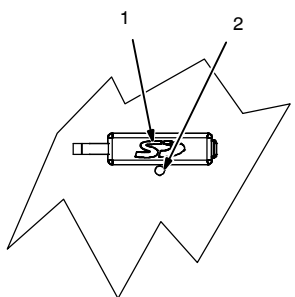




## Dynasty<sup>®</sup> – Maxstar<sup>®</sup> Hot Wire Expansion

Read and follow the power source Owner's Manual and labels carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.

### 1-1. Software Expansion



1 Memory Card Port  
2 Indicator LED

**Card Requirements:**

- ☞ Purchased software expansion memory card required.

**Enabling Software Expansion:**

Insert card containing software expansion into port. LED indicator blinks green while machine is reading from or writing to the card. After successfully reading from or writing to the card, the LED switches

from blinking green to continuous green. The machine is now ready to use software expansion. **Do not** remove card while LED is blinking green.

☞ Software expansion card must remain in memory card port to enable software expansion.

**Disabling Software Expansion:**

Remove the software expansion card from the memory card port.

**Troubleshooting:**

Problem: Indicator LED is continuous red.  
Remedy: Remove and reinsert card. If problem continues, the card is bad. Contact Factory Authorized Service Center for a replacement card.

The memory card port uses an SD memory card. The SD Logo is a trademark of the SD-3C LLC Company.

**Hot Wire Expansion** – Enabling the Hot Wire software expansion configures the machine to the Hot Wire Power Source process. When Hot Wire is enabled —

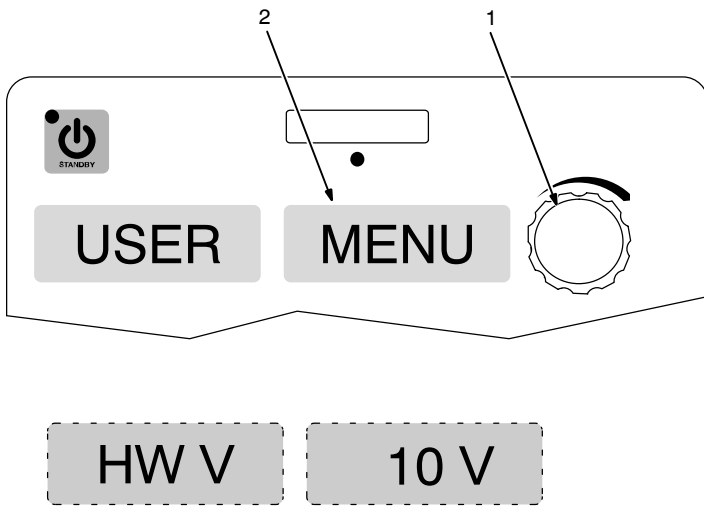
[HWPS] is displayed in the left meter window with the Hot Wire amperage.

Front panel TIG/Stick process and access to parameters for Preflow, Postflow, DIG are disabled.

User menu selections for Arc Starting Method, Tungsten Diameter Selection, and Trigger Mode are not accessible.

Tech Menu selections Stick Stuck, Open Circuit Voltage, and Weld Timers are not accessible.

### 1-2. Hot Wire Voltage



1 Encoder Control  
2 Parameter Display

☞ See Operation section in Owner's Manual for additional information on accessing User Setup Menu.

1 Encoder Control  
2 Parameter Display

Use Encoder control to select Hot Wire Voltage. (Voltage range is 5 – 20 volts. Default voltage is 10 volts.)

The Hot Wire Voltage setting adjusts the threshold above which the power source will shut off the output. The lower the voltage setting the lower the probability of initiating an arc between the wire and the workpiece at wire disconnection. A higher setting may be necessary, especially when AC or pulse welding (depending on circuit inductance). In these cases the unit needs to increase the voltage to drive fast-changing currents. To avoid arcing, this value should be set as low as practical within each circuit setup, but high enough to avoid output on/off oscillations from the higher voltage that may be present during AC or pulsing.

Changes in amperage, circuit configuration (resistance, inductance), Pulse or AC Wave Shape parameters may require a change in Hot Wire Voltage.