

Welding transformer test

焊接变压器测试

1. Switch off the Main switch Q1 of machine

关闭主电源。

2. **Wait around 10min before you do anything on the wiring of pacemaker!!! The capacitors need that time to discharge!!!**

等10分钟，不要碰任何线，因电容要放电!!!

3. Disconnect both welding cables from Pacemaker.

拆下焊接变频器的电缆。



4. Measure the resistant of booth cable to earth. If the value is very low maybe the transformer primary side have short circuit to earth or the cables are damaged and make some contact to earth. If looks ok (endless or very high resistant) go to point 5.

测量两个电缆对地的电阻，如果非常小，可能是焊接变压器对地短路了，或电缆对地短路。如果是好的（很高的电阻），看第5点。

5. Take the welding copper wire completely out of welder.

将焊机上铜线拆下（不让上下焊轮短路）。

6. Control that Pendulum roller head is lift up. Put a carton or another isolating material between both welding rollers to make sure that you don't have any contact between the rolls.

上焊臂升起，放一些硬质板在上下焊轮中间，以确保上下不接触。

7. Connect an external cable 230VAC (phase and neutral) to the welding cables, which you have removed on pacemaker before. Use for this external supply a 10A fuse breaker to protect the supply in case of a short circuit of welding transformer. (Take a look to picture on point 3)

连接外部220Vac（相线和中线）到焊接电缆上，之前将电缆从焊接变频器拆

下。用10安培熔断器保护外部电源，万一变压器短路（看第三点，的照片）

8. Before you switch on the external supply check again:

在打开外接电源前，再检查一遍：

- Wire removed?

电缆是否从焊接变频器上拆下。

- Pendulum rollerhead lift up and isolation between welding rolls?

上焊轮是否升起和绝缘。

9. Now switch on the external supply. If the 10A fuse breaker do not trip is a good sign and it don't looks like short circuit of welding transformer.

打开外部电源，如果10A的熔断器没烧掉，则焊接变压器看起来是没短路。

10. To control the output of welding transformer you can measure the voltage between the welding rolls (VAC). The measured voltage is depending on the type of welding transformer. If you change the transformer step this value has also to change. Check the output voltage of each step. Don't worry if you measure only around 5VAC, the output voltage of welding transformer is a low voltage.

此时可测量焊接变压器的输出，在焊轮处测量（交流），测量电压的大小根据变压器的型号。变比改变了，则电压改变。检查变压器输出每一级的电压，不要担心输出电压，焊接变压器的输出电压仅仅在5Vac左右，非常低。



Before you change the transformer step switch off first the external supply!!! 在改变变压器的档位前，关闭外部电源。