TRANSTIG 170, TRANSTIG 210
Control Panel Overview | Setting Welding Parameters

Fronius
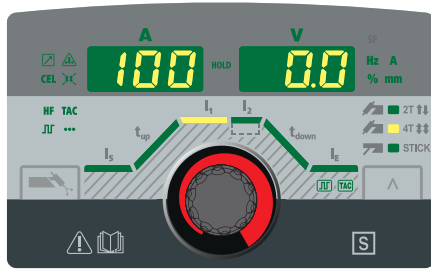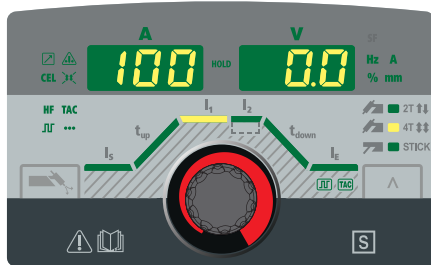
	To select the operating mode
2T ↑↓	2-step mode: Short weld seams
4T ↕↕	4-step mode: Longer weld seams
STICK	SMAW
	Allow shielding gas to flow out for 30 seconds

Adjustable welding parameters:

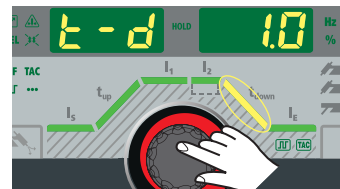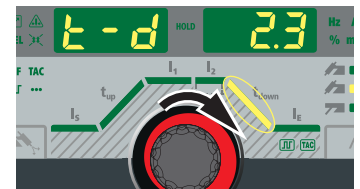|	
I_S	Starting current
t_{up}	UpSlope
I_1	Main current (welding current)
I_2	Reduced current
t_{down}	DownSlope
I_E	Final current
⊓	Pulses
TAC	Tacking

Setting the welding parameters:

1. **Press** selection dial to enable parameter selection

2. **Turn** selection dial to select the desired parameter

3. **Press** selection dial to confirm the selected parameter

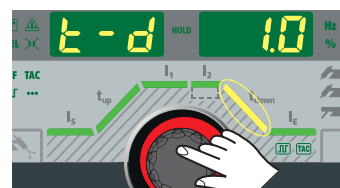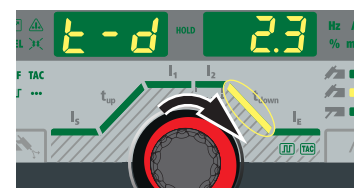4. **Turn** selection dial to select the desired value

Operating Instructions:
www.fronius.com/transtig

TRANSTIG 170, TRANSTIG 210
Description of Setup Parameters

Accessing the Setup menu:

1. Press and hold
2. Press

Exiting the Setup menu:

Rod electrode Setup menu:

HCU	HotStart current
HtI	Starting current duration
F-P	Pulse frequency
ASt	Anti-stick
CEL	CEL mode
Str	Start ramp
dYn	Dynamic correction
UCo	Break voltage
FAC	Reset welding system
2nd	Setup Menu 2nd Level

TIG Setup Menu, 1st Level:

ELd	Electrode diameter
SPt	Spot welding time/interval welding time
SPb	Interval pause time
tAC	Tacking
F-P	Pulse frequency
dcY	Duty cycle
I-G	Base current
t-S	Starting current time
t-E	Final current time
GPr	Gas pre-flow time
GPo	Gas post-flow time
GPU	Gas purging
FAC	Reset welding system
2nd + tIG	TIG Setup Menu, 2nd Level
2nd	Setup Menu 2nd Level

TIG Setup Menu, 2nd Level:

St1	Slope time 1
St2	Slope time 2
trI	Trigger mode
IGn	HF ignition
Ptd	Pulse TAC display
Ito	Ignition time out
ArC	Arc break monitoring
CSS	Comfort Stop sensitivity
UCo	Break voltage
ACS	Main current changeover
r	Welding circuit resistance

Setup Menu 2nd Level (TIG and SMAW):

SAt	System active time
Sot	System on time
FUS	Fuse
SoF	Software version
tSd	Automatic shutdown

SAFETY
Before working with the device, ensure that you have read and understood all the documents provided in hard copy and online. This document does not describe all the functions of the device. For a complete description of the device, refer to the Operating Instructions.