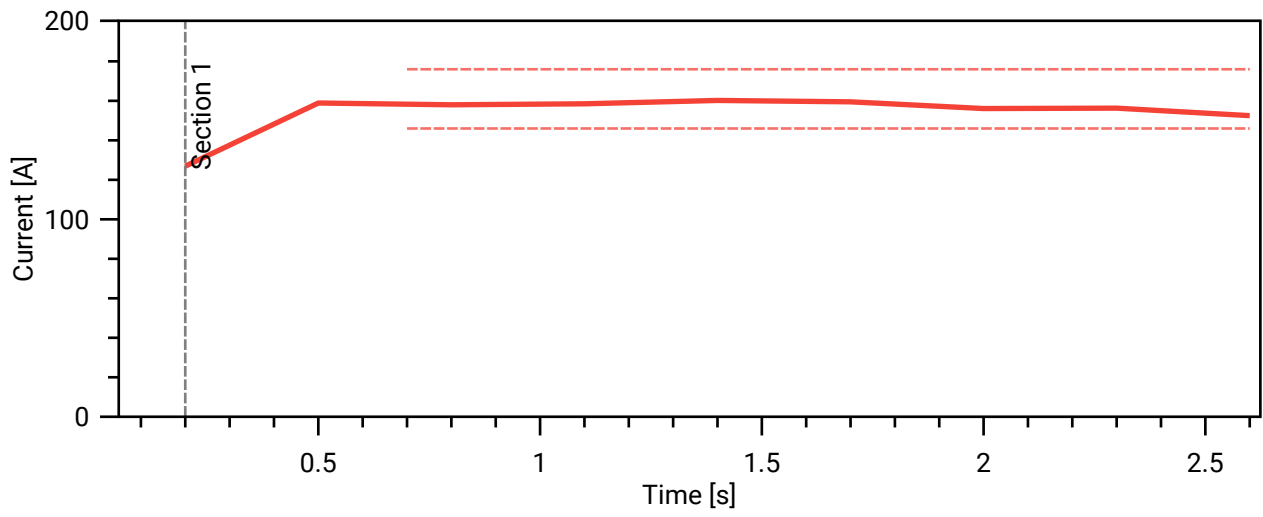
#### QMaster

Welding current command value	161 A (15 A / -15 A)
Voltage command value	13.9 V (3.0 V / -3.0 V)
Wire speed command value	7.0 m/min (2.3 m/min / -2.1 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

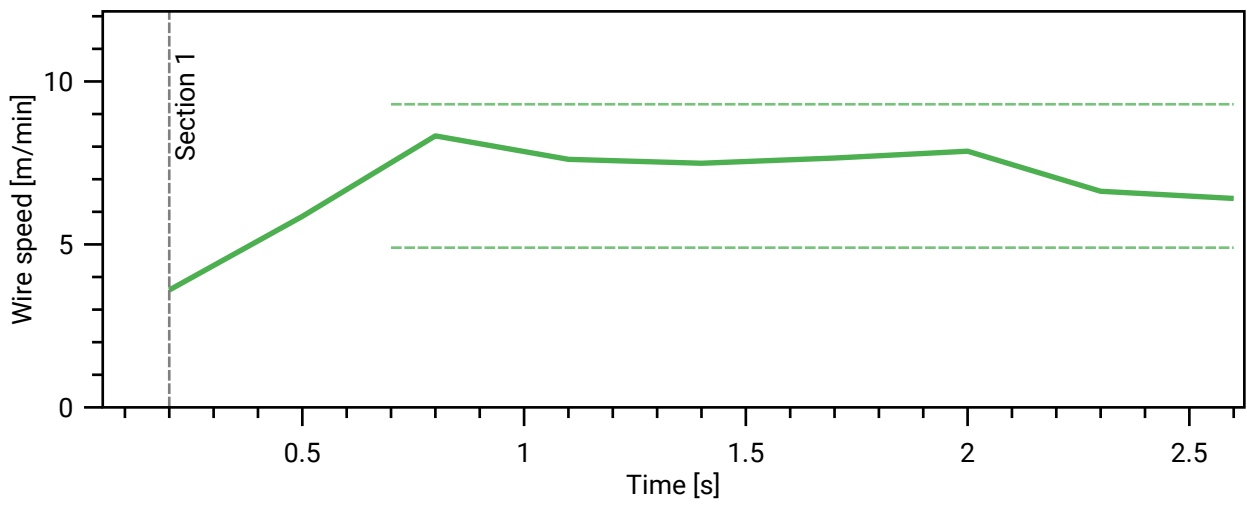
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:36 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.193 m

## Machine

Name	<a href="#">TPS5000CMT Second Line</a>
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

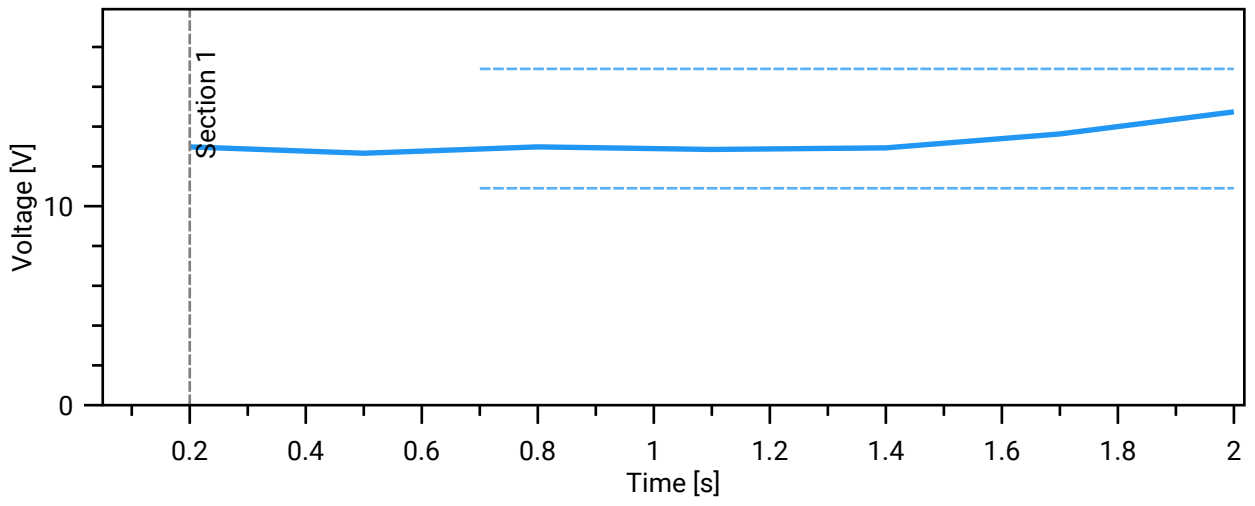
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	61
Arc gas consumption	0.5 l
Wire consumption (length)	0.193 m
Reference number of weld characteristic	1053
Wire speed	7 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	12.79 V
I approximately	169.8 A
Spatter free ignition	Off
SynchroPulse	Off

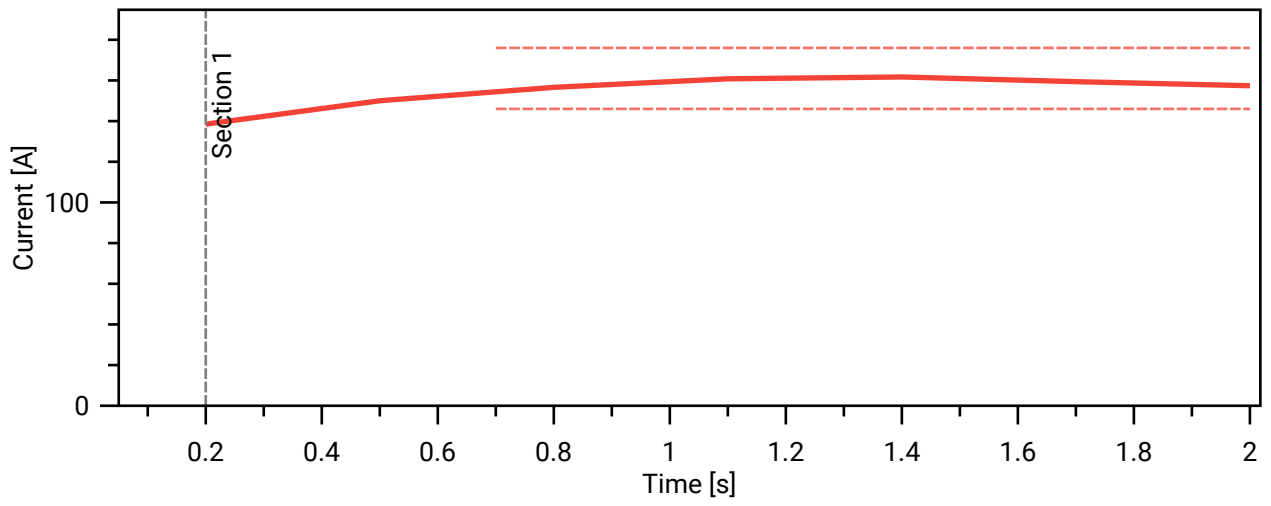
#### QMaster

Welding current command value	161 A (15 A / -15 A)
Voltage command value	13.9 V (3.0 V / -3.0 V)
Wire speed command value	7.0 m/min (2.3 m/min / -2.1 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

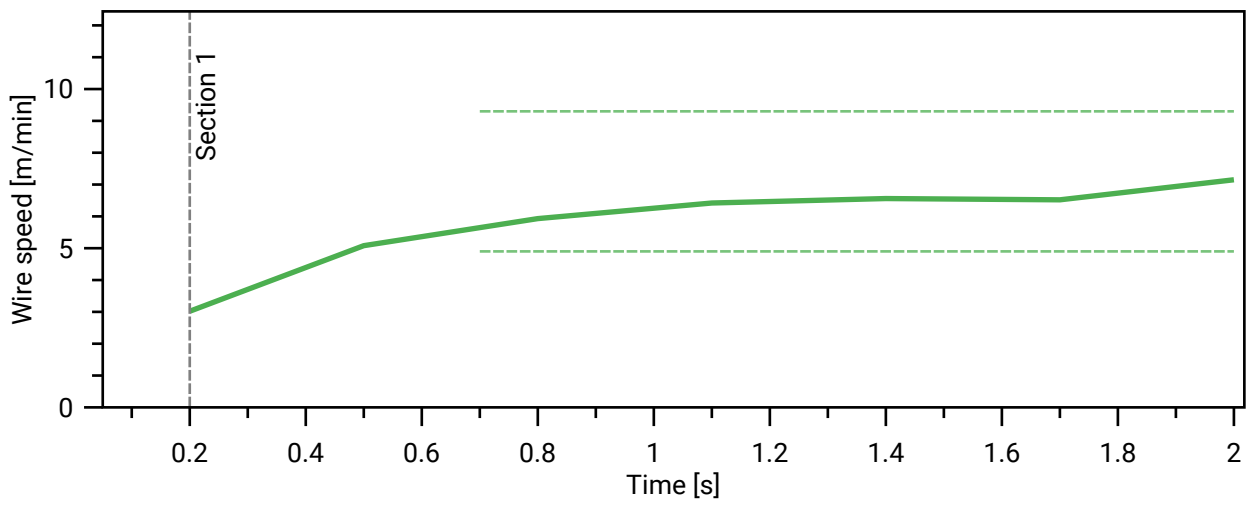
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:40 PM
Duration	0.5 s
Limit violations	None
Wire consumption (length)	0.019 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

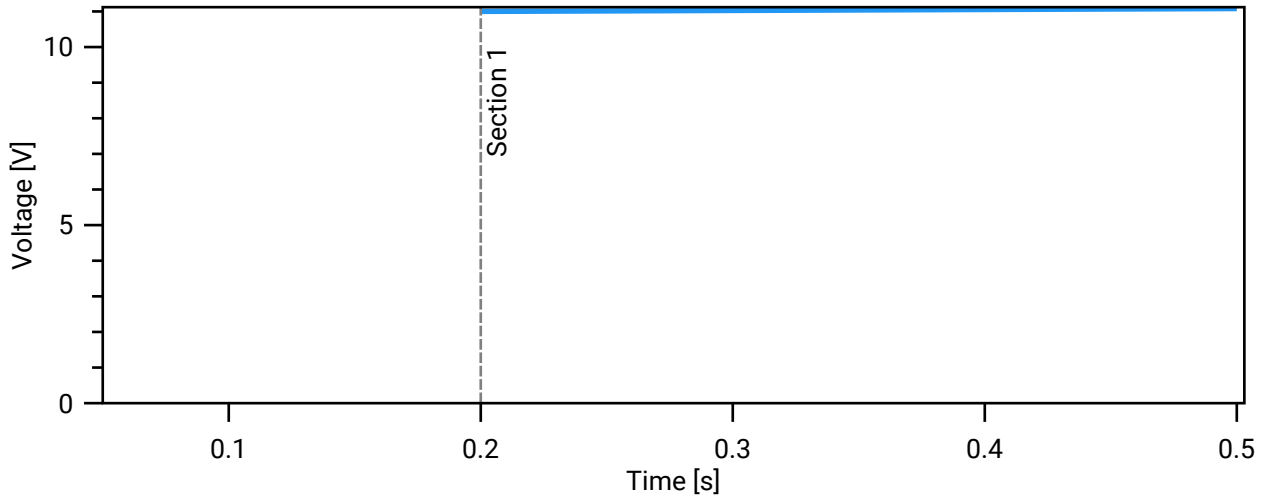
#### Section values

Welding mode	mig cmt
Duration	0.5 s
Job number	62
Arc gas consumption	0.3 l
Wire consumption (length)	0.019 m
Reference number of weld characteristic	1053
Wire speed	4.8 m/min
Arc length correction	-1 %
Pulse correction	0 %
U approximately	11.28 V
I approximately	114.4 A
Spatter free ignition	Off
SynchroPulse	Off

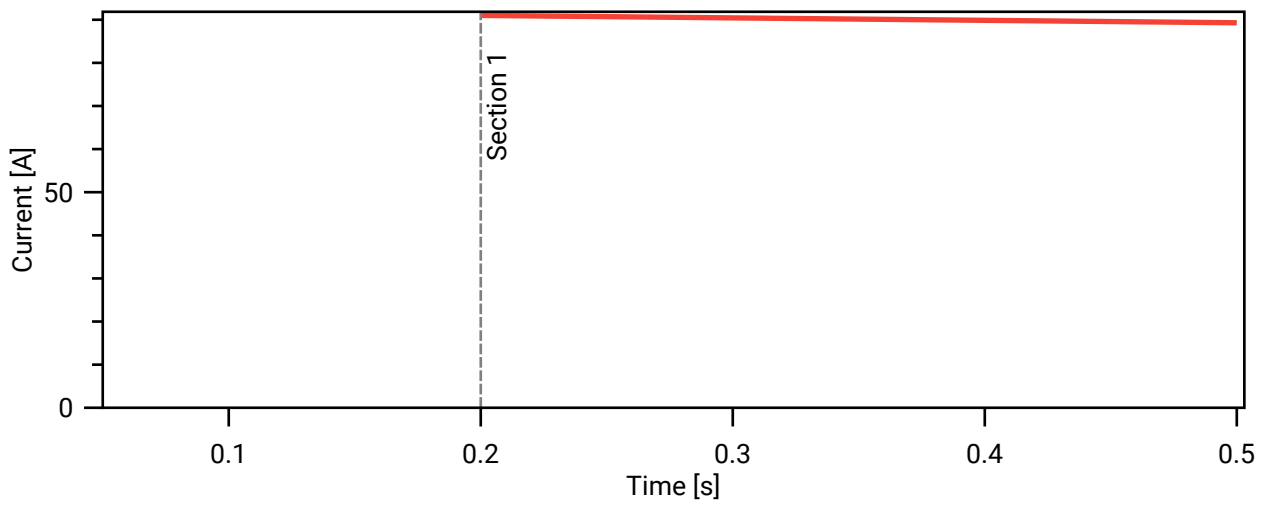
#### QMaster

Welding current command value	105 A (12 A / -12 A)
Voltage command value	12.1 V (2.0 V / -2.0 V)
Wire speed command value	4.8 m/min (1.6 m/min / -2.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

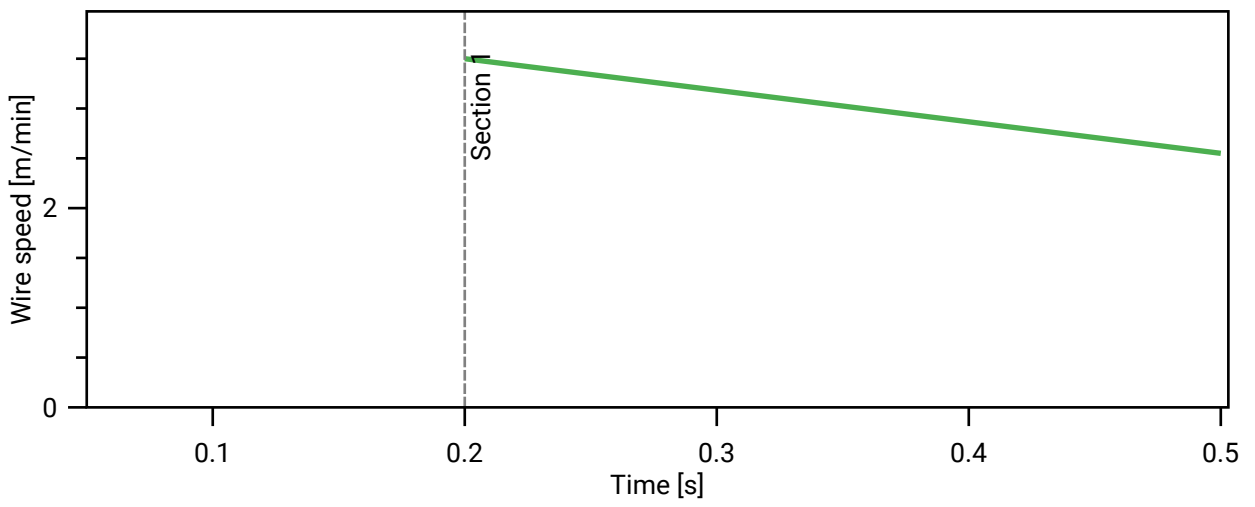
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:42 PM
Duration	1.5 s
Limit violations	None
Wire consumption (length)	0.092 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

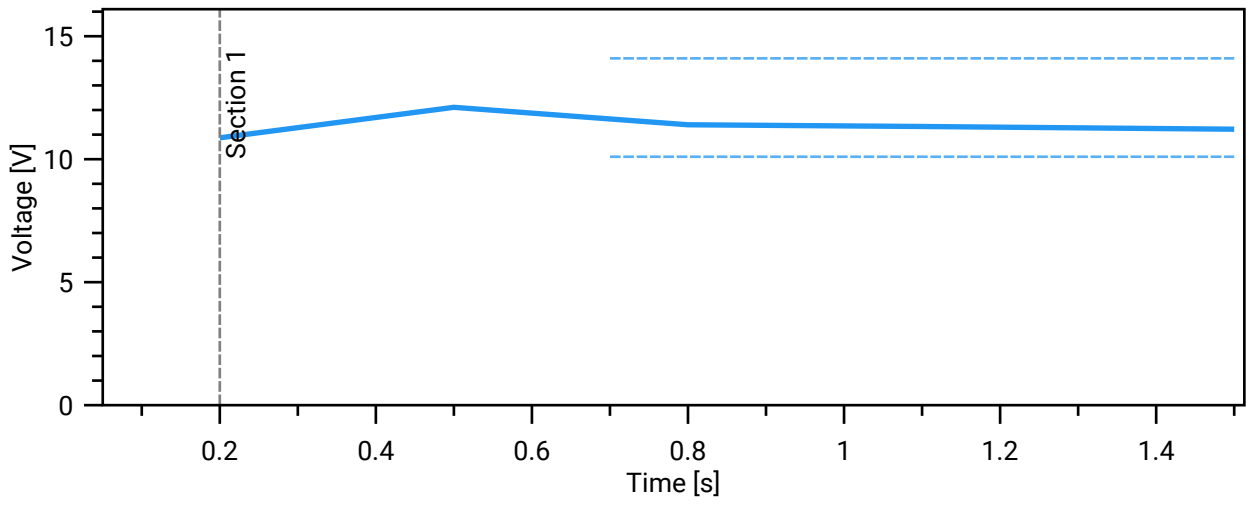
#### Section values

Welding mode	mig cmt
Duration	1.5 s
Job number	62
Arc gas consumption	0.1 l
Wire consumption (length)	0.092 m
Reference number of weld characteristic	1053
Wire speed	4.8 m/min
Arc length correction	-1 %
Pulse correction	0 %
U approximately	11.28 V
I approximately	114.4 A
Spatter free ignition	Off
SynchroPulse	Off

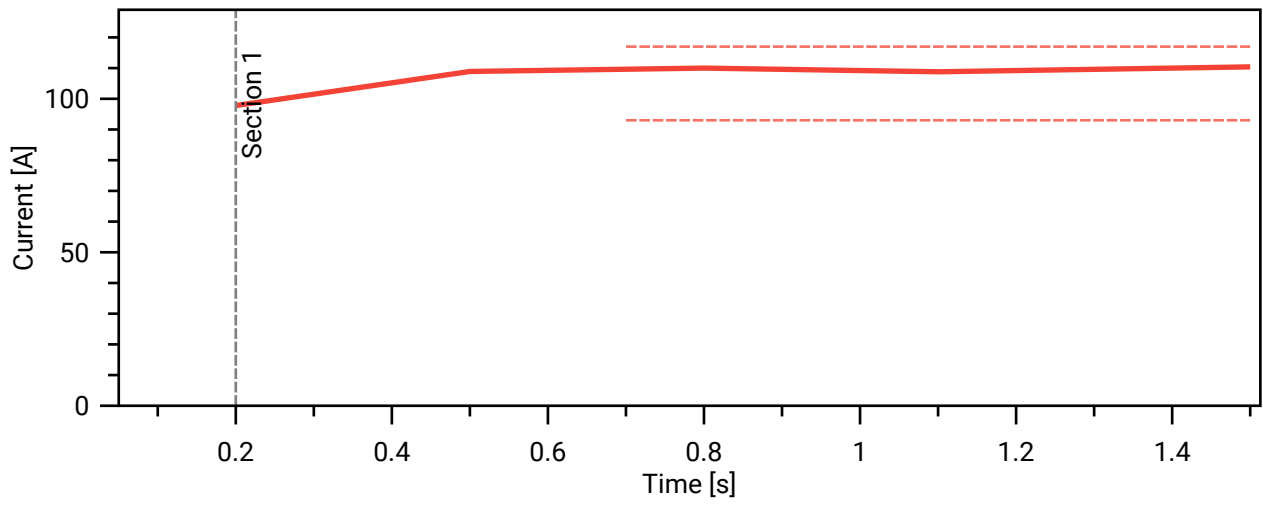
#### QMaster

Welding current command value	105 A (12 A / -12 A)
Voltage command value	12.1 V (2.0 V / -2.0 V)
Wire speed command value	4.8 m/min (1.6 m/min / -2.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

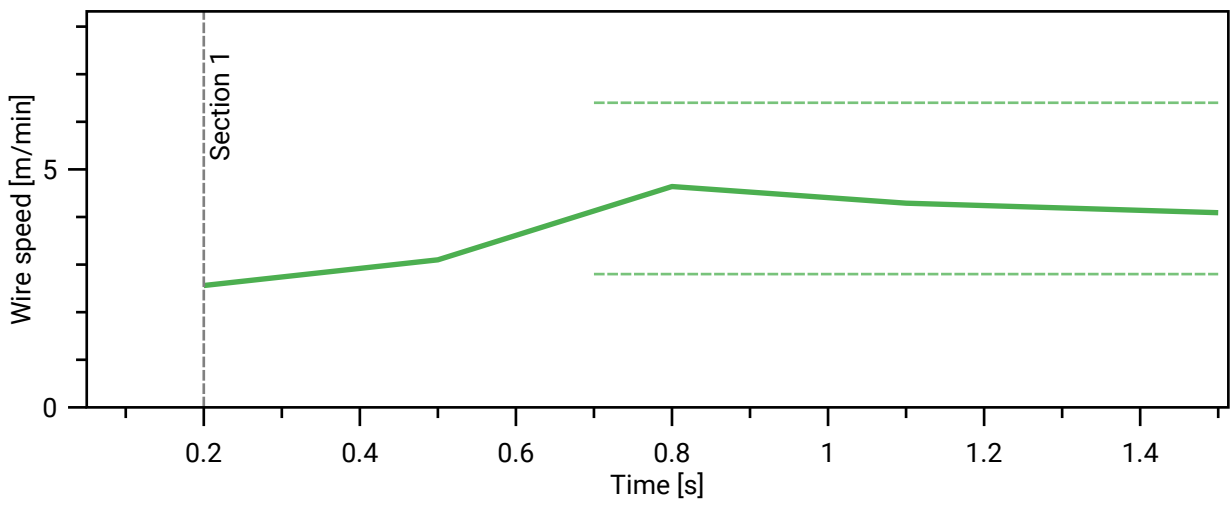
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:45 PM
Duration	1.1 s
Limit violations	None
Wire consumption (length)	0.056 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

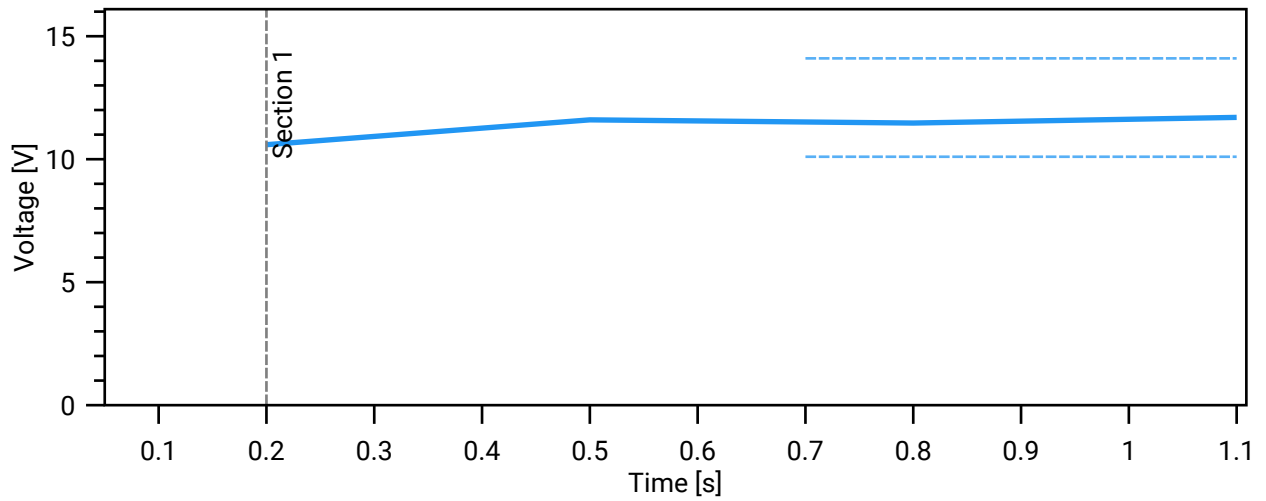
#### Section values

Welding mode	mig cmt
Duration	1.1 s
Job number	62
Arc gas consumption	0.3 l
Wire consumption (length)	0.056 m
Reference number of weld characteristic	1053
Wire speed	4.8 m/min
Arc length correction	-1 %
Pulse correction	0 %
U approximately	11.28 V
I approximately	114.4 A
Spatter free ignition	Off
SynchroPulse	Off

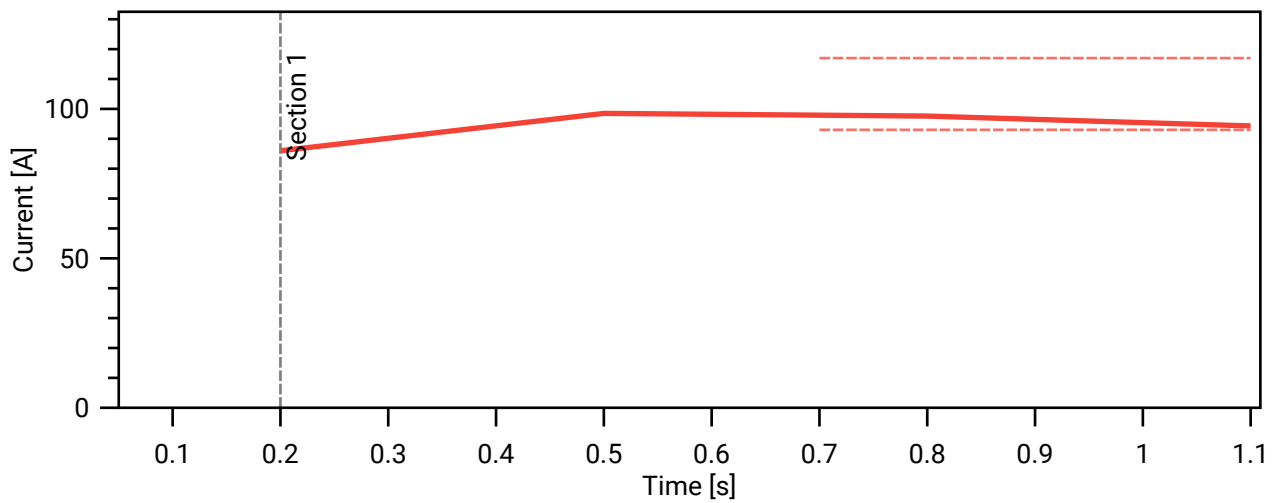
#### QMaster

Welding current command value	105 A (12 A / -12 A)
Voltage command value	12.1 V (2.0 V / -2.0 V)
Wire speed command value	4.8 m/min (1.6 m/min / -2.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

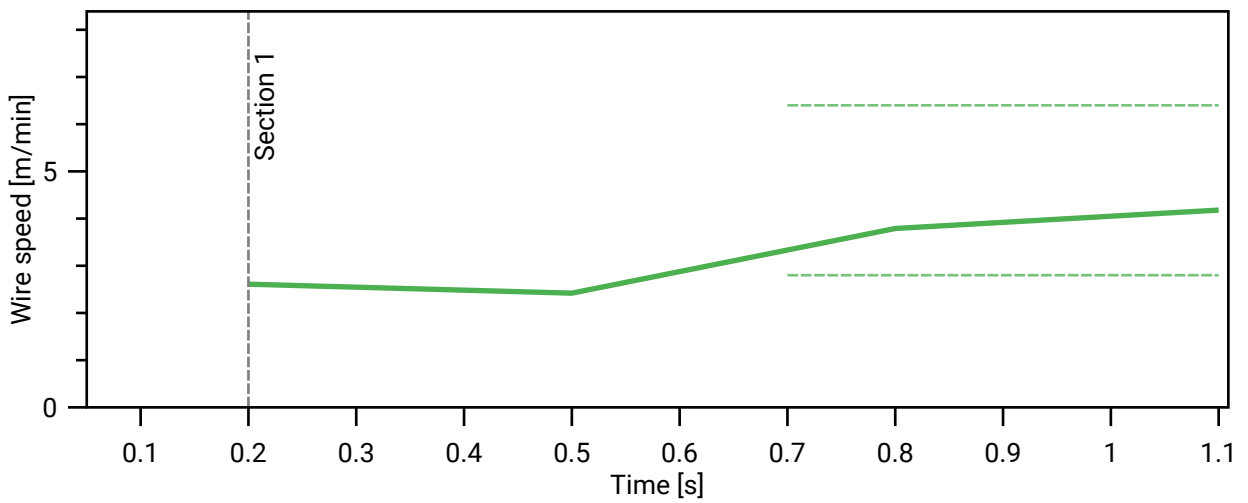
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:47 PM
Duration	1.4 s
Limit violations	None
Wire consumption (length)	0.092 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

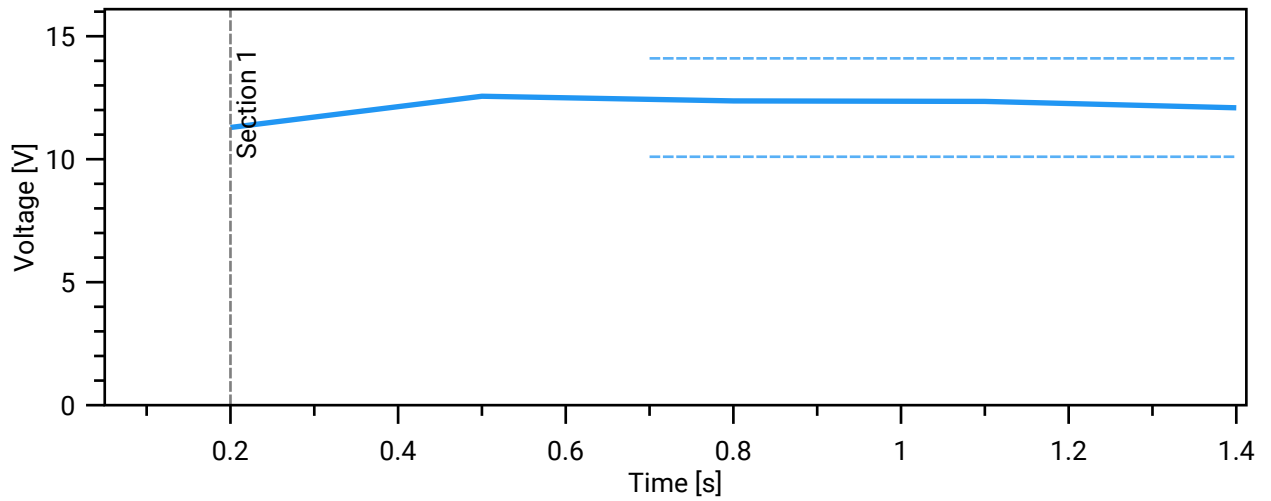
#### Section values

Welding mode	mig cmt
Duration	1.4 s
Job number	62
Arc gas consumption	0.4 l
Wire consumption (length)	0.092 m
Reference number of weld characteristic	1053
Wire speed	4.8 m/min
Arc length correction	-1 %
Pulse correction	0 %
U approximately	11.28 V
I approximately	114.4 A
Spatter free ignition	Off
SynchroPulse	Off

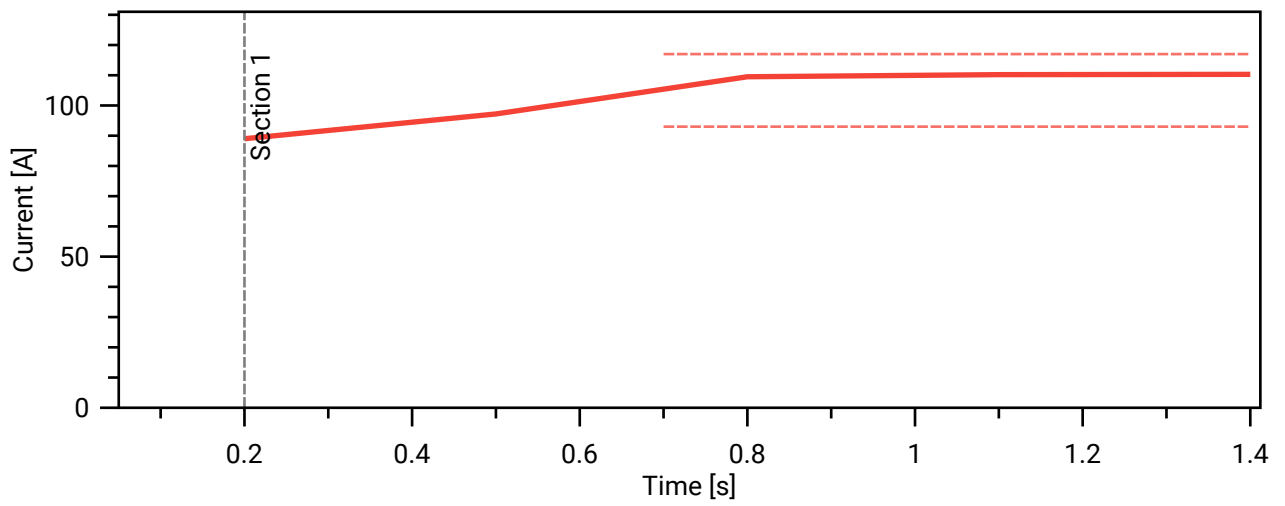
#### QMaster

Welding current command value	105 A (12 A / -12 A)
Voltage command value	12.1 V (2.0 V / -2.0 V)
Wire speed command value	4.8 m/min (1.6 m/min / -2.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

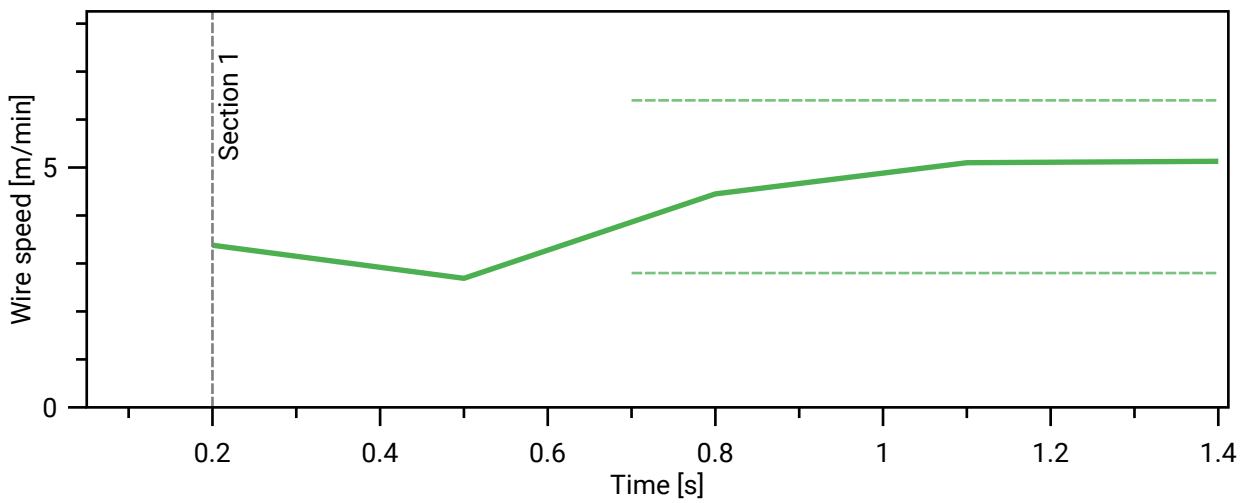
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:50 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.219 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

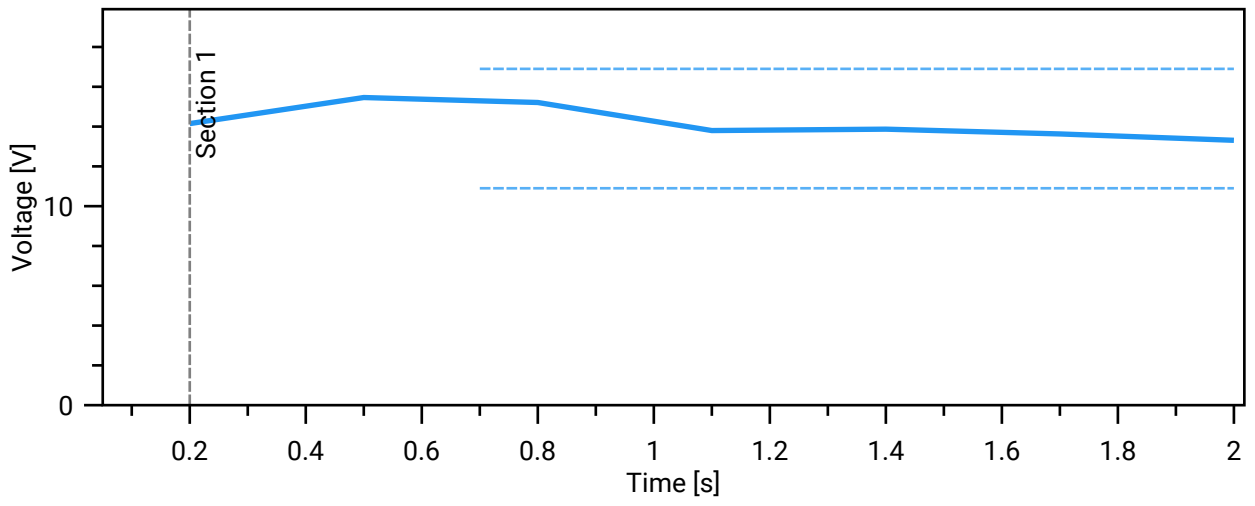
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	61
Arc gas consumption	0.6 l
Wire consumption (length)	0.219 m
Reference number of weld characteristic	1053
Wire speed	7 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	12.79 V
I approximately	169.8 A
Spatter free ignition	Off
SynchroPulse	Off

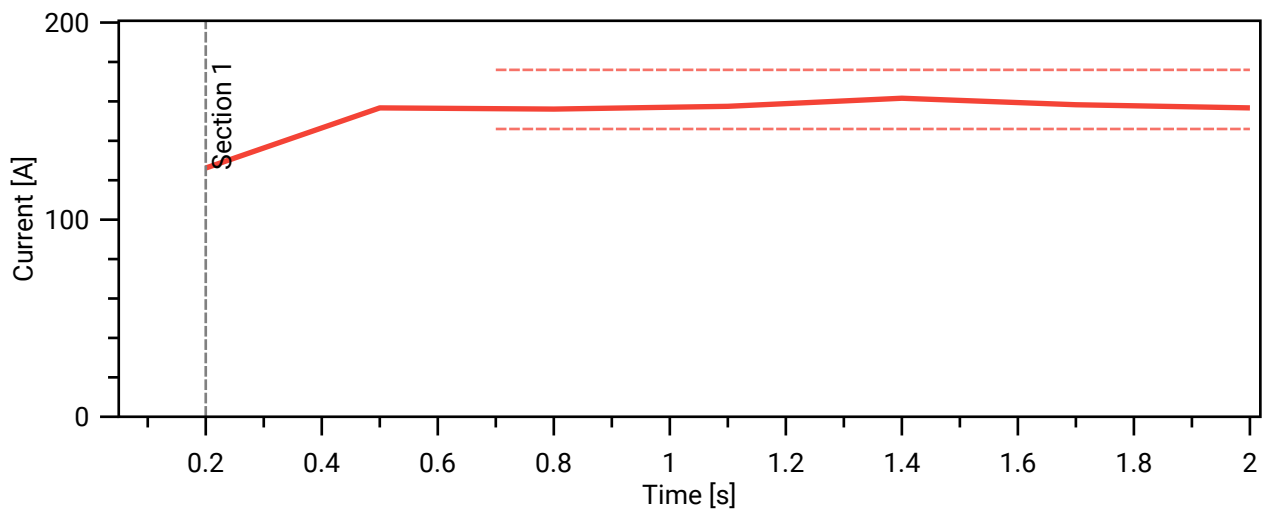
#### QMaster

Welding current command value	161 A (15 A / -15 A)
Voltage command value	13.9 V (3.0 V / -3.0 V)
Wire speed command value	7.0 m/min (2.3 m/min / -2.1 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

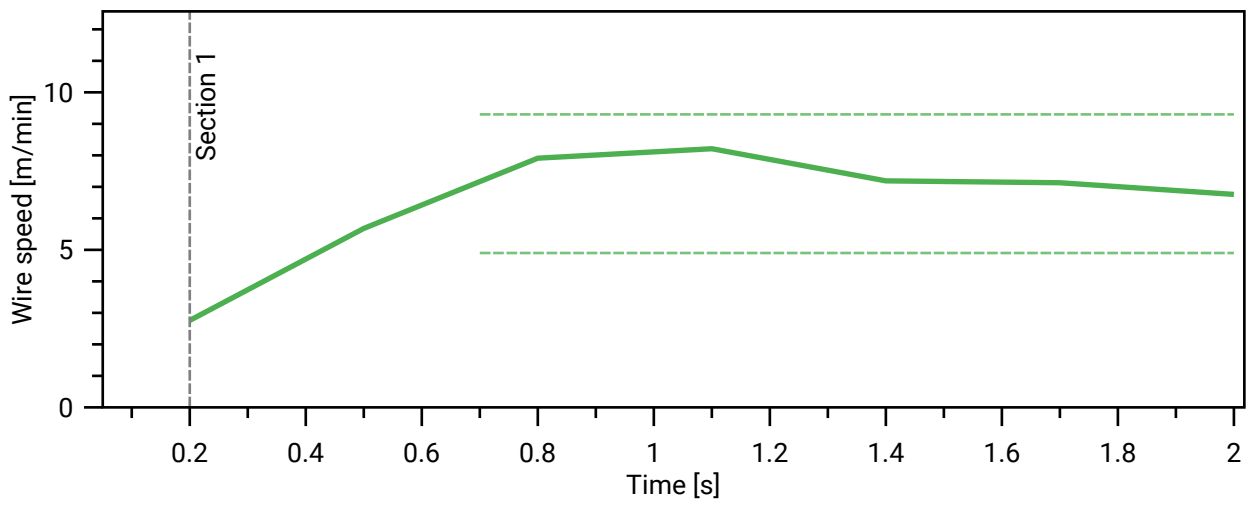
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:53 PM
Duration	2.3 s
Limit violations	None
Wire consumption (length)	0.242 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

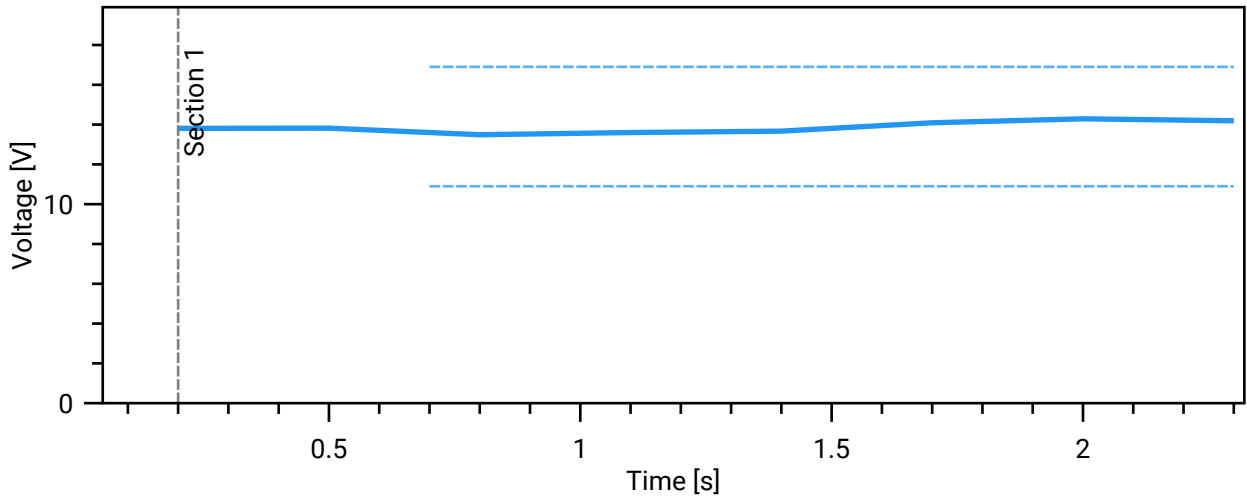
#### Section values

Welding mode	mig cmt
Duration	2.3 s
Job number	61
Arc gas consumption	0.6 l
Wire consumption (length)	0.242 m
Reference number of weld characteristic	1053
Wire speed	7 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	12.79 V
I approximately	169.8 A
Spatter free ignition	Off
SynchroPulse	Off

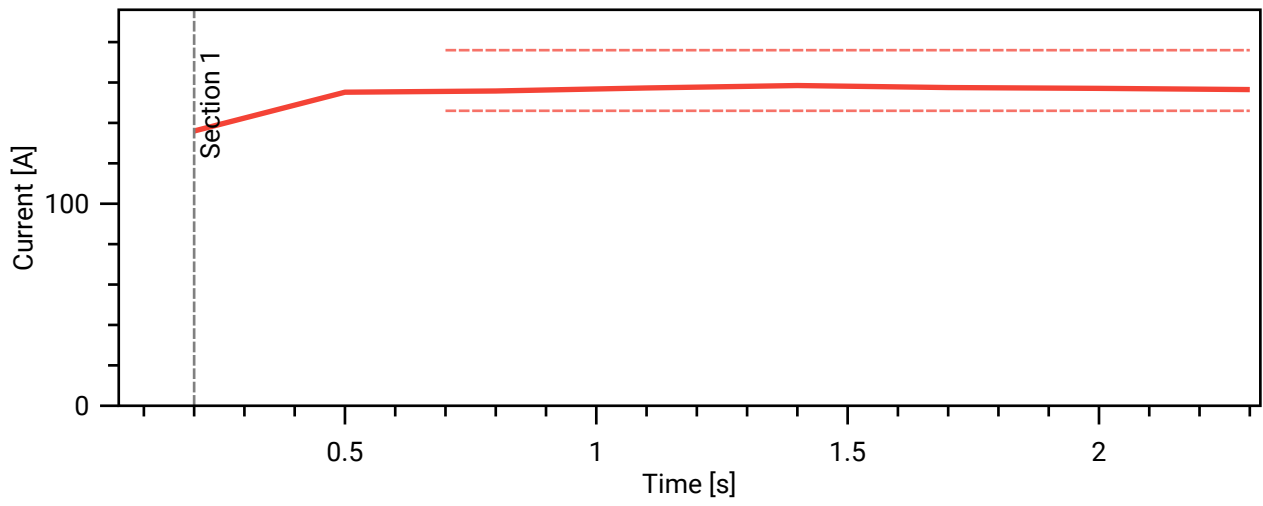
#### QMaster

Welding current command value	161 A (15 A / -15 A)
Voltage command value	13.9 V (3.0 V / -3.0 V)
Wire speed command value	7.0 m/min (2.3 m/min / -2.1 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

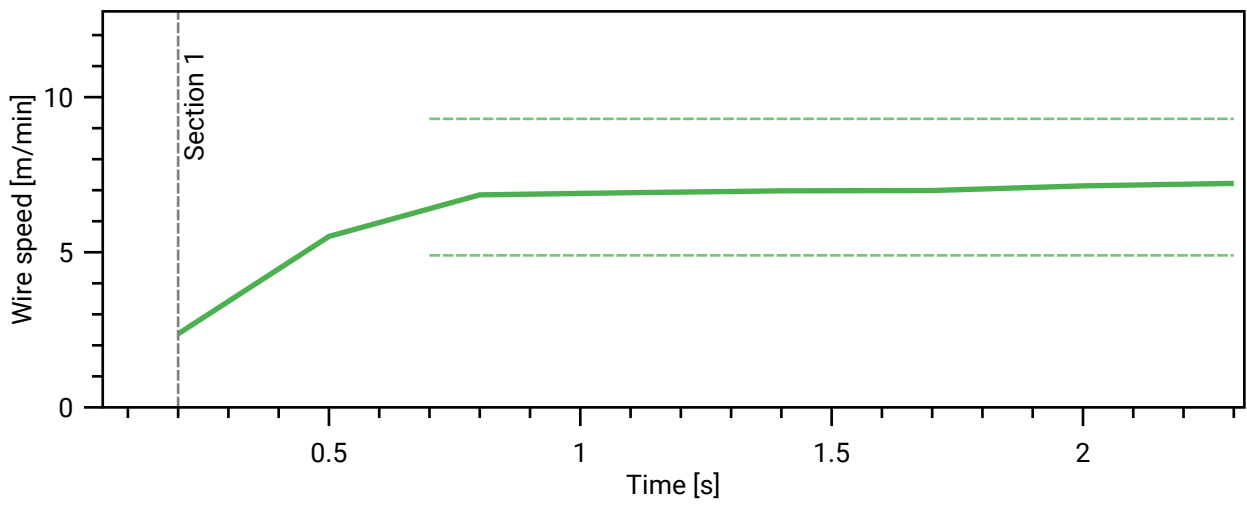
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:12:57 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.209 m

## Machine

Name	<a href="#">TPS5000CMT Second Line</a>
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

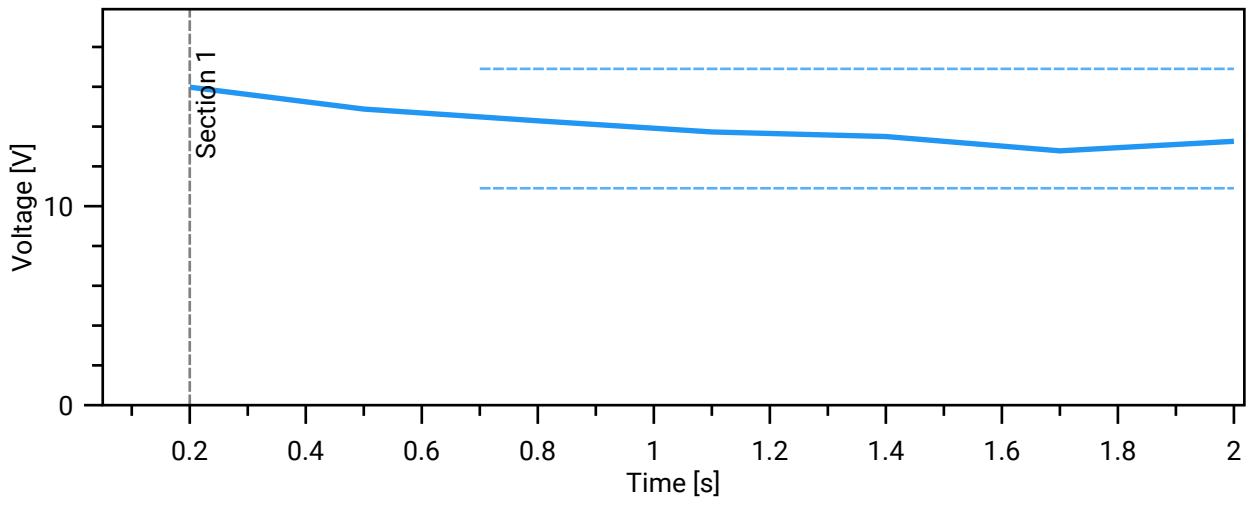
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	61
Arc gas consumption	0.6 l
Wire consumption (length)	0.209 m
Reference number of weld characteristic	1053
Wire speed	7 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	12.79 V
I approximately	169.8 A
Spatter free ignition	Off
SynchroPulse	Off

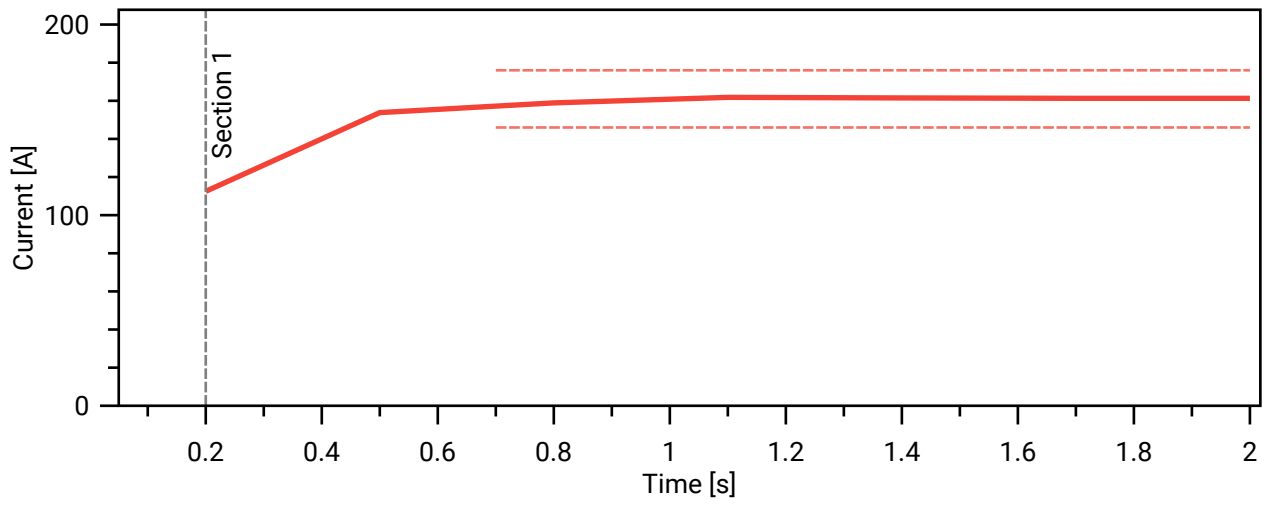
#### QMaster

Welding current command value	161 A (15 A / -15 A)
Voltage command value	13.9 V (3.0 V / -3.0 V)
Wire speed command value	7.0 m/min (2.3 m/min / -2.1 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

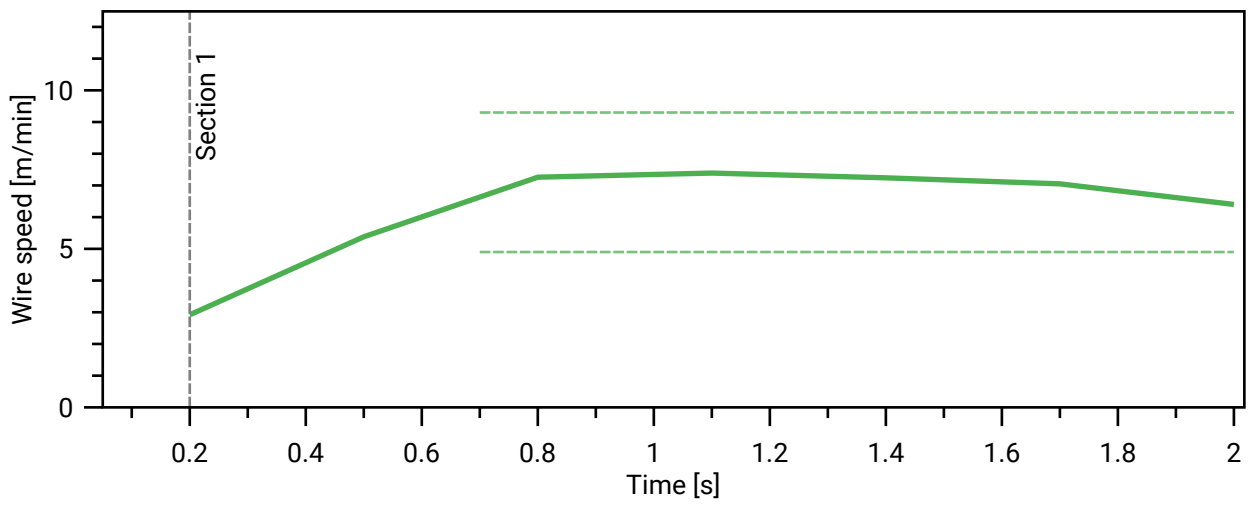
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:01 PM
Duration	1.7 s
Limit violations	None
Wire consumption (length)	0.099 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

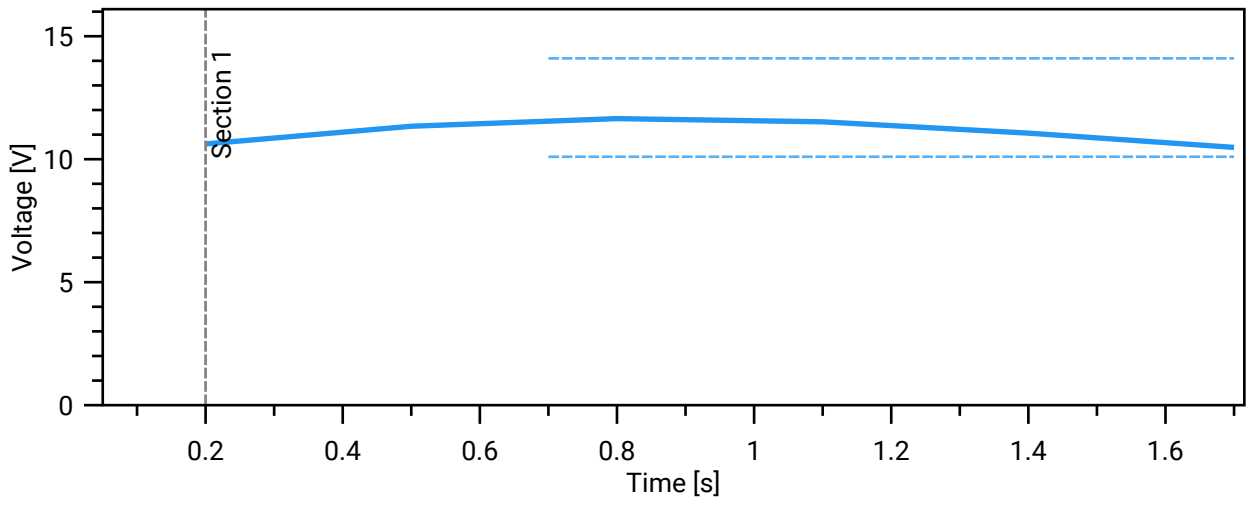
#### Section values

Welding mode	mig cmt
Duration	1.7 s
Job number	62
Arc gas consumption	0.5 l
Wire consumption (length)	0.099 m
Reference number of weld characteristic	1053
Wire speed	4.8 m/min
Arc length correction	-1 %
Pulse correction	0 %
U approximately	11.28 V
I approximately	114.4 A
Spatter free ignition	Off
SynchroPulse	Off

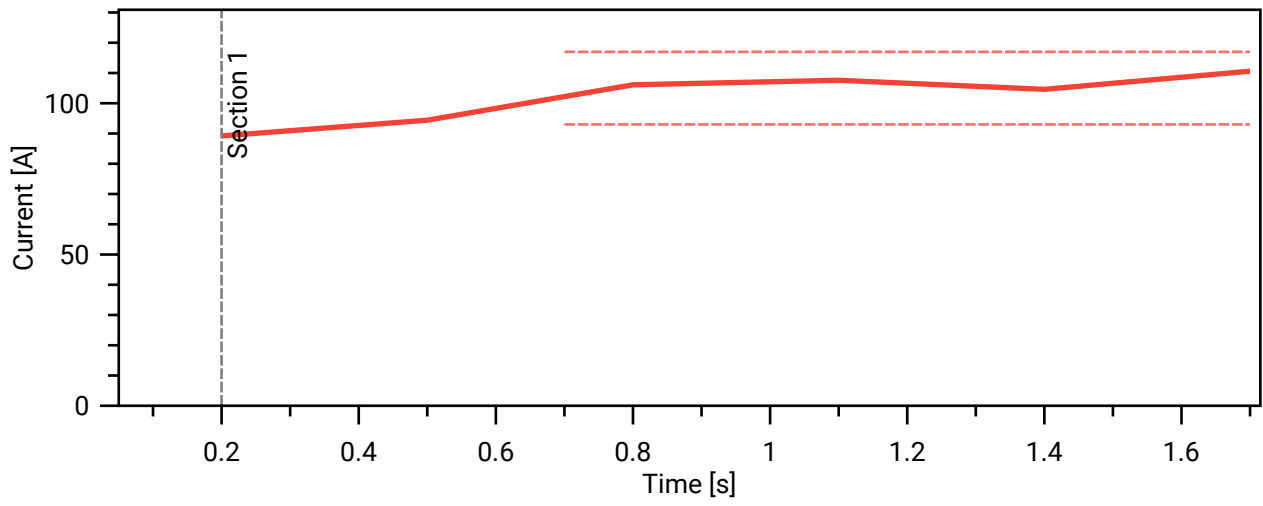
#### QMaster

Welding current command value	105 A (12 A / -12 A)
Voltage command value	12.1 V (2.0 V / -2.0 V)
Wire speed command value	4.8 m/min (1.6 m/min / -2.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

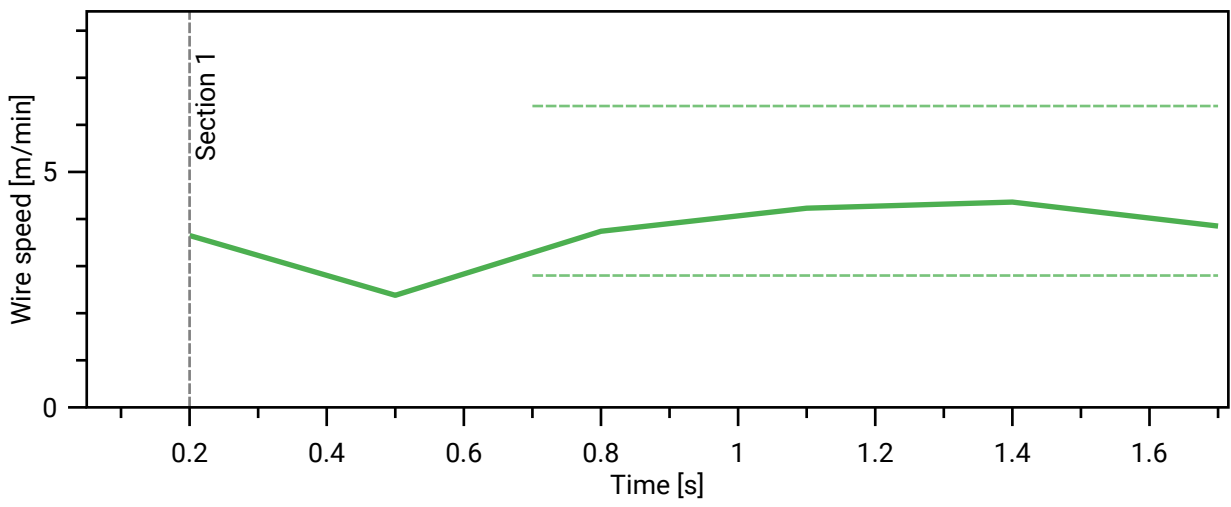
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:04 PM
Duration	1.7 s
Limit violations	None
Wire consumption (length)	0.092 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

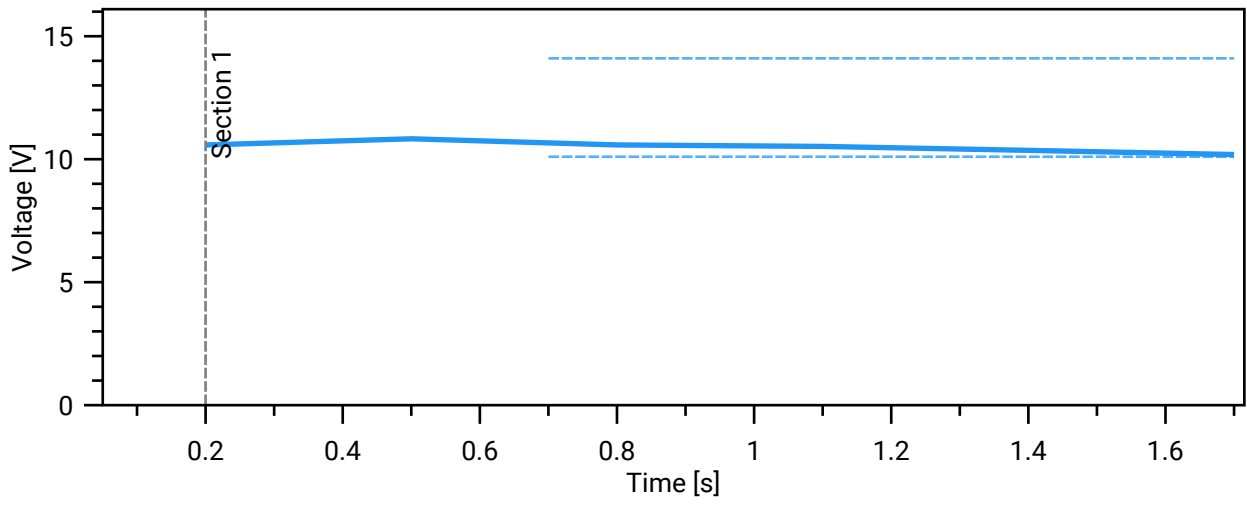
#### Section values

Welding mode	mig cmt
Duration	1.7 s
Job number	62
Arc gas consumption	0.5 l
Wire consumption (length)	0.092 m
Reference number of weld characteristic	1053
Wire speed	4.8 m/min
Arc length correction	-1 %
Pulse correction	0 %
U approximately	11.28 V
I approximately	114.4 A
Spatter free ignition	Off
SynchroPulse	Off

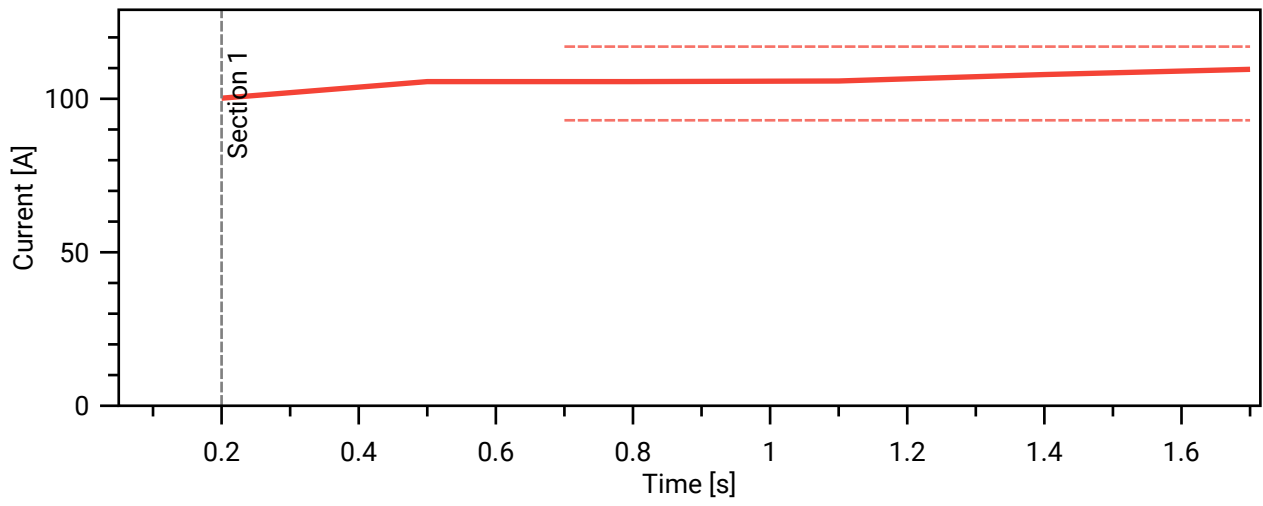
#### QMaster

Welding current command value	105 A (12 A / -12 A)
Voltage command value	12.1 V (2.0 V / -2.0 V)
Wire speed command value	4.8 m/min (1.6 m/min / -2.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

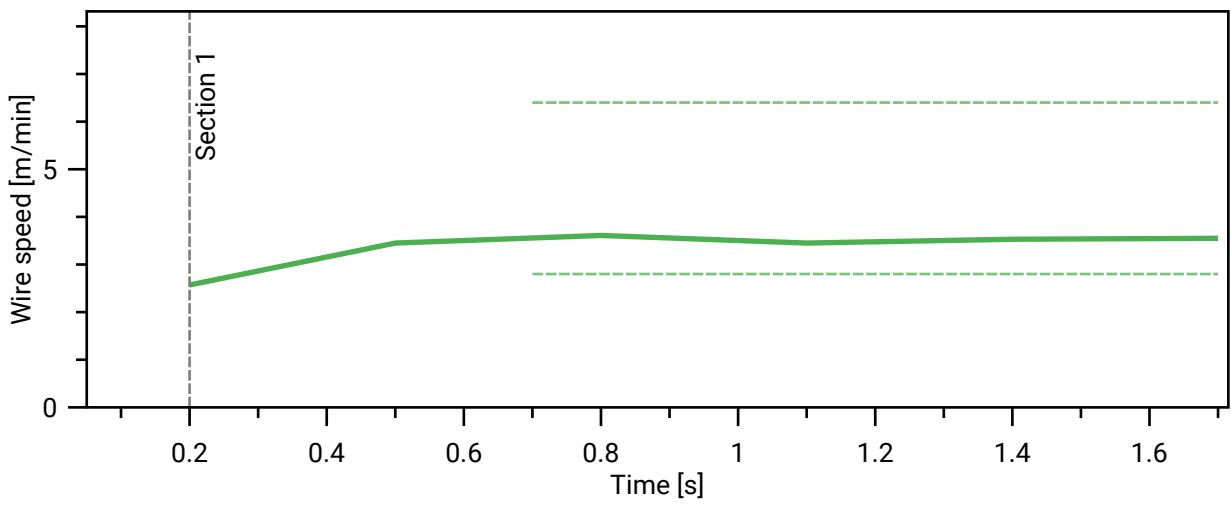
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:07 PM
Duration	0.5 s
Limit violations	None
Wire consumption (length)	0.03 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

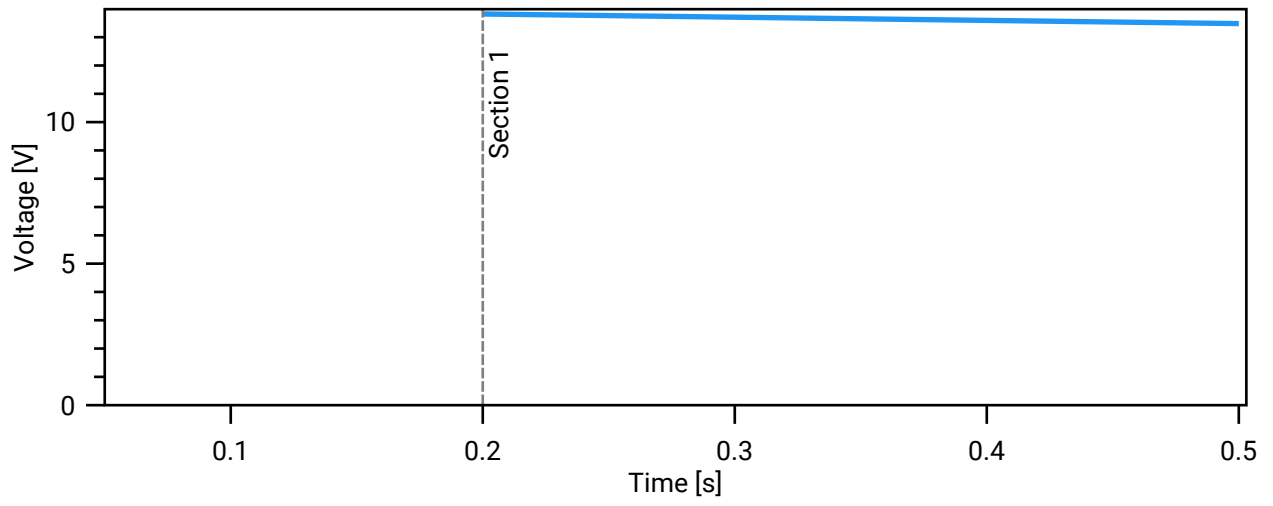
#### Section values

Welding mode	mig cmt
Duration	0.5 s
Job number	63
Arc gas consumption	0.2 l
Wire consumption (length)	0.03 m
Reference number of weld characteristic	1053
Wire speed	7.5 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	13.35 V
I approximately	178.3 A
Spatter free ignition	Off
SynchroPulse	Off

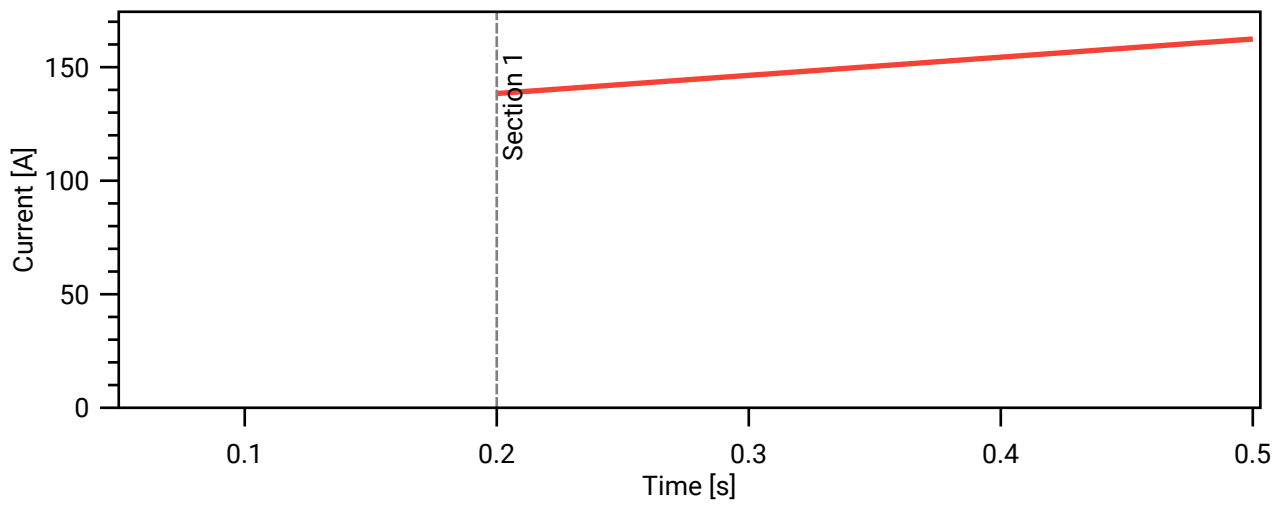
#### QMaster

Welding current command value	175 A (15 A / -15 A)
Voltage command value	13.6 V (4.0 V / -4.0 V)
Wire speed command value	7.5 m/min (2.2 m/min / -4.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

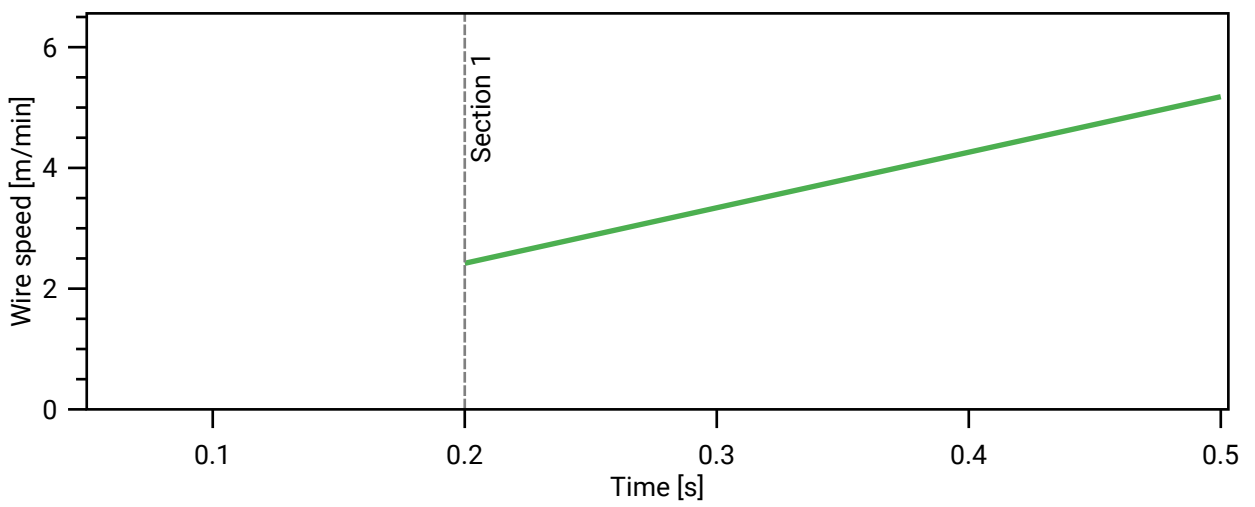
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:09 PM
Duration	0.8 s
Limit violations	None
Wire consumption (length)	0.062 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

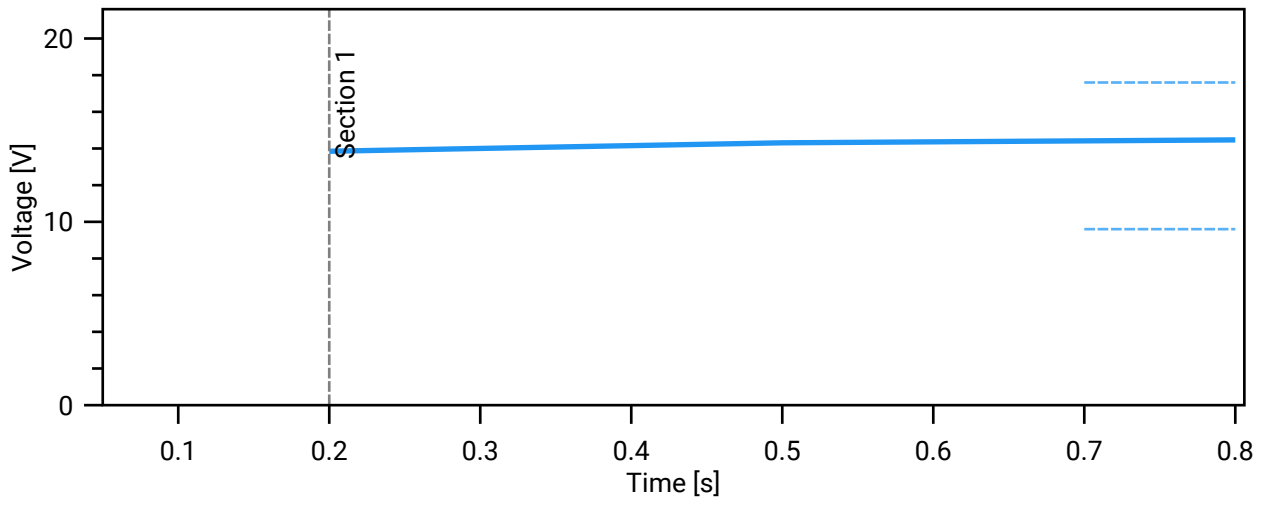
#### Section values

Welding mode	mig cmt
Duration	0.8 s
Job number	63
Arc gas consumption	0.2 l
Wire consumption (length)	0.062 m
Reference number of weld characteristic	1053
Wire speed	7.5 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	13.35 V
I approximately	178.3 A
Spatter free ignition	Off
SynchroPulse	Off

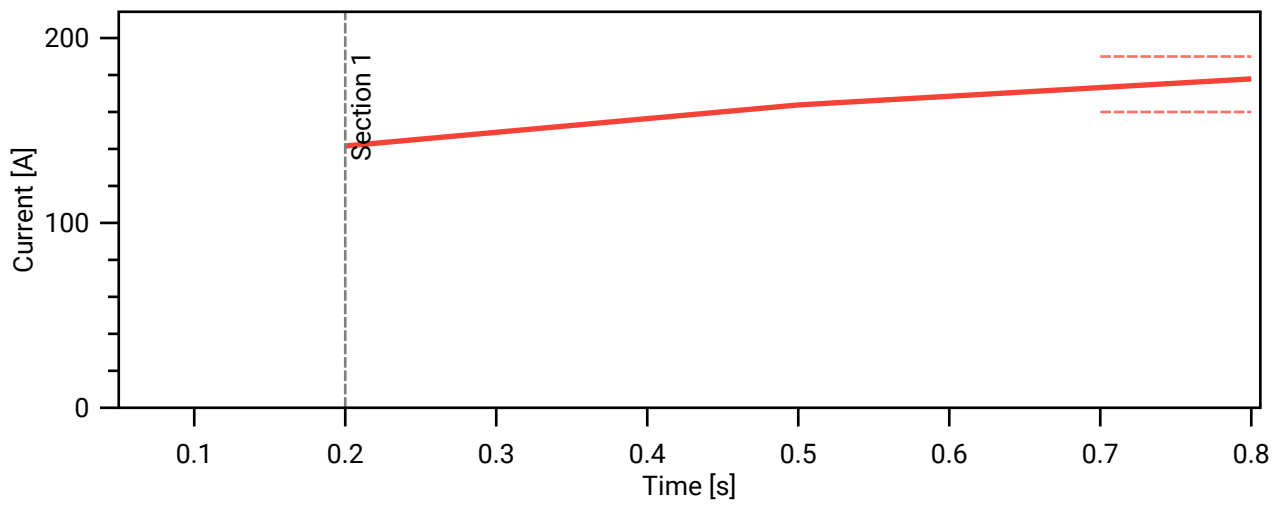
#### QMaster

Welding current command value	175 A (15 A / -15 A)
Voltage command value	13.6 V (4.0 V / -4.0 V)
Wire speed command value	7.5 m/min (2.2 m/min / -4.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

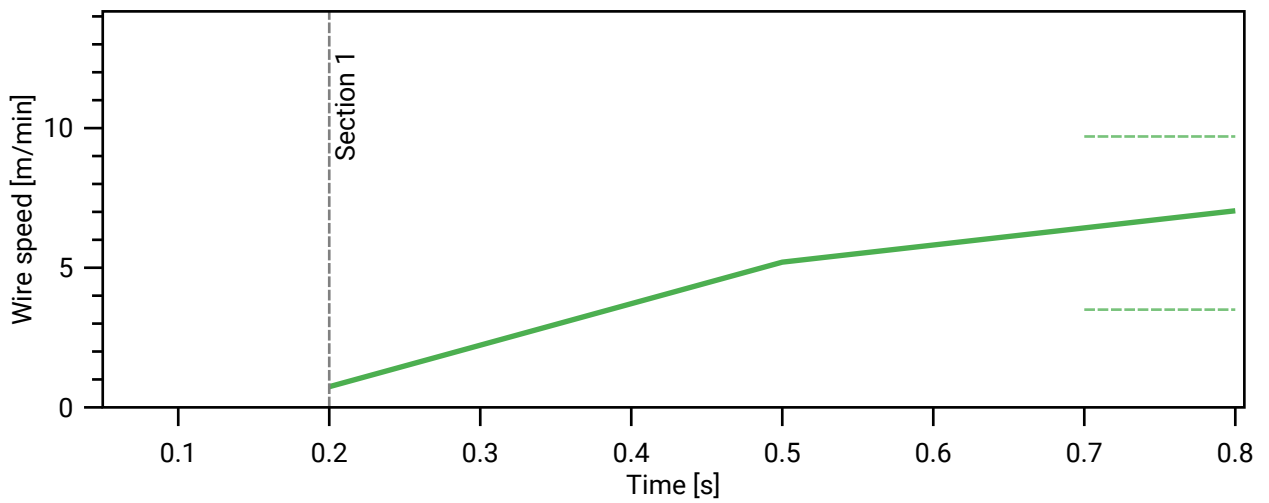
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:11 PM
Duration	0.5 s
Limit violations	None
Wire consumption (length)	0.025 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

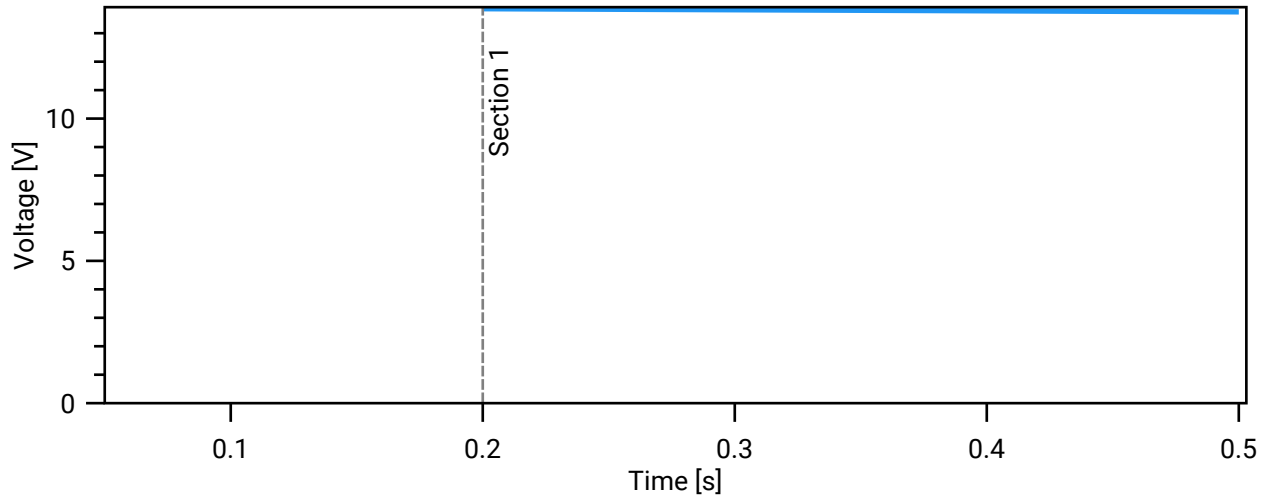
#### Section values

Welding mode	mig cmt
Duration	0.5 s
Job number	63
Arc gas consumption	0.1 l
Wire consumption (length)	0.025 m
Reference number of weld characteristic	1053
Wire speed	7.5 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	13.35 V
I approximately	178.3 A
Spatter free ignition	Off
SynchroPulse	Off

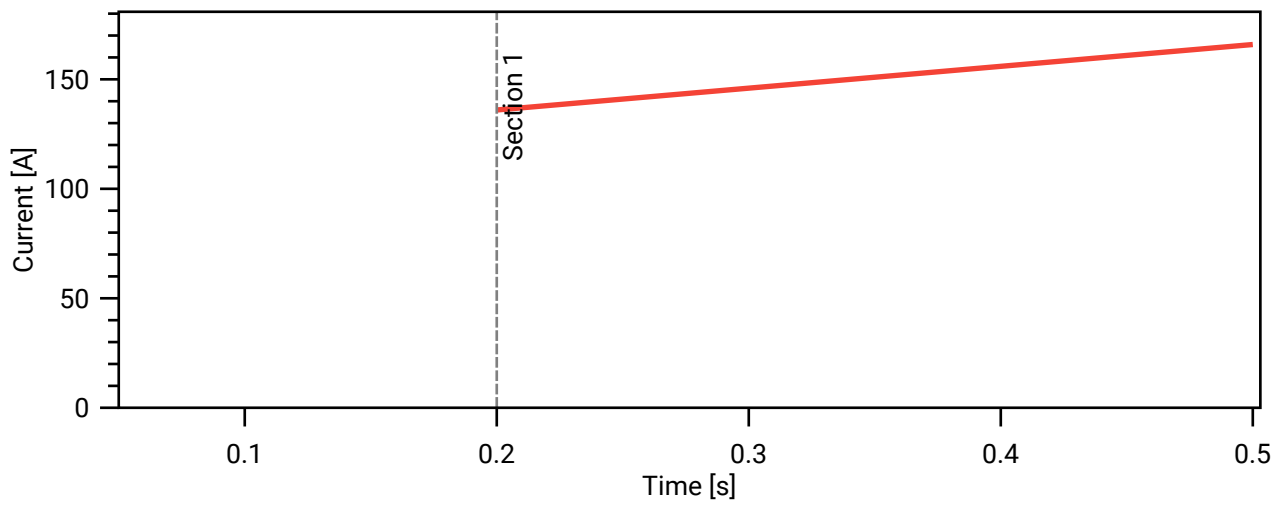
#### QMaster

Welding current command value	175 A (15 A / -15 A)
Voltage command value	13.6 V (4.0 V / -4.0 V)
Wire speed command value	7.5 m/min (2.2 m/min / -4.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

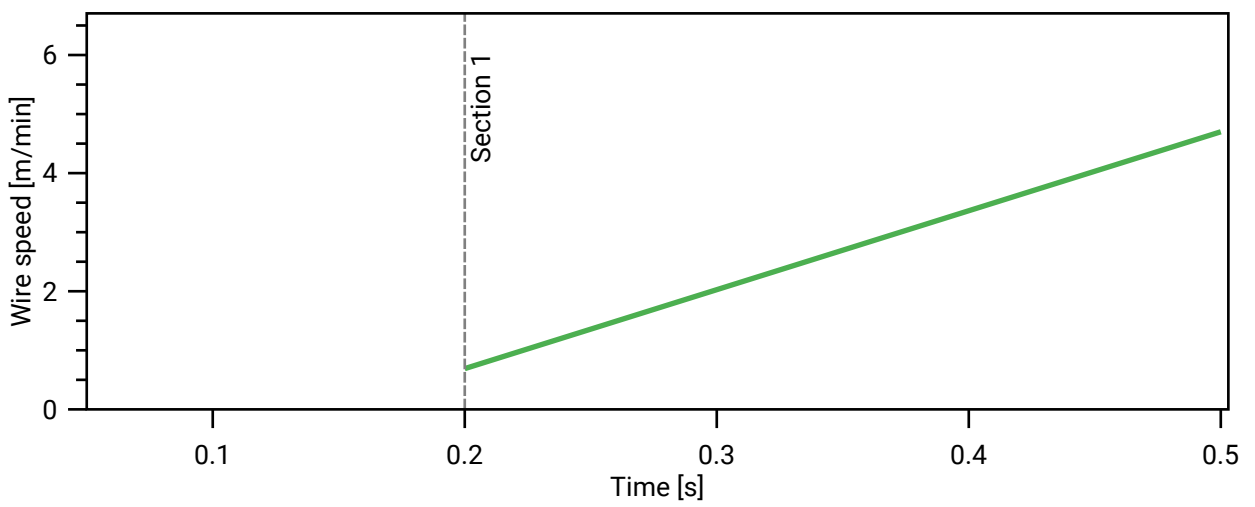
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:13 PM
Duration	0.5 s
Limit violations	None
Wire consumption (length)	0.021 m

## Machine

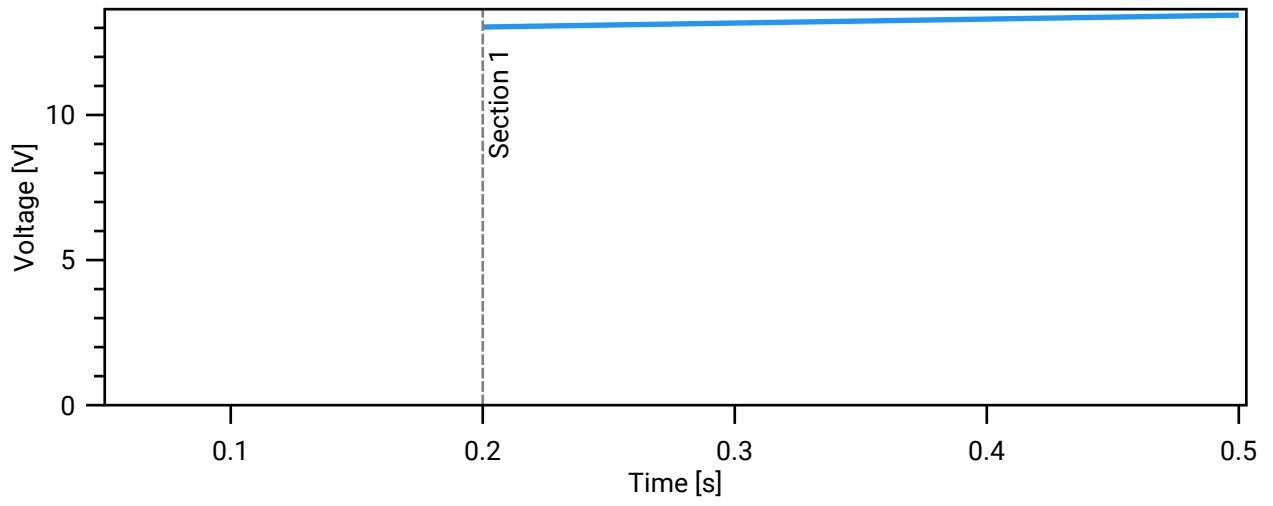
Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

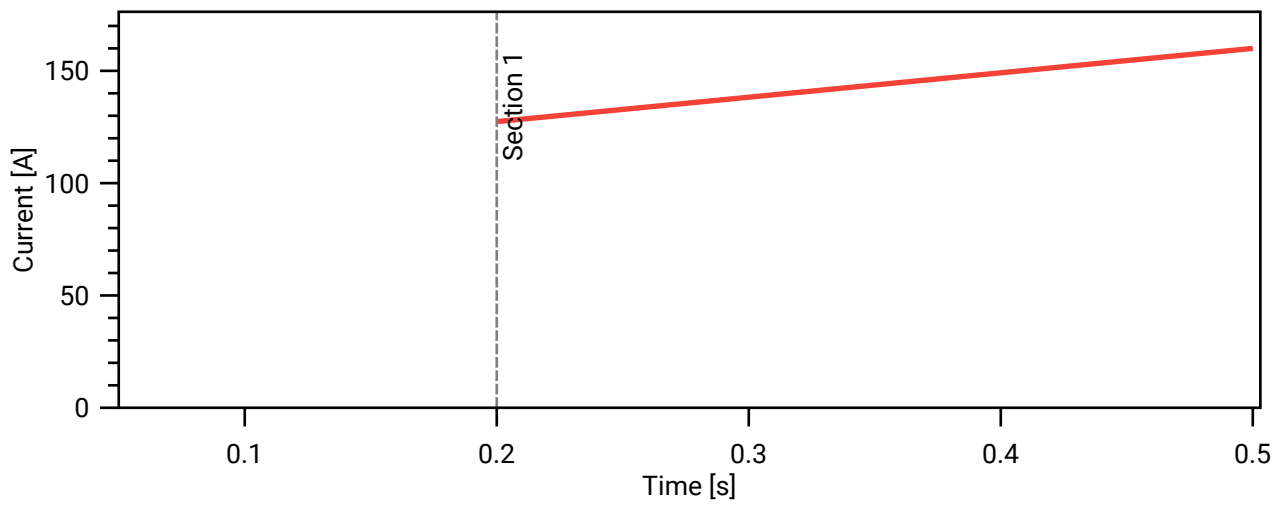
### Section 1

Section values		QMaster	
Welding mode	mig cmt	Welding current command value	175 A (15 A / -15 A)
Duration	0.5 s	Voltage command value	13.6 V (4.0 V / -4.0 V)
Job number	63	Wire speed command value	7.5 m/min (2.2 m/min / -4.0 m/min)
Arc gas consumption	0.1 l	Max. duration of current deviation	0.5 s
Wire consumption (length)	0.021 m	Max. duration of voltage deviation	0.5 s
Reference number of weld characteristic	1053	Max. duration of wire speed deviation	0.5 s
Wire speed	7.5 m/min	Reaction	Warning
Arc length correction	2 %		
Pulse correction	0 %		
U approximately	13.35 V		
I approximately	178.3 A		
Spatter free ignition	Off		
SynchroPulse	Off		

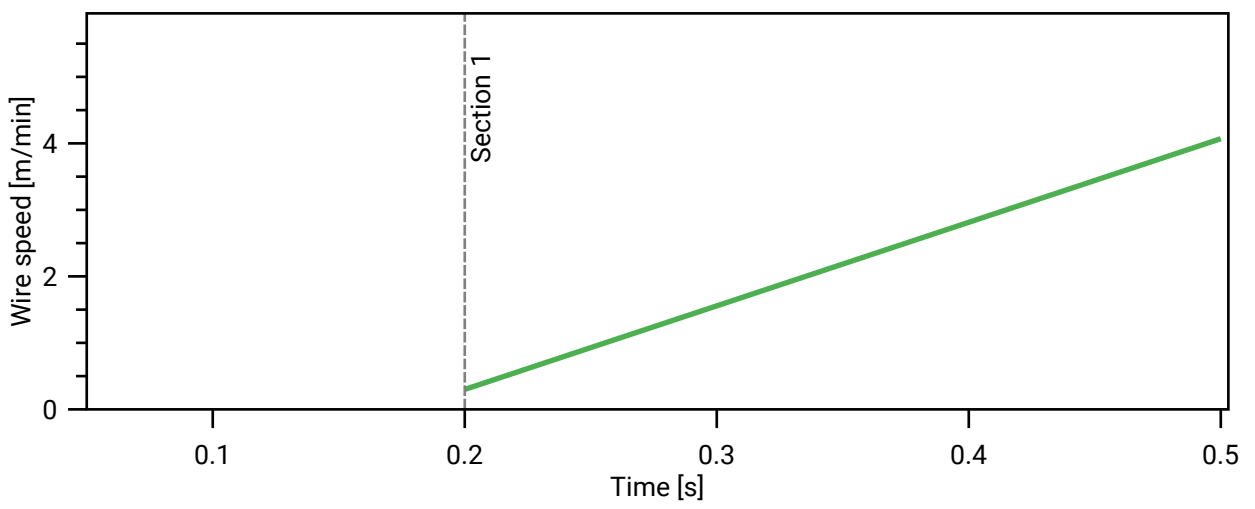
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:15 PM
Duration	0.5 s
Limit violations	None
Wire consumption (length)	0.027 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

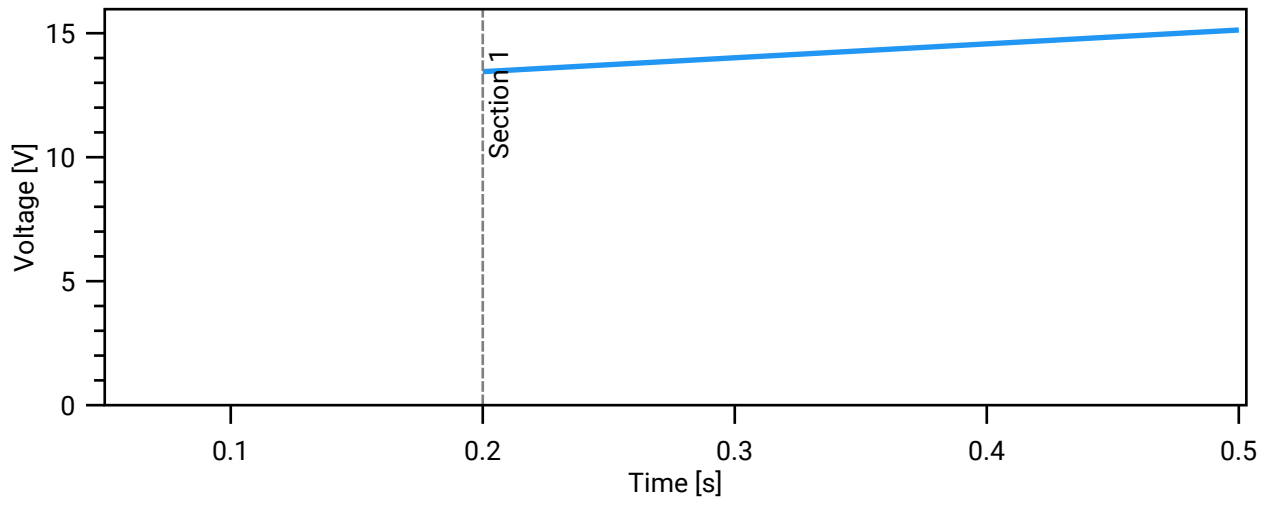
#### Section values

Welding mode	mig cmt
Duration	0.5 s
Job number	63
Arc gas consumption	0.1 l
Wire consumption (length)	0.027 m
Reference number of weld characteristic	1053
Wire speed	7.5 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	13.35 V
I approximately	178.3 A
Spatter free ignition	Off
SynchroPulse	Off

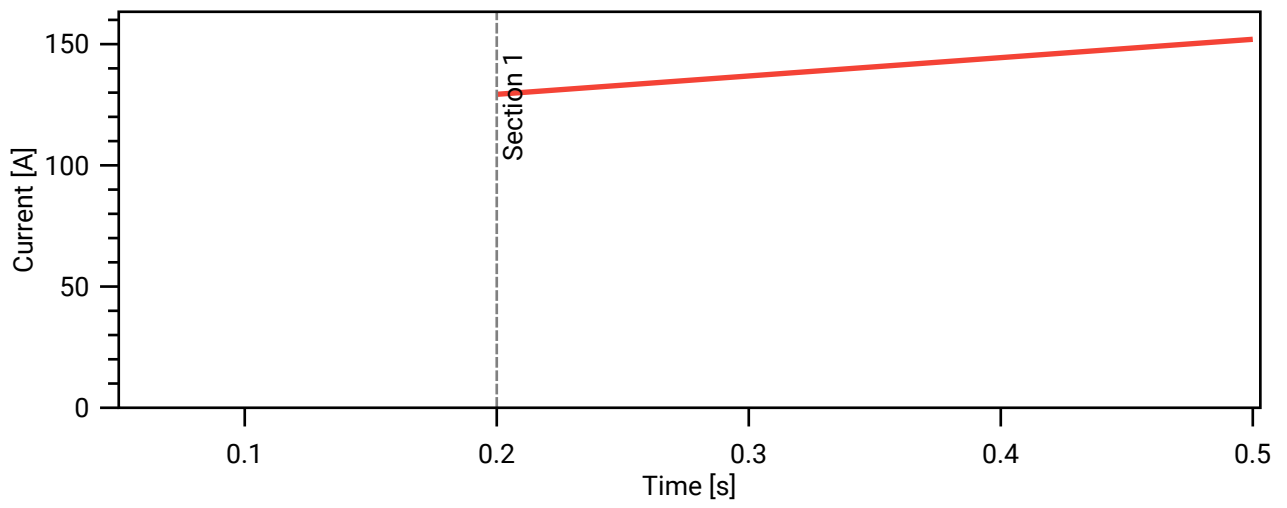
#### QMaster

Welding current command value	175 A (15 A / -15 A)
Voltage command value	13.6 V (4.0 V / -4.0 V)
Wire speed command value	7.5 m/min (2.2 m/min / -4.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

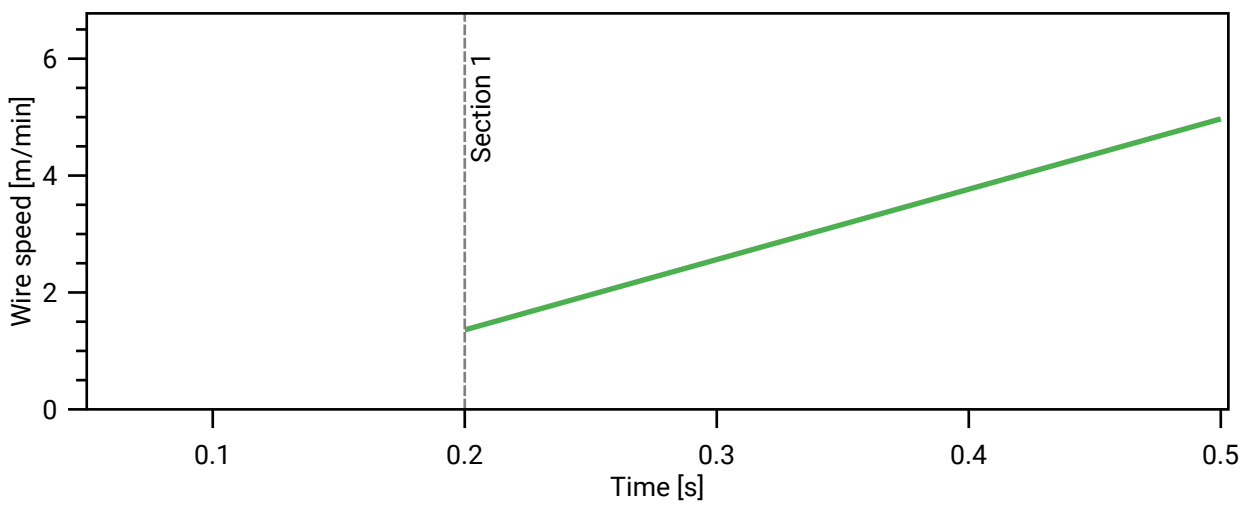
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:17 PM
Duration	0.5 s
Limit violations	None
Wire consumption (length)	0.029 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

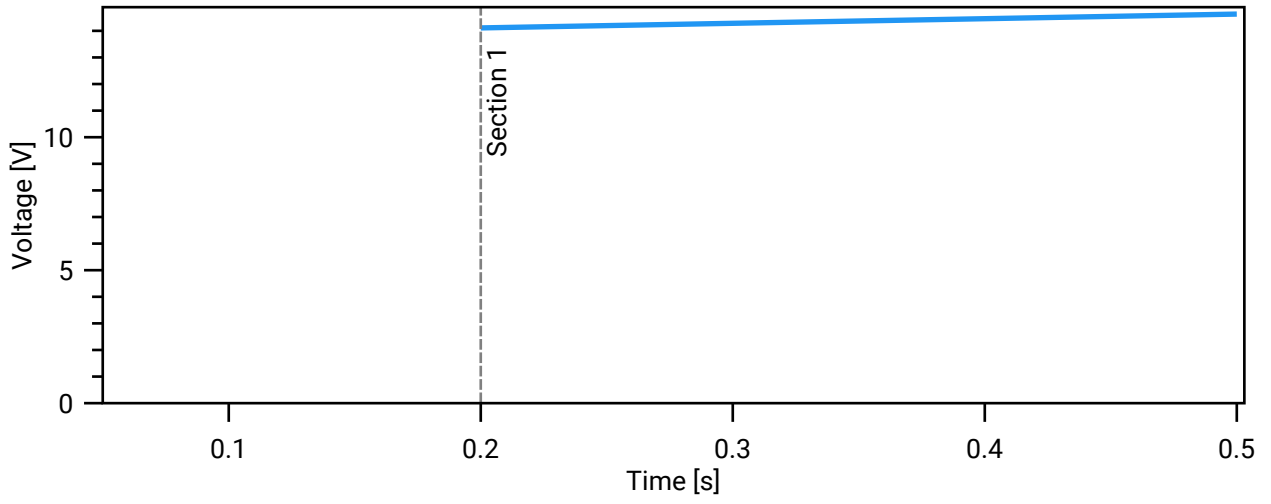
#### Section values

Welding mode	mig cmt
Duration	0.5 s
Job number	63
Arc gas consumption	0.2 l
Wire consumption (length)	0.029 m
Reference number of weld characteristic	1053
Wire speed	7.5 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	13.35 V
I approximately	178.3 A
Spatter free ignition	Off
SynchroPulse	Off

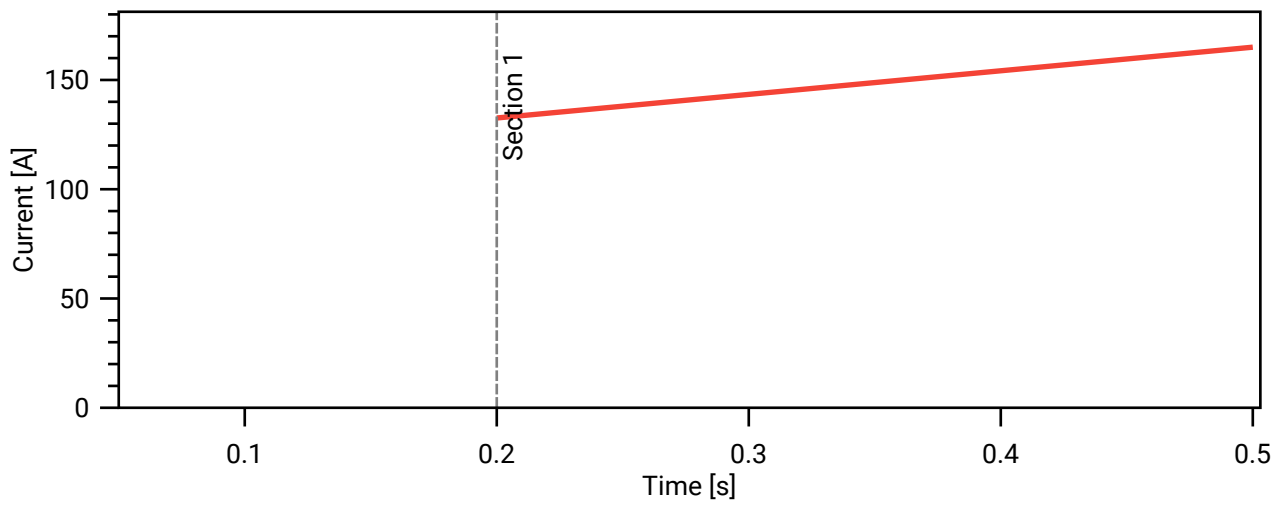
#### QMaster

Welding current command value	175 A (15 A / -15 A)
Voltage command value	13.6 V (4.0 V / -4.0 V)
Wire speed command value	7.5 m/min (2.2 m/min / -4.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

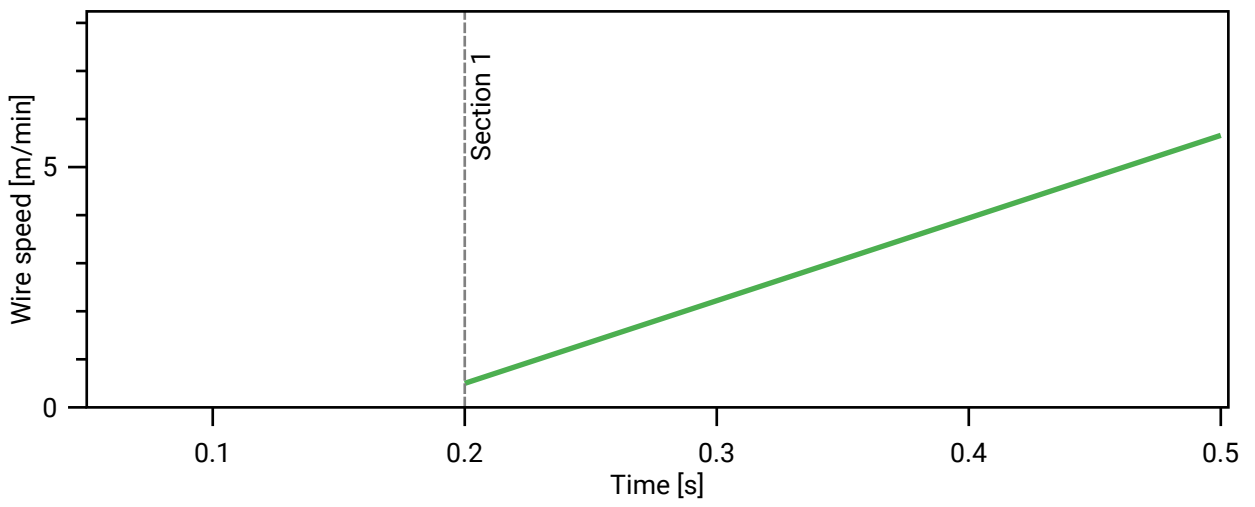
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:19 PM
Duration	0.5 s
Limit violations	None
Wire consumption (length)	0.036 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

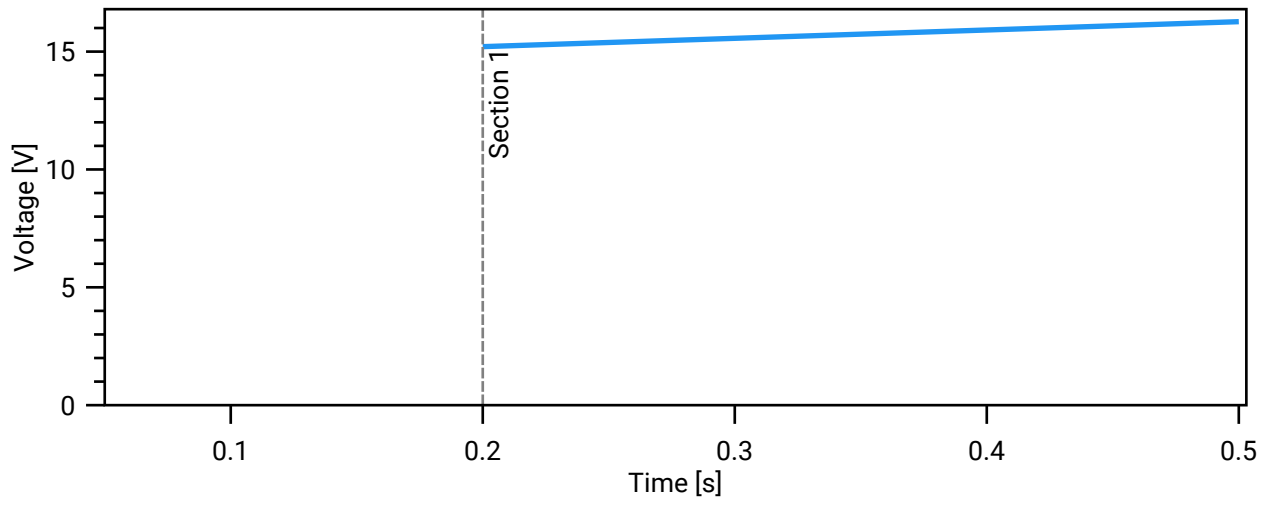
#### Section values

Welding mode	mig cmt
Duration	0.5 s
Job number	63
Arc gas consumption	0.2 l
Wire consumption (length)	0.036 m
Reference number of weld characteristic	1053
Wire speed	7.5 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	13.35 V
I approximately	178.3 A
Spatter free ignition	Off
SynchroPulse	Off

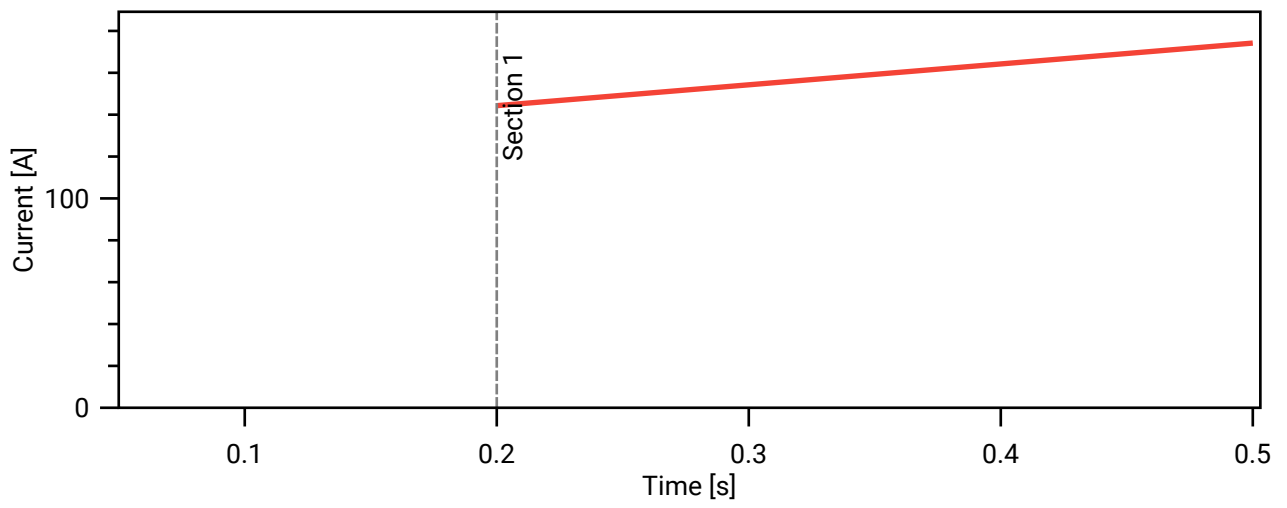
#### QMaster

Welding current command value	175 A (15 A / -15 A)
Voltage command value	13.6 V (4.0 V / -4.0 V)
Wire speed command value	7.5 m/min (2.2 m/min / -4.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

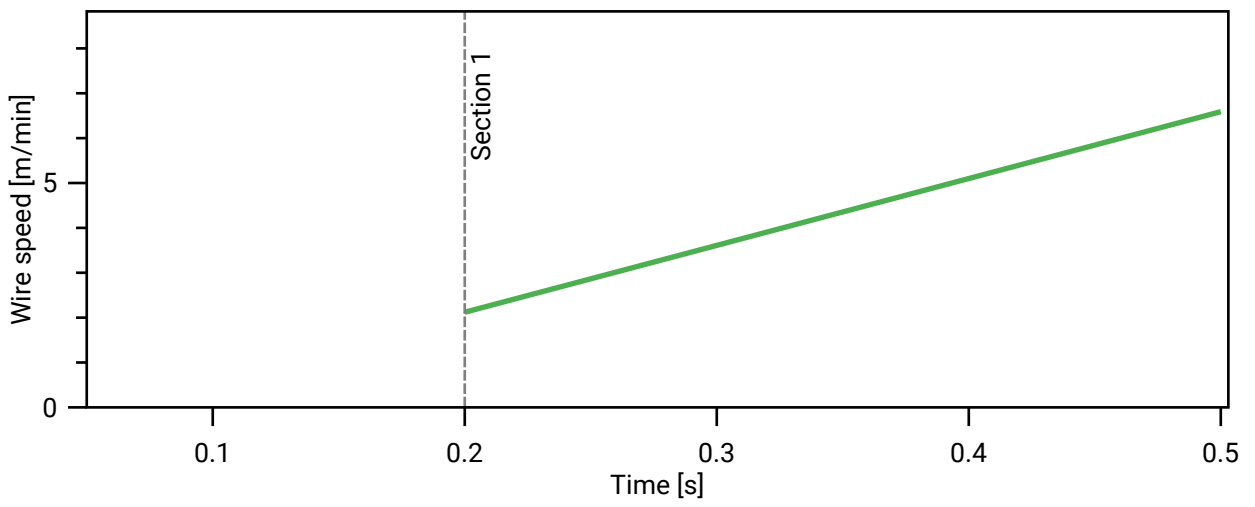
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:21 PM
Duration	0.5 s
Limit violations	None
Wire consumption (length)	0.032 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

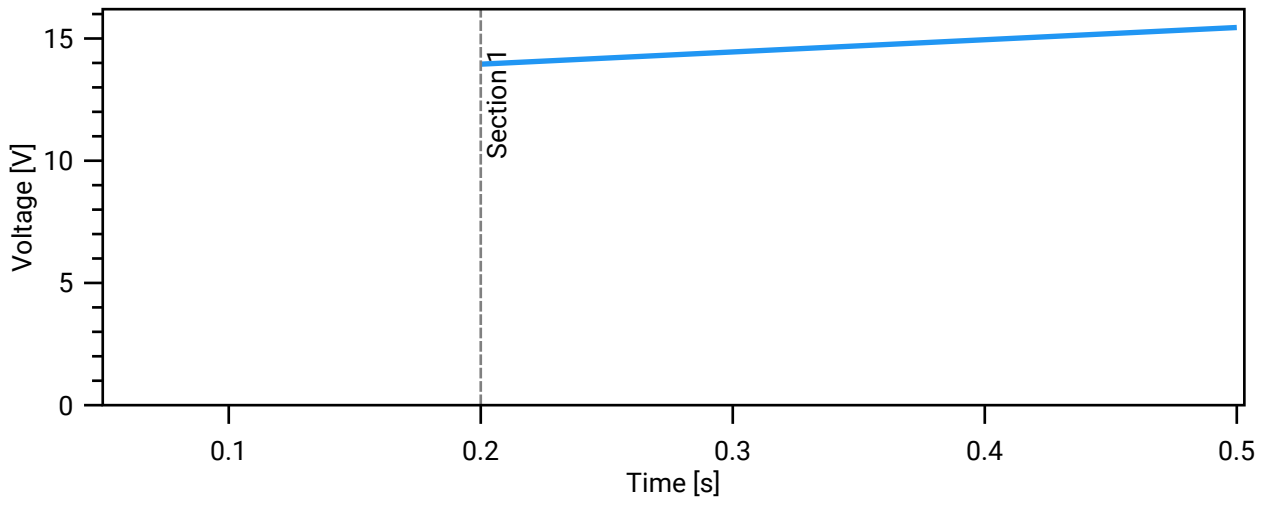
#### Section values

Welding mode	mig cmt
Duration	0.5 s
Job number	63
Arc gas consumption	0.2 l
Wire consumption (length)	0.032 m
Reference number of weld characteristic	1053
Wire speed	7.5 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	13.35 V
I approximately	178.3 A
Spatter free ignition	Off
SynchroPulse	Off

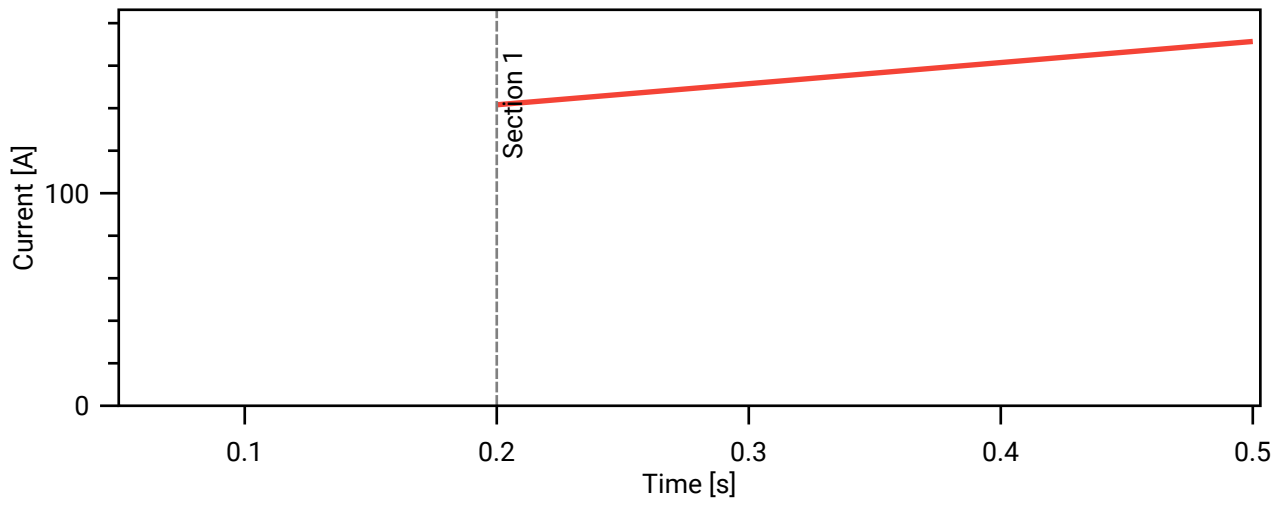
#### QMaster

Welding current command value	175 A (15 A / -15 A)
Voltage command value	13.6 V (4.0 V / -4.0 V)
Wire speed command value	7.5 m/min (2.2 m/min / -4.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

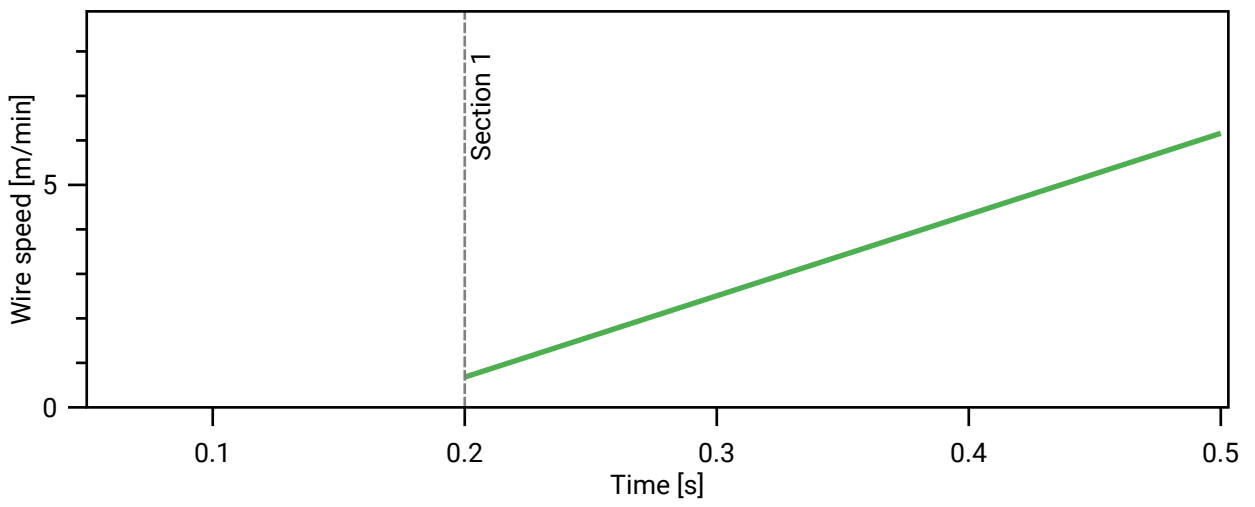
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:23 PM
Duration	1.4 s
Limit violations	None
Wire consumption (length)	0.097 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

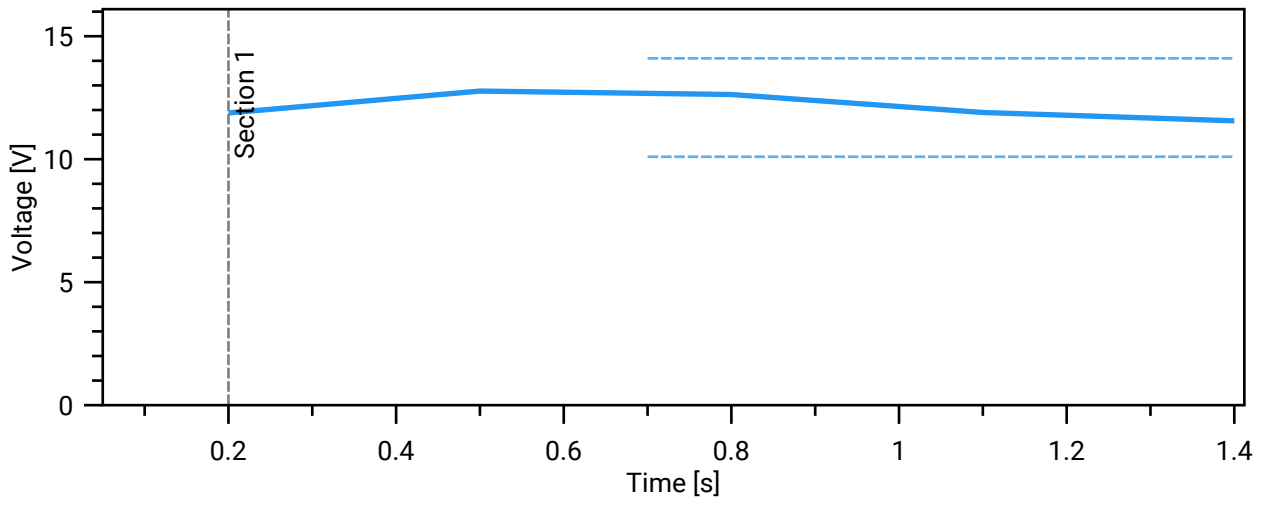
#### Section values

Welding mode	mig cmt
Duration	1.4 s
Job number	62
Arc gas consumption	0.4 l
Wire consumption (length)	0.097 m
Reference number of weld characteristic	1053
Wire speed	4.8 m/min
Arc length correction	-1 %
Pulse correction	0 %
U approximately	11.28 V
I approximately	114.4 A
Spatter free ignition	Off
SynchroPulse	Off

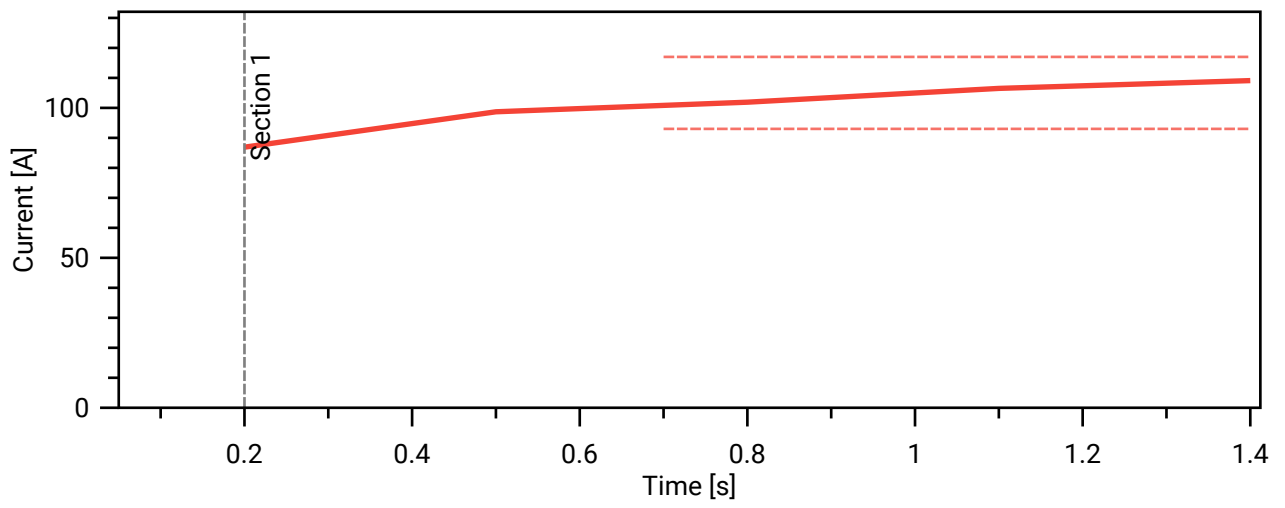
#### QMaster

Welding current command value	105 A (12 A / -12 A)
Voltage command value	12.1 V (2.0 V / -2.0 V)
Wire speed command value	4.8 m/min (1.6 m/min / -2.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

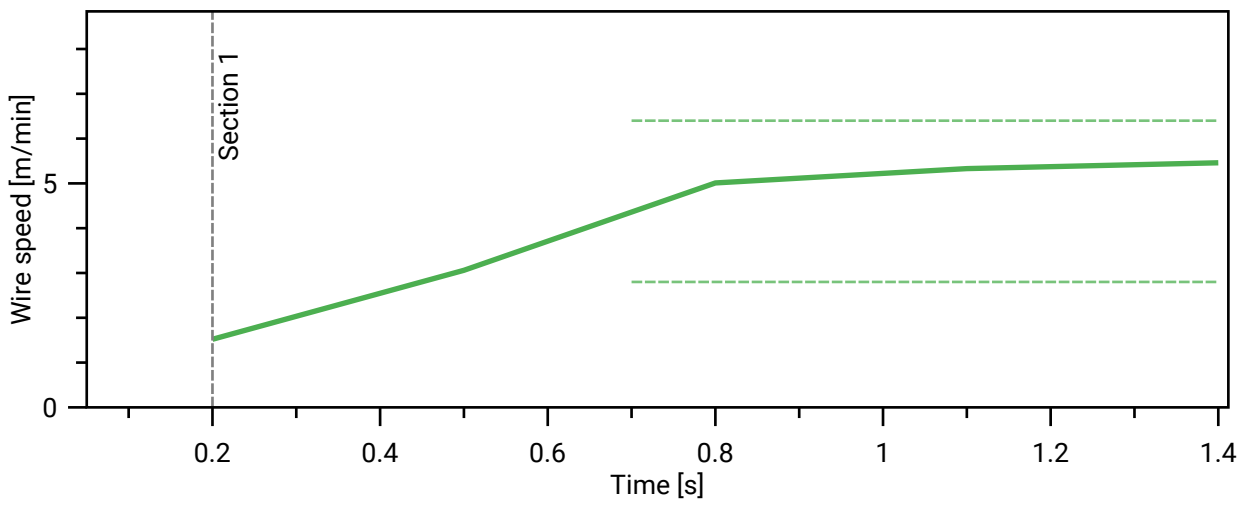
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:26 PM
Duration	1.4 s
Limit violations	None
Wire consumption (length)	0.096 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

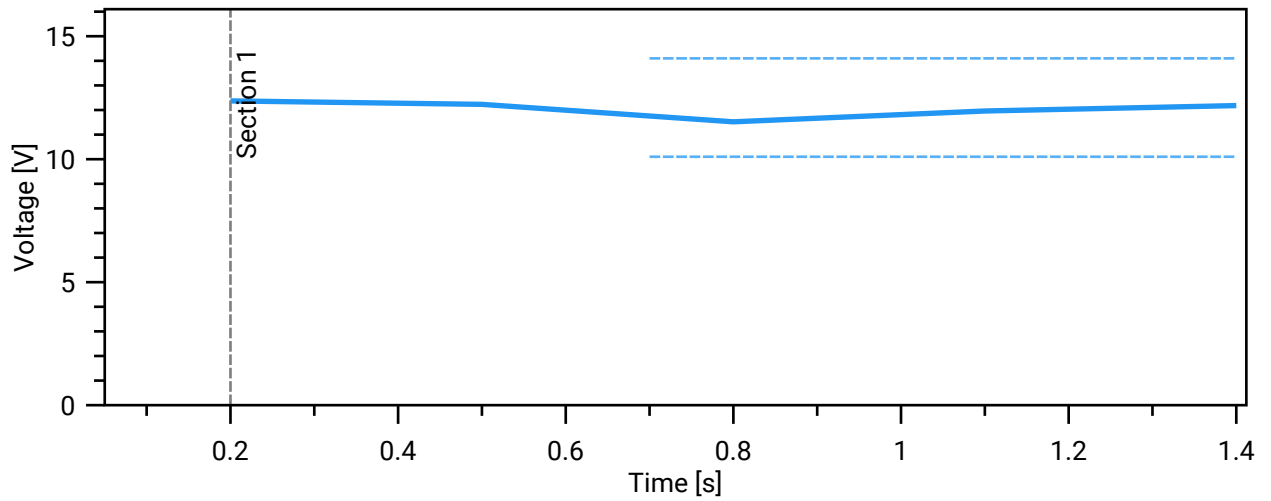
#### Section values

Welding mode	mig cmt
Duration	1.4 s
Job number	62
Arc gas consumption	0.4 l
Wire consumption (length)	0.096 m
Reference number of weld characteristic	1053
Wire speed	4.8 m/min
Arc length correction	-1 %
Pulse correction	0 %
U approximately	11.28 V
I approximately	114.4 A
Spatter free ignition	Off
SynchroPulse	Off

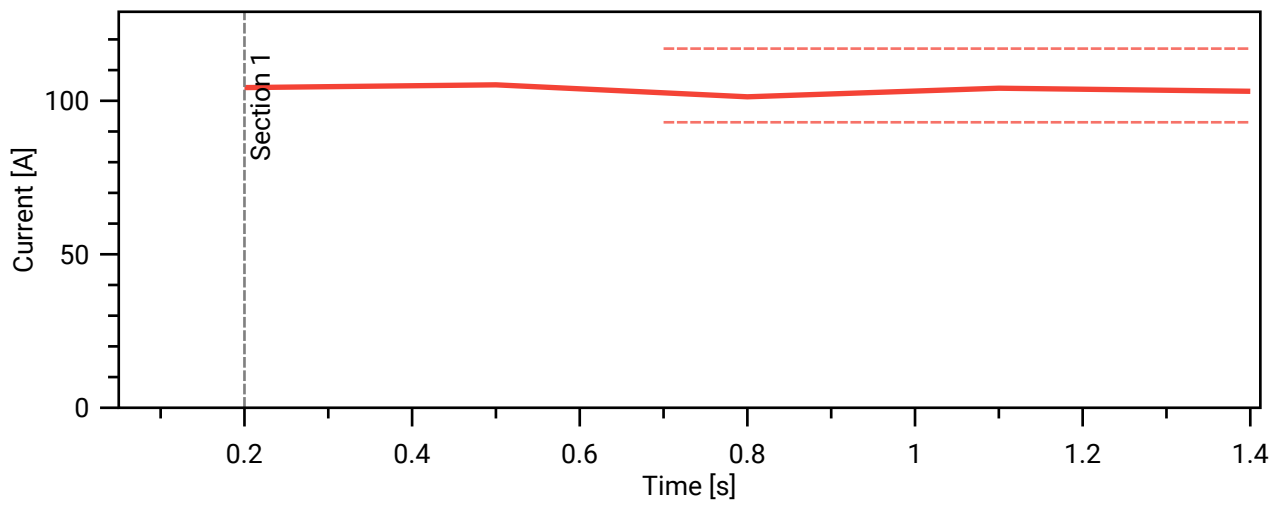
#### QMaster

Welding current command value	105 A (12 A / -12 A)
Voltage command value	12.1 V (2.0 V / -2.0 V)
Wire speed command value	4.8 m/min (1.6 m/min / -2.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

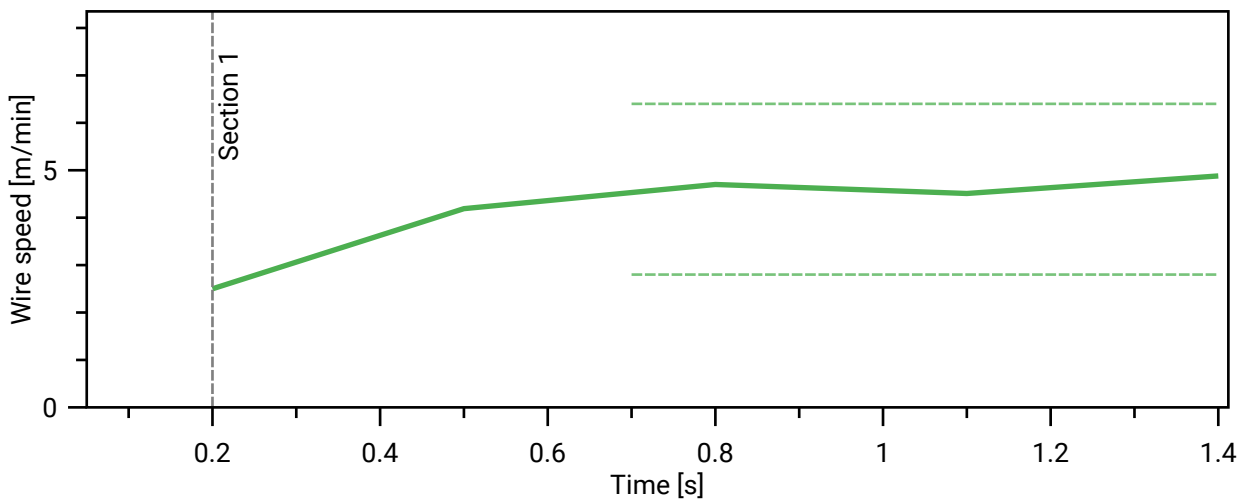
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:28 PM
Duration	2.9 s
Limit violations	None
Wire consumption (length)	0.245 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

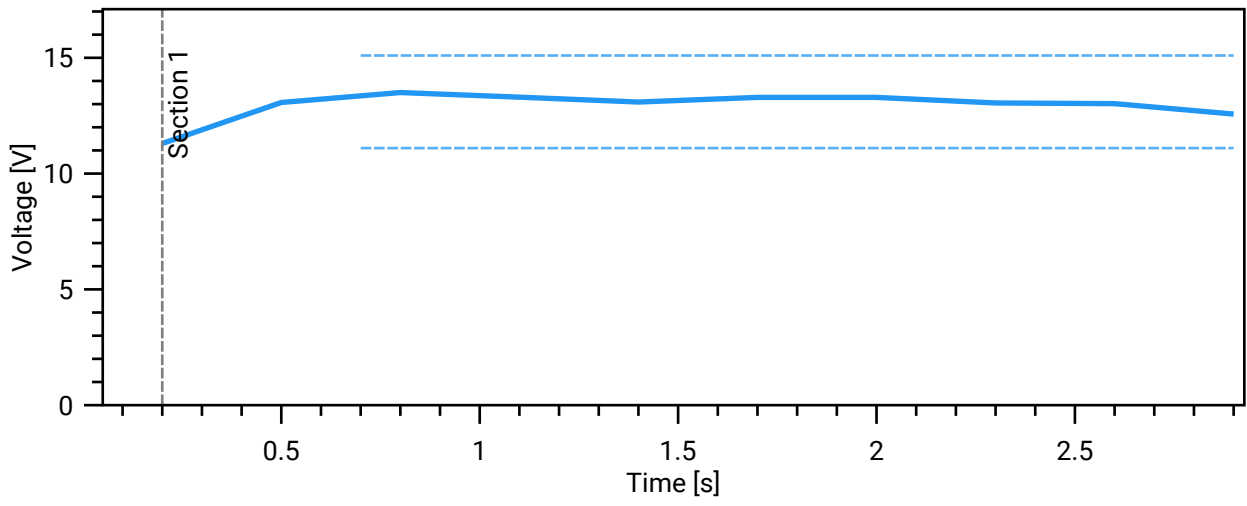
#### Section values

Welding mode	mig cmt
Duration	2.9 s
Job number	64
Arc gas consumption	0.1 l
Wire consumption (length)	0.245 m
Reference number of weld characteristic	1053
Wire speed	4.4 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	10.82 V
I approximately	104.5 A
Spatter free ignition	Off
SynchroPulse	Off

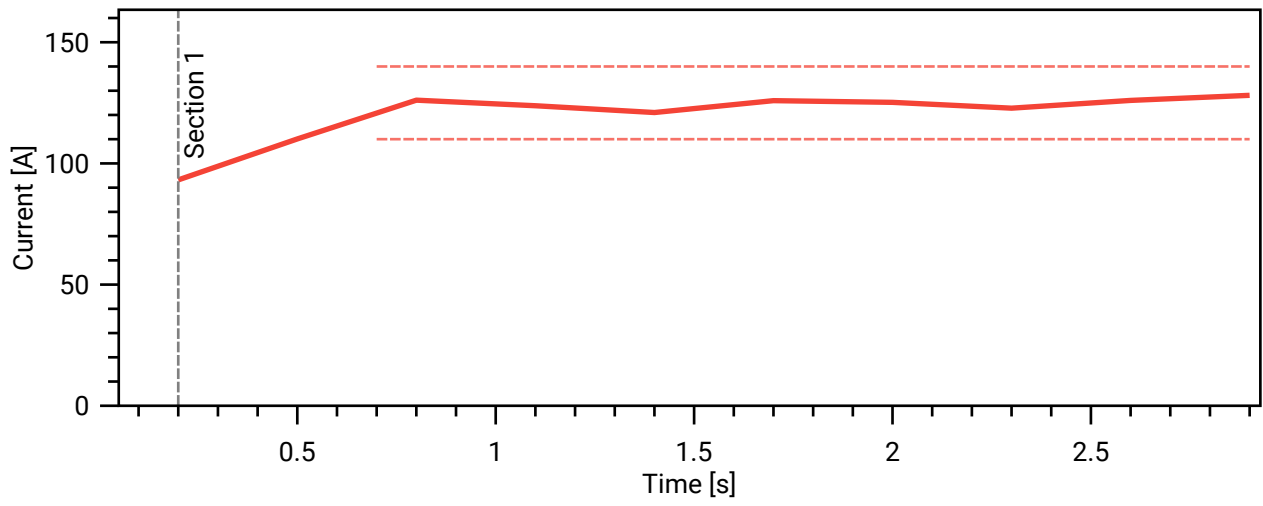
#### QMaster

Welding current command value	125 A (15 A / -15 A)
Voltage command value	13.1 V (2.0 V / -2.0 V)
Wire speed command value	5.5 m/min (1.7 m/min / -1.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

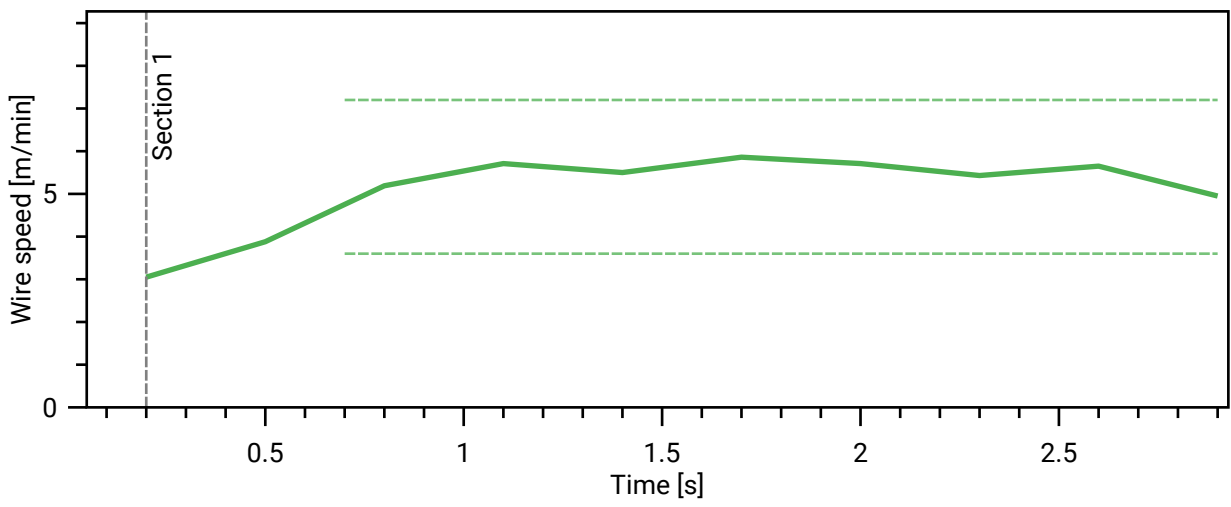
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:33 PM
Duration	2.4 s
Limit violations	None
Wire consumption (length)	0.196 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

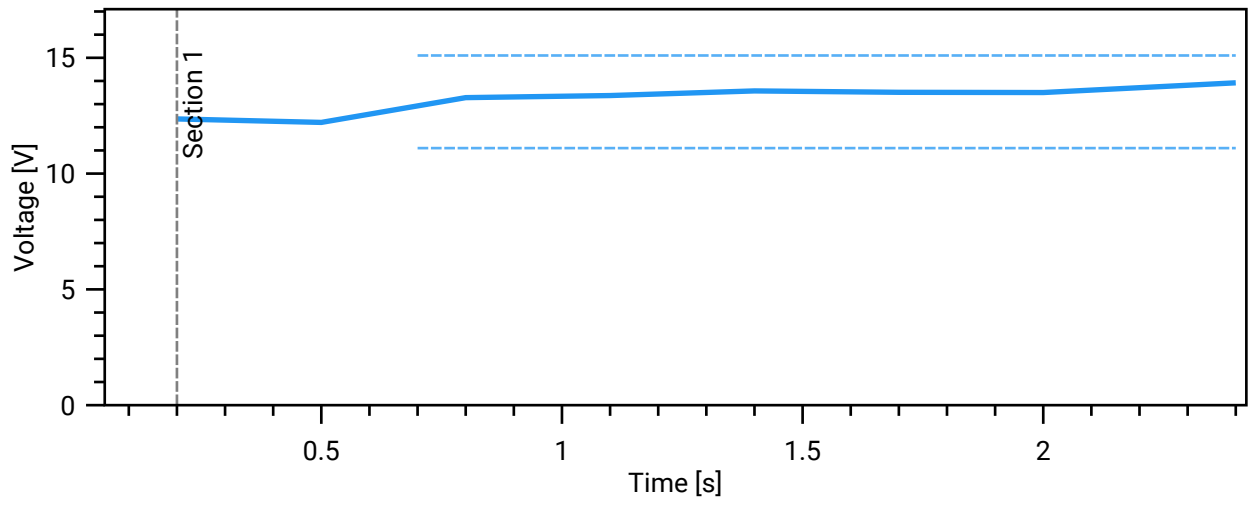
#### Section values

Welding mode	mig cmt
Duration	2.4 s
Job number	64
Arc gas consumption	0.1 l
Wire consumption (length)	0.196 m
Reference number of weld characteristic	1053
Wire speed	4.4 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	10.82 V
I approximately	104.5 A
Spatter free ignition	Off
SynchroPulse	Off

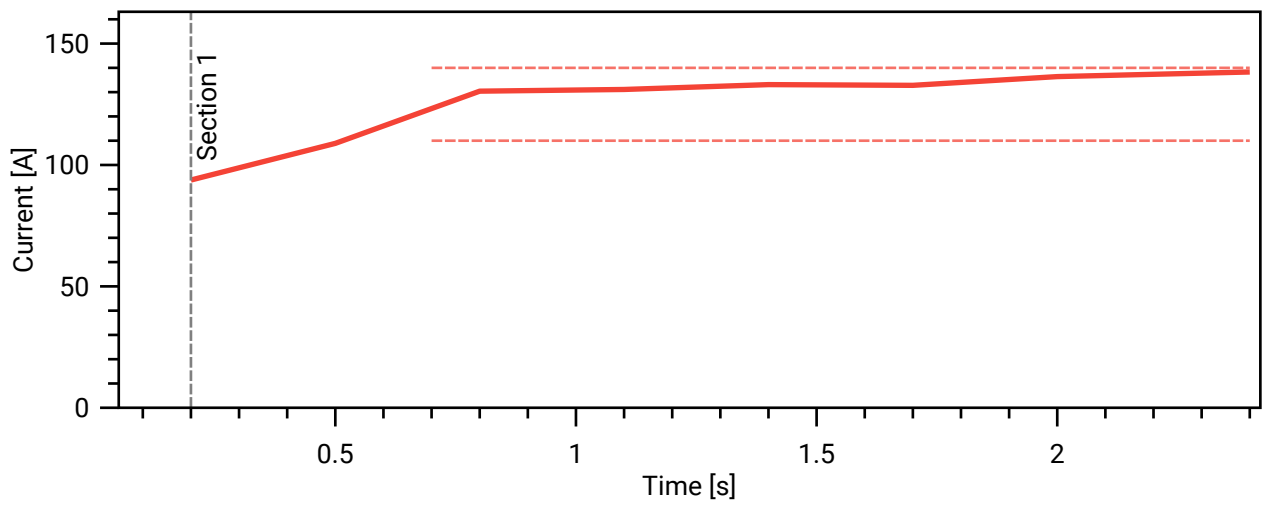
#### QMaster

Welding current command value	125 A (15 A / -15 A)
Voltage command value	13.1 V (2.0 V / -2.0 V)
Wire speed command value	5.5 m/min (1.7 m/min / -1.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

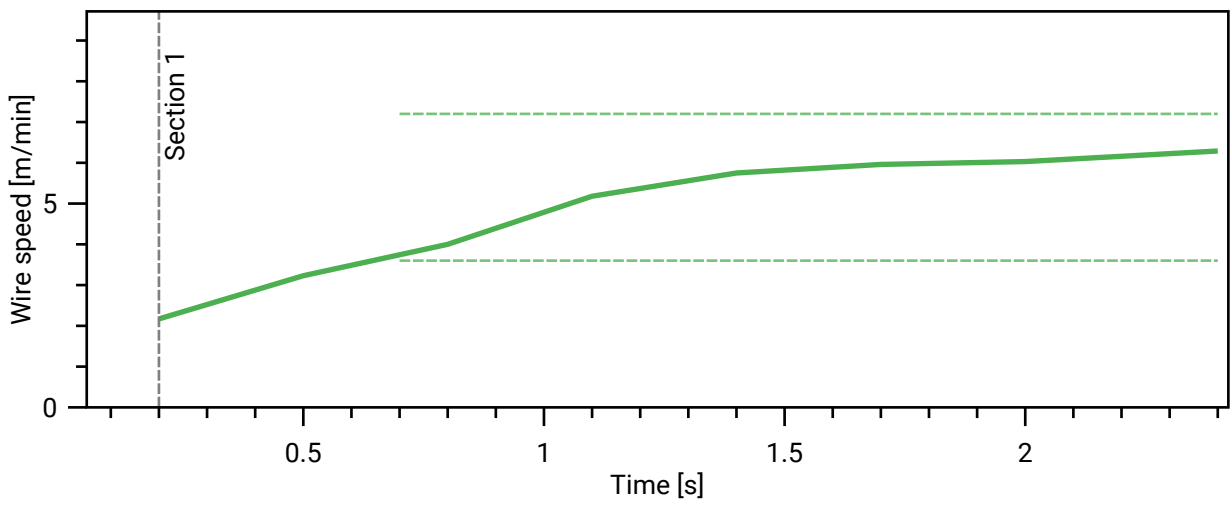
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:37 PM
Duration	3.6 s
Limit violations	None
Wire consumption (length)	0.324 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

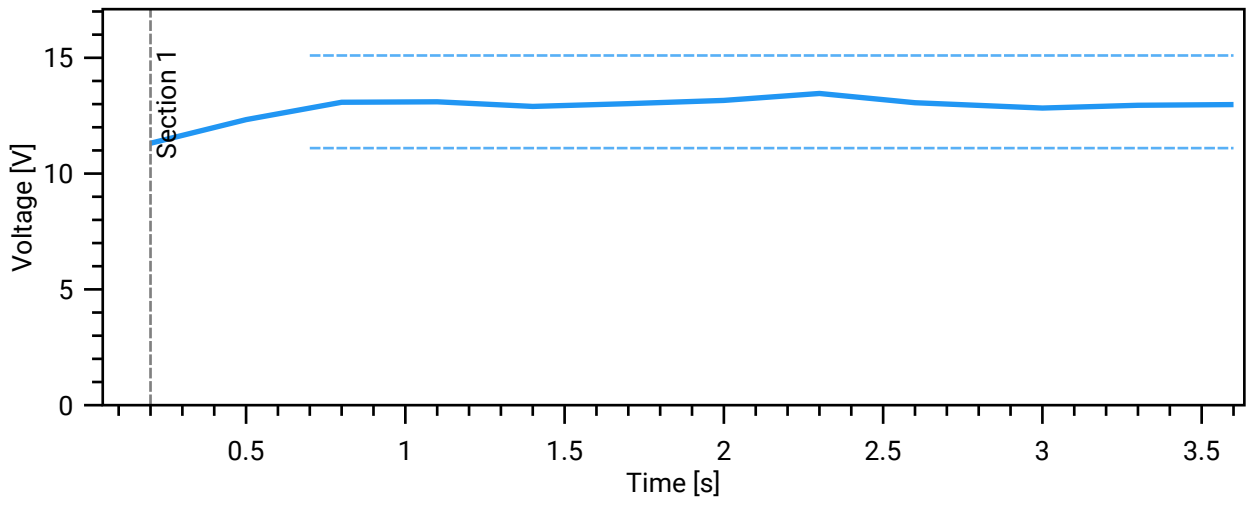
#### Section values

Welding mode	mig cmt
Duration	3.6 s
Job number	64
Arc gas consumption	0.1 l
Wire consumption (length)	0.324 m
Reference number of weld characteristic	1053
Wire speed	4.4 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	10.82 V
I approximately	104.5 A
Spatter free ignition	Off
SynchroPulse	Off

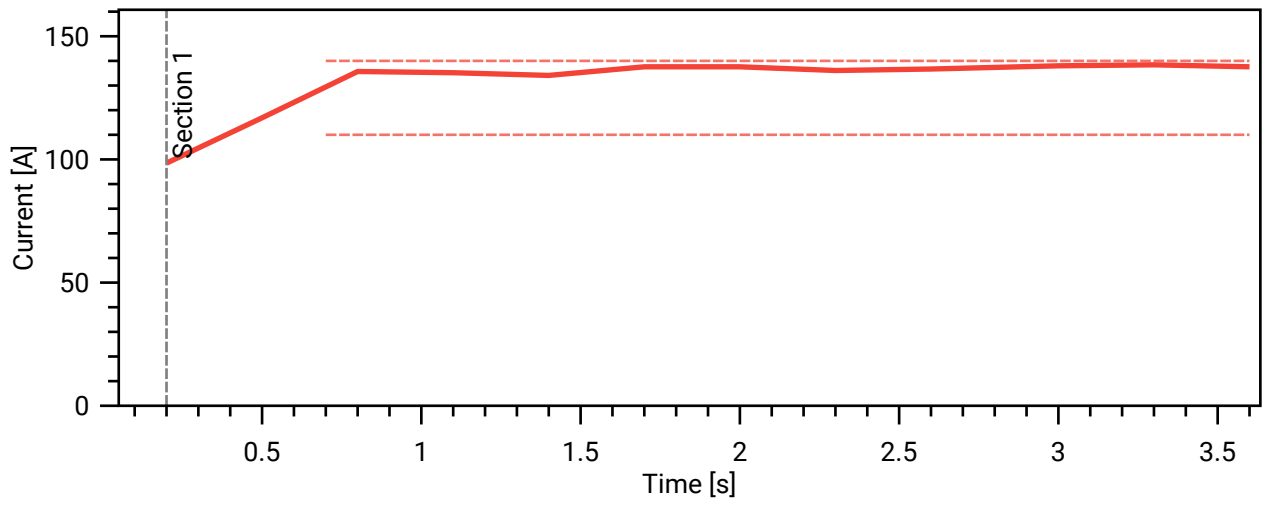
#### QMaster

Welding current command value	125 A (15 A / -15 A)
Voltage command value	13.1 V (2.0 V / -2.0 V)
Wire speed command value	5.5 m/min (1.7 m/min / -1.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

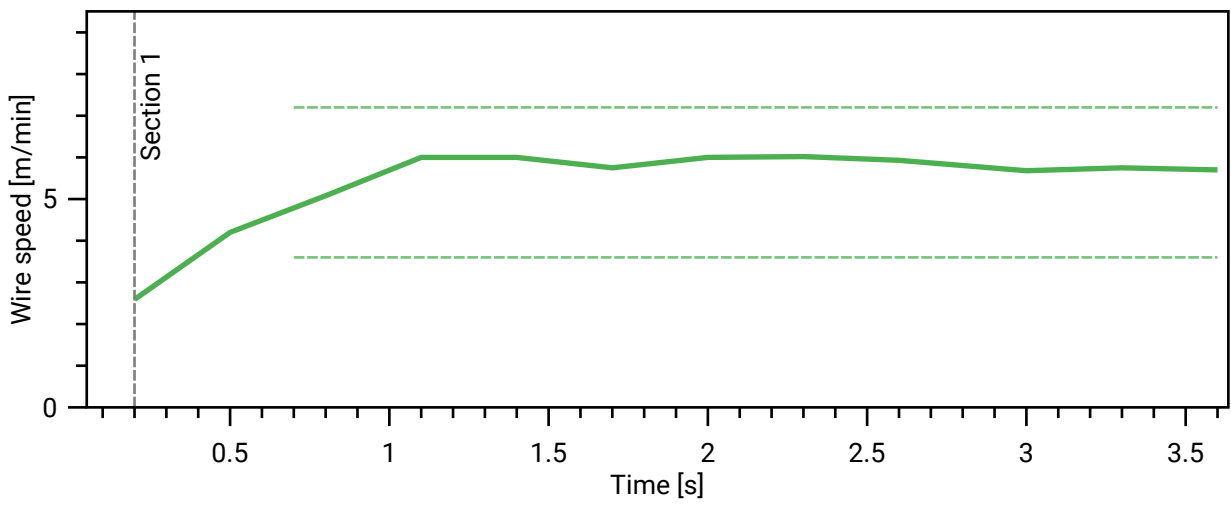
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:42 PM
Duration	3.2 s
Limit violations	None
Wire consumption (length)	0.287 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

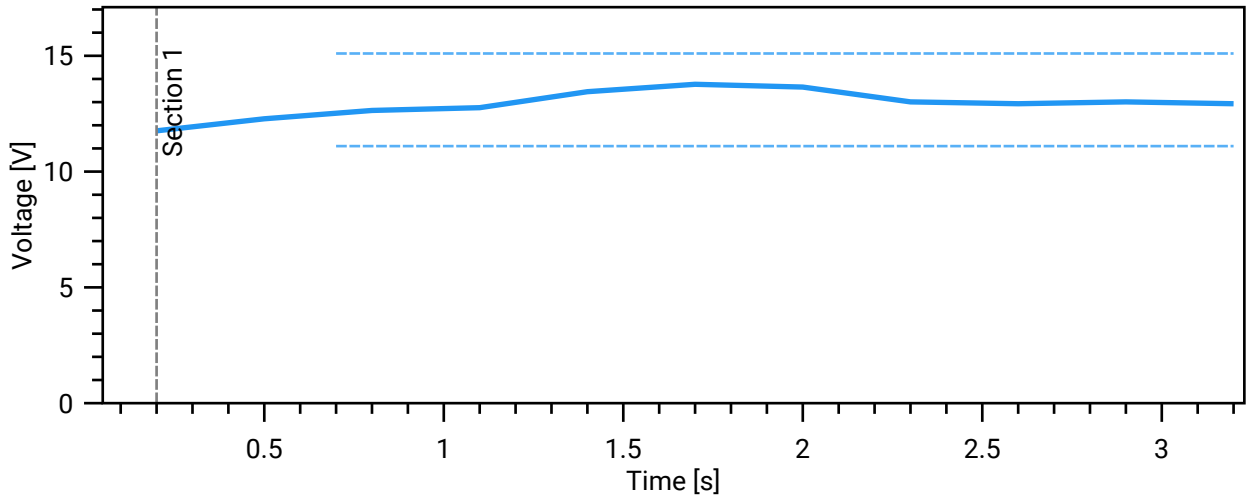
#### Section values

Welding mode	mig cmt
Duration	3.2 s
Job number	64
Arc gas consumption	0.1 l
Wire consumption (length)	0.287 m
Reference number of weld characteristic	1053
Wire speed	4.4 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	10.82 V
I approximately	104.5 A
Spatter free ignition	Off
SynchroPulse	Off

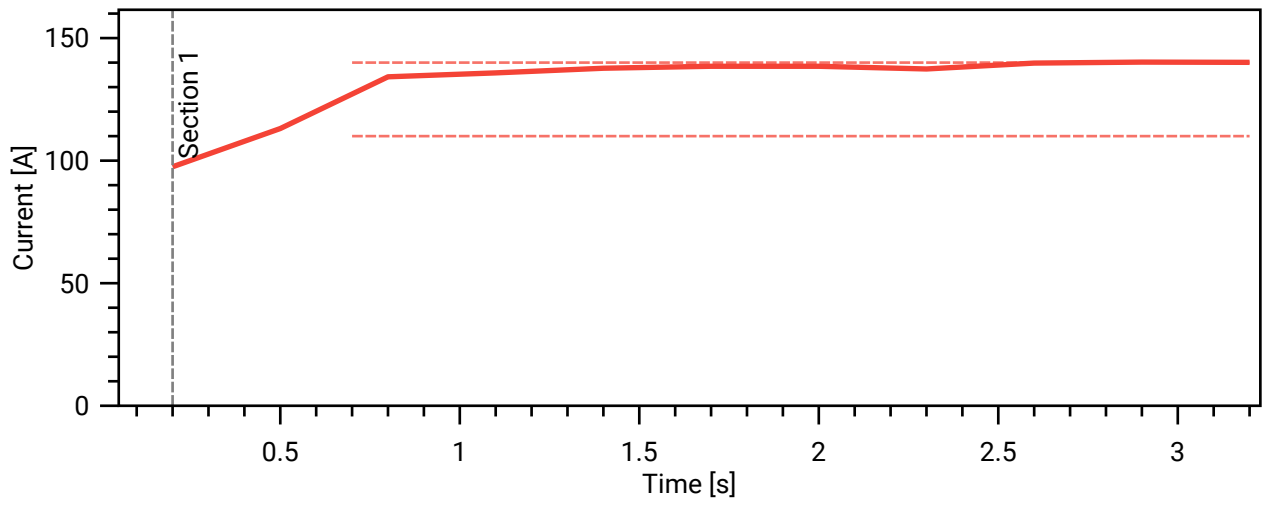
#### QMaster

Welding current command value	125 A (15 A / -15 A)
Voltage command value	13.1 V (2.0 V / -2.0 V)
Wire speed command value	5.5 m/min (1.7 m/min / -1.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

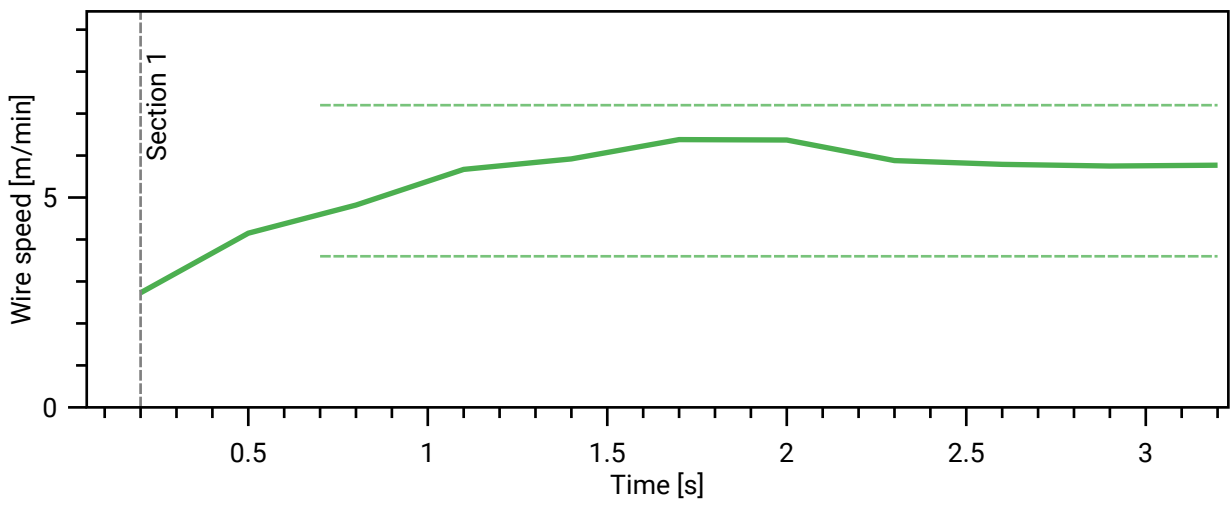
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:46 PM
Duration	3.6 s
Limit violations	None
Wire consumption (length)	0.344 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

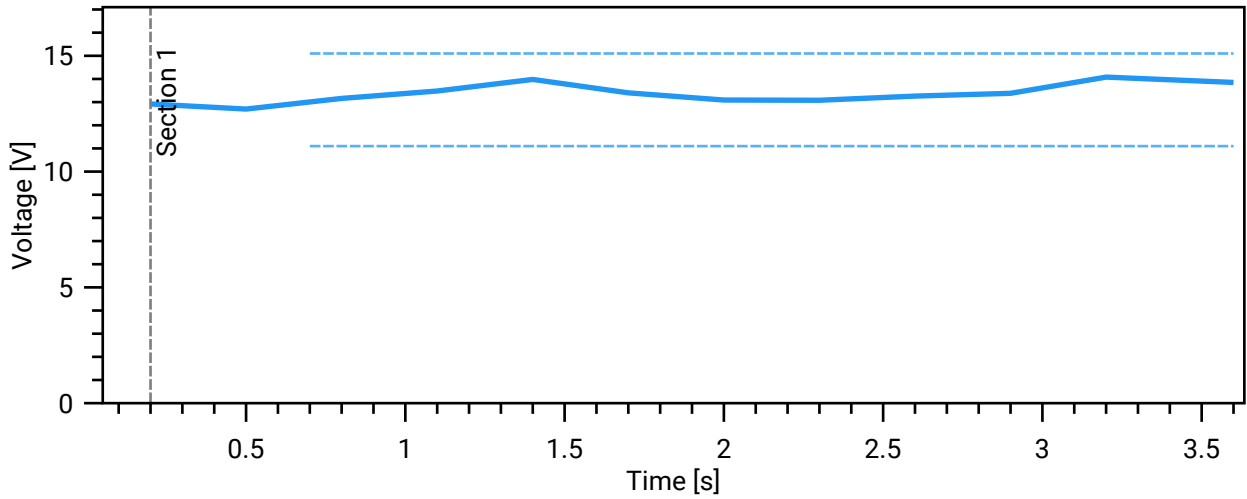
#### Section values

Welding mode	mig cmt
Duration	3.6 s
Job number	64
Arc gas consumption	0.1 l
Wire consumption (length)	0.344 m
Reference number of weld characteristic	1053
Wire speed	4.4 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	10.82 V
I approximately	104.5 A
Spatter free ignition	Off
SynchroPulse	Off

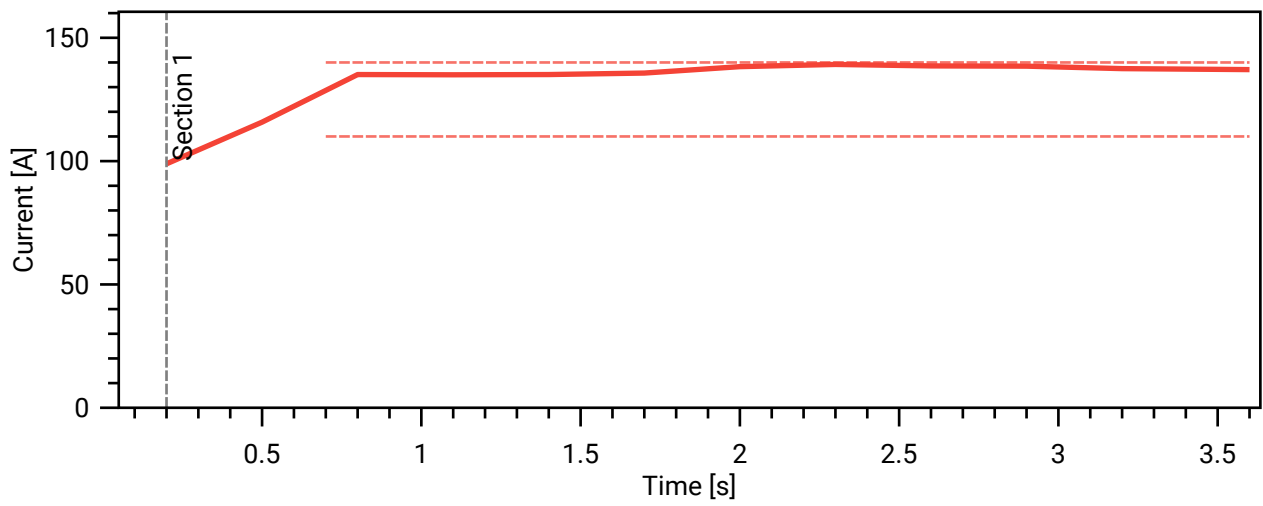
#### QMaster

Welding current command value	125 A (15 A / -15 A)
Voltage command value	13.1 V (2.0 V / -2.0 V)
Wire speed command value	5.5 m/min (1.7 m/min / -1.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

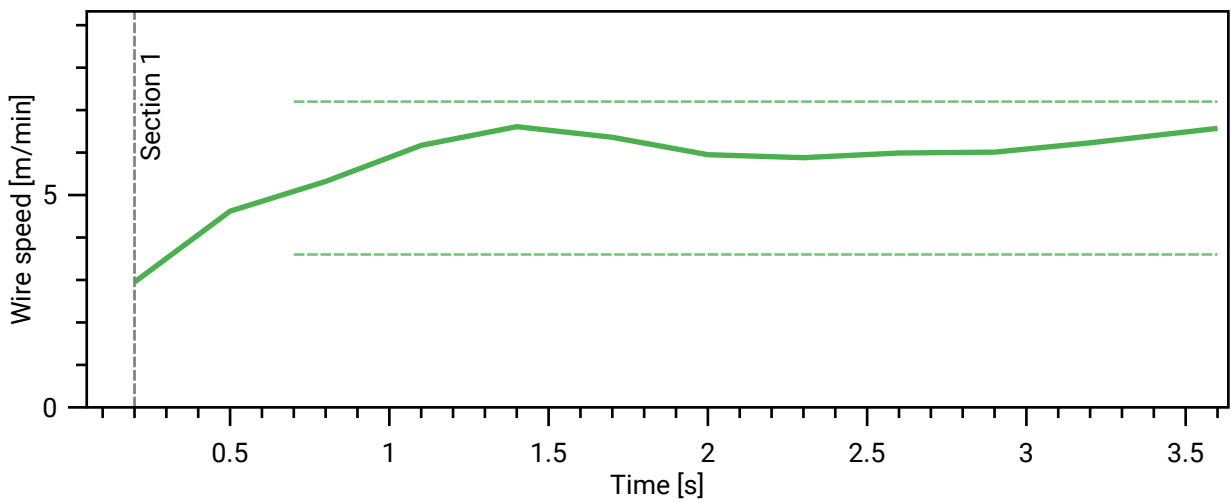
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:51 PM
Duration	2.6 s
Limit violations	None
Wire consumption (length)	0.216 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

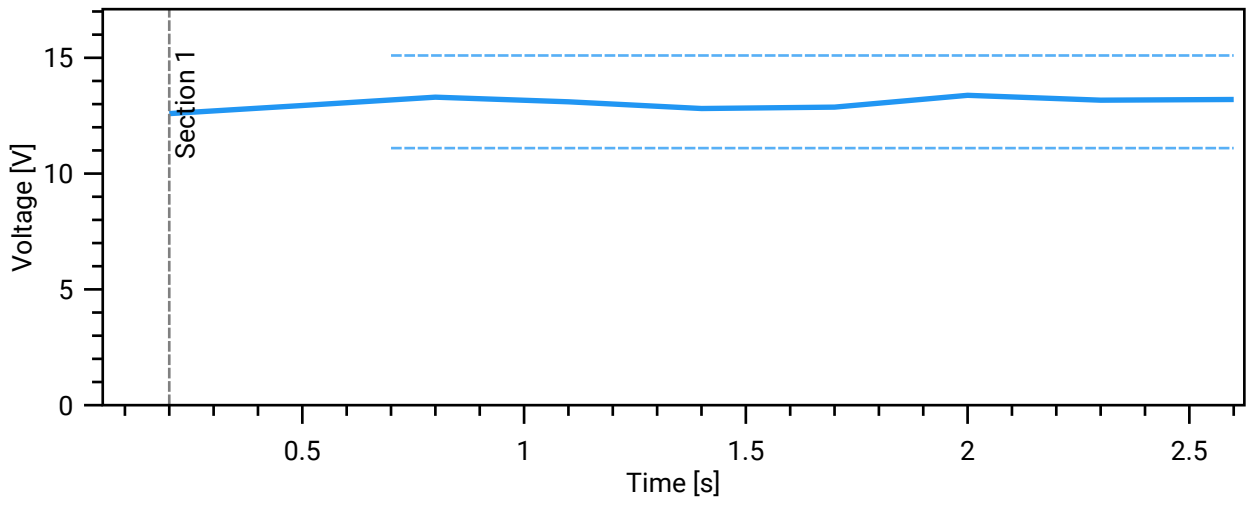
#### Section values

Welding mode	mig cmt
Duration	2.6 s
Job number	64
Arc gas consumption	0.1 l
Wire consumption (length)	0.216 m
Reference number of weld characteristic	1053
Wire speed	4.4 m/min
Arc length correction	2 %
Pulse correction	0 %
U approximately	10.82 V
I approximately	104.5 A
Spatter free ignition	Off
SynchroPulse	Off

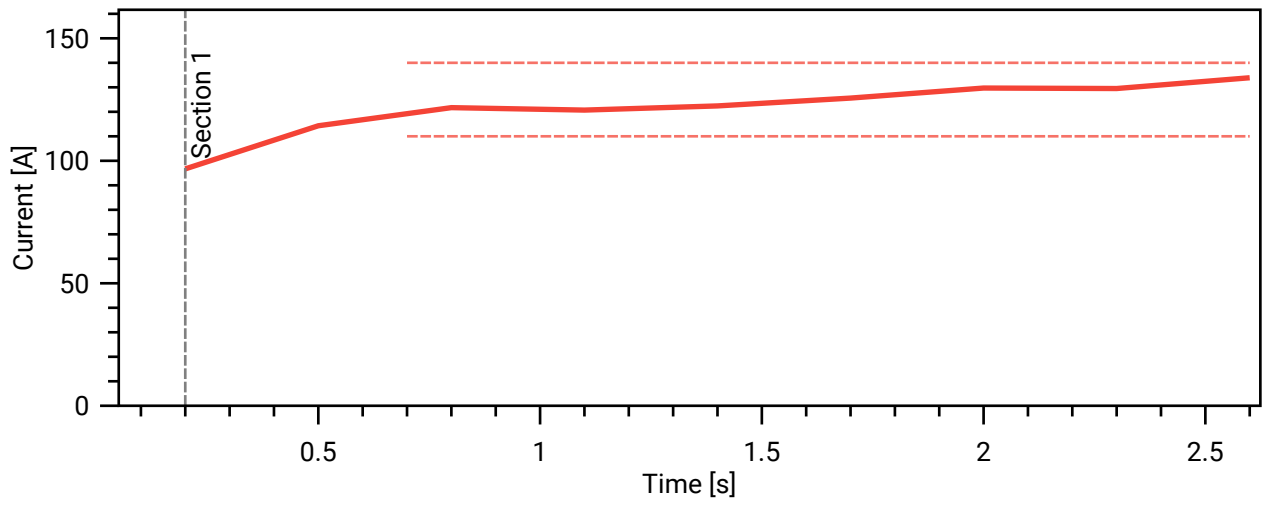
#### QMaster

Welding current command value	125 A (15 A / -15 A)
Voltage command value	13.1 V (2.0 V / -2.0 V)
Wire speed command value	5.5 m/min (1.7 m/min / -1.9 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

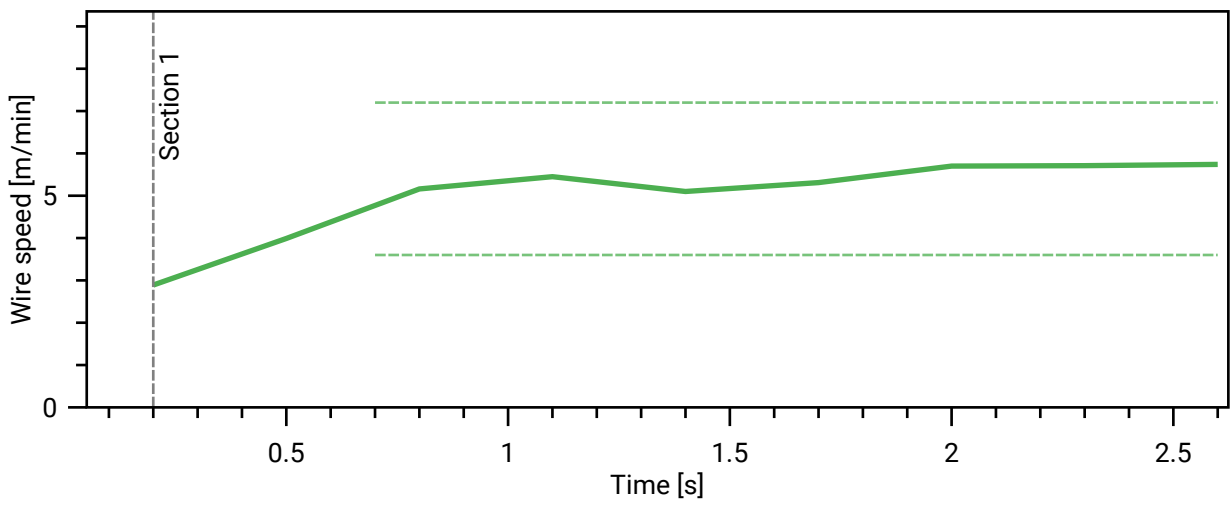
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:55 PM
Duration	1.7 s
Limit violations	None
Wire consumption (length)	0.138 m

## Machine

Name	<a href="#">TPS5000CMT Second Line</a>
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

#### Section values

Welding mode	mig cmt
Duration	0.2 s
Job number	65
Arc gas consumption	0.2 l
Wire consumption (length)	0.006 m
Reference number of weld characteristic	1053
Wire speed	3.3 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	9.96 V
I approximately	87.6 A
Spatter free ignition	Off
SynchroPulse	Off

#### QMaster

Welding current command value	133 A (15 A / -15 A)
Voltage command value	14.3 V (3.0 V / -3.0 V)
Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

### Section 2

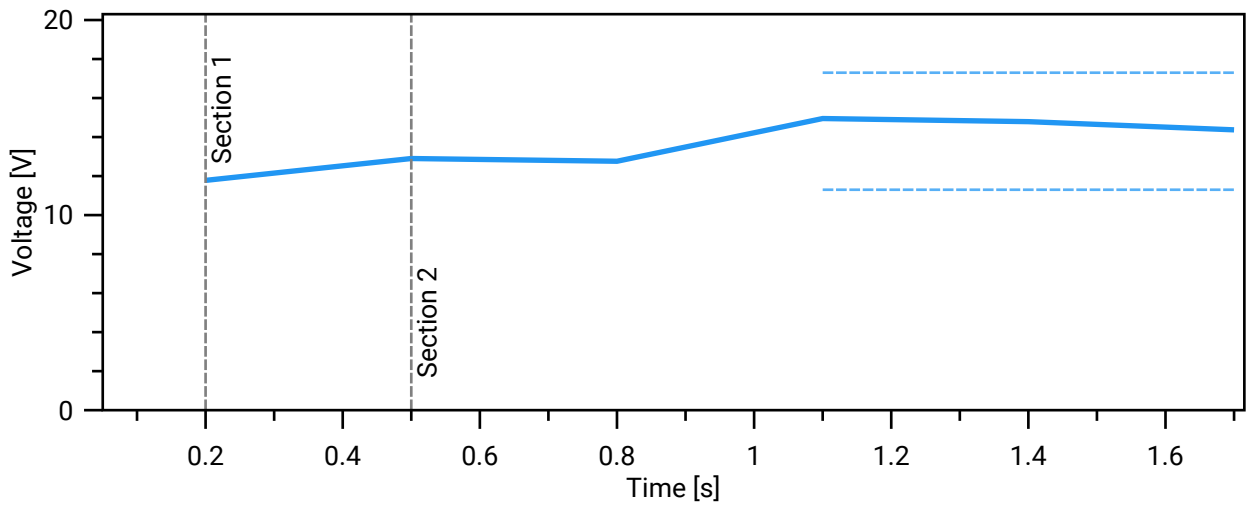
#### Section values

Welding mode	mig cmt
Duration	1.5 s
Job number	65
Arc gas consumption	0.3 l
Wire consumption (length)	0.131 m
Reference number of weld characteristic	1053
Wire speed	5.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	11.81 V
I approximately	136.1 A
Spatter free ignition	Off
SynchroPulse	Off

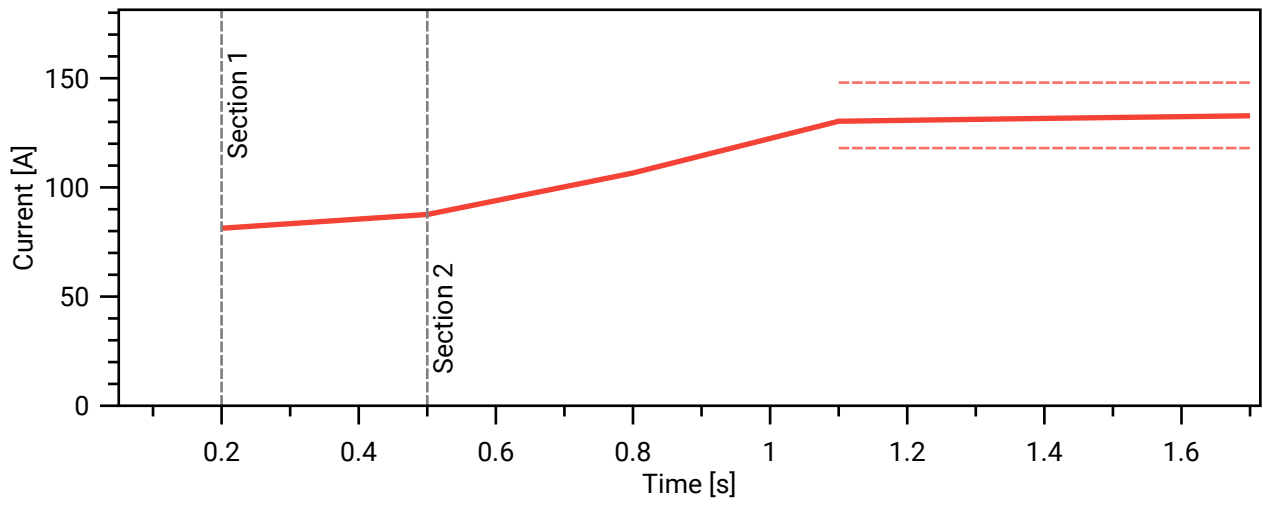
#### QMaster

Welding current command value	133 A (15 A / -15 A)
Voltage command value	14.3 V (3.0 V / -3.0 V)
Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

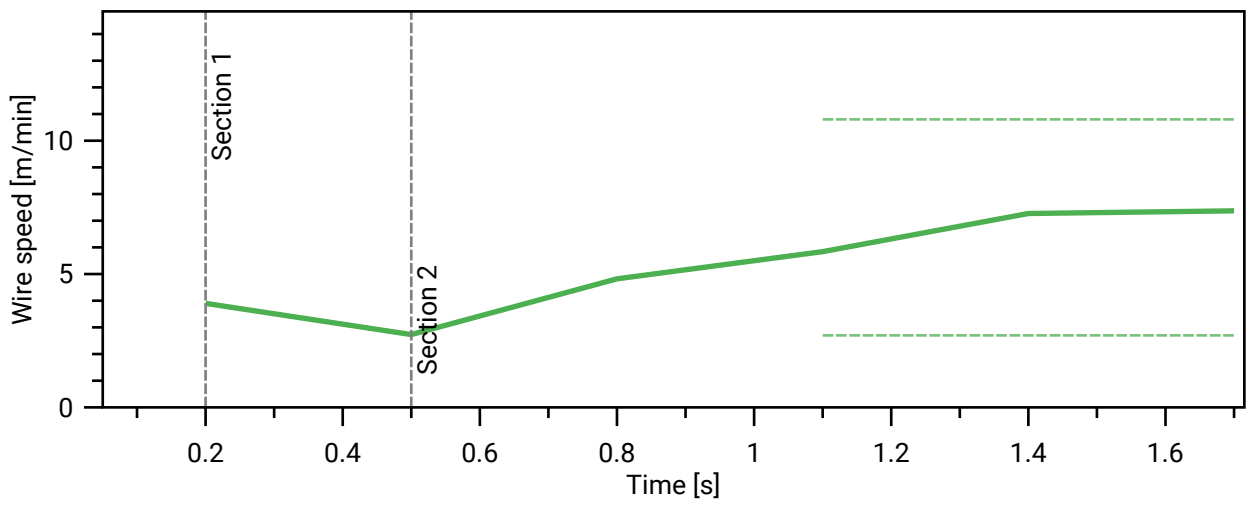
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:13:58 PM
Duration	2.6 s
Limit violations	None
Wire consumption (length)	0.243 m

## Machine

Name	<a href="#">TPS5000CMT Second Line</a>
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

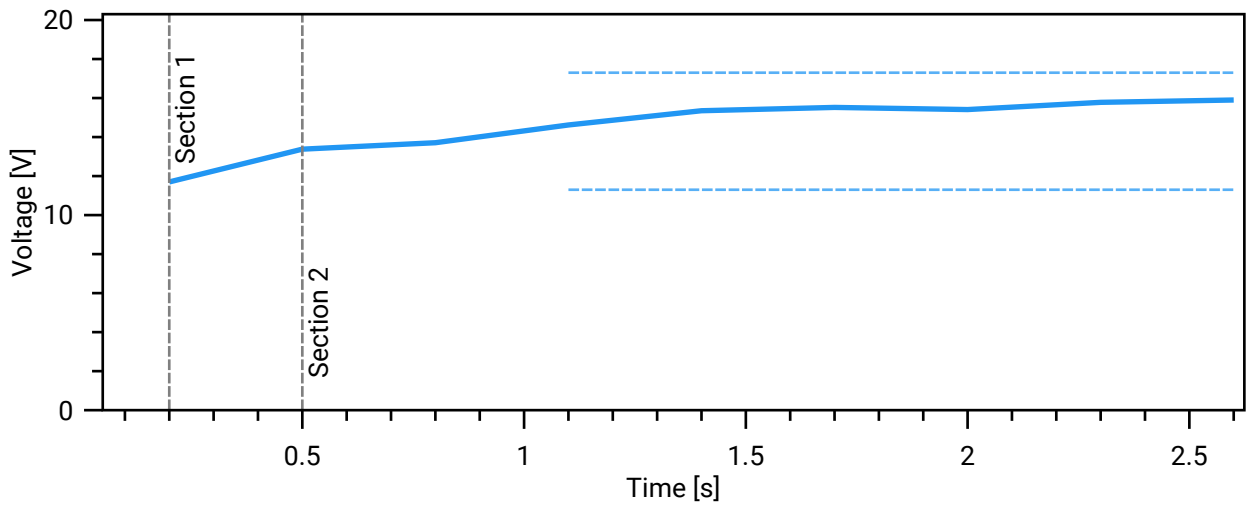
### Section 1

Section values		QMaster	
Welding mode	mig cmt	Welding current command value	133 A (15 A / -15 A)
Duration	0.2 s	Voltage command value	14.3 V (3.0 V / -3.0 V)
Job number	65	Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Arc gas consumption	0.1 l	Max. duration of current deviation	0.5 s
Wire consumption (length)	0.004 m	Max. duration of voltage deviation	0.5 s
Reference number of weld characteristic	1053	Max. duration of wire speed deviation	0.5 s
Wire speed	3.3 m/min	Reaction	Warning
Arc length correction	-2 %		
Pulse correction	0 %		
U approximately	9.96 V		
I approximately	87.6 A		
Spatter free ignition	Off		
SynchroPulse	Off		

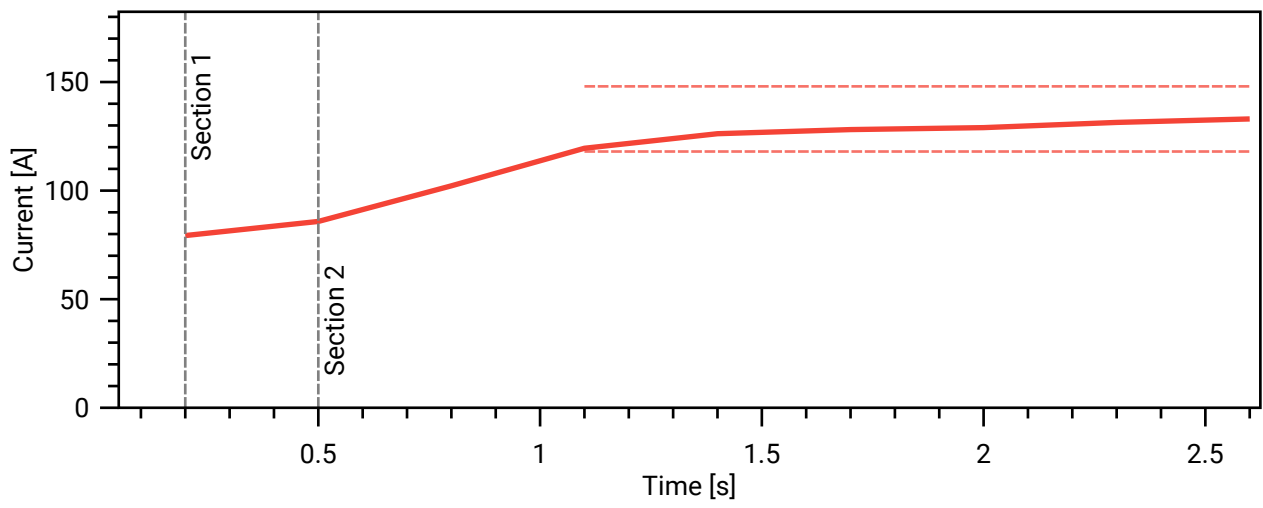
### Section 2

Section values		QMaster	
Welding mode	mig cmt	Welding current command value	133 A (15 A / -15 A)
Duration	2.4 s	Voltage command value	14.3 V (3.0 V / -3.0 V)
Job number	65	Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Arc gas consumption	0.6 l	Max. duration of current deviation	0.5 s
Wire consumption (length)	0.239 m	Max. duration of voltage deviation	0.5 s
Reference number of weld characteristic	1053	Max. duration of wire speed deviation	0.5 s
Wire speed	5.5 m/min	Reaction	Warning
Arc length correction	-2 %		
Pulse correction	0 %		
U approximately	11.81 V		
I approximately	136.1 A		
Spatter free ignition	Off		
SynchroPulse	Off		

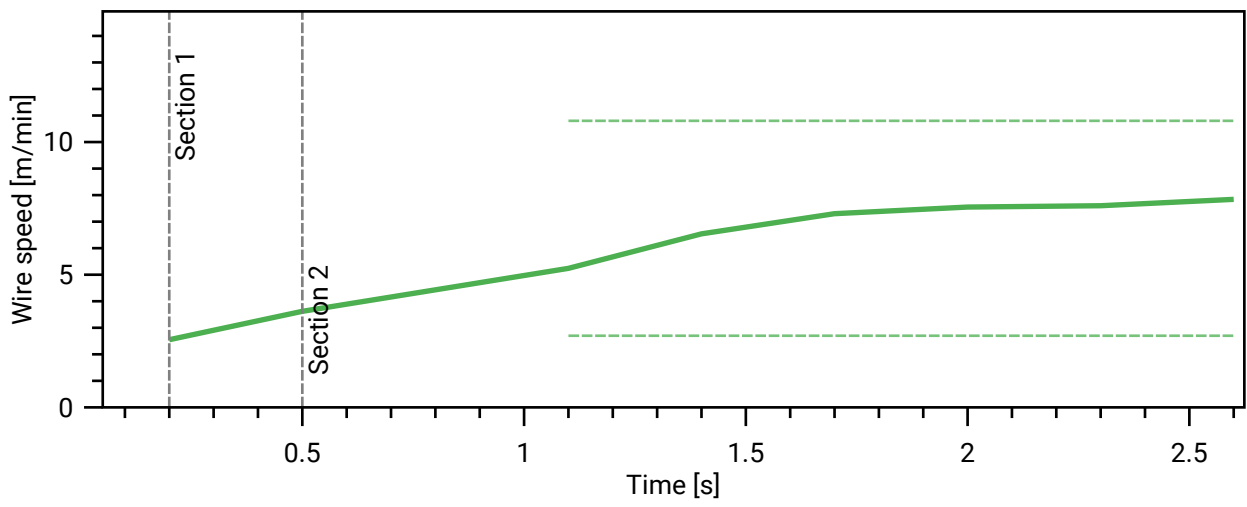
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:03 PM
Duration	2.9 s
Limit violations	None
Wire consumption (length)	0.281 m

## Machine

Name	<a href="#">TPS5000CMT Second Line</a>
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

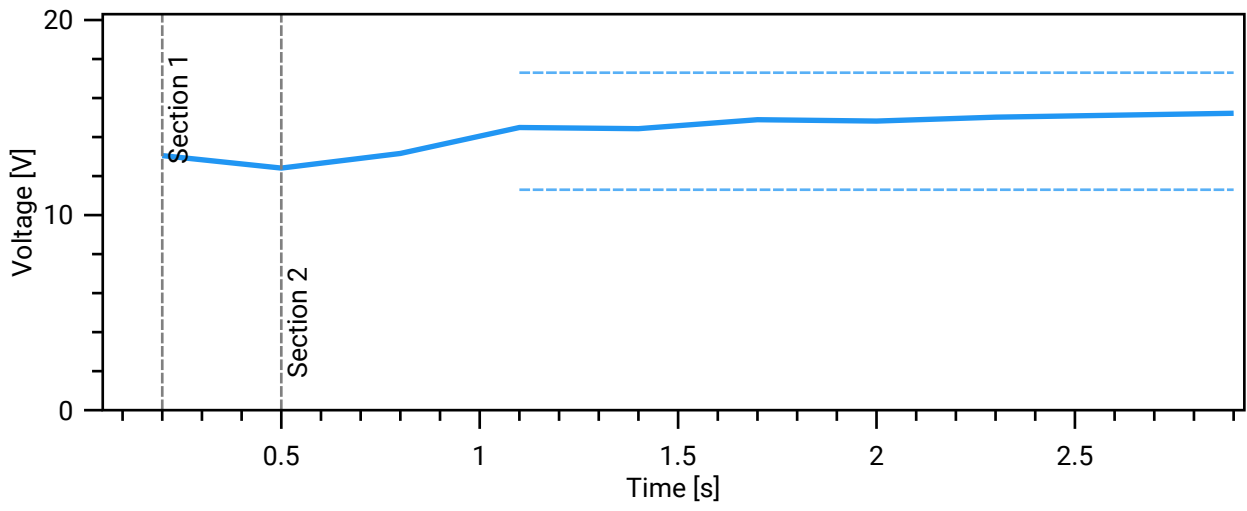
### Section 1

Section values		QMaster	
Welding mode	mig cmt	Welding current command value	133 A (15 A / -15 A)
Duration	0.2 s	Voltage command value	14.3 V (3.0 V / -3.0 V)
Job number	65	Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Arc gas consumption	0.1 l	Max. duration of current deviation	0.5 s
Wire consumption (length)	0.004 m	Max. duration of voltage deviation	0.5 s
Reference number of weld characteristic	1053	Max. duration of wire speed deviation	0.5 s
Wire speed	3.3 m/min	Reaction	Warning
Arc length correction	-2 %		
Pulse correction	0 %		
U approximately	9.96 V		
I approximately	87.6 A		
Spatter free ignition	Off		
SynchroPulse	Off		

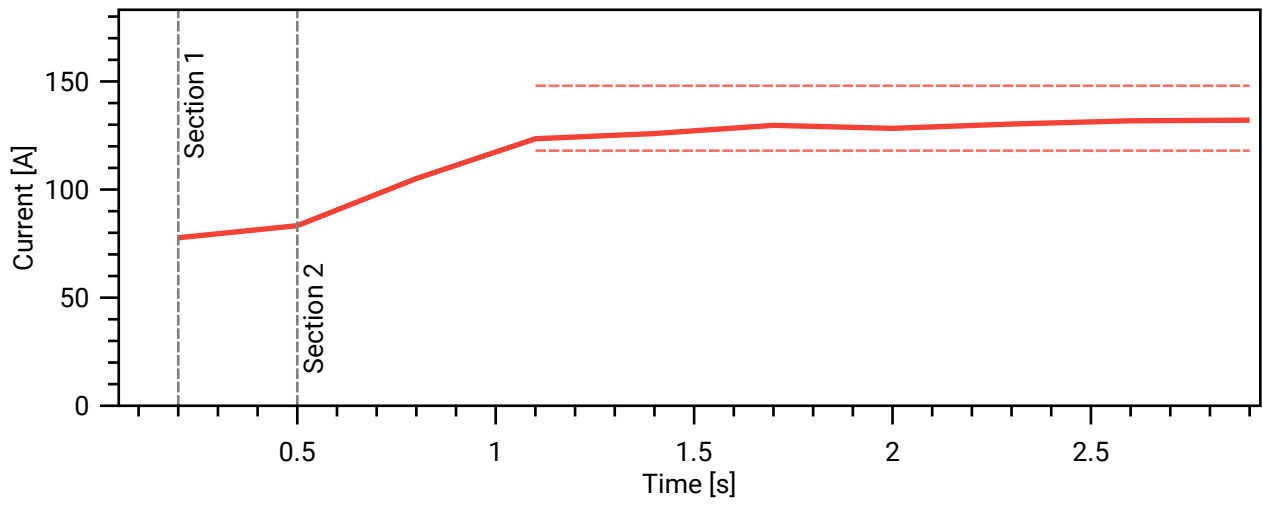
### Section 2

Section values		QMaster	
Welding mode	mig cmt	Welding current command value	133 A (15 A / -15 A)
Duration	2.7 s	Voltage command value	14.3 V (3.0 V / -3.0 V)
Job number	65	Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Arc gas consumption	0.5 l	Max. duration of current deviation	0.5 s
Wire consumption (length)	0.277 m	Max. duration of voltage deviation	0.5 s
Reference number of weld characteristic	1053	Max. duration of wire speed deviation	0.5 s
Wire speed	5.5 m/min	Reaction	Warning
Arc length correction	-2 %		
Pulse correction	0 %		
U approximately	11.81 V		
I approximately	136.1 A		
Spatter free ignition	Off		
SynchroPulse	Off		

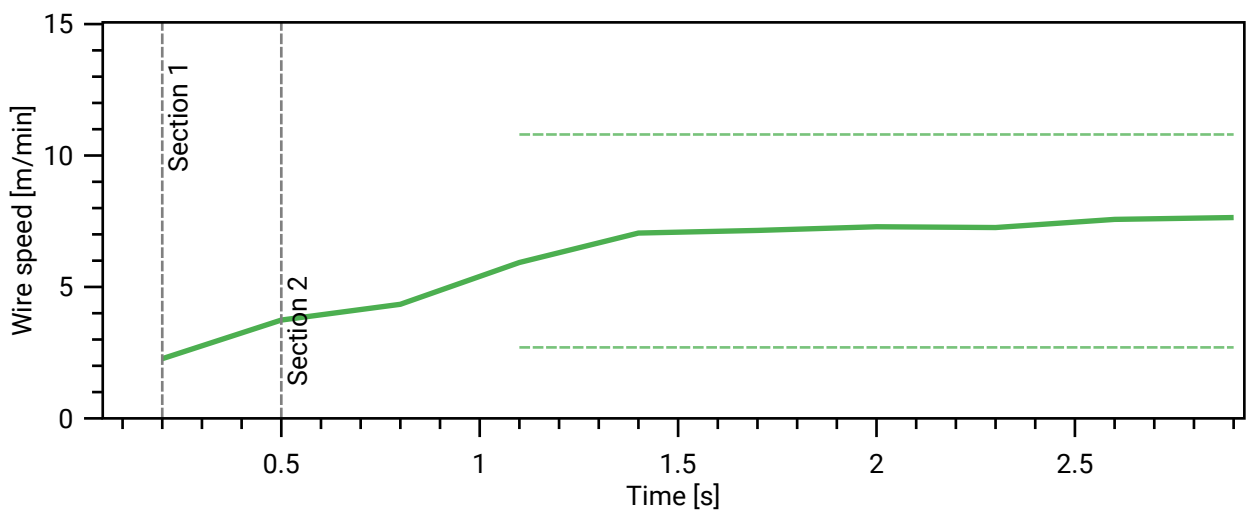
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:07 PM
Duration	2.6 s
Limit violations	None
Wire consumption (length)	0.248 m

## Machine

Name	<a href="#">TPS5000CMT Second Line</a>
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

#### Section values

Welding mode	mig cmt
Duration	0.2 s
Job number	65
Arc gas consumption	0.1 l
Wire consumption (length)	0.004 m
Reference number of weld characteristic	1053
Wire speed	3.3 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	9.96 V
I approximately	87.6 A
Spatter free ignition	Off
SynchroPulse	Off

#### QMaster

Welding current command value	133 A (15 A / -15 A)
Voltage command value	14.3 V (3.0 V / -3.0 V)
Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

### Section 2

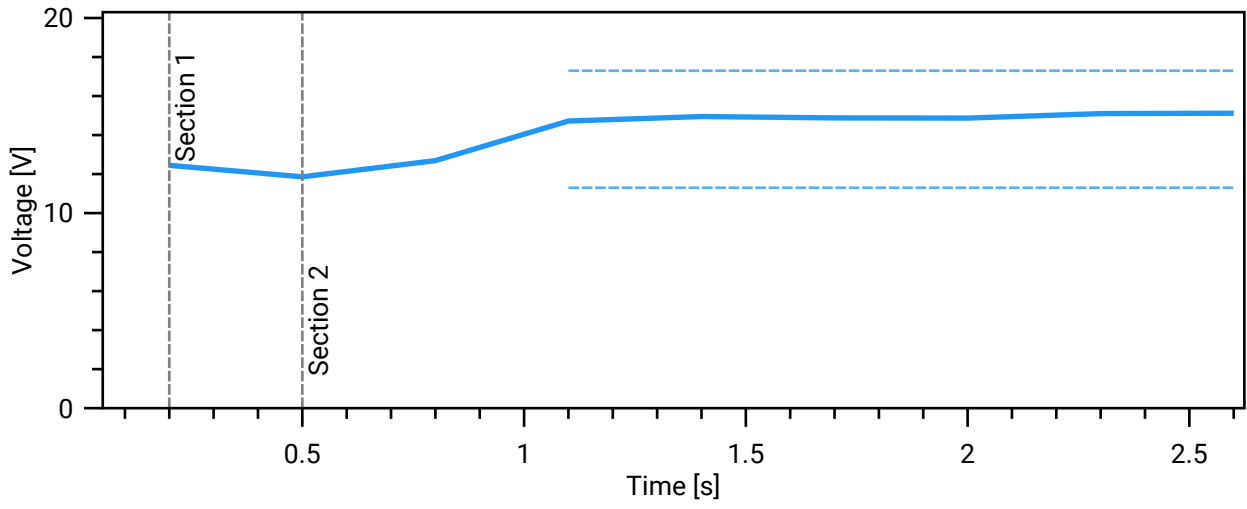
#### Section values

Welding mode	mig cmt
Duration	2.4 s
Job number	65
Arc gas consumption	0.5 l
Wire consumption (length)	0.244 m
Reference number of weld characteristic	1053
Wire speed	5.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	11.81 V
I approximately	136.1 A
Spatter free ignition	Off
SynchroPulse	Off

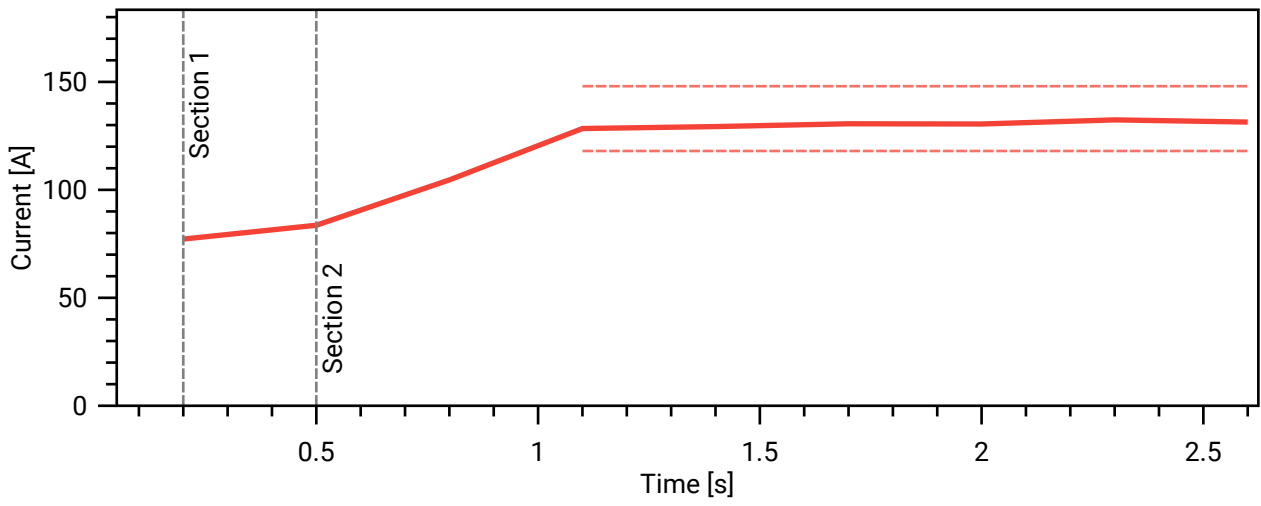
#### QMaster

Welding current command value	133 A (15 A / -15 A)
Voltage command value	14.3 V (3.0 V / -3.0 V)
Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

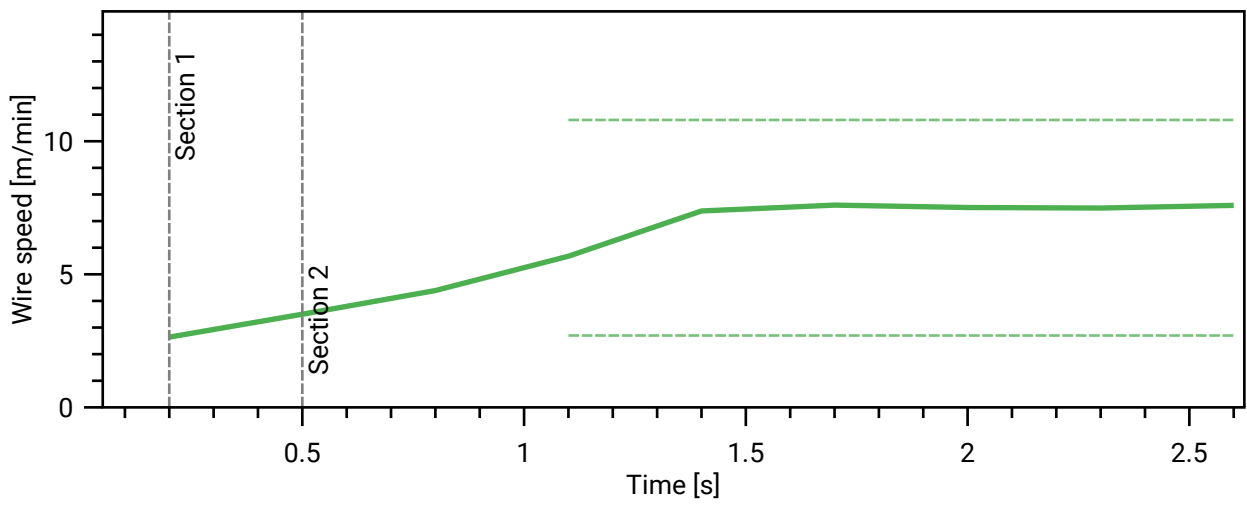
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:11 PM
Duration	2.9 s
Limit violations	None
Wire consumption (length)	0.317 m

## Machine

Name	<a href="#">TPS5000CMT Second Line</a>
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

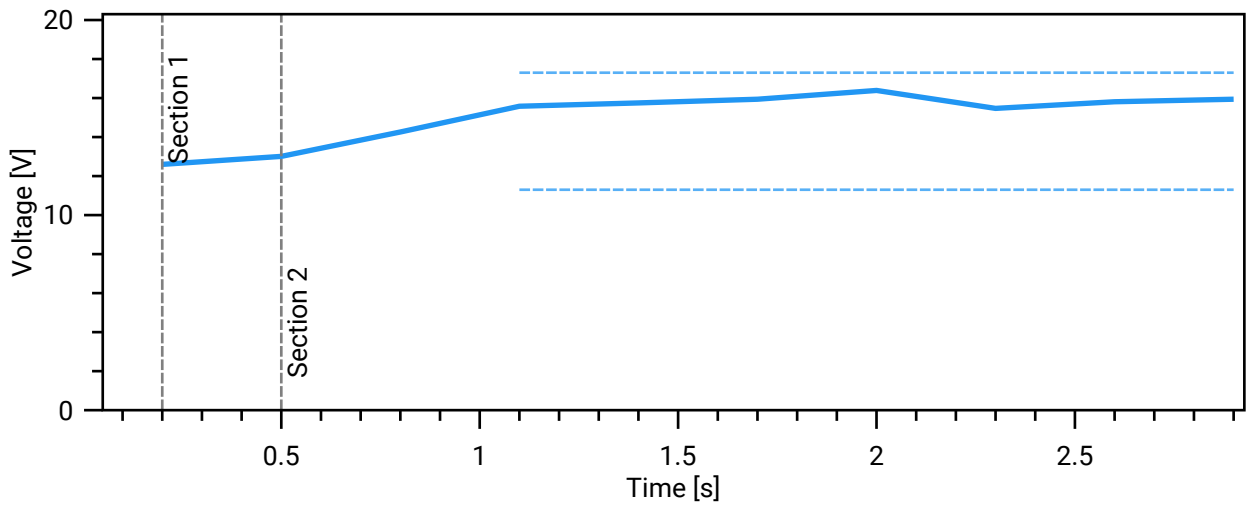
### Section 1

Section values		QMaster	
Welding mode	mig cmt	Welding current command value	133 A (15 A / -15 A)
Duration	0.2 s	Voltage command value	14.3 V (3.0 V / -3.0 V)
Job number	65	Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Arc gas consumption	0.1 l	Max. duration of current deviation	0.5 s
Wire consumption (length)	0.004 m	Max. duration of voltage deviation	0.5 s
Reference number of weld characteristic	1053	Max. duration of wire speed deviation	0.5 s
Wire speed	3.3 m/min	Reaction	Warning
Arc length correction	-2 %		
Pulse correction	0 %		
U approximately	9.96 V		
I approximately	87.6 A		
Spatter free ignition	Off		
SynchroPulse	Off		

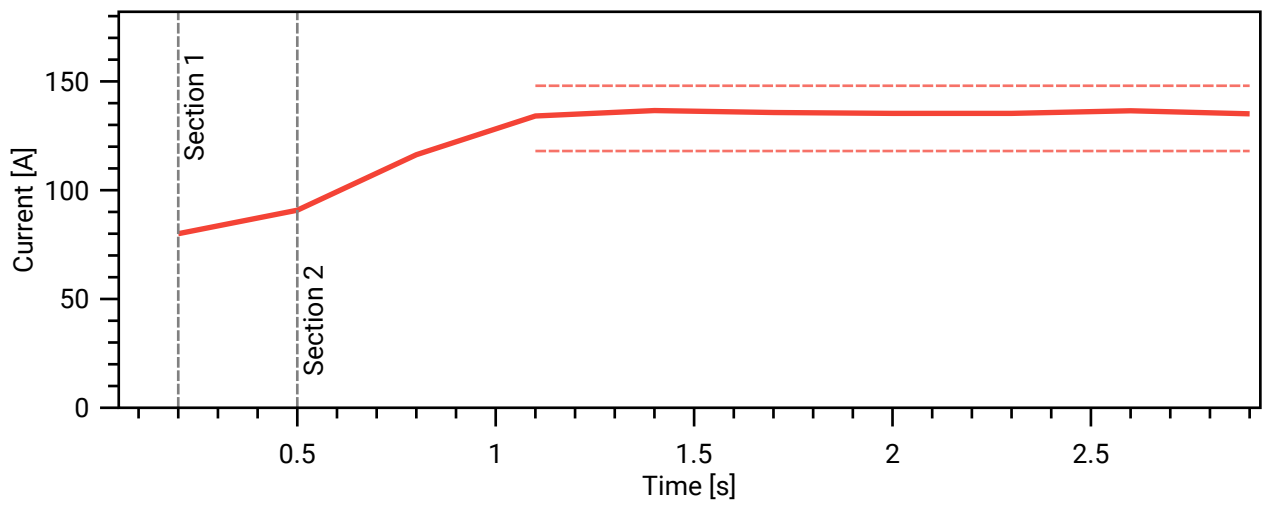
### Section 2

Section values		QMaster	
Welding mode	mig cmt	Welding current command value	133 A (15 A / -15 A)
Duration	2.7 s	Voltage command value	14.3 V (3.0 V / -3.0 V)
Job number	65	Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Arc gas consumption	0.5 l	Max. duration of current deviation	0.5 s
Wire consumption (length)	0.312 m	Max. duration of voltage deviation	0.5 s
Reference number of weld characteristic	1053	Max. duration of wire speed deviation	0.5 s
Wire speed	5.5 m/min	Reaction	Warning
Arc length correction	-2 %		
Pulse correction	0 %		
U approximately	11.81 V		
I approximately	136.1 A		
Spatter free ignition	Off		
SynchroPulse	Off		

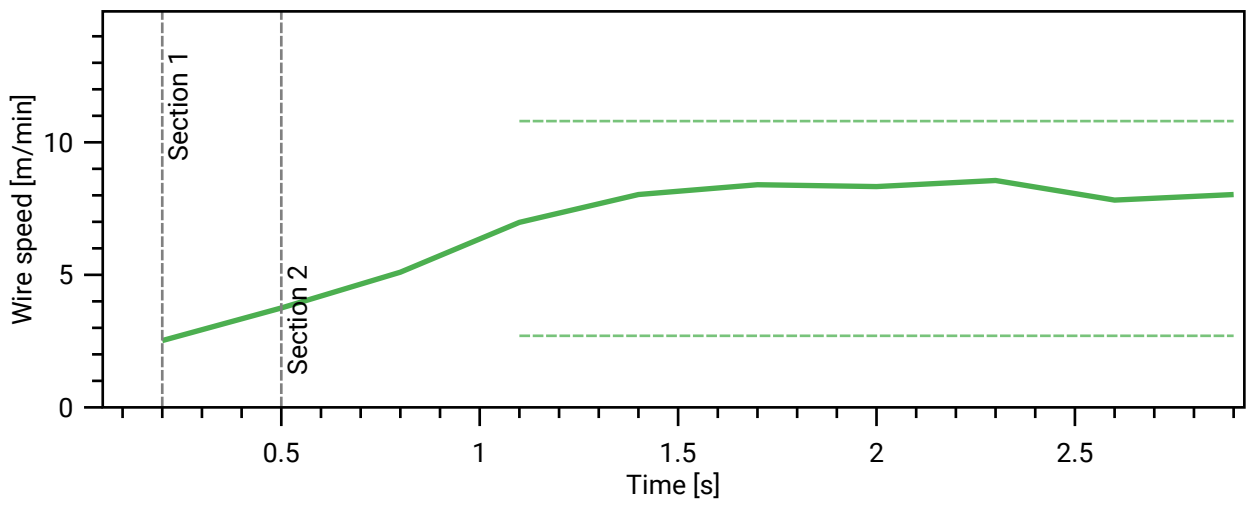
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:15 PM
Duration	2.3 s
Limit violations	None
Wire consumption (length)	0.239 m

## Machine

Name	<a href="#">TPS5000CMT Second Line</a>
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

#### Section values

Welding mode	mig cmt
Duration	0.2 s
Job number	65
Arc gas consumption	0.1 l
Wire consumption (length)	0.004 m
Reference number of weld characteristic	1053
Wire speed	3.3 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	9.96 V
I approximately	87.6 A
Spatter free ignition	Off
SynchroPulse	Off

#### QMaster

Welding current command value	133 A (15 A / -15 A)
Voltage command value	14.3 V (3.0 V / -3.0 V)
Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

### Section 2

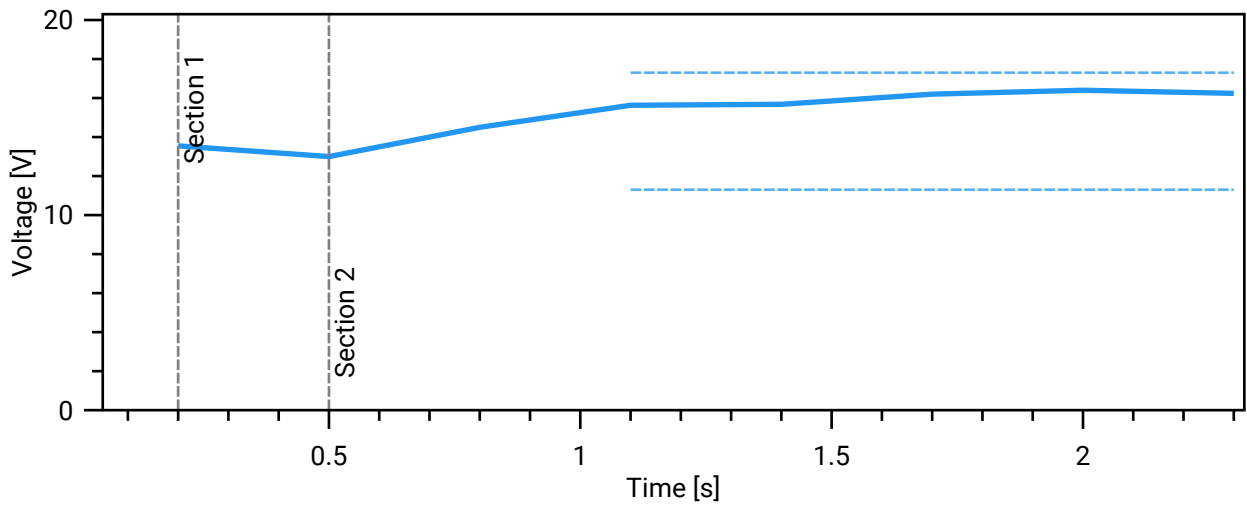
#### Section values

Welding mode	mig cmt
Duration	2.1 s
Job number	65
Arc gas consumption	0.2 l
Wire consumption (length)	0.235 m
Reference number of weld characteristic	1053
Wire speed	5.5 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	11.81 V
I approximately	136.1 A
Spatter free ignition	Off
SynchroPulse	Off

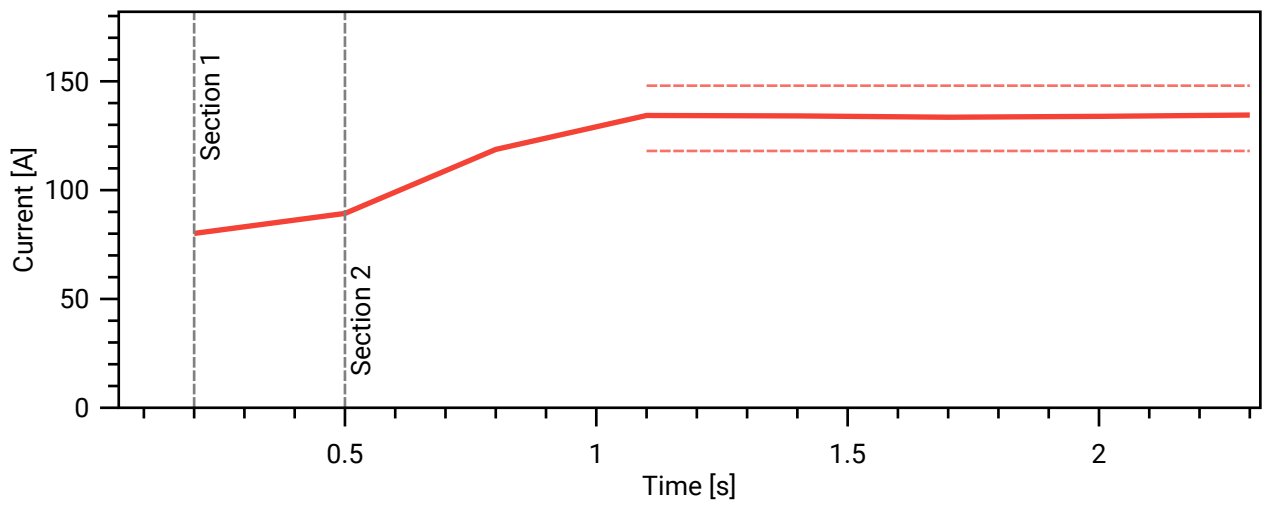
#### QMaster

Welding current command value	133 A (15 A / -15 A)
Voltage command value	14.3 V (3.0 V / -3.0 V)
Wire speed command value	5.5 m/min (5.3 m/min / -2.8 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

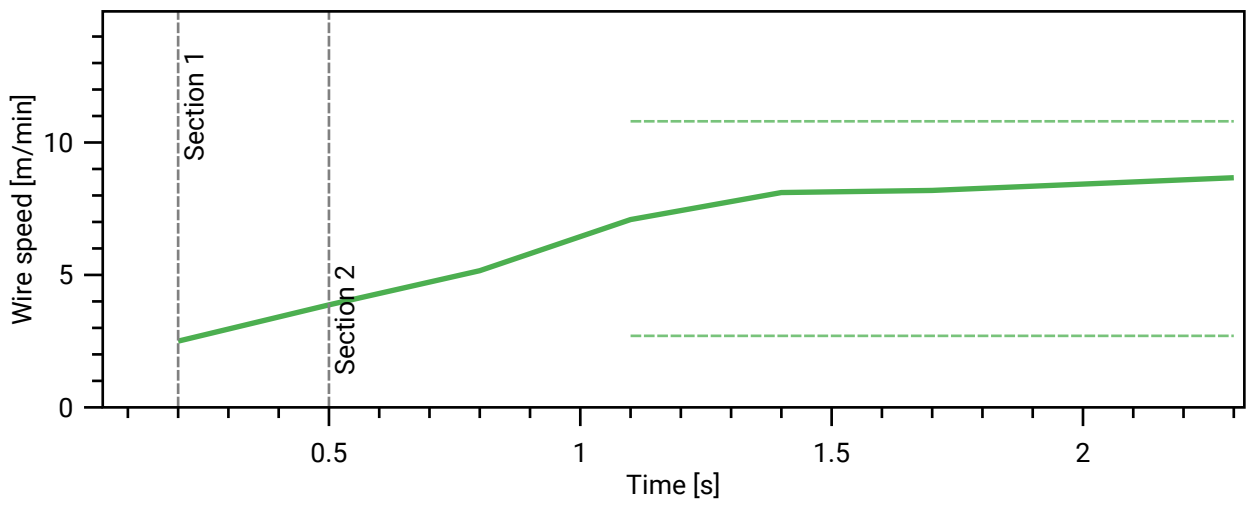
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:19 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.231 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

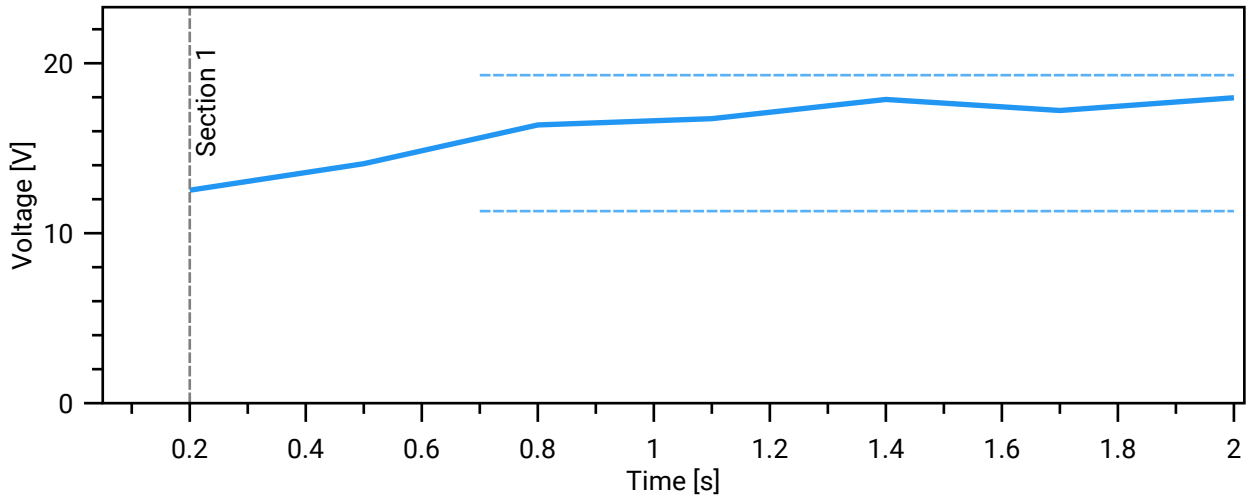
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	66
Arc gas consumption	0 l
Wire consumption (length)	0.231 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

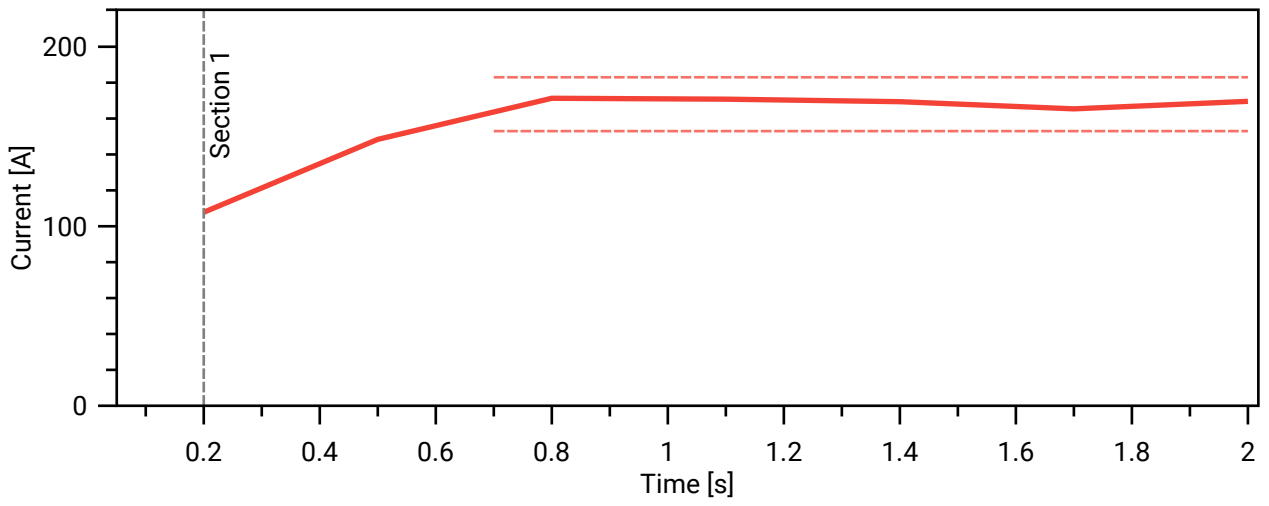
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

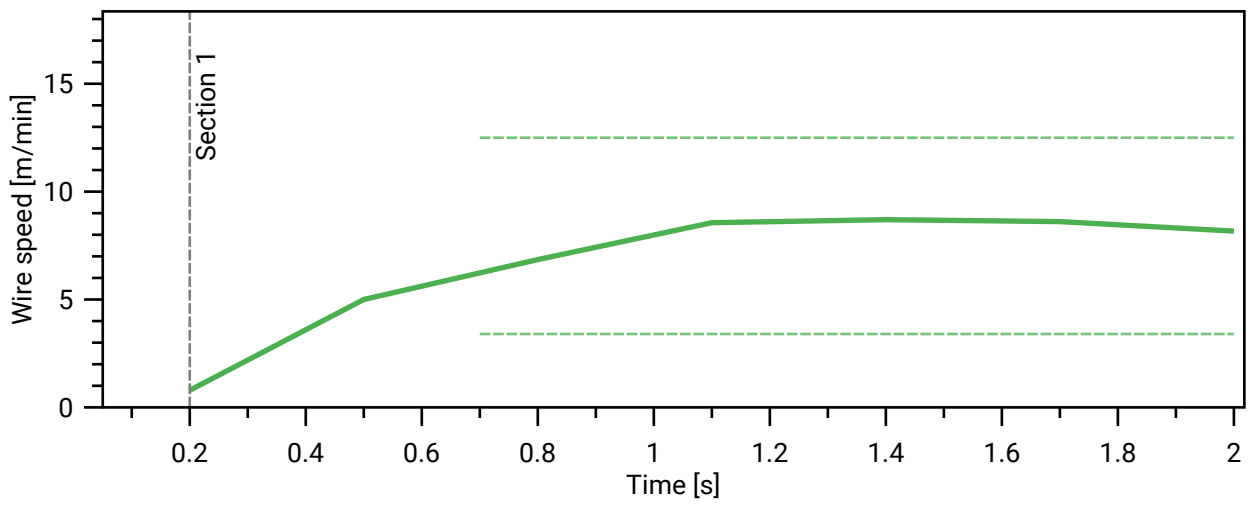
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:23 PM
Duration	2.3 s
Limit violations	None
Wire consumption (length)	0.28 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

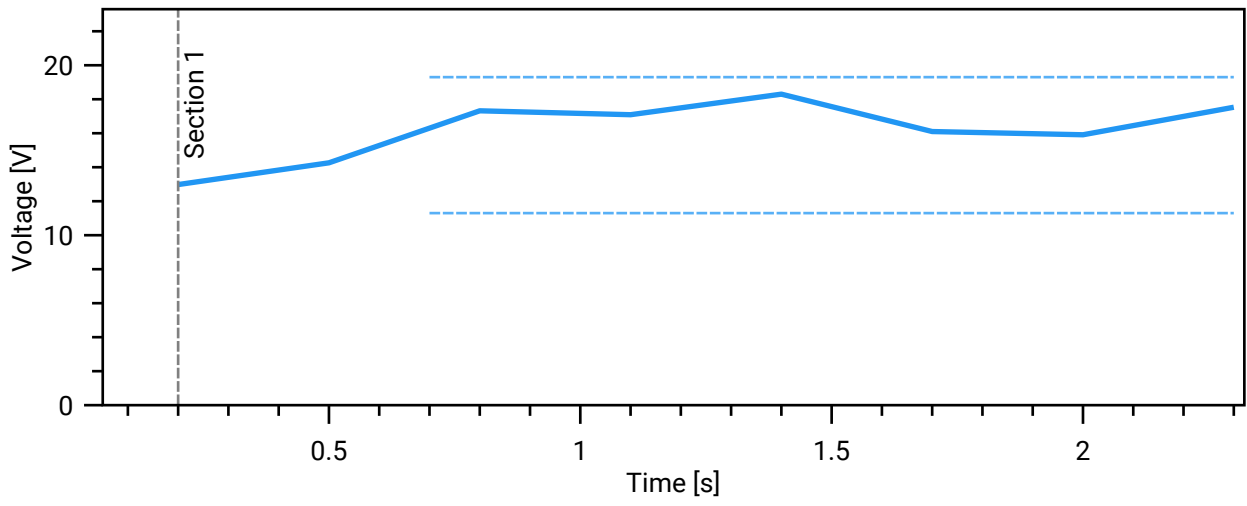
#### Section values

Welding mode	mig cmt
Duration	2.3 s
Job number	66
Arc gas consumption	0.1 l
Wire consumption (length)	0.28 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

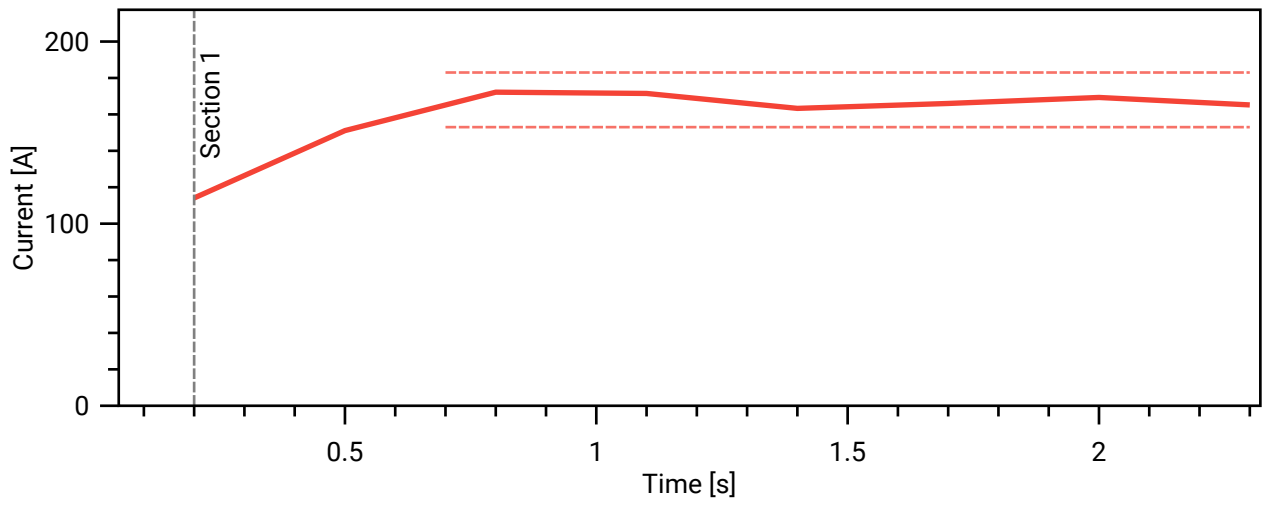
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

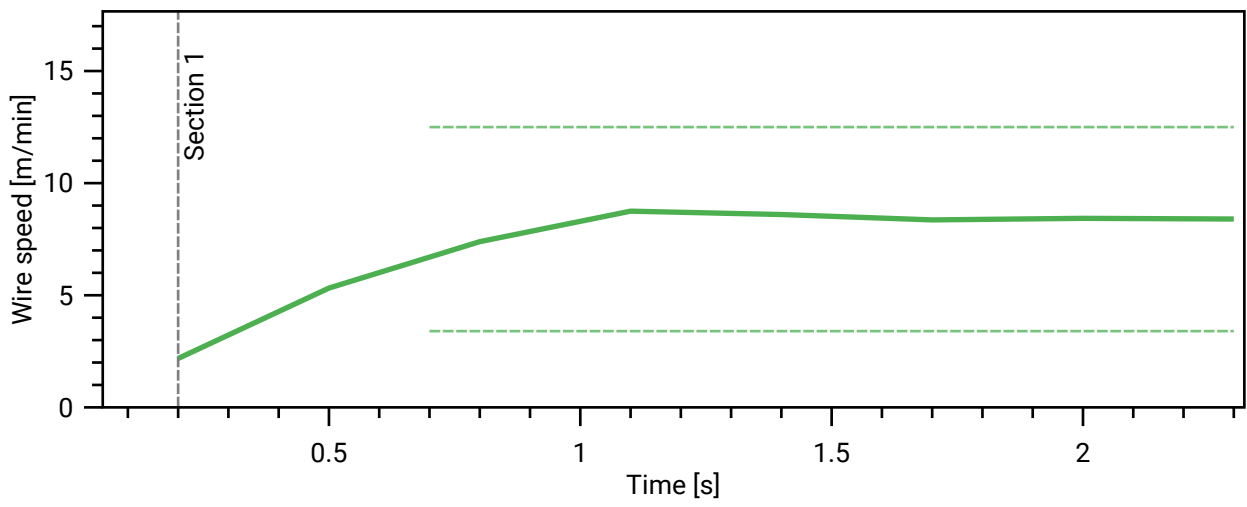
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:26 PM
Duration	2.9 s
Limit violations	None
Wire consumption (length)	0.36 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

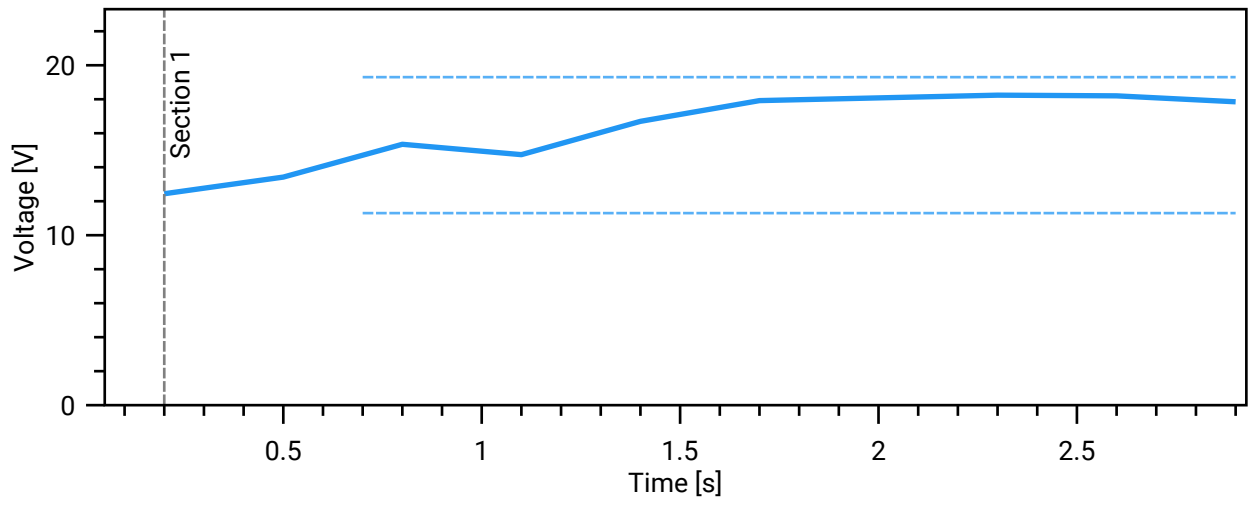
#### Section values

Welding mode	mig cmt
Duration	2.9 s
Job number	66
Arc gas consumption	0.1 l
Wire consumption (length)	0.36 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

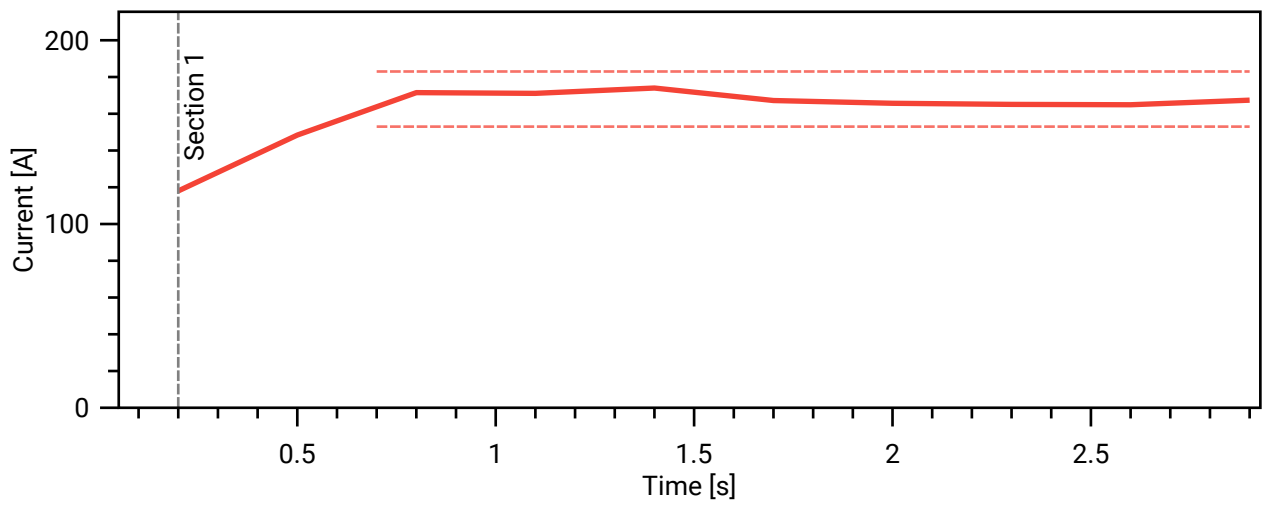
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

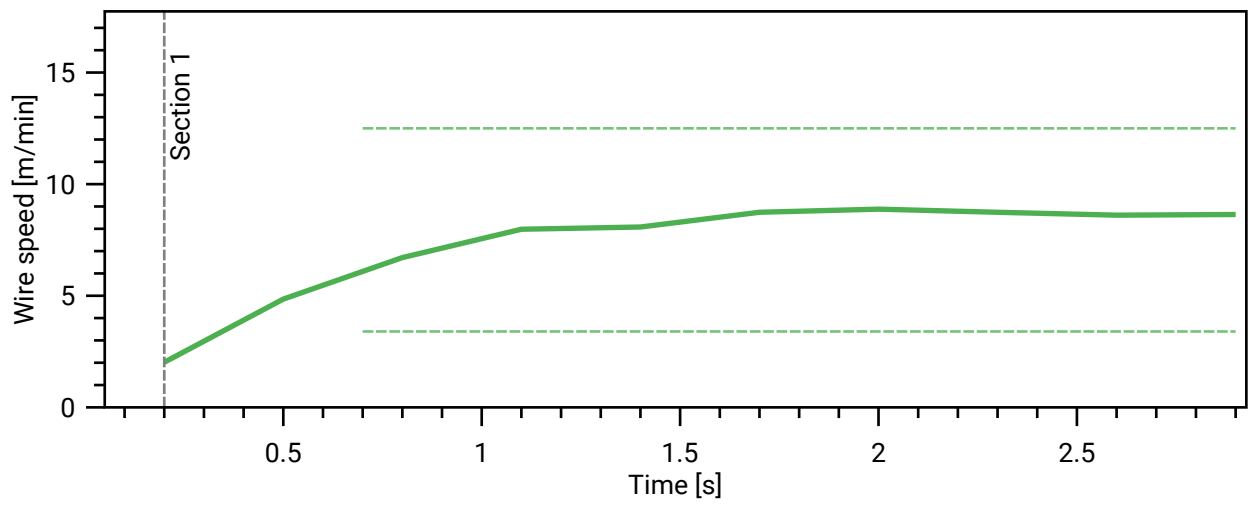
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:31 PM
Duration	3.9 s
Limit violations	None
Wire consumption (length)	0.477 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

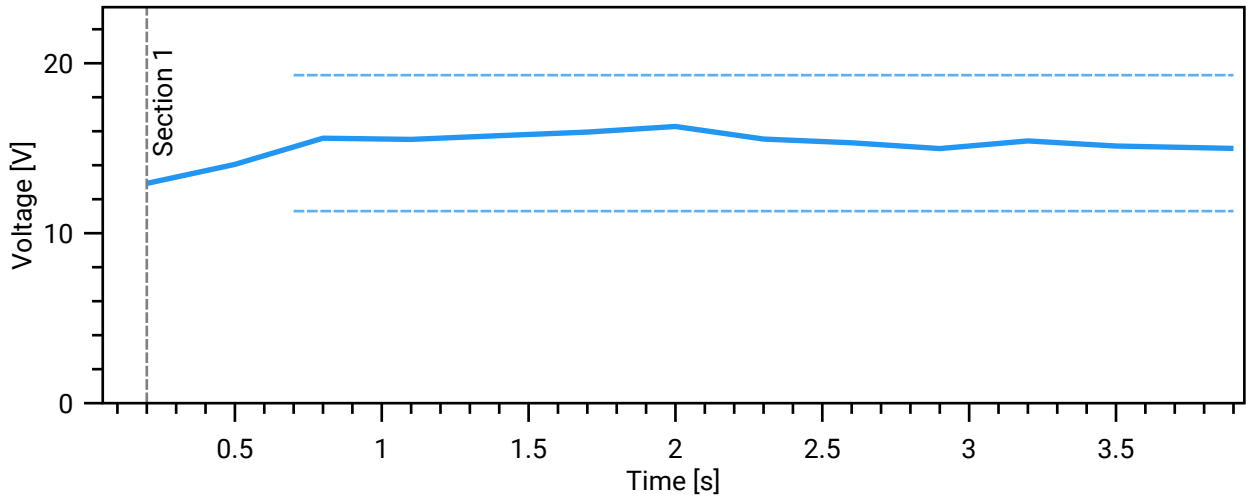
#### Section values

Welding mode	mig cmt
Duration	3.9 s
Job number	66
Arc gas consumption	0.1 l
Wire consumption (length)	0.477 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

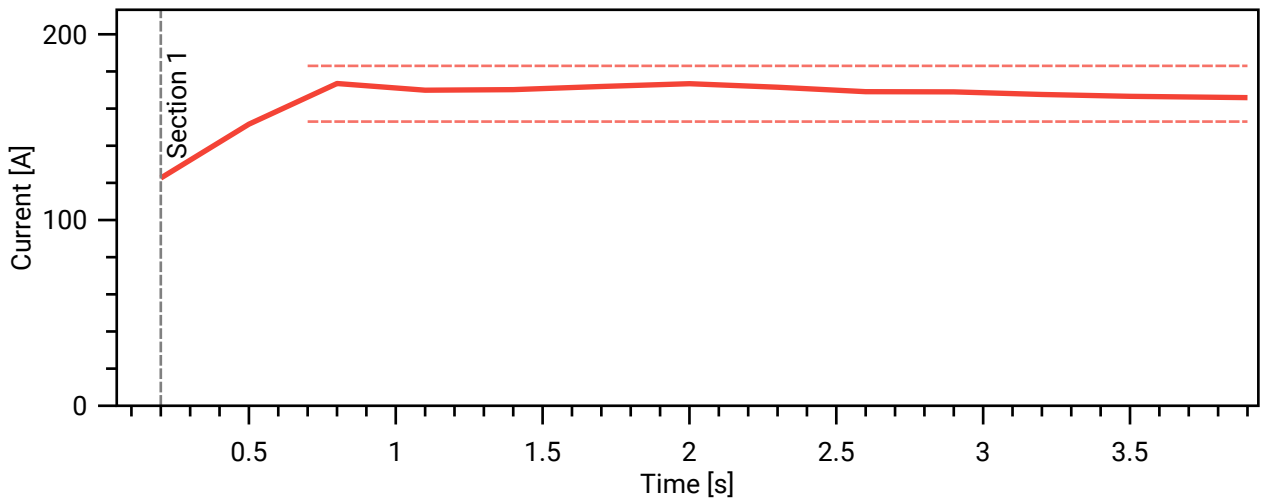
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

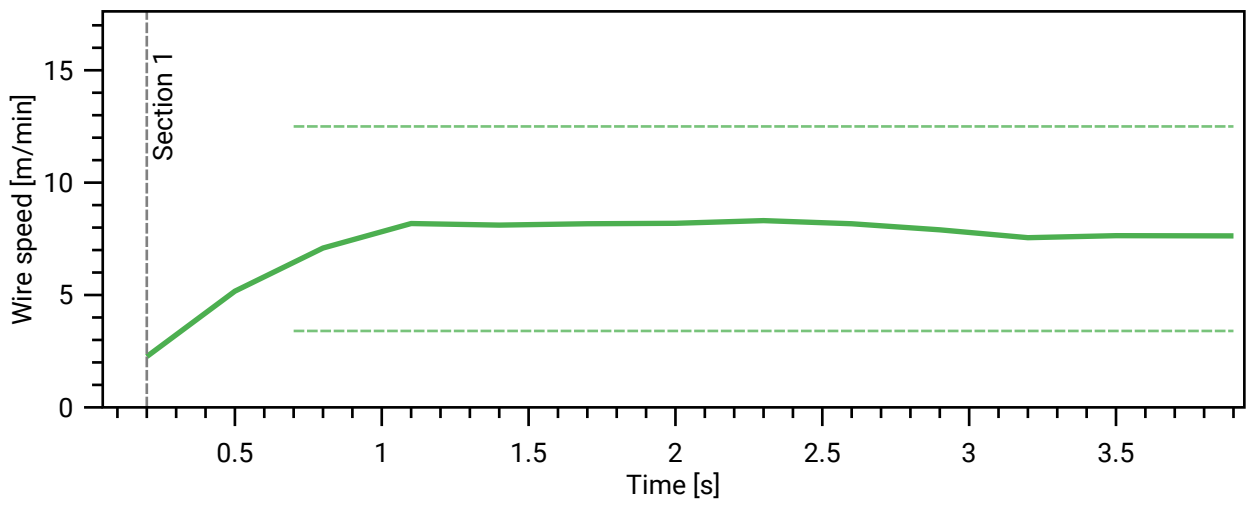
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:36 PM
Duration	3.5 s
Limit violations	None
Wire consumption (length)	0.425 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

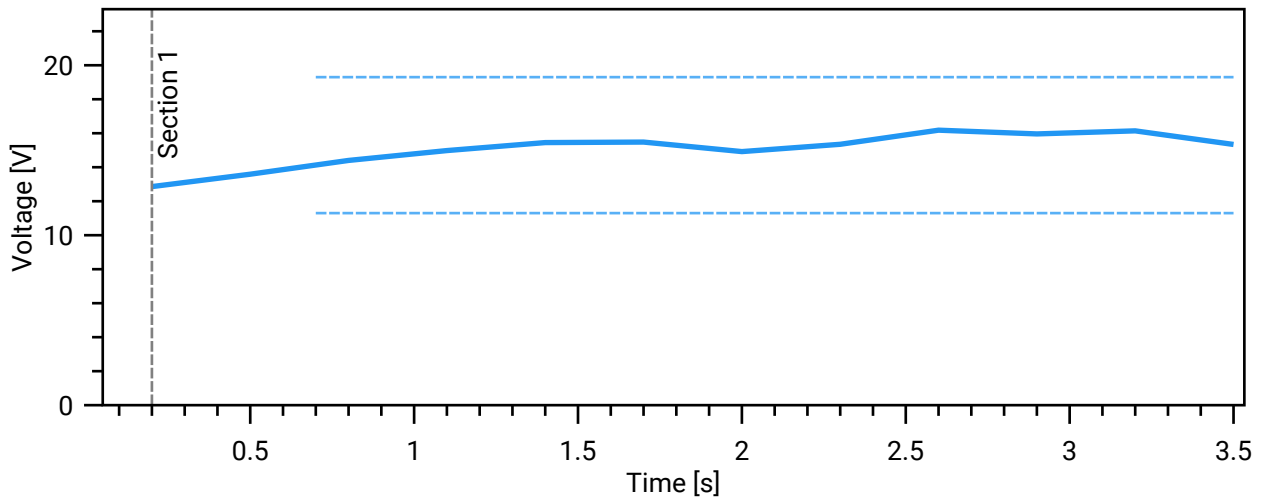
#### Section values

Welding mode	mig cmt
Duration	3.5 s
Job number	66
Arc gas consumption	0.1 l
Wire consumption (length)	0.425 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

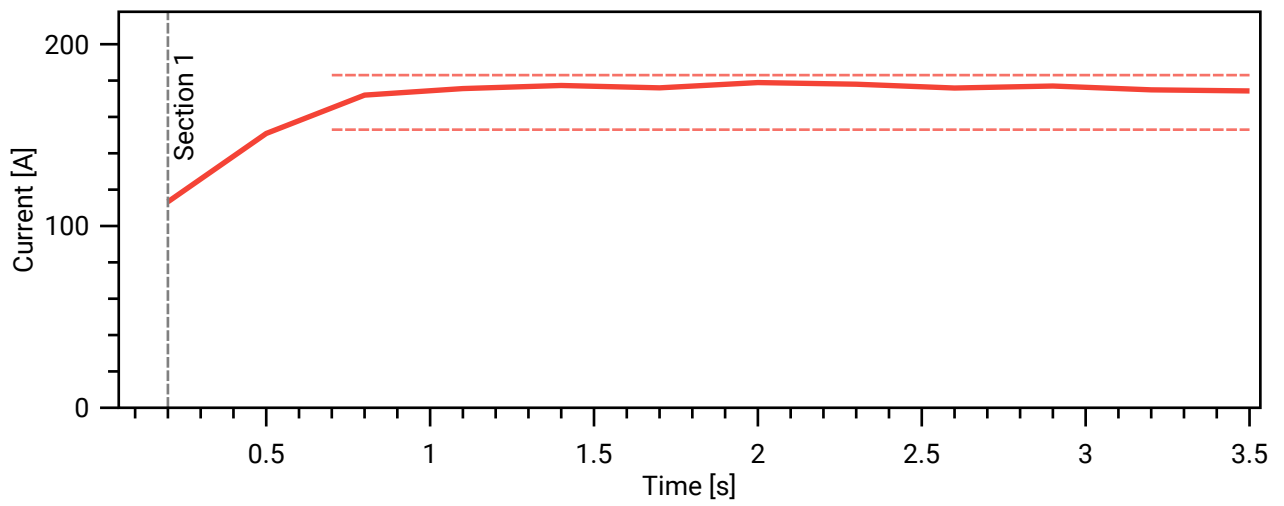
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

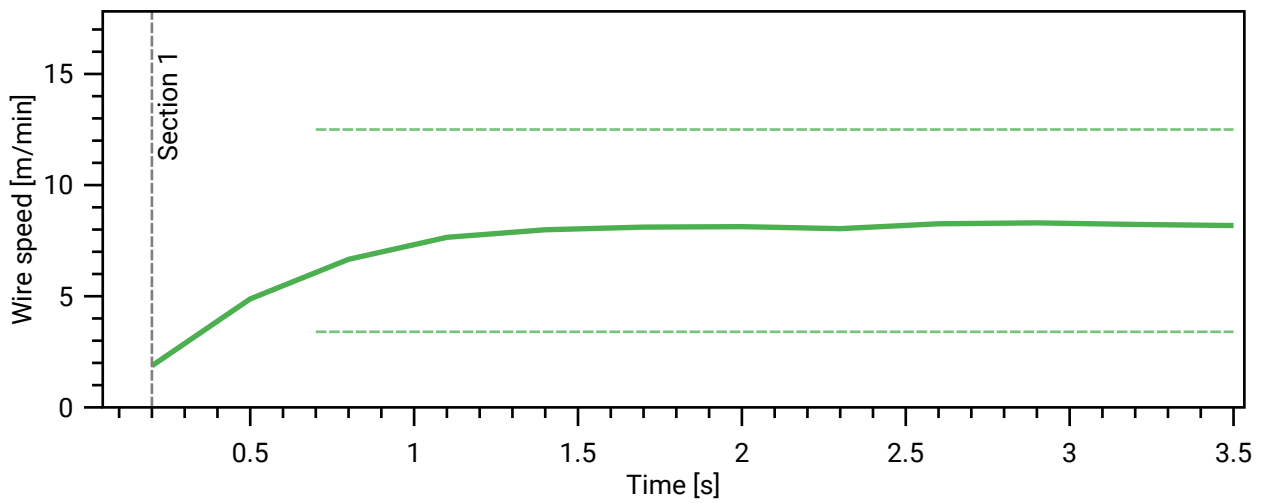
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:41 PM
Duration	3.2 s
Limit violations	None
Wire consumption (length)	0.371 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

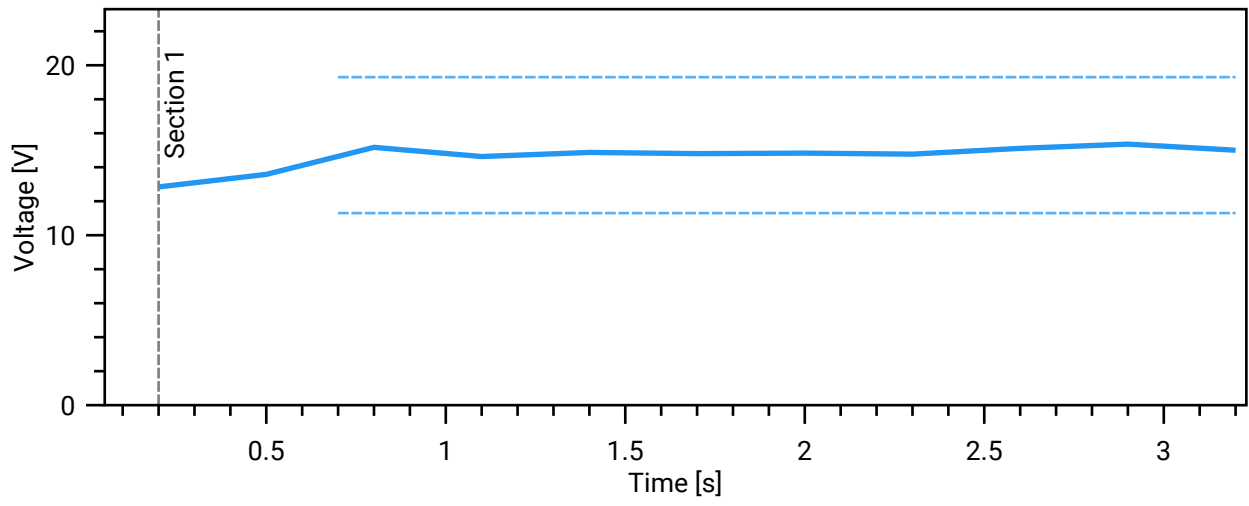
#### Section values

Welding mode	mig cmt
Duration	3.2 s
Job number	66
Arc gas consumption	0.1 l
Wire consumption (length)	0.371 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

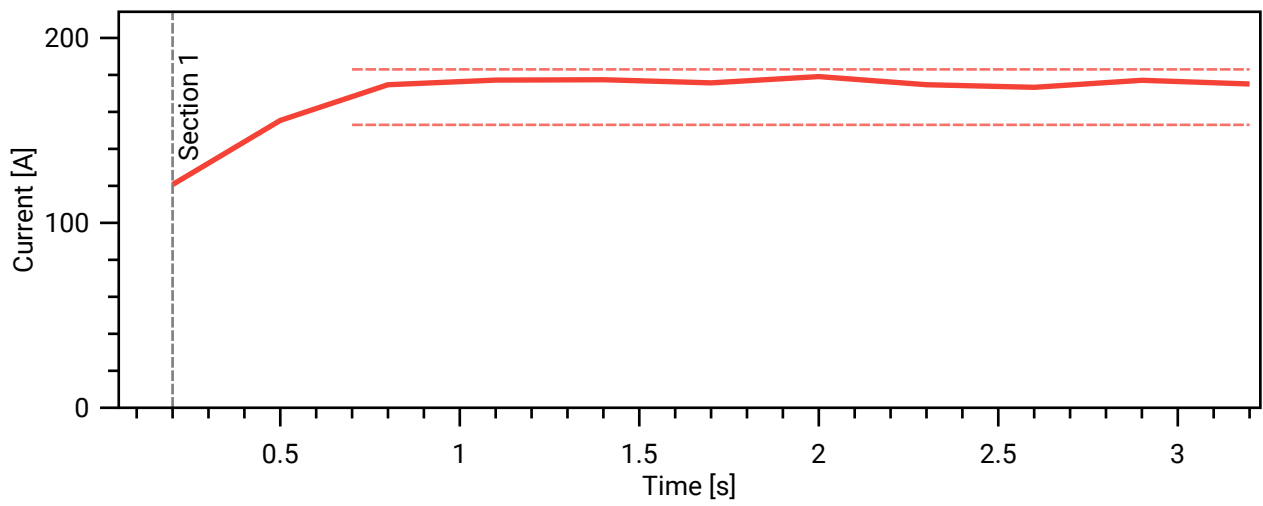
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

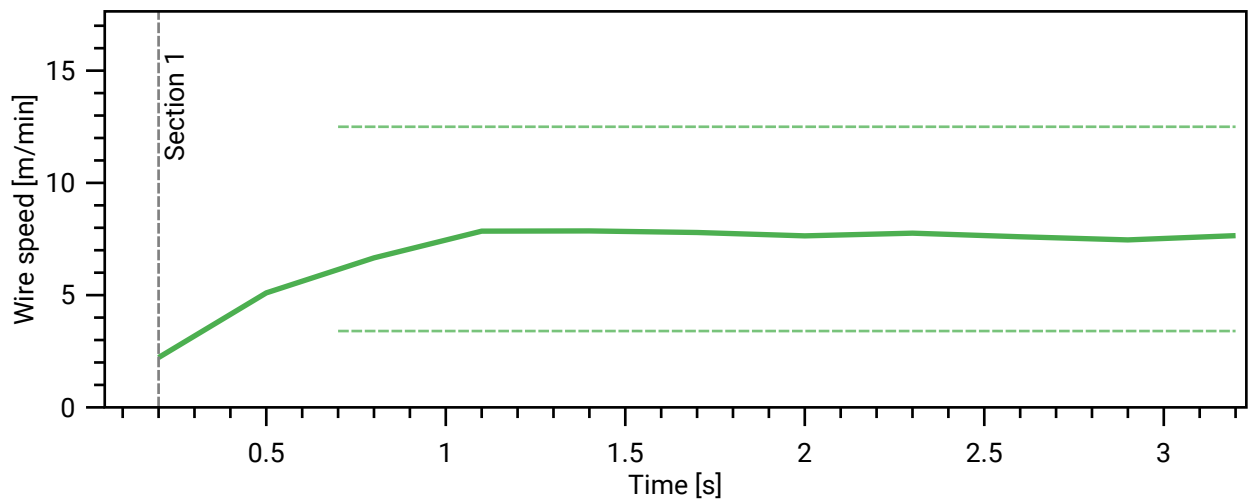
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:46 PM
Duration	1.1 s
Limit violations	None
Wire consumption (length)	0.096 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

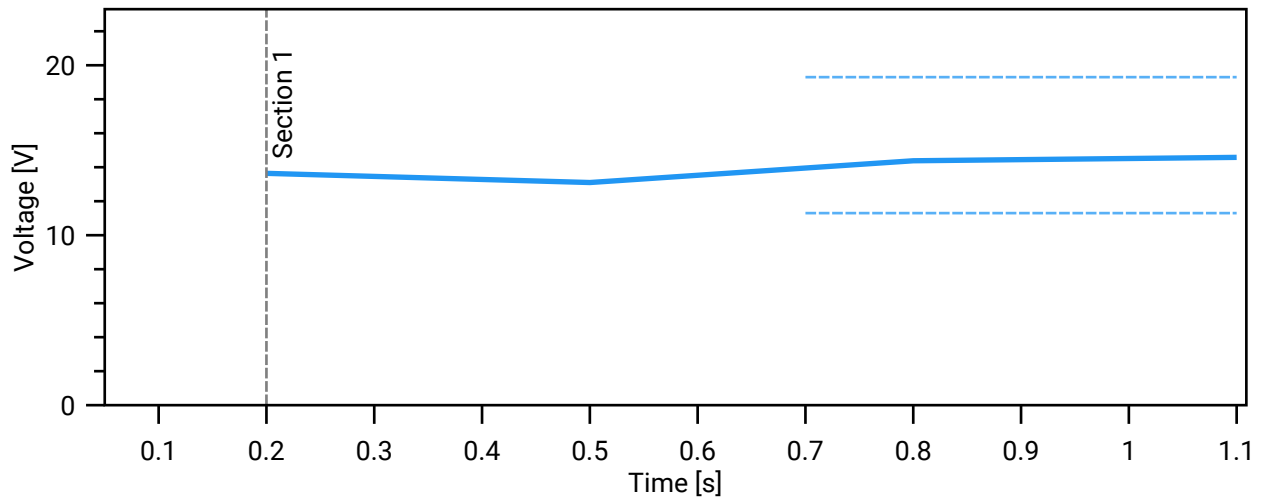
#### Section values

Welding mode	mig cmt
Duration	1.1 s
Job number	66
Arc gas consumption	0.1 l
Wire consumption (length)	0.096 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

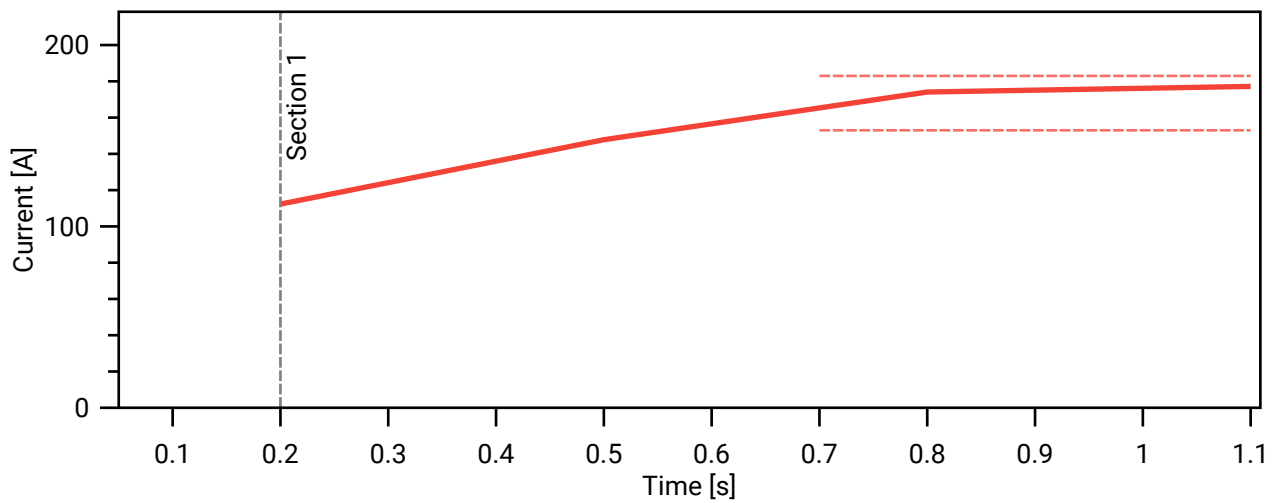
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

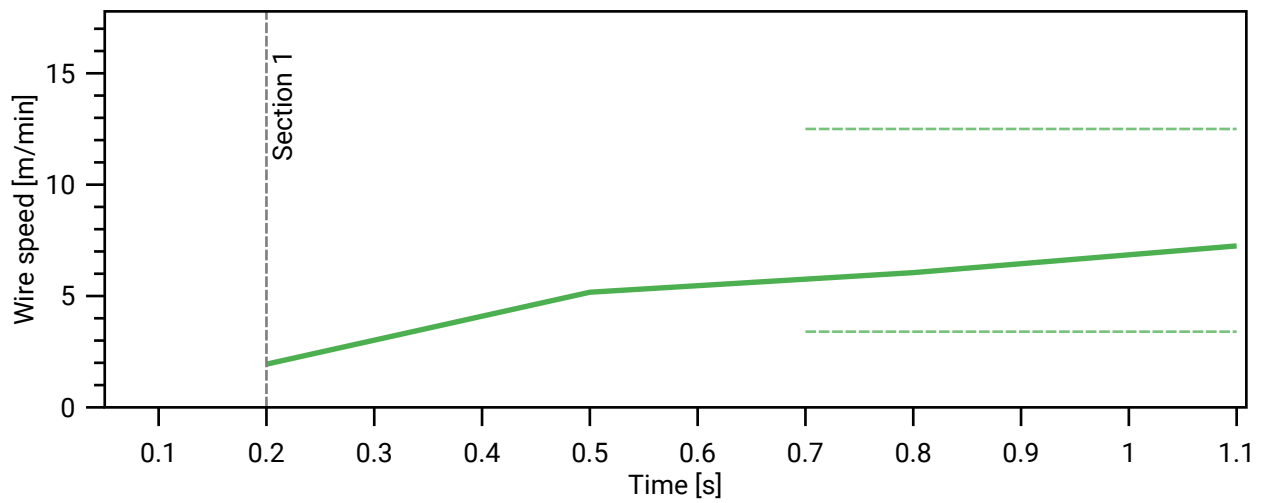
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:48 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.244 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

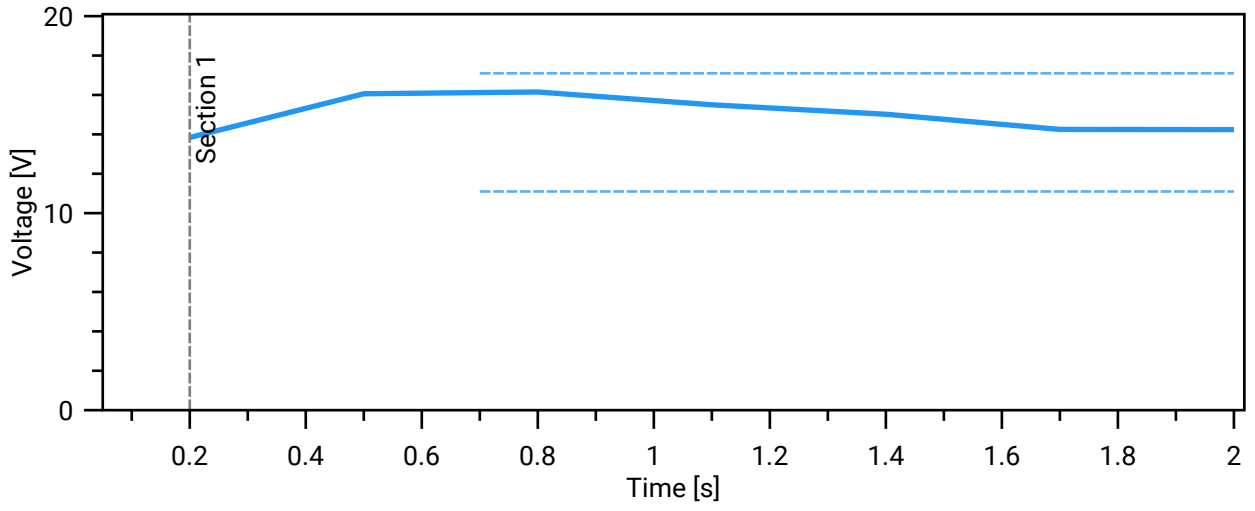
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	69
Arc gas consumption	0.5 l
Wire consumption (length)	0.244 m
Reference number of weld characteristic	1053
Wire speed	7.7 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	13.76 V
I approximately	180.9 A
Spatter free ignition	Off
SynchroPulse	Off

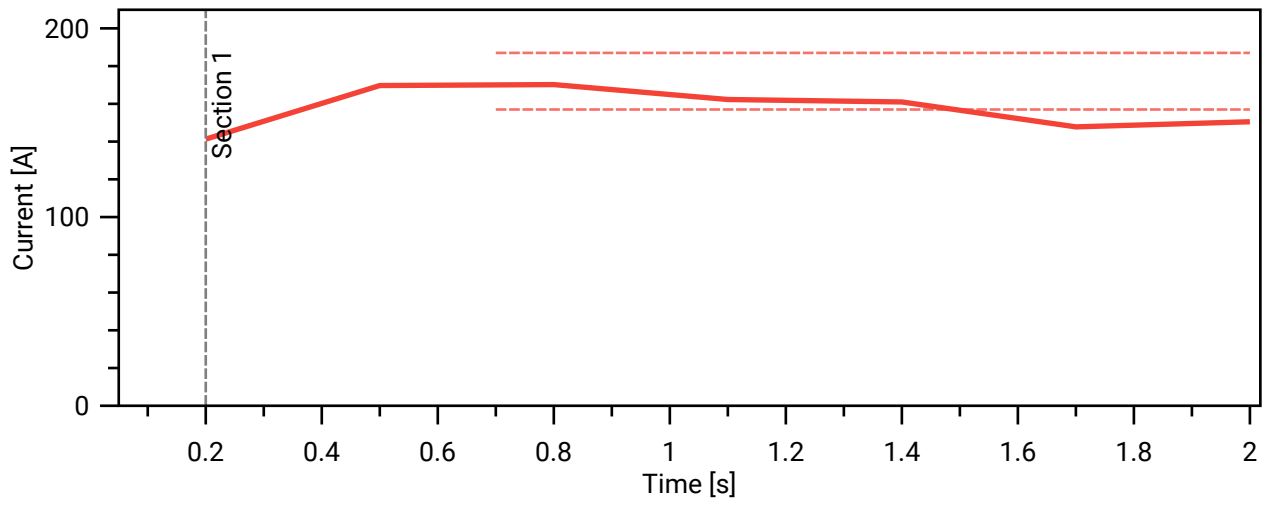
#### QMaster

Welding current command value	172 A (15 A / -15 A)
Voltage command value	14.1 V (3.0 V / -3.0 V)
Wire speed command value	7.7 m/min (1.8 m/min / -2.8 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

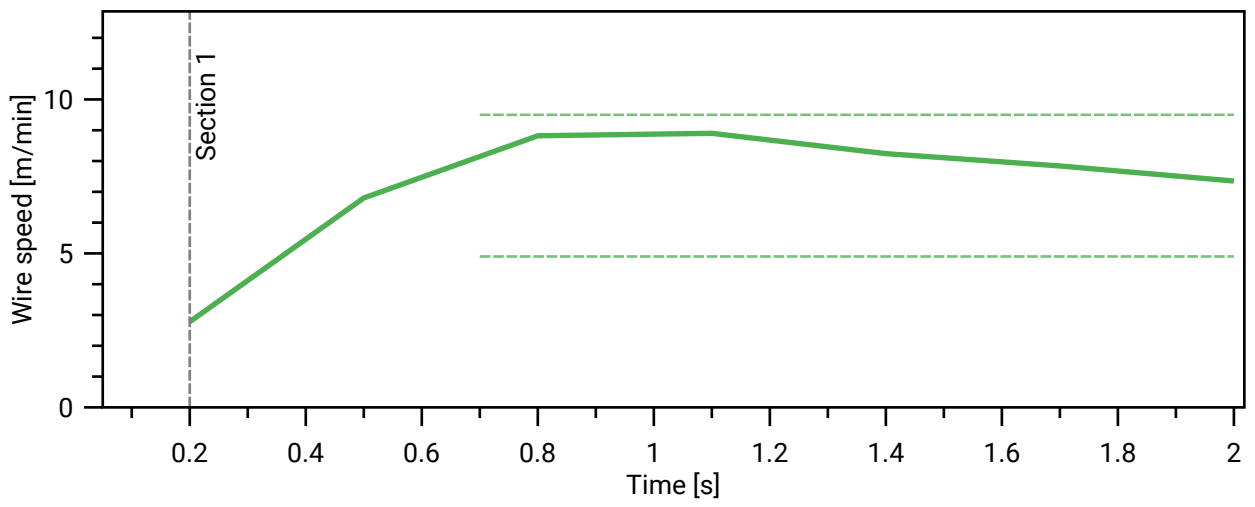
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:51 PM
Duration	1.4 s
Limit violations	None
Wire consumption (length)	0.137 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

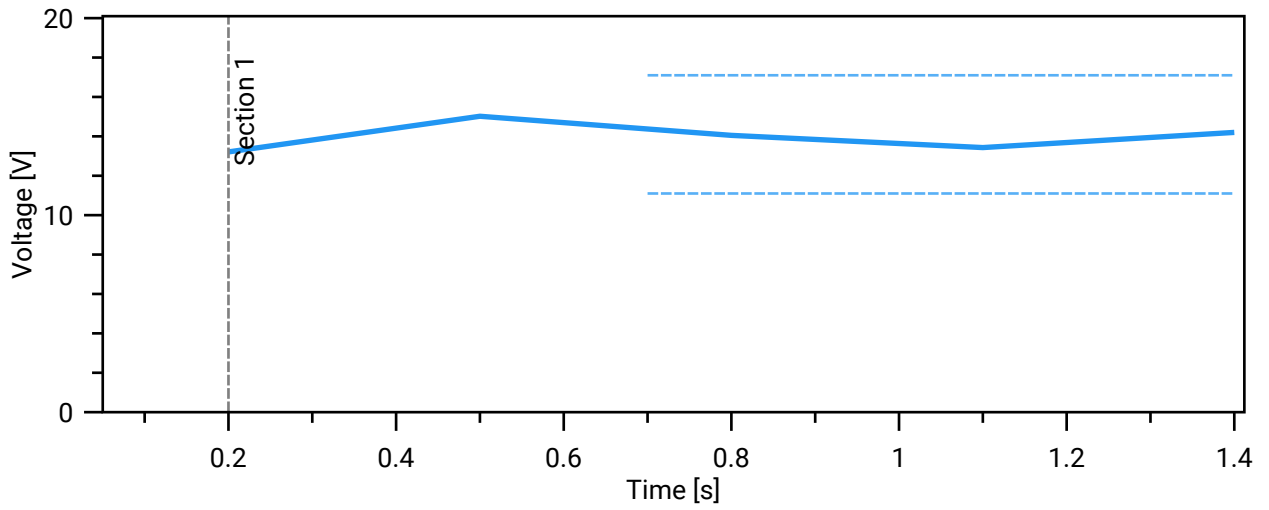
#### Section values

Welding mode	mig cmt
Duration	1.4 s
Job number	69
Arc gas consumption	0.4 l
Wire consumption (length)	0.137 m
Reference number of weld characteristic	1053
Wire speed	7.7 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	13.76 V
I approximately	180.9 A
Spatter free ignition	Off
SynchroPulse	Off

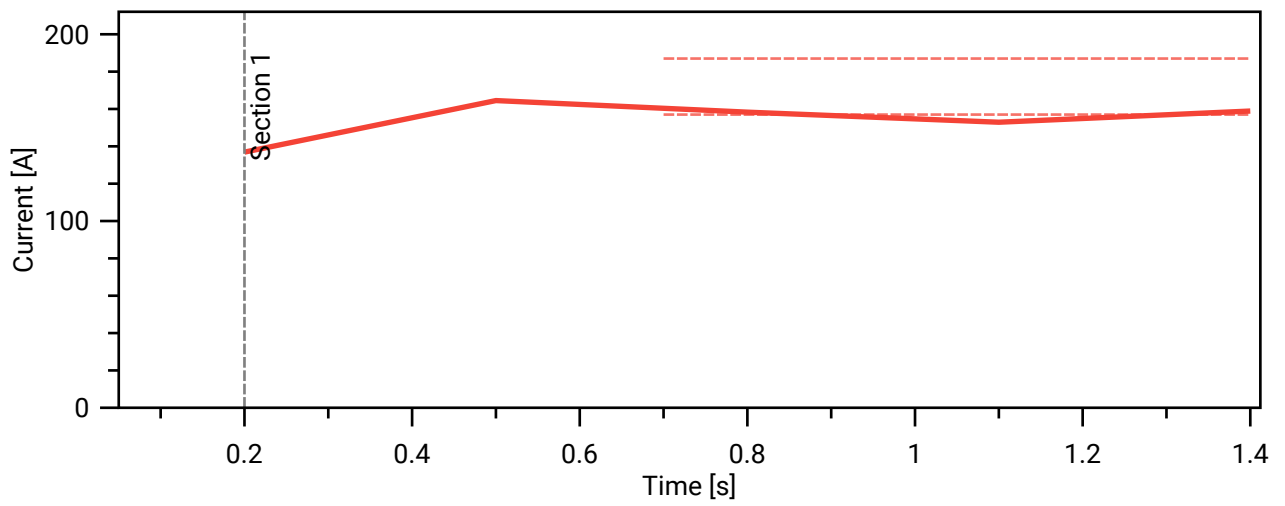
#### QMaster

Welding current command value	172 A (15 A / -15 A)
Voltage command value	14.1 V (3.0 V / -3.0 V)
Wire speed command value	7.7 m/min (1.8 m/min / -2.8 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

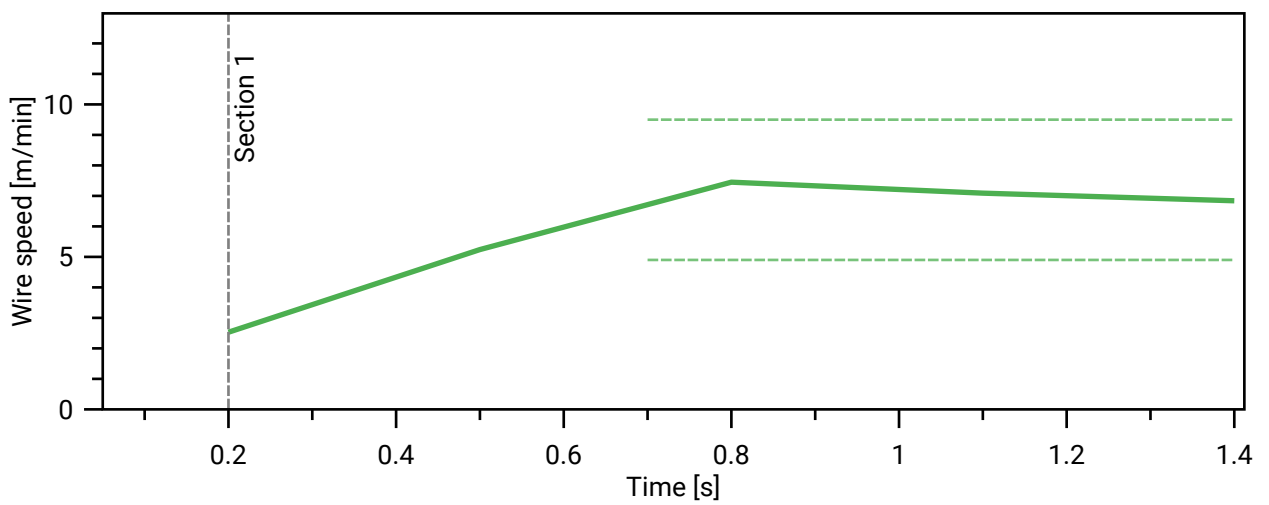
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:54 PM
Duration	3.2 s
Limit violations	None
Wire consumption (length)	0.391 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

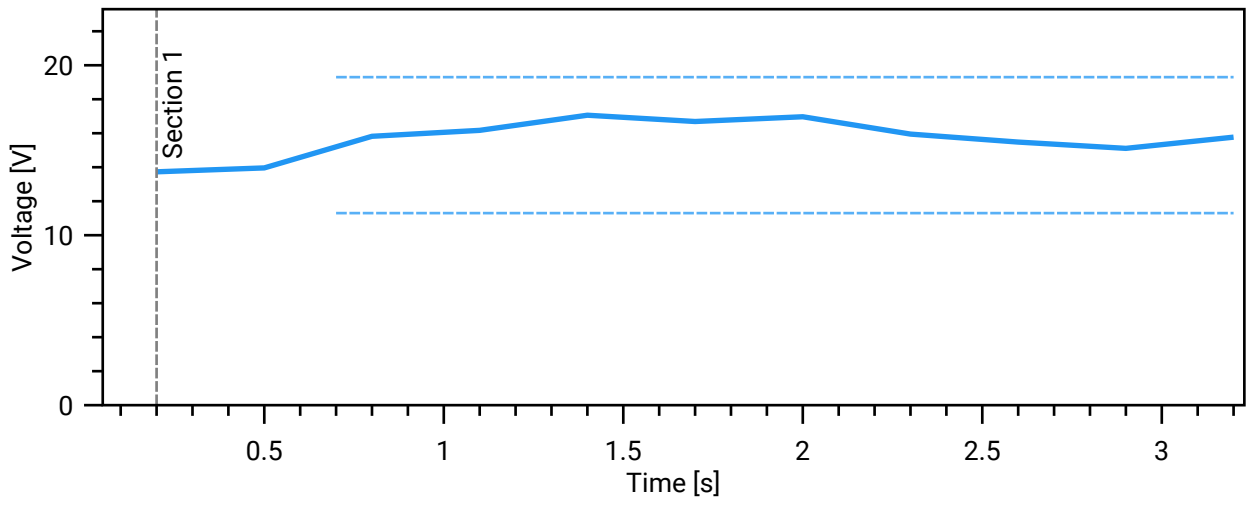
#### Section values

Welding mode	mig cmt
Duration	3.2 s
Job number	66
Arc gas consumption	0.1 l
Wire consumption (length)	0.391 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

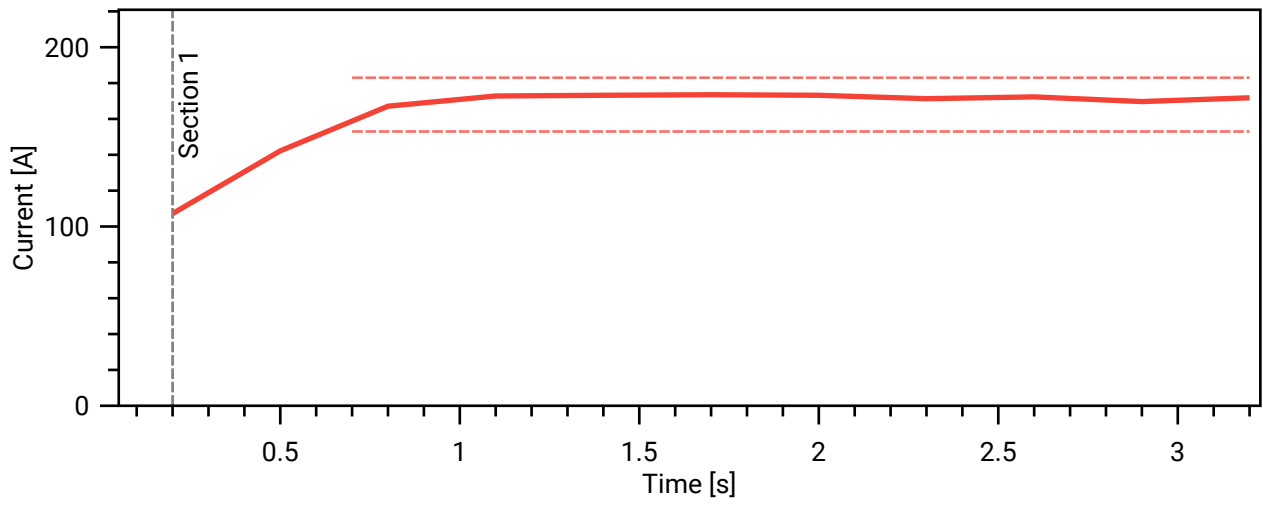
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

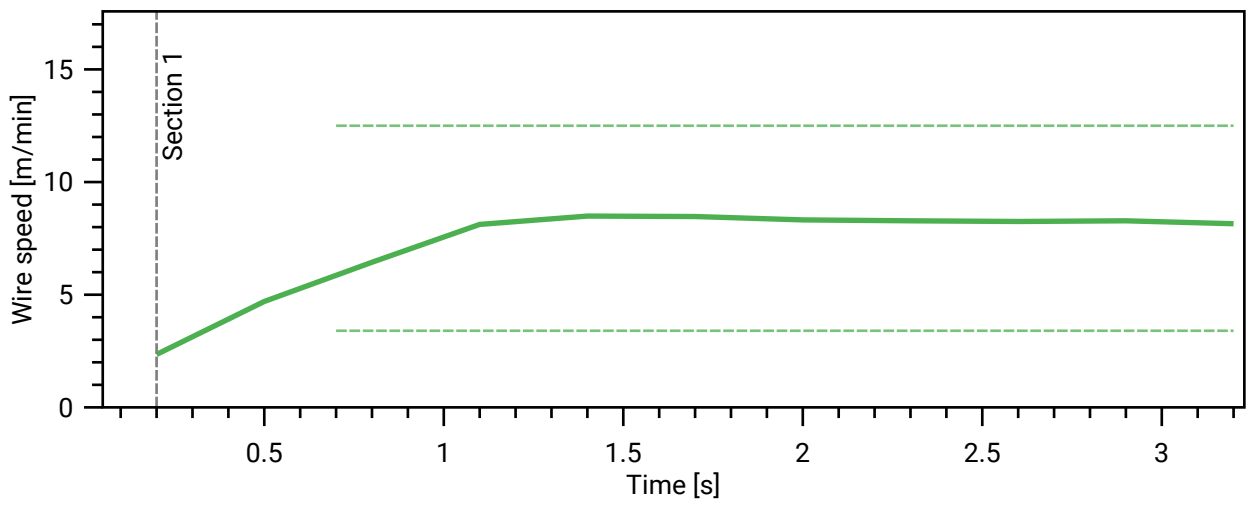
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:14:59 PM
Duration	3.9 s
Limit violations	None
Wire consumption (length)	0.534 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

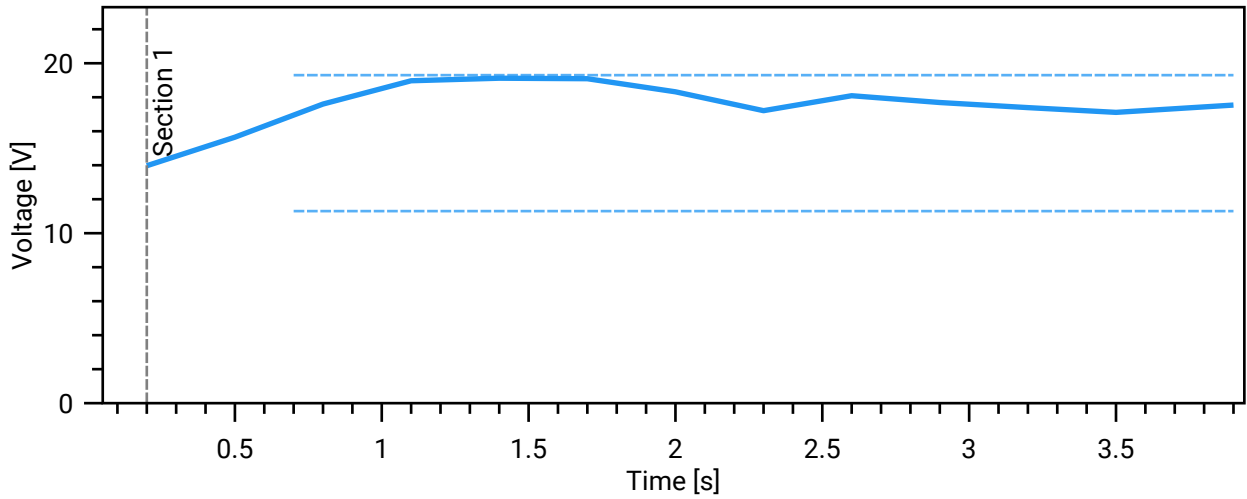
#### Section values

Welding mode	mig cmt
Duration	3.9 s
Job number	66
Arc gas consumption	0.1 l
Wire consumption (length)	0.534 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

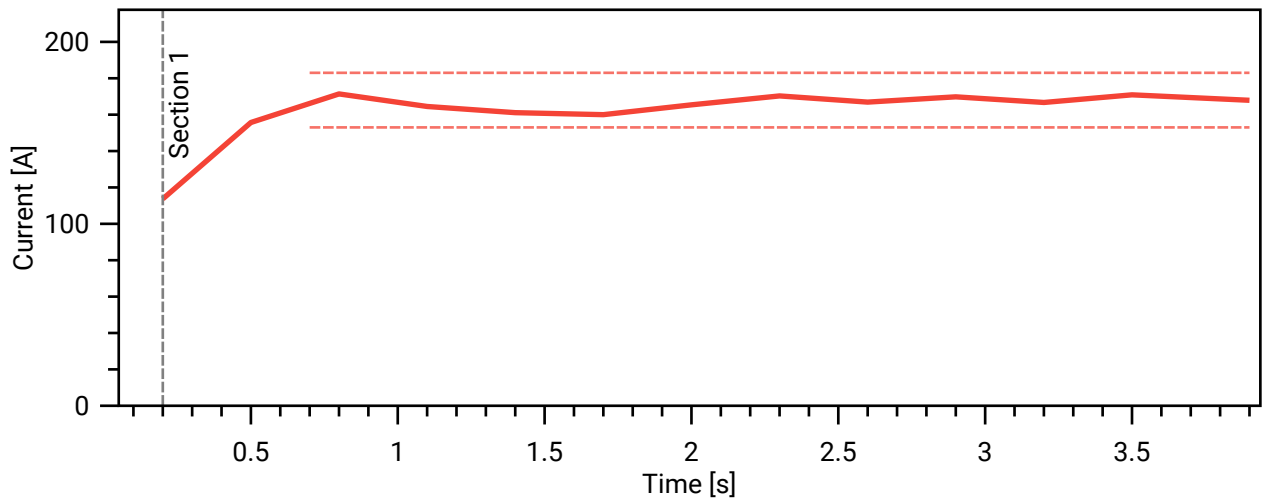
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

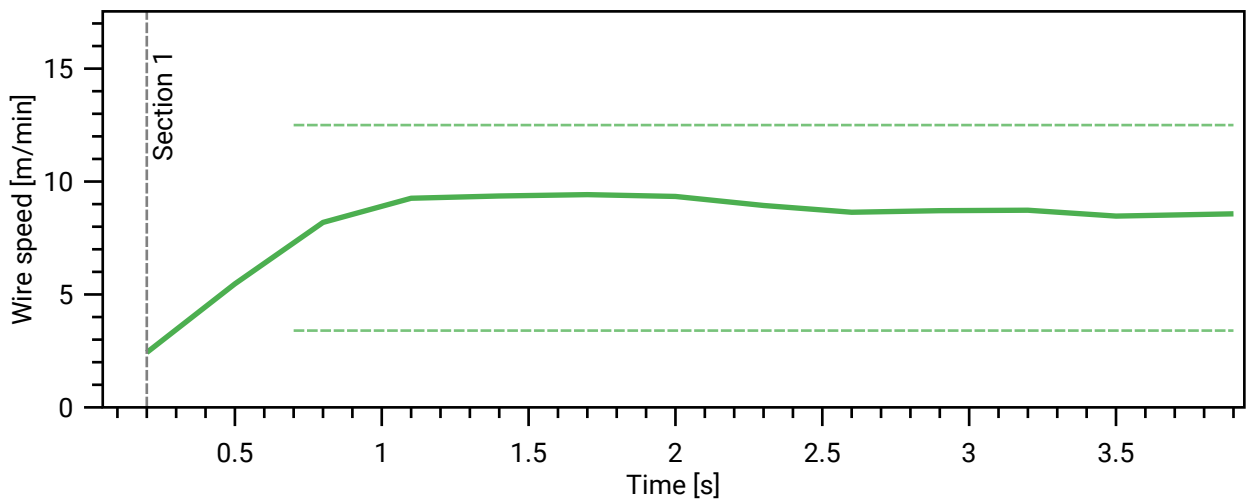
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:15:04 PM
Duration	4.1 s
Limit violations	None
Wire consumption (length)	0.562 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

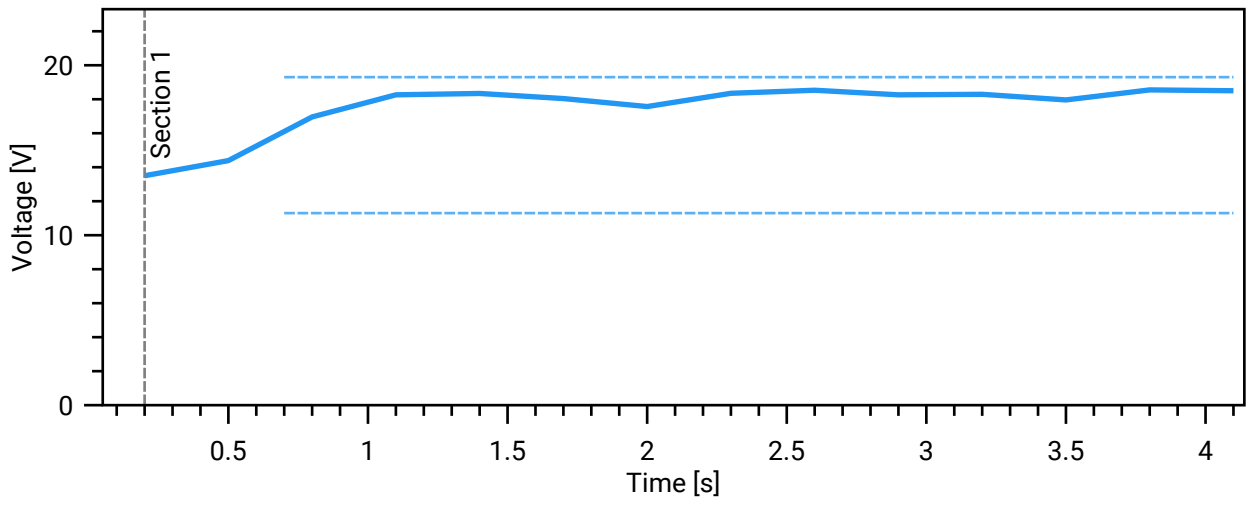
#### Section values

Welding mode	mig cmt
Duration	4.1 s
Job number	66
Arc gas consumption	0.1 l
Wire consumption (length)	0.562 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

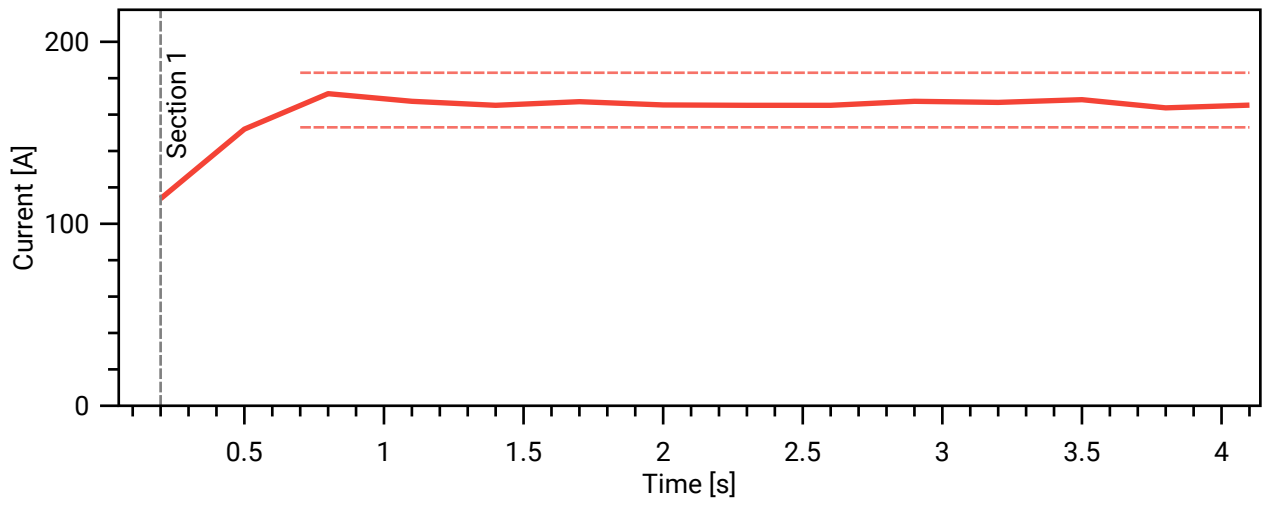
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

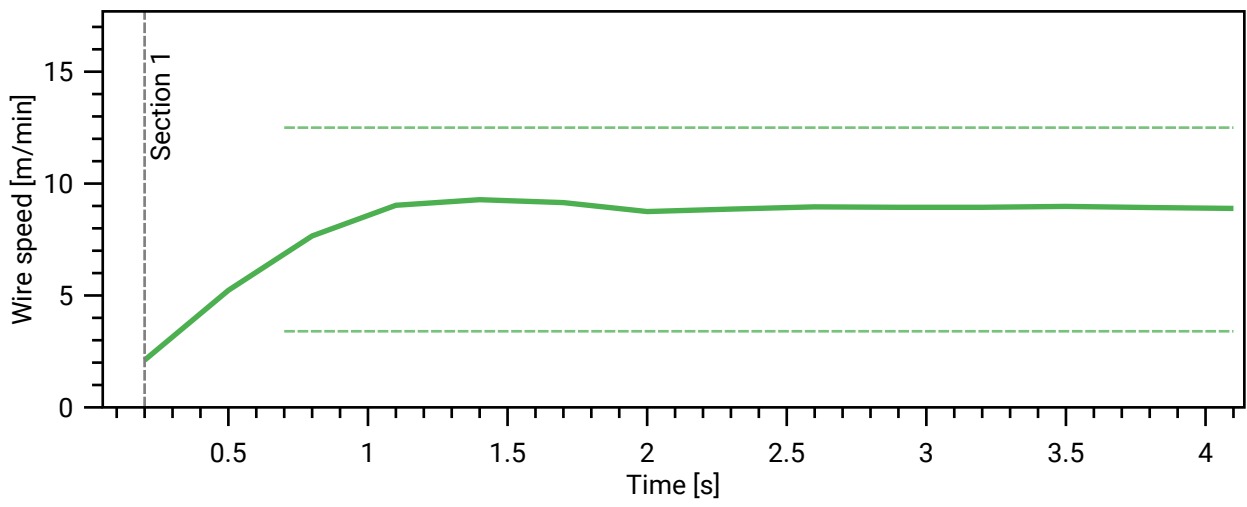
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:15:10 PM
Duration	2.9 s
Limit violations	None
Wire consumption (length)	0.381 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

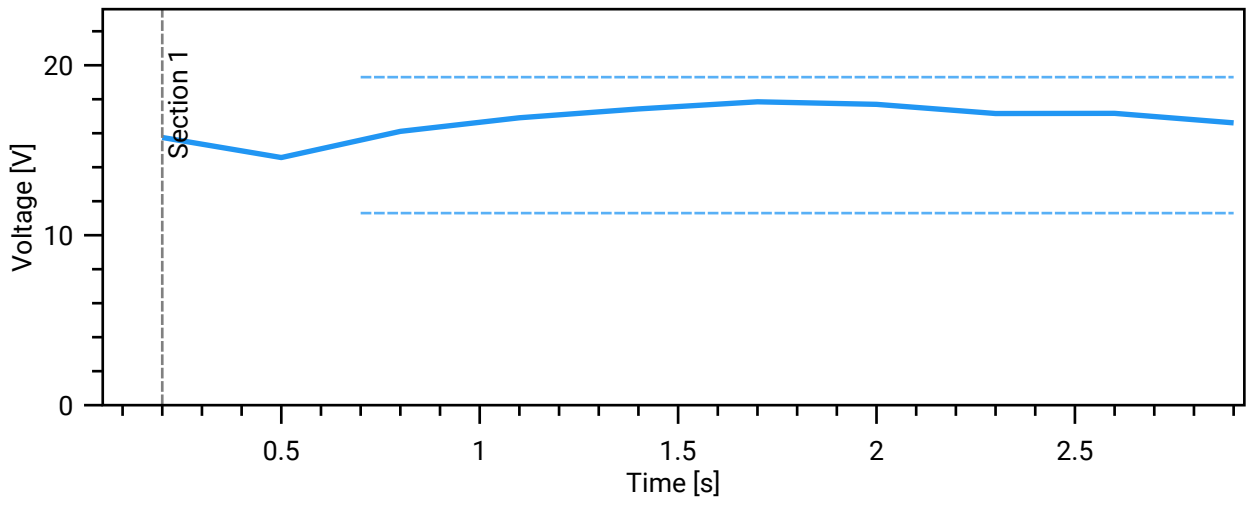
#### Section values

Welding mode	mig cmt
Duration	2.9 s
Job number	66
Arc gas consumption	0.1 l
Wire consumption (length)	0.381 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

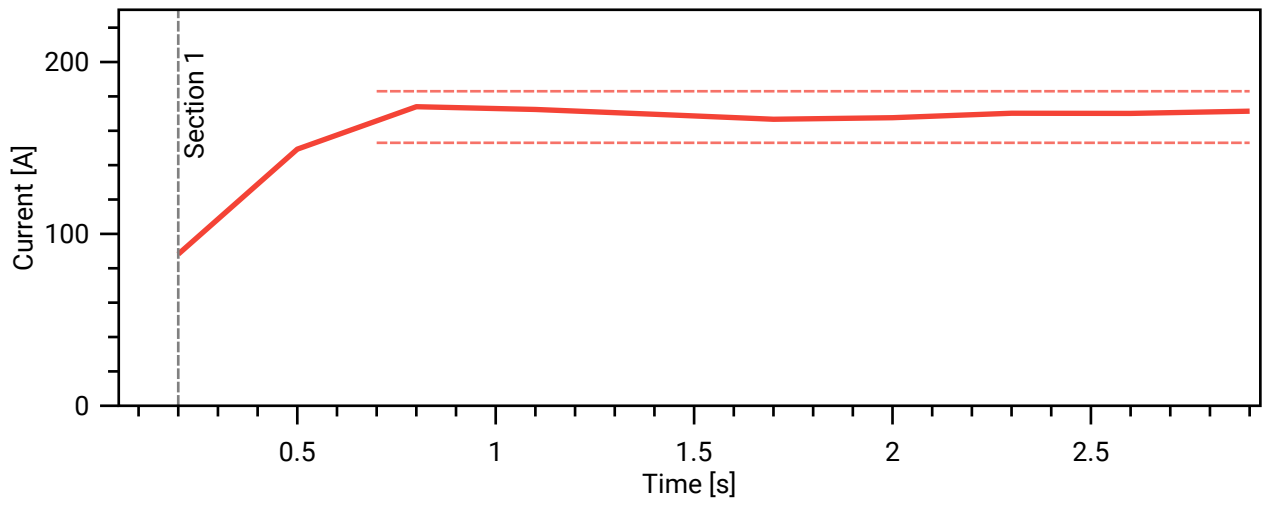
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

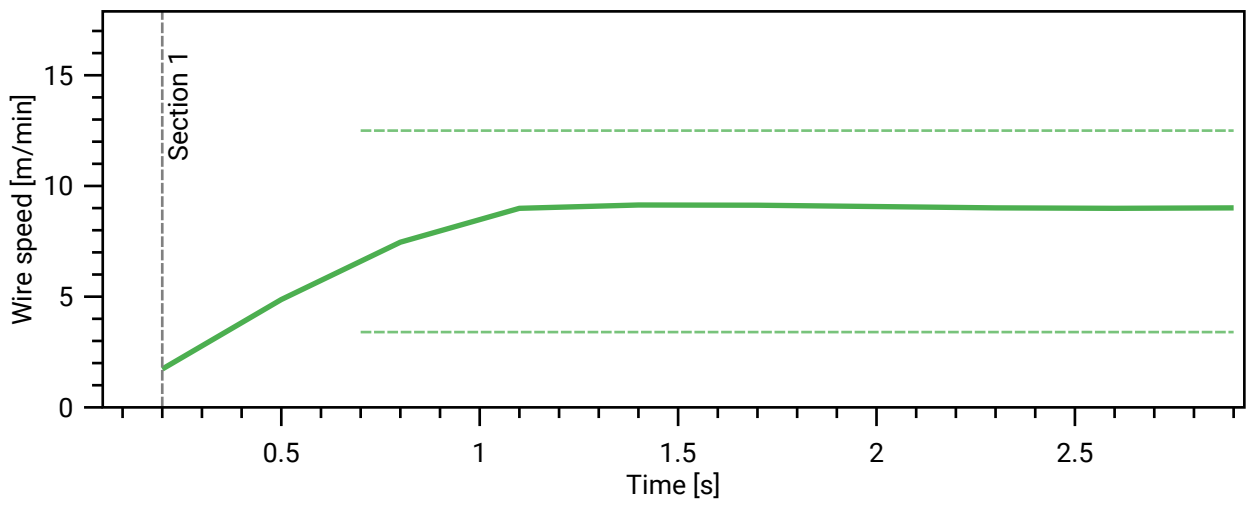
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:15:14 PM
Duration	1.7 s
Limit violations	None
Wire consumption (length)	0.177 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

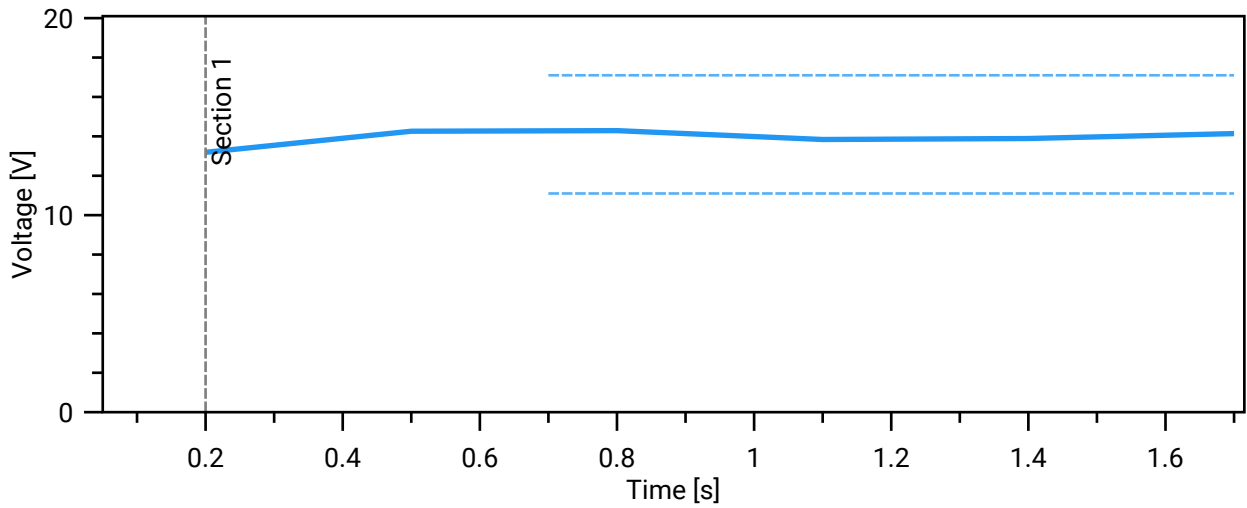
#### Section values

Welding mode	mig cmt
Duration	1.7 s
Job number	69
Arc gas consumption	0.4 l
Wire consumption (length)	0.177 m
Reference number of weld characteristic	1053
Wire speed	7.7 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	13.76 V
I approximately	180.9 A
Spatter free ignition	Off
SynchroPulse	Off

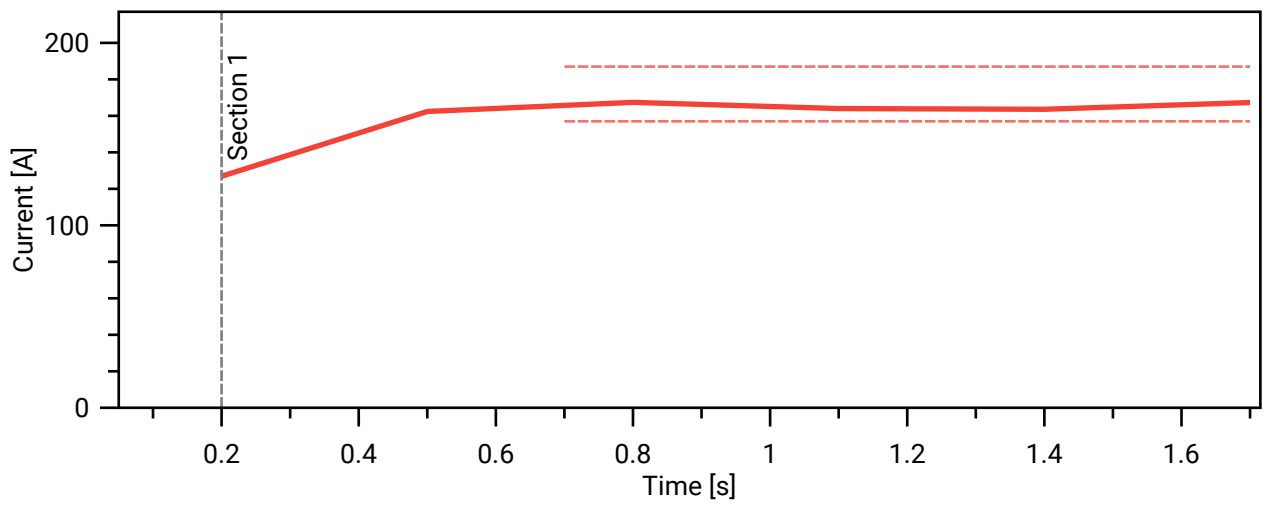
#### QMaster

Welding current command value	172 A (15 A / -15 A)
Voltage command value	14.1 V (3.0 V / -3.0 V)
Wire speed command value	7.7 m/min (1.8 m/min / -2.8 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

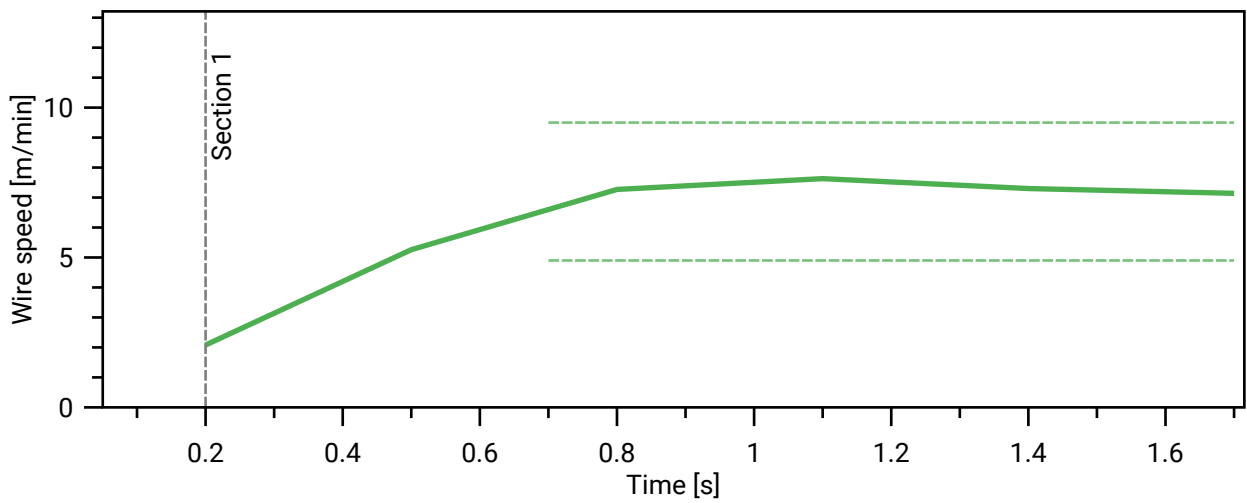
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:15:17 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.191 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

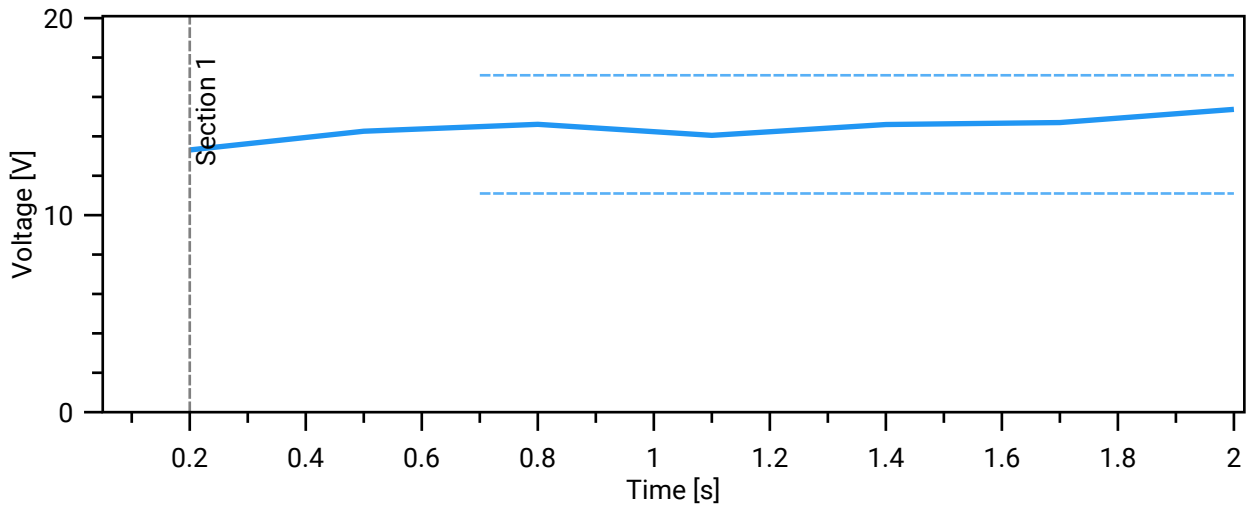
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	69
Arc gas consumption	0.5 l
Wire consumption (length)	0.191 m
Reference number of weld characteristic	1053
Wire speed	7.7 m/min
Arc length correction	-2 %
Pulse correction	0 %
U approximately	13.76 V
I approximately	180.9 A
Spatter free ignition	Off
SynchroPulse	Off

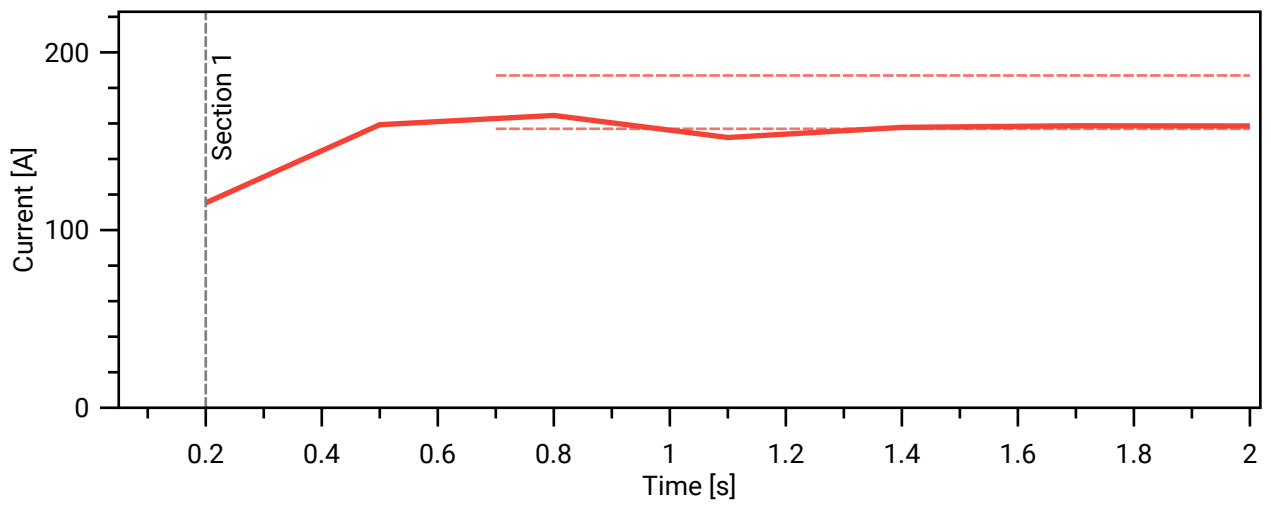
#### QMaster

Welding current command value	172 A (15 A / -15 A)
Voltage command value	14.1 V (3.0 V / -3.0 V)
Wire speed command value	7.7 m/min (1.8 m/min / -2.8 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

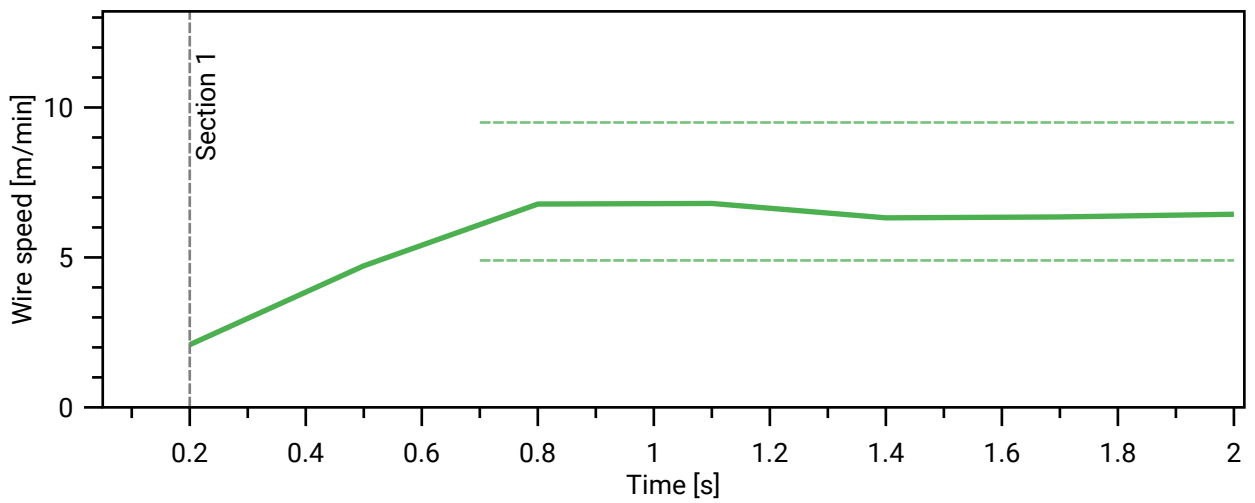
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:15:21 PM
Duration	2 s
Limit violations	None
Wire consumption (length)	0.234 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

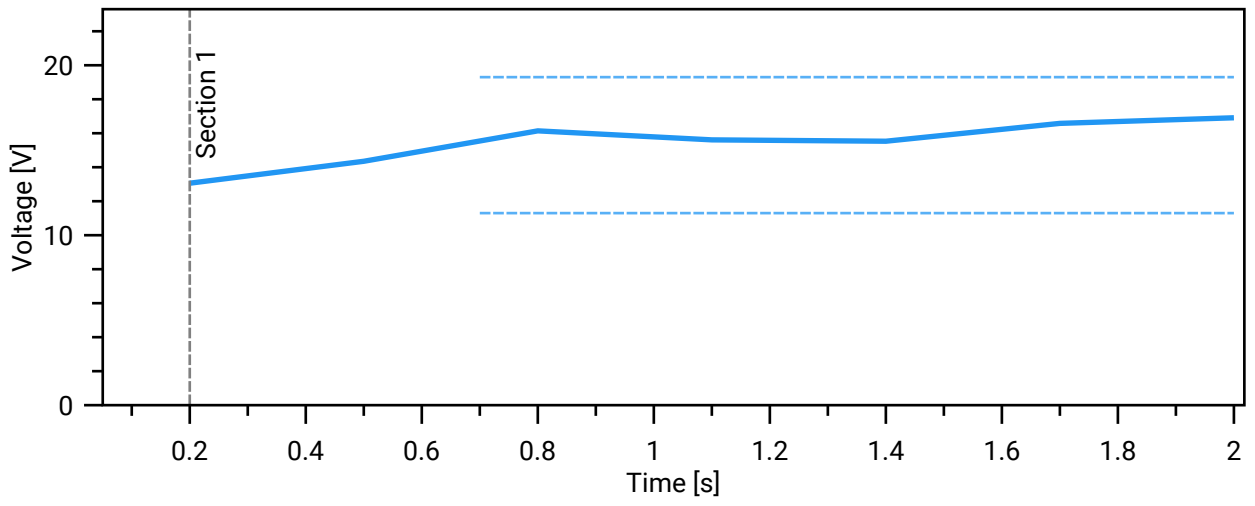
#### Section values

Welding mode	mig cmt
Duration	2 s
Job number	66
Arc gas consumption	0.1 l
Wire consumption (length)	0.234 m
Reference number of weld characteristic	1053
Wire speed	5.39 m/min
Arc length correction	3 %
Pulse correction	0.5 %
U approximately	11.79 V
I approximately	132.6 A
Spatter free ignition	Off
SynchroPulse	Off

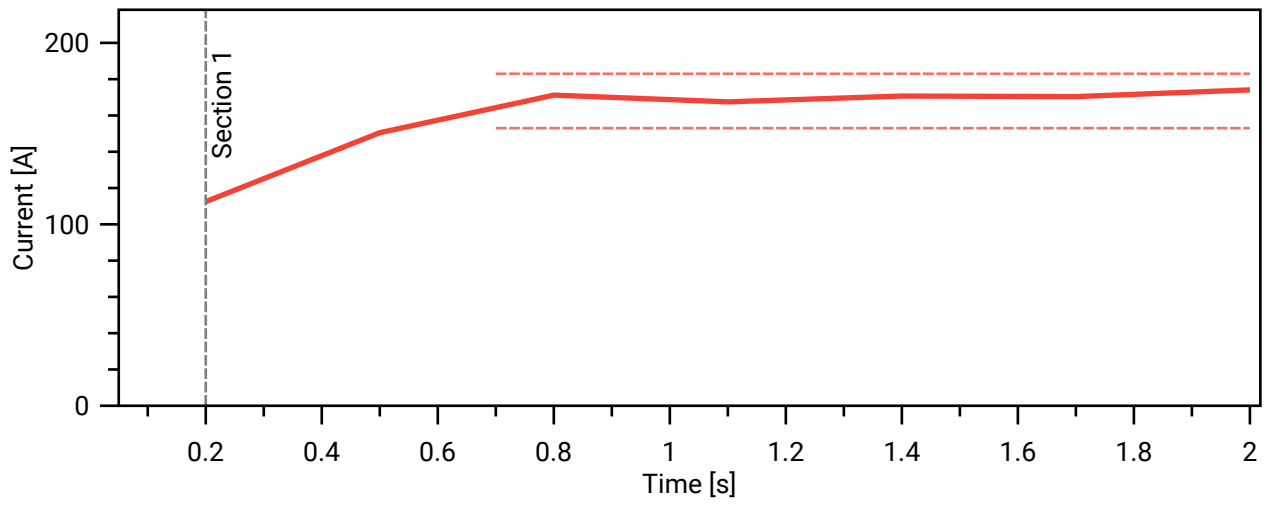
#### QMaster

Welding current command value	168 A (15 A / -15 A)
Voltage command value	15.3 V (4.0 V / -4.0 V)
Wire speed command value	7.7 m/min (4.8 m/min / -4.3 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

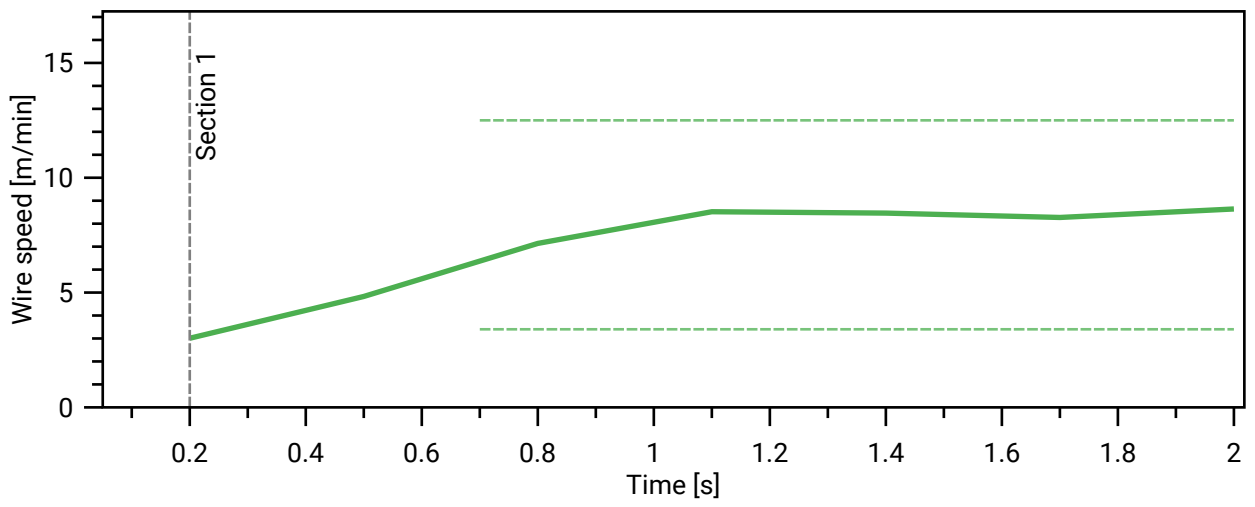
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:15:24 PM
Duration	2.6 s
Limit violations	None
Wire consumption (length)	0.275 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

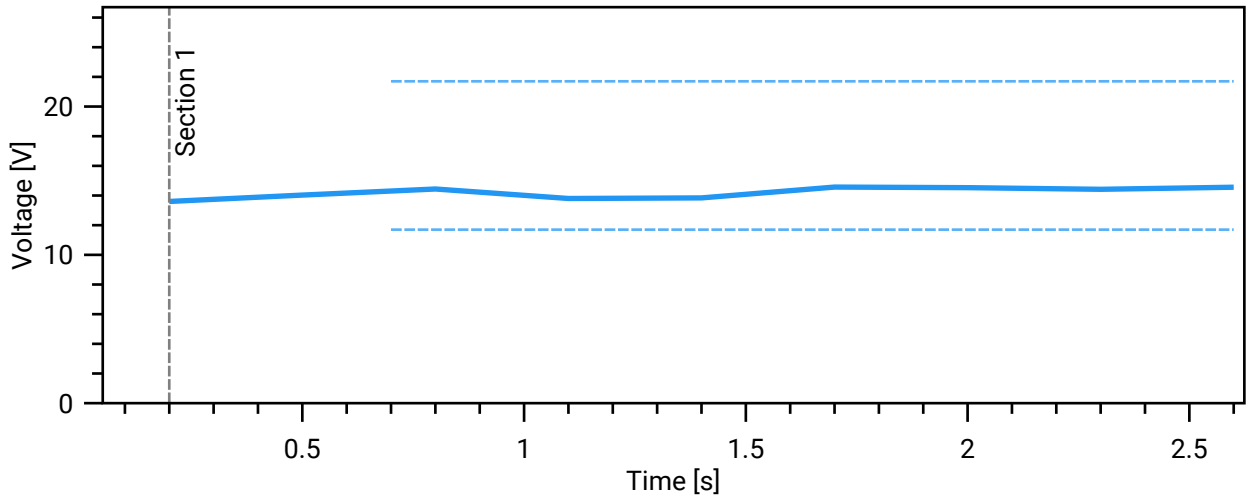
#### Section values

Welding mode	mig cmt
Duration	2.6 s
Job number	67
Arc gas consumption	0 l
Wire consumption (length)	0.275 m
Reference number of weld characteristic	1053
Wire speed	5.18 m/min
Arc length correction	4 %
Pulse correction	0 %
U approximately	11.62 V
I approximately	125.9 A
Spatter free ignition	Off
SynchroPulse	Off

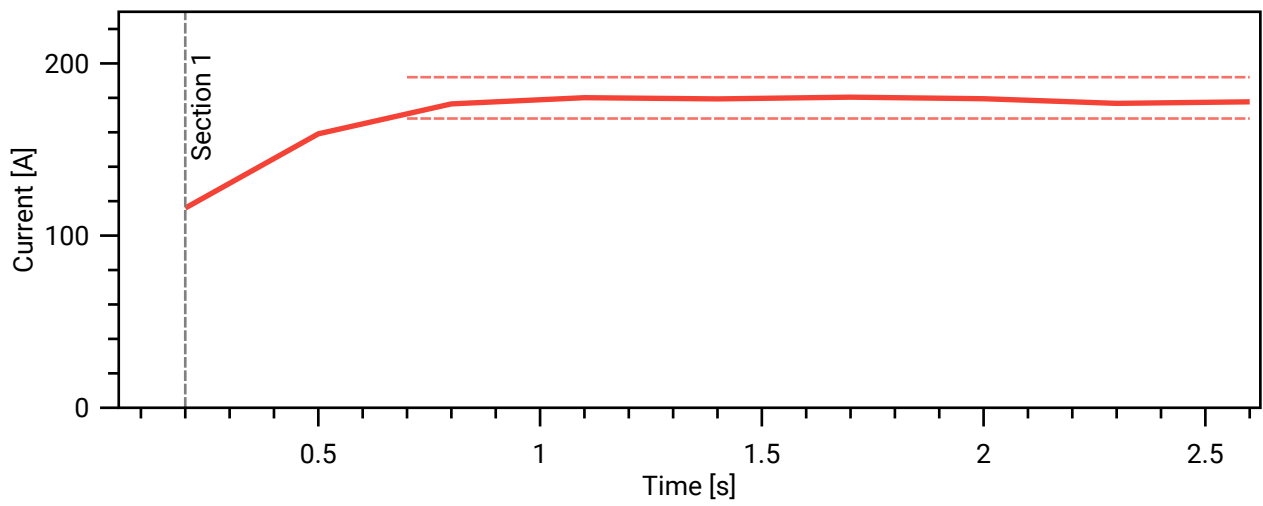
#### QMaster

Welding current command value	180 A (12 A / -12 A)
Voltage command value	16.7 V (5.0 V / -5.0 V)
Wire speed command value	7.4 m/min (2.5 m/min / -3.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

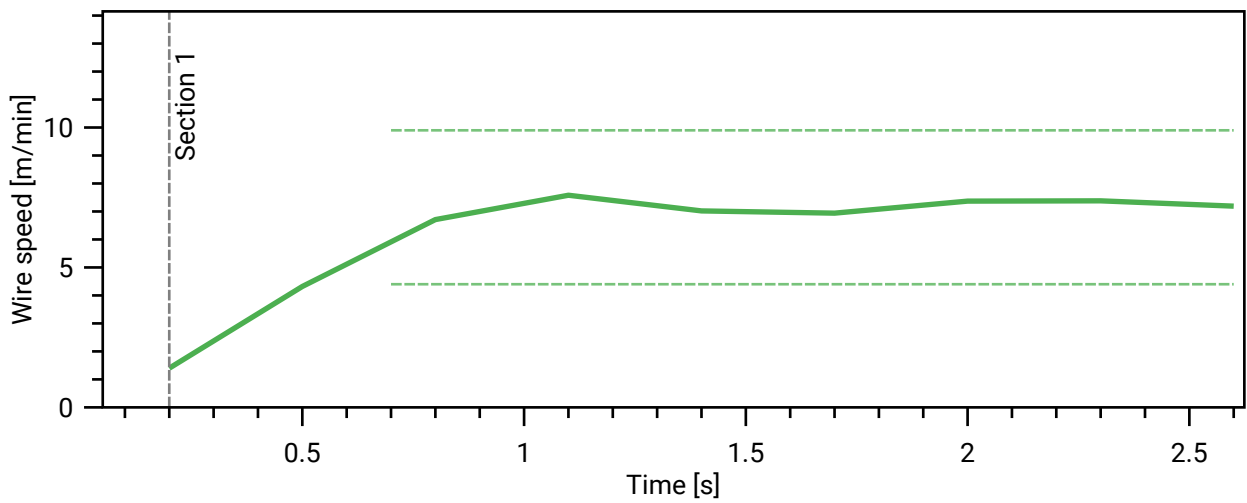
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:15:28 PM
Duration	4.5 s
Limit violations	None
Wire consumption (length)	0.595 m

## Machine

Name	<a href="#">TPS5000CMT Second Line</a>
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

#### Section values

Welding mode	mig cmt
Duration	0.1 s
Job number	68
Arc gas consumption	0 l
Wire consumption (length)	0.001 m
Reference number of weld characteristic	1053
Wire speed	7.2 m/min
Arc length correction	-3 %
Pulse correction	0.3 %
U approximately	12.97 V
I approximately	173.4 A
Spatter free ignition	Off
SynchroPulse	Off

#### QMaster

Welding current command value	178 A (10 A / 0 A)
Voltage command value	16.0 V (2.0 V / -1.0 V)
Wire speed command value	8.0 m/min (2.0 m/min / -1.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

### Section 2

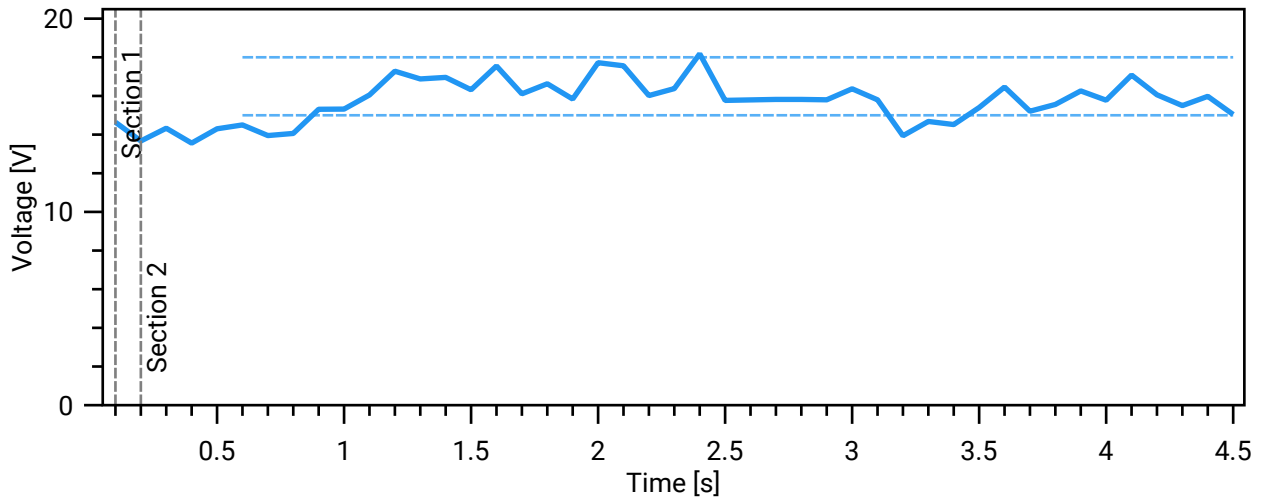
#### Section values

Welding mode	mig cmt
Duration	4.4 s
Job number	68
Arc gas consumption	0.9 l
Wire consumption (length)	0.594 m
Reference number of weld characteristic	1053
Wire speed	8 m/min
Arc length correction	-3 %
Pulse correction	0.3 %
U approximately	14.38 V
I approximately	184.8 A
Spatter free ignition	Off
SynchroPulse	Off

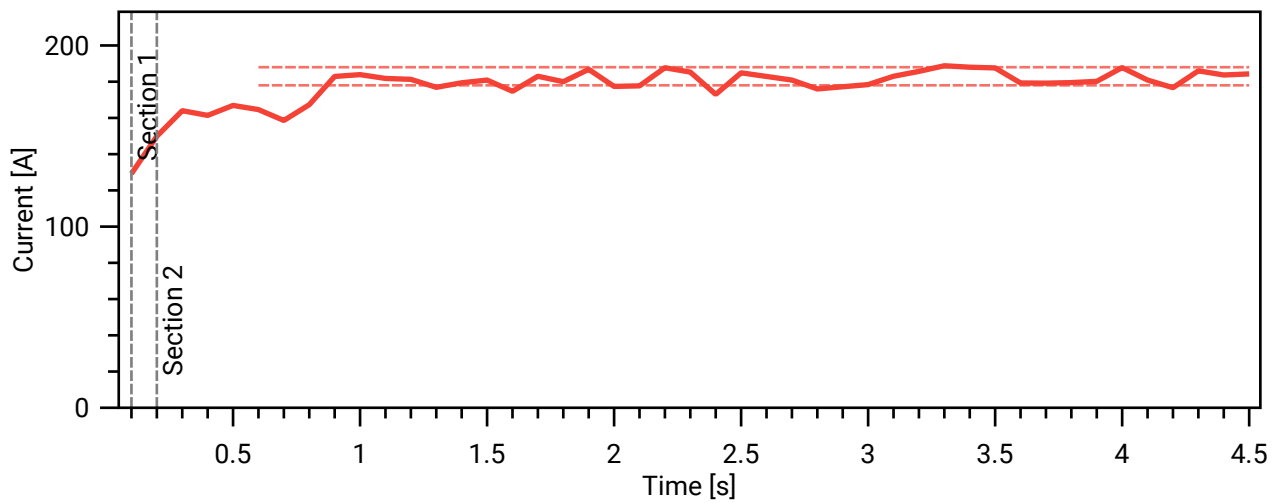
#### QMaster

Welding current command value	178 A (10 A / 0 A)
Voltage command value	16.0 V (2.0 V / -1.0 V)
Wire speed command value	8.0 m/min (2.0 m/min / -1.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

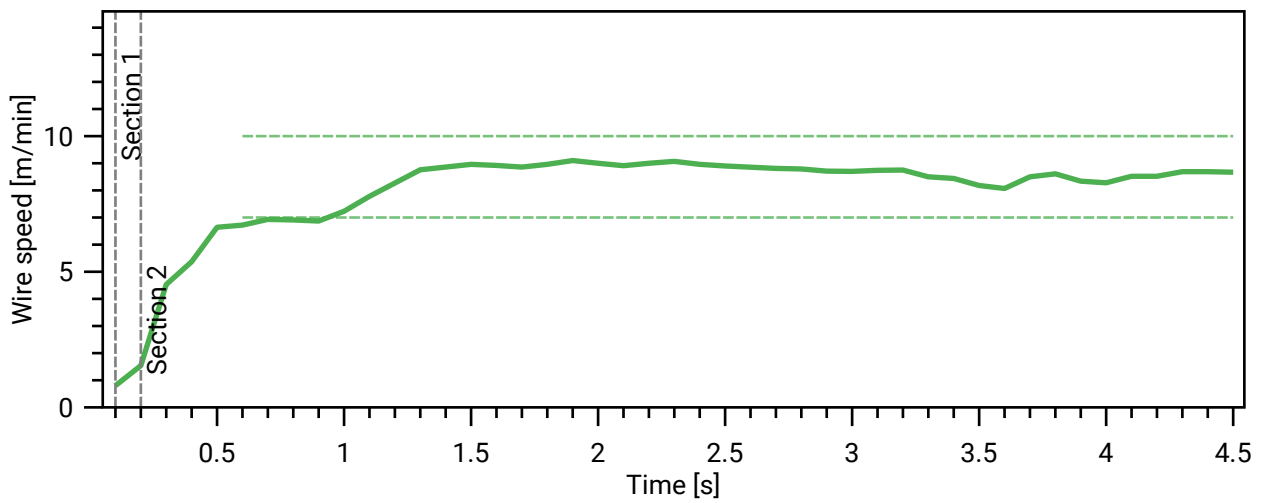
# Actual values



— Voltage



— Current



— Wire speed

## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:15:34 PM
Duration	2.6 s
Limit violations	None
Wire consumption (length)	0.252 m

## Machine

Name	TPS5000CMT Second Line
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

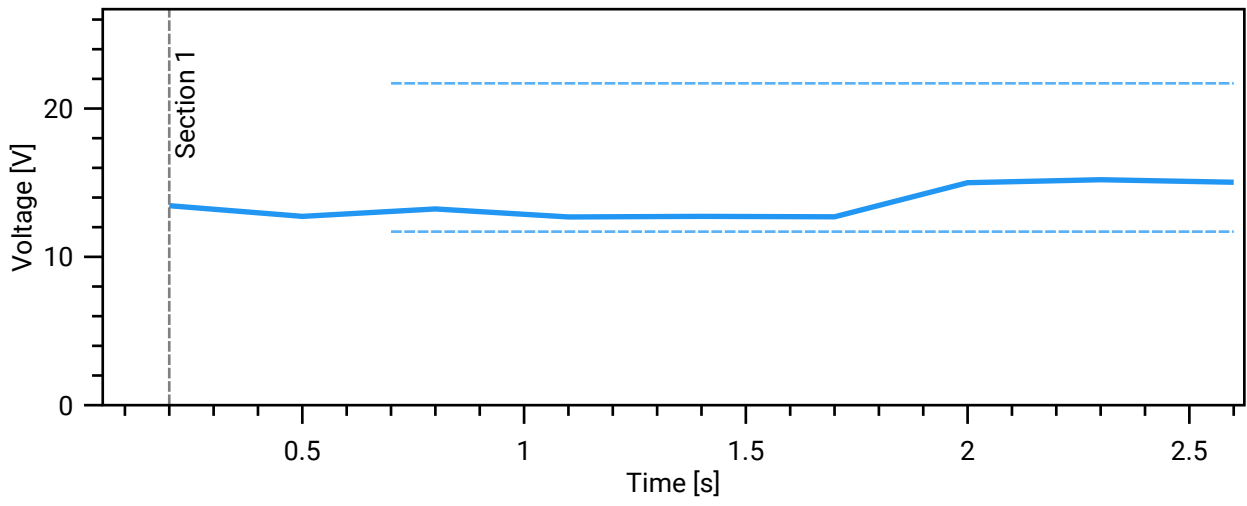
#### Section values

Welding mode	mig cmt
Duration	2.6 s
Job number	67
Arc gas consumption	0 l
Wire consumption (length)	0.252 m
Reference number of weld characteristic	1053
Wire speed	5.18 m/min
Arc length correction	4 %
Pulse correction	0 %
U approximately	11.62 V
I approximately	125.9 A
Spatter free ignition	Off
SynchroPulse	Off

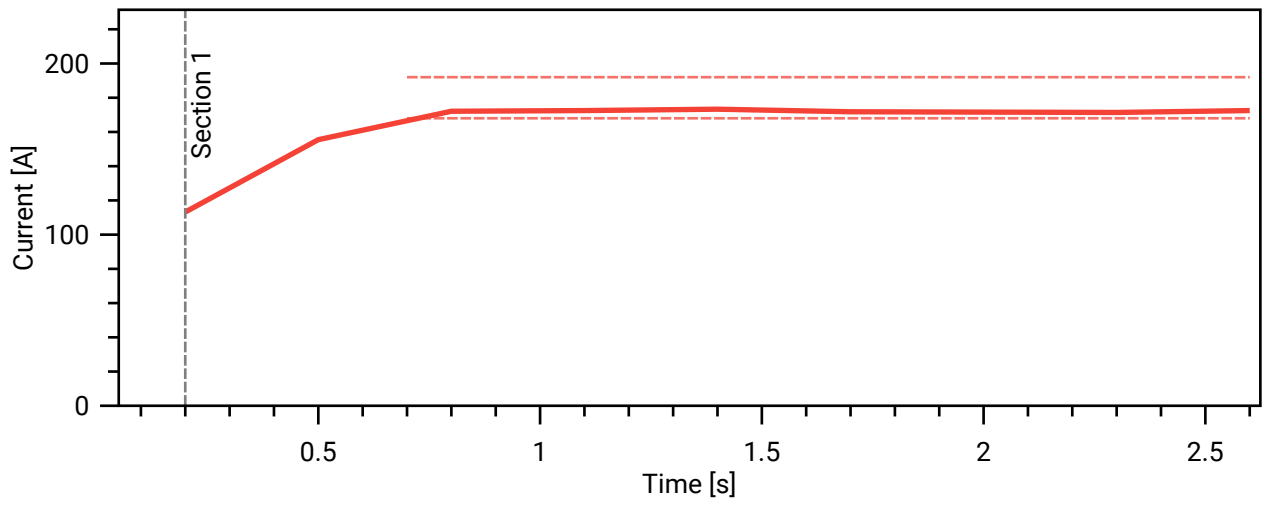
#### QMaster

Welding current command value	180 A (12 A / -12 A)
Voltage command value	16.7 V (5.0 V / -5.0 V)
Wire speed command value	7.4 m/min (2.5 m/min / -3.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

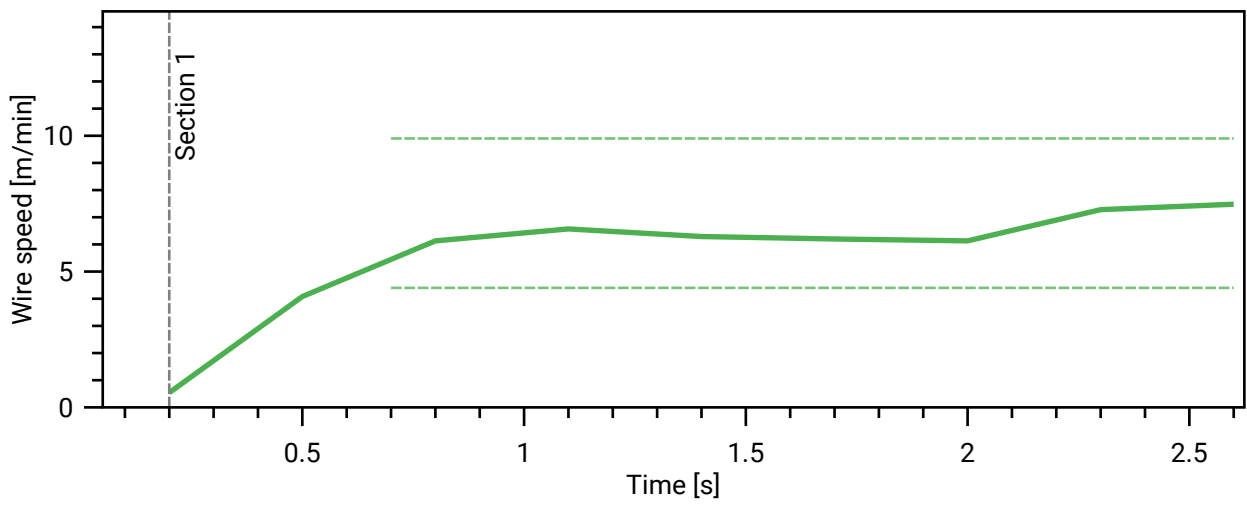
# Actual values



— Voltage



— Current



— Wire speed



## Seam

Weld details	<a href="#">Details</a>
Weld date	7/29/2019 2:15:38 PM
Duration	4.2 s
Limit violations	None
Wire consumption (length)	0.563 m

## Machine

Name	<a href="#">TPS5000CMT Second Line</a>
Machine serial number	25421995
Model	TPS5000CMT
Machine location	/Fronius/Fronius International (Austria)/Plant Sattledt/Mechanical Production/Robot Cell
IP address	10.8.64.230

## Sections

### Section 1

#### Section values

Welding mode	mig cmt
Duration	0.1 s
Job number	68
Arc gas consumption	0 l
Wire consumption (length)	0.002 m
Reference number of weld characteristic	1053
Wire speed	7.2 m/min
Arc length correction	-3 %
Pulse correction	0.3 %
U approximately	12.97 V
I approximately	173.4 A
Spatter free ignition	Off
SynchroPulse	Off

#### QMaster

Welding current command value	178 A (10 A / 0 A)
Voltage command value	16.0 V (2.0 V / -1.0 V)
Wire speed command value	8.0 m/min (2.0 m/min / -1.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

### Section 2

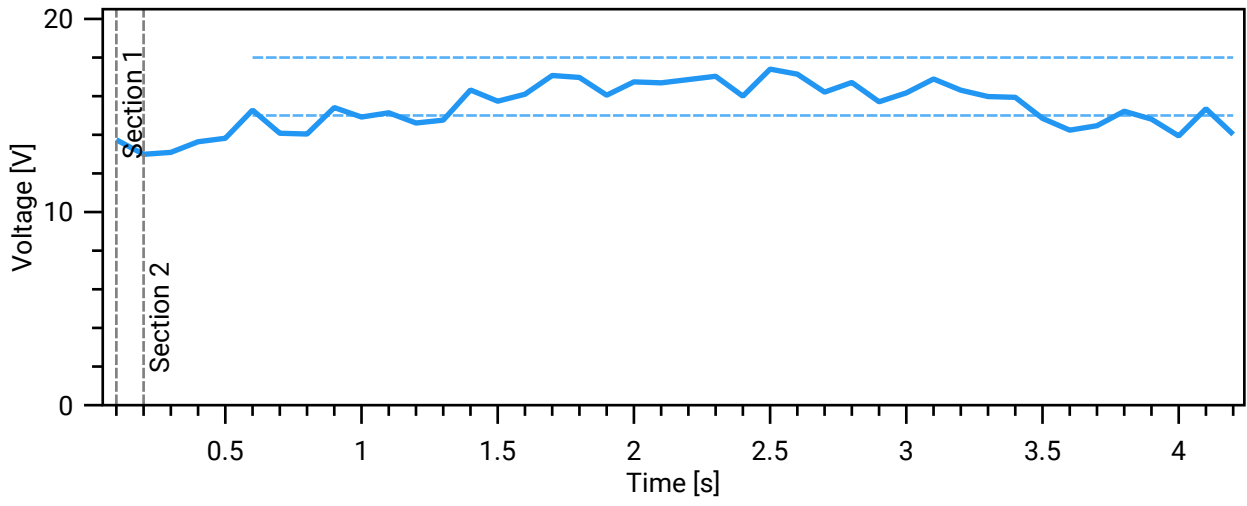
#### Section values

Welding mode	mig cmt
Duration	4.1 s
Job number	68
Arc gas consumption	0.8 l
Wire consumption (length)	0.561 m
Reference number of weld characteristic	1053
Wire speed	8 m/min
Arc length correction	-3 %
Pulse correction	0.3 %
U approximately	14.38 V
I approximately	184.8 A
Spatter free ignition	Off
SynchroPulse	Off

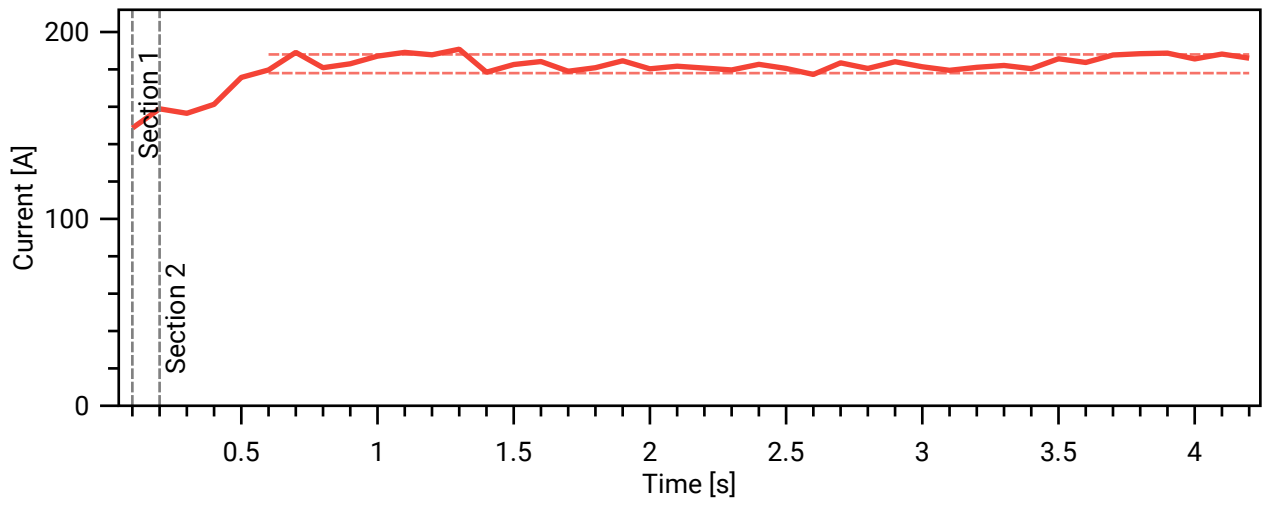
#### QMaster

Welding current command value	178 A (10 A / 0 A)
Voltage command value	16.0 V (2.0 V / -1.0 V)
Wire speed command value	8.0 m/min (2.0 m/min / -1.0 m/min)
Max. duration of current deviation	0.5 s
Max. duration of voltage deviation	0.5 s
Max. duration of wire speed deviation	0.5 s
Reaction	Warning

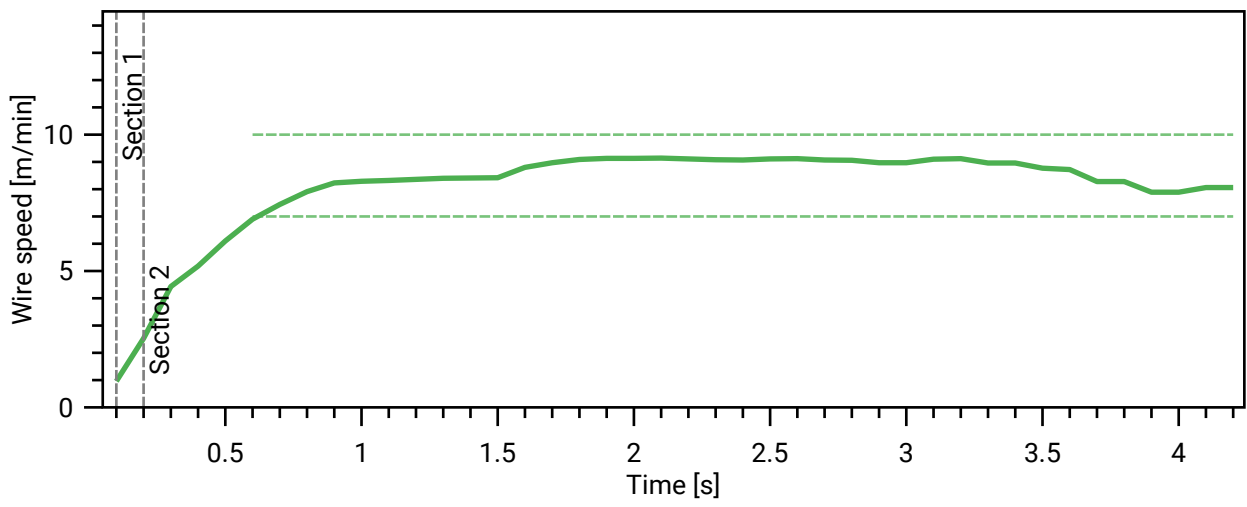
# Actual values



— Voltage



— Current



— Wire speed

# Jobs

Machine: 25421995

Job number: 60 Valid from: 4/25/2017 1:58:58 PM

Common	
Name	Tasse heften
Material	ST37
Gas	M21 Ar+18%CO2
Wire	G3Si1
Wire diameter	0.1
Characteristic	1053
Process	
Process	CMT
Job slope	Off
Process parameter	
I	91 A
Wire speed	3.5 m/min
U	10.0 V
Arc-length corr.	-2 %
Dynamic/pulse correction	0.0
Process pre-settings	
Gas pre-flow	0.1 s
Gas post-flow	0.2 s
Feeder creep speed	Auto
Feeder inching speed	7 m/min
Burn-back corr.	0.15 s
f-synchro	Off
WFS deviation	0 m/min
Upper arc length correction	0 %
Gas	13 l/min
Gas factor	Auto
Mode	
Mode	Special 2-step
Mode pre-settings	
Starting current	135 %
UpSlope	1.0 s
Final current	50 %
Start current duration (t-s)	Off
Final current duration (t-e)	Off
Spot time	1.0 s
Slope 2	1.0 s
Job correction	
Arc length job correction	0 %
Lower job power correction	0 %
Upper job power correction	0 %
QMaster	
current command value	88 A
Lower current limit	-7 A
Upper current limit	7 A
Max. duration of current deviation	0.5 s
Voltage command value	10.8 V
Lower voltage limit	-2.0 V
Upper voltage limit	2.0 V
Max. duration of voltage deviation	0.5 s
Reaction	Warning
Lower wire speed limit	-0.9 m/min
Upper wire speed limit	1.4 m/min
Max. duration of wire speed deviation	0.5 s
Documentation	
Documentation	On
Every n-th seam	1
Every n seconds	0.1 s

Job number: 61 Valid from: 4/25/2017 1:58:58 PM

<b>Common</b>	
Name	Rohr
Material	ST37
Gas	M21 Ar+18%CO2
Wire	G3Si1
Wire diameter	0.1
Characteristic	1053
Process	
Process	CMT
Job slope	Off
Process parameter	
I	170 A
Wire speed	7 m/min
U	12.8 V
Arc-length corr.	-2 %
Dynamic/pulse correction	0.0
Process pre-settings	
Gas pre-flow	0.1 s
Gas post-flow	0.2 s
Feeder creep speed	Auto
Feeder inching speed	7 m/min
Burn-back corr.	0.15 s
f-synchro	Off
WFS deviation	0 m/min
Upper arc length correction	0 %
Gas	13 l/min
Gas factor	Auto
Mode	
Mode	Special 2-step
Mode pre-settings	
Starting current	135 %
UpSlope	1.0 s
Final current	50 %
Start current duration (t-s)	Off
Final current duration (t-e)	Off
Spot time	1.0 s
Slope 2	1.0 s
Job correction	
Arc length job correction	0 %
Lower job power correction	0 %
Upper job power correction	0 %
QMaster	
current command value	161 A
Lower current limit	-15 A
Upper current limit	15 A
Max. duration of current deviation	0.5 s
Voltage command value	13.9 V
Lower voltage limit	-3.0 V
Upper voltage limit	3.0 V
Max. duration of voltage deviation	0.5 s
Reaction	Warning
Lower wire speed limit	-2.1 m/min
Upper wire speed limit	2.3 m/min
Max. duration of wire speed deviation	0.5 s
Documentation	
Documentation	On
Every n-th seam	1
Every n seconds	0.1 s

<b>Common</b>	
Name	Hefter
Material	ST37
Gas	M21 Ar+18%CO2
Wire	G3Si1
Wire diameter	0.1
Characteristic	1053
Process	
Process	CMT
Job slope	Off
Process parameter	
I	114 A
Wire speed	4.8 m/min
U	11.3 V
Arc-length corr.	-1 %
Dynamic/pulse correction	0.0
Process pre-settings	
Gas pre-flow	0.1 s
Gas post-flow	0.2 s
Feeder creep speed	Auto
Feeder inching speed	7 m/min
Burn-back corr.	0.10 s
f-synchro	Off
WFS deviation	0 m/min
Upper arc length correction	0 %
Gas	13 l/min
Gas factor	Auto
Mode	
Mode	Spot-welding
Mode pre-settings	
Starting current	135 %
UpSlope	1.0 s
Final current	50 %
Start current duration (t-s)	Off
Final current duration (t-e)	Off
Spot time	1.0 s
Slope 2	1.0 s
Job correction	
Arc length job correction	0 %
Lower job power correction	0 %
Upper job power correction	0 %
QMaster	
current command value	105 A
Lower current limit	-12 A
Upper current limit	12 A
Max. duration of current deviation	0.5 s
Voltage command value	12.1 V
Lower voltage limit	-2.0 V
Upper voltage limit	2.0 V
Max. duration of voltage deviation	0.5 s
Reaction	Warning
Lower wire speed limit	-2 m/min
Upper wire speed limit	1.6 m/min
Max. duration of wire speed deviation	0.5 s
Documentation	
Documentation	On
Every n-th seam	1
Every n seconds	0.1 s

<b>Common</b>	
Name	Tasse Loecher
Material	ST37
Gas	M21 Ar+18%CO2
Wire	G3Si1
Wire diameter	0.1
Characteristic	1053
Process	
Process	CMT
Job slope	Off
Process parameter	
I	178 A
Wire speed	7.5 m/min
U	13.3 V
Arc-length corr.	2 %
Dynamic/pulse correction	0.0
Process pre-settings	
Gas pre-flow	0.1 s
Gas post-flow	0.1 s
Feeder creep speed	Auto
Feeder inching speed	7 m/min
Burn-back corr.	0.00 s
f-synchro	Off
WFS deviation	0 m/min
Upper arc length correction	0 %
Gas	13 l/min
Gas factor	Auto
Mode	
Mode	Special 2-step
Mode pre-settings	
Starting current	135 %
UpSlope	1.0 s
Final current	50 %
Start current duration (t-s)	Off
Final current duration (t-e)	Off
Spot time	1.0 s
Slope 2	1.0 s
Job correction	
Arc length job correction	0 %
Lower job power correction	0 %
Upper job power correction	0 %
QMaster	
current command value	175 A
Lower current limit	-15 A
Upper current limit	15 A
Max. duration of current deviation	0.5 s
Voltage command value	13.6 V
Lower voltage limit	-4.0 V
Upper voltage limit	4.0 V
Max. duration of voltage deviation	0.5 s
Reaction	Warning
Lower wire speed limit	-4 m/min
Upper wire speed limit	2.2 m/min
Max. duration of wire speed deviation	0.5 s
Documentation	
Documentation	On
Every n-th seam	1
Every n seconds	0.1 s

Job number: 64 Valid from: 4/25/2017 1:58:58 PM

<b>Common</b>	
Name	Tasse Naehte
Material	ST37
Gas	M21 Ar+18%CO2
Wire	G3Si1
Wire diameter	0.1
Characteristic	1053
Process	
Process	CMT
Job slope	Off
Process parameter	
I	136 A
Wire speed	5.5 m/min
U	11.8 V
Arc-length corr.	2 %
Dynamic/pulse correction	0.0
Process pre-settings	
Gas pre-flow	0.1 s
Gas post-flow	0.2 s
Feeder creep speed	Auto
Feeder inching speed	7 m/min
Burn-back corr.	0.10 s
f-synchro	4.0 Hz
WFS deviation	0 m/min
Upper arc length correction	0 %
Gas	13 l/min
Gas factor	Auto
Mode	
Mode	Special 2-step
Mode pre-settings	
Starting current	80 %
UpSlope	0.4 s
Final current	50 %
Start current duration (t-s)	0.2 s
Final current duration (t-e)	Off
Spot time	1.0 s
Slope 2	0.4 s
Job correction	
Arc length job correction	0 %
Lower job power correction	0 %
Upper job power correction	0 %
QMaster	
current command value	125 A
Lower current limit	-15 A
Upper current limit	15 A
Max. duration of current deviation	0.5 s
Voltage command value	13.1 V
Lower voltage limit	-2.0 V
Upper voltage limit	2.0 V
Max. duration of voltage deviation	0.5 s
Reaction	Warning
Lower wire speed limit	-1.9 m/min
Upper wire speed limit	1.7 m/min
Max. duration of wire speed deviation	0.5 s
Documentation	
Documentation	On
Every n-th seam	1
Every n seconds	0.1 s

Job number: 65 Valid from: 4/25/2017 1:58:58 PM

<b>Common</b>	
Name	Stumpf vorne
Material	ST37
Gas	M21 Ar+18%CO2
Wire	G3Si1
Wire diameter	0.1
Characteristic	1053
Process	
Process	CMT
Job slope	Off
Process parameter	
I	136 A
Wire speed	5.5 m/min
U	11.8 V
Arc-length corr.	-2 %
Dynamic/pulse correction	0.0
Process pre-settings	
Gas pre-flow	0.1 s
Gas post-flow	0.1 s
Feeder creep speed	Auto
Feeder inching speed	7 m/min
Burn-back corr.	0.08 s
f-synchro	Off
WFS deviation	0 m/min
Upper arc length correction	0 %
Gas	13 l/min
Gas factor	Auto
Mode	
Mode	Special 2-step
Mode pre-settings	
Starting current	60 %
UpSlope	0.4 s
Final current	50 %
Start current duration (t-s)	0.4 s
Final current duration (t-e)	Off
Spot time	1.0 s
Slope 2	0.4 s
Job correction	
Arc length job correction	0 %
Lower job power correction	0 %
Upper job power correction	0 %
QMaster	
current command value	133 A
Lower current limit	-15 A
Upper current limit	15 A
Max. duration of current deviation	0.5 s
Voltage command value	14.3 V
Lower voltage limit	-3.0 V
Upper voltage limit	3.0 V
Max. duration of voltage deviation	0.5 s
Reaction	Warning
Lower wire speed limit	-2.8 m/min
Upper wire speed limit	5.3 m/min
Max. duration of wire speed deviation	0.5 s
Documentation	
Documentation	On
Every n-th seam	1
Every n seconds	0.1 s



<b>Common</b>	
Name	Kehlnaehte
Material	ST37
Gas	M21 Ar+18%CO2
Wire	G3Si1
Wire diameter	0.1
Characteristic	1053
Process	
Process	CMT
Job slope	Off
Process parameter	
I	181 A
Wire speed	7.7 m/min
U	13.8 V
Arc-length corr.	3 %
Dynamic/pulse correction	0.5
Process pre-settings	
Gas pre-flow	0.1 s
Gas post-flow	0.2 s
Feeder creep speed	Auto
Feeder inching speed	7 m/min
Burn-back corr.	0.05 s
f-synchro	Off
WFS deviation	0 m/min
Upper arc length correction	2 %
Gas	13 l/min
Gas factor	Auto
Mode	
Mode	Special 2-step
Mode pre-settings	
Starting current	70 %
UpSlope	0.4 s
Final current	50 %
Start current duration (t-s)	0.2 s
Final current duration (t-e)	Off
Spot time	1.0 s
Slope 2	0.4 s
Job correction	
Arc length job correction	0 %
Lower job power correction	0 %
Upper job power correction	0 %
QMaster	
current command value	168 A
Lower current limit	-15 A
Upper current limit	15 A
Max. duration of current deviation	0.5 s
Voltage command value	15.3 V
Lower voltage limit	-4.0 V
Upper voltage limit	4.0 V
Max. duration of voltage deviation	0.5 s
Reaction	Warning
Lower wire speed limit	-4.3 m/min
Upper wire speed limit	4.8 m/min
Max. duration of wire speed deviation	0.5 s
Documentation	
Documentation	On
Every n-th seam	1
Every n seconds	0.1 s

<b>Common</b>	
Name	Fallnaehte
Material	ST37
Gas	M21 Ar+18%CO2
Wire	G3Si1
Wire diameter	0.1
Characteristic	1053
Process	
Process	CMT
Job slope	Off
Process parameter	
I	181 A
Wire speed	7.7 m/min
U	13.8 V
Arc-length corr.	-2 %
Dynamic/pulse correction	0.0
Process pre-settings	
Gas pre-flow	0.1 s
Gas post-flow	0.1 s
Feeder creep speed	Auto
Feeder inching speed	7 m/min
Burn-back corr.	0.10 s
f-synchro	Off
WFS deviation	0 m/min
Upper arc length correction	0 %
Gas	13 l/min
Gas factor	Auto
Mode	
Mode	Special 2-step
Mode pre-settings	
Starting current	135 %
UpSlope	1.0 s
Final current	50 %
Start current duration (t-s)	Off
Final current duration (t-e)	Off
Spot time	1.0 s
Slope 2	1.0 s
Job correction	
Arc length job correction	0 %
Lower job power correction	0 %
Upper job power correction	0 %
QMaster	
current command value	172 A
Lower current limit	-15 A
Upper current limit	15 A
Max. duration of current deviation	0.5 s
Voltage command value	14.1 V
Lower voltage limit	-3.0 V
Upper voltage limit	3.0 V
Max. duration of voltage deviation	0.5 s
Reaction	Warning
Lower wire speed limit	-2.8 m/min
Upper wire speed limit	1.8 m/min
Max. duration of wire speed deviation	0.5 s
Documentation	
Documentation	On
Every n-th seam	1
Every n seconds	0.1 s

<b>Common</b>	
Name	Eck Seite
Material	ST37
Gas	M21 Ar+18%CO2
Wire	G3Si1
Wire diameter	0.1
Characteristic	1053
Process	
Process	CMT
Job slope	Off
Process parameter	
I	177 A
Wire speed	7.4 m/min
U	13.1 V
Arc-length corr.	4 %
Dynamic/pulse correction	0.0
Process pre-settings	
Gas pre-flow	0.1 s
Gas post-flow	0.1 s
Feeder creep speed	Auto
Feeder inching speed	7 m/min
Burn-back corr.	0.00 s
f-synchro	Off
WFS deviation	0 m/min
Upper arc length correction	0 %
Gas	13 l/min
Gas factor	Auto
Mode	
Mode	Special 2-step
Mode pre-settings	
Starting current	70 %
UpSlope	0.4 s
Final current	50 %
Start current duration (t-s)	0.1 s
Final current duration (t-e)	Off
Spot time	1.0 s
Slope 2	0.4 s
Job correction	
Arc length job correction	0 %
Lower job power correction	0 %
Upper job power correction	0 %
QMaster	
current command value	180 A
Lower current limit	-12 A
Upper current limit	12 A
Max. duration of current deviation	0.5 s
Voltage command value	16.7 V
Lower voltage limit	-5.0 V
Upper voltage limit	5.0 V
Max. duration of voltage deviation	0.5 s
Reaction	Warning
Lower wire speed limit	-3 m/min
Upper wire speed limit	2.5 m/min
Max. duration of wire speed deviation	0.5 s
Documentation	
Documentation	On
Every n-th seam	1
Every n seconds	0.1 s

<b>Common</b>	
Name	V Seite
Material	ST37
Gas	M21 Ar+18%CO2
Wire	G3Si1
Wire diameter	0.1
Characteristic	1053
Process	
Process	CMT
Job slope	Off
Process parameter	
I	185 A
Wire speed	8 m/min
U	14.4 V
Arc-length corr.	-3 %
Dynamic/pulse correction	0.3
Process pre-settings	
Gas pre-flow	0.1 s
Gas post-flow	0.1 s
Feeder creep speed	30 m/min
Feeder inching speed	7 m/min
Burn-back corr.	0.00 s
f-synchro	Off
WFS deviation	0 m/min
Upper arc length correction	0 %
Gas	13 l/min
Gas factor	Auto
Mode	
Mode	Special 2-step
Mode pre-settings	
Starting current	90 %
UpSlope	0.4 s
Final current	50 %
Start current duration (t-s)	0.2 s
Final current duration (t-e)	Off
Spot time	1.0 s
Slope 2	0.4 s
Job correction	
Arc length job correction	0 %
Lower job power correction	0 %
Upper job power correction	0 %
QMaster	
current command value	178 A
Lower current limit	0 A
Upper current limit	10 A
Max. duration of current deviation	0.5 s
Voltage command value	16.0 V
Lower voltage limit	-1.0 V
Upper voltage limit	2.0 V
Max. duration of voltage deviation	0.5 s
Reaction	Warning
Lower wire speed limit	-1 m/min
Upper wire speed limit	2 m/min
Max. duration of wire speed deviation	0.5 s
Documentation	
Documentation	On
Every n-th seam	1
Every n seconds	0.1 s