parweld
WELDING THE FUTURE

XTI 903W

OPERATOR MANUAL

ISSUE 1

Welcome

Thank you for choosing Parweld. This Owner's Manual is designed to help you get the most out of your Parweld products. Please take time to read the Safety Precautions. They will help you protect yourself against potential hazards in the workplace. With proper maintenance this equipment should provide years of reliable service. All our systems conform to ISO9001: 2015 and are independently audited by NQA.

The entire product range carries the CE and UKCA mark, and is constructed in accordance with European directives and the product specific standards where they apply.

Further Information

Parweld is the UK's leading manufacturer of MIG, TIG and Plasma torches and consumables.

For more information about Parweld's complete range visit: www.parweld.com

Contents

1.0 Safety Precautions

ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on.

Do not touch live electrical parts.

Wear dry, sound insulating gloves and body protection.

Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work ground.

Additional safety precautions are required when any of the following electrically hazardous conditions are present: in damp locations or while wearing wet clothing; on metal structures such as floors, gratings, or scaffolds; when in cramped positions such as sitting, kneeling, or lying; or when there is a high risk of unavoidable or accidental contact with the work piece or ground.

Disconnect input power before installing or servicing this equipment. Lockout/tagout input power according to Safety Standards.

Properly install and ground this equipment according to national and local standards.

Always verify the supply ground - check and ensure that input power cable ground wire is properly connected to ground terminal in the receptacle outlet.

When making input connections, attach a proper grounding conductor first - double-check connections.

Frequently inspect input power cable for damage or bare wiring - replace cable immediately if damaged - bare wiring can kill.

Turn off all equipment when not in use.

Do not use worn, damaged, under sized, or poorly spliced cables.

Do not drape cables over your body.

If earth grounding of the work piece is required, ground it directly with a separate cable.

Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.

Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.

Wear a safety harness if working above floor level.

Keep all panels and covers securely in place.

Clamp work cable with good metal-to-metal contact to work piece or worktable as near the weld as practical.

Insulate work clamp when not connected to work piece to prevent contact with any metal object.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

FUMES AND GASES can be hazardous.

Keep your head out of the fumes. Do not breathe the fumes. If inside, ventilate the area and/or use local forced ventilation at the arc to remove welding fumes and gases.

If ventilation is poor, wear an approved respirator.

Read and understand the Material Safety Data Sheets (MSDS's) and the manufacturer's instructions for metals, consumable, coatings, cleaners, and de-greasers.

Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watch person nearby. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.

Do not weld in locations near de-greasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapours to form highly toxic and irritating gases.

Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.

ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense, visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

Wear an approved welding helmet fitted with a proper shade of filter lense to protect your face and eyes when welding or watching

Wear approved safety glasses with side shields under your helmet.

Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.

Wear protective clothing made from durable, flame resistant material (leather, heavy cotton, or wool) and foot protection. Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot work piece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.

WELDING can cause fire or explosion.

Remove all flammables within 10m of the welding arc. If this is not possible, tightly cover them with approved covers.

Do not weld where flying sparks can strike flammable material.

Protect yourself and others from flying sparks and hot metal.

Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.

Watch for fire, and keep a fire extinguisher nearby. Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.

Do not weld on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to local regulations

Connect work cable to the work as close to the welding area as practical to prevent welding current from travelling along, possibly unknown paths and causing electric shock, sparks, and fire hazards.

Wear oil-free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap. Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding.

FLYING METAL can injure eyes.
Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool they can throw off slag. Wear approved safety glasses with side shields even under your welding helmet.

BUILDUP OF GAS can injure or kill.
Shut off shielding gas supply when not in use. Always ventilate confined spaces or use approved air-supplied respirator.

HOT PARTS can cause severe burns.
Do not touch hot parts with bare hands.

Allow cooling period before working on gun or torch.

To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.

MAGNETIC FIELDS can affect pacemakers.
Pacemaker wearers keep away.

Wearers should consult their doctor before going near arc welding, gouging, or spot welding operations.

NOISE can damage hearing.
Noise from some processes or equipment can damage hearing.

Wear approved ear protection if noise level is high.

Shielding gas cylinders contain gas under high pressure.

CYLINDERS can explode if damaged.
Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs. Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping. Keep cylinders away from any welding or other electrical circuits. Never drape a welding torch over a gas cylinder. Never allow a welding electrode to touch any cylinder. Never weld on a pressurized cylinder - explosion will result. Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.

Turn face away from valve outlet when opening cylinder valve.

Use the right equipment, correct procedures, and sufficient number of persons to lift and move cylinders.

Read and follow instructions on compressed gas cylinders, associated equipment, and Compressed Gas Association (CGA) recommendations.

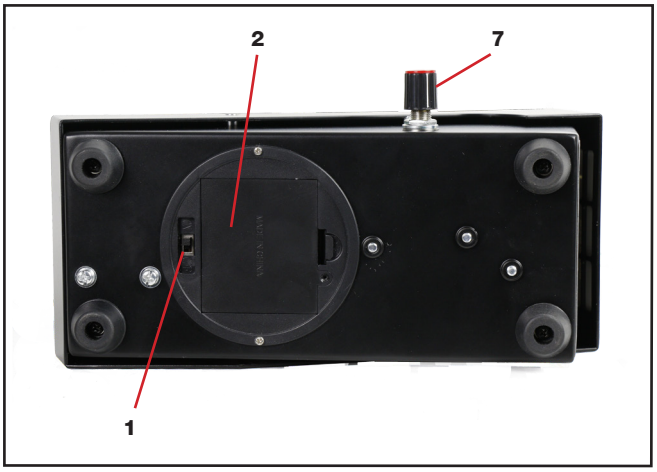
2.0 Product Description

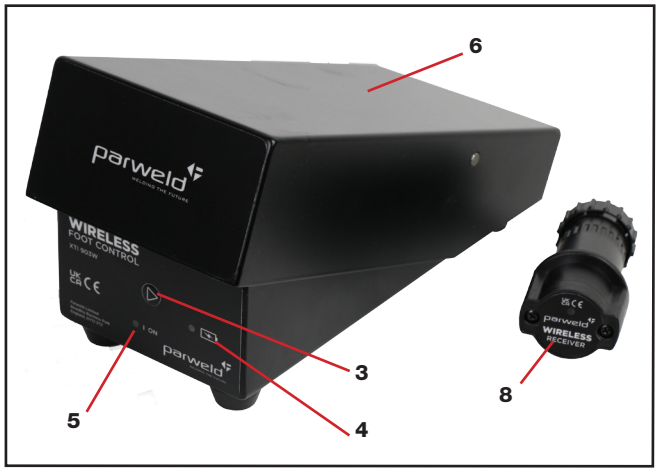
This foot control is designed to give the operator manual control of the welding current through operation of the foot pedal.

3.0 Technical Specifications

	XTI 903W
Battery Type	3x AA Rechargeable
Battery Life	Standby Mode 5 Days Operator Mode 3 Days
Communication Mode	Bluetooth Class 2
Connection Range	10M

Please note that the XTI 903W is only compatible with machines of serial number 2206 or later. Older machines can be upgraded so please contact Parweld for further details.





4.0 Description of Controls

1) On /Off switch

2) Battery Compartment

3) Pairing button

4) Bluetooth indicator/Battery Condition

5) Power On light

6) Moving foot plate.

7) Trimmer control

8) Wireless receiver

5.0 Installation

Read entire installation section before starting installation.

SAFETY PRECAUTIONS

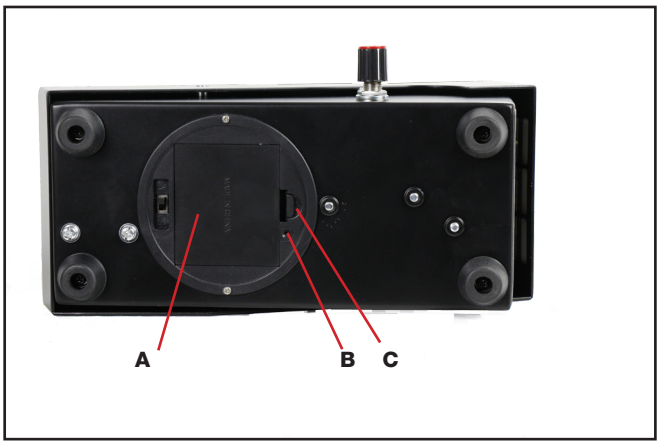
- **ELECTRIC SHOCK can kill.**
- **Only personnel that have read and understood the Operating Manual should install and operate this equipment.**
- **Machine must be grounded per any national, local or other applicable electrical regulations.**
- **The power switch is to be in the OFF position when installing receiver module.**

5.1 Location

Be sure to locate the foot control on a flat stable surface just ahead of where you would normally place you foot

In areas, free from moisture and dust.

Ambient temperature between 0-40^{0}C.



In areas, free from oil, steam and corrosive gases.

In areas, not subjected to abnormal vibration or shock.

In areas not exposed to direct sunlight or rain/water.

5.2 Range

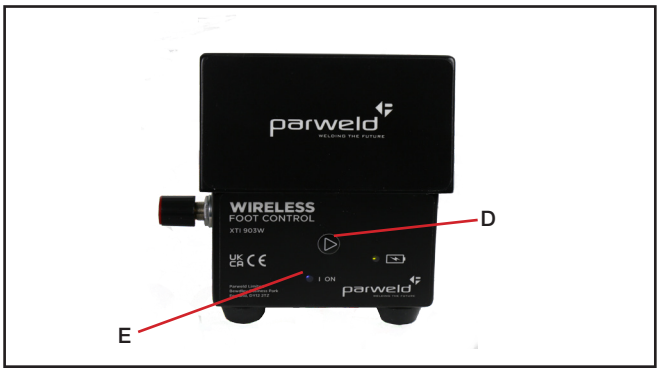
The foot pedal uses Class 2 Bluetooth technology and has an operating range of up to 10m. Obstacles between the transmitter and the receiver can deteriorate the signal. Attenuators can be anything from humidity, walls, windows, and other obstacles made of glass, wood, metal, or concrete, that reflect and scatter radio waves. While radio waves can pass through objects, the amount of attenuation and effective loss varies with the type and density of the obstruction.

5.3 Installing Batteries.

Turn the unit over and remove the small screw (**B**) on the battery cover, and then open the battery cover (**A**) using the finger slot (**C**). Install 3 AA batteries taking care to observe the correct polarity. We recommend the use of rechargeable batteries with a capacity of 2000mAh or higher to give the best operating life and lowest running costs. Refit the battery cover (**A**) and screw (**B**).

5.4 Connecting

Fit the wireless receiver into the control socket on the front of the welding machine ensuring the keyway in the plug is located before pushing it home and securing with the hand nut. Switch on the foot control using the switch on the base. This must be done before powering up the Bluetooth receiver.



The Green power light on the foot control should illuminate, if not check battery condition and ensure they are correctly inserted. Switch on the power source and the light on the end of the receiver should illuminate. If it fails to illuminate ensure the receiver is correctly inserted into the socket on the machine.

Note:- On certain models of machine it is necessary to put the control panel in the **remote** operation mode using a selector switch on the front panel of the machine or through the machine help menu.

5.5 Pairing

The foot control should be already paired to the receiver this can be confirmed by pressing down on the foot pedal, if not already on the Bluetooth indicator light should come on solid blue, the control is ready to use. If the Blue light is flashing either the receiver is not powered on, bluetooth is out of range or the unit needs to be paired. Check the receiver is powered on and the foot control is within range before attempting to pair the devices.

Pairing, ensure all other wireless receivers in the local area are switched off. Press the pairing button (**D**) on the end of the foot control for 3 seconds and release. The control will now go into pairing mode and once it has established a connection with the receiver the blue light (**E**) will stop flashing and turn solid blue. Once paired there should be no need to repair the unit even if it has been powered off.

6.0 Operation

WARNING

When using an open arc process, it is necessary to use correct eye, head, and body protection.

6.1

If your machine is a multiprocess model with LCD panel ensure the control mode is set to foot control in the help menu.

1. Ensure the foot control is switched on before powering up the Bluetooth receiver.

2. Use the trimmer on the side of the foot control to limit the maximum welding current you wish to use.

3. To start welding press the foot control until the pre-gas and then HF start. Allow the arc to establish and then increase the current by depressing the pedal until you reach the required level.

4. To stop welding remove pressure on the pedal and the amps will reduce until the switch is operated which will switch off the arc and start any preprogrammed post gas flow.

5. After use switch off the Foot Control using the on/off switch at the base

6.2 Sleep Mode

After 10 minutes of inactivity the foot control will enter sleep mode. The power light will remain on but the bluetooth light will go out. To wake up the control simply depress the pedal briefly and release. The control will wake up and re establish bluetooth connection and be ready for use.

7.0 ROUTINE MAINTENANCE

The only routine maintenance required for the foot switch is a thorough cleaning and inspection, with the frequency depending on the usage and the operating environment.

1. **Disconnect from the welding machine**
2. **Blow out the inside with low pressure compressed air ensuring to wear goggles.**

7.1 Fault Finding

Fault	Remedy
Blue light does not come on even after foot control is depressed or pairing button operated	Ensure power switch is in the ON position, in the base of foot control Ensure Green light is on on the foot Control Check and replace batteries
Amps won't change as the foot control is engaged	Ensure that the foot control is powered up before the receiver. Turn off the power source or disconnect the receiver before trying again.
Blue light flashes	Ensure receiver is connected and powered on (yellow light on the end of the receiver should be on)
Foot control operates but power source does not respond	Check yellow light on receiver is flashing when the foot control is operated, if not move foot control closer to the receiver Re-establish the bluetooth connection between the foot control and receiver. Ensure the machine is compatible with Wireless receiver. (Check serial number as per table in section 3.0 on page 5)

8.0 EC Declaration of Conformity

Hereby we declare that the machines as stated below

Type: XTI 903W

Conform to the Low Voltage Directive: 2014/35/EEC
EMC Directive 2014/35/EEC

European standard: EN/IEC 60974-1

This is to certify that the tested sample is in conformity with all provisions of the above detailed EU directives and product standards.

8.1 RoHS Compliance Declaration

Directive 2011/65/EU of the European Parliament
Amended 2015/863 and 2017/2102

Restriction of use of certain hazardous substances in electrical and electronic equipment

Type: XTI 903W
The above listed products are certified to be compliant with the RoHS directive with all homogeneous component parts being controlled to ensure material contents as per the list below.

Cadmium 0.01% by weight
Lead 0.1% by weight
Mercury 0.1% by weight
Hexavalent chromium 0.1% by weight
Polybrominated biphenyl's (pbbs) 0.1% by weight
Polybrominated diphenyl ethers (pbdes) 0.1% by weight

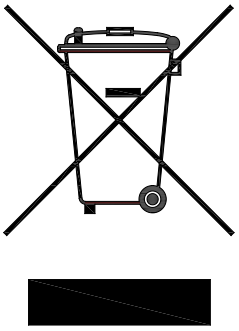
It should be noted that under specific exempted applications, where lead is used as an alloying element the following limits are applied in accordance with the regulations.

Copper and copper alloy parts use less than 4% by weight of each homogeneous component.

Steel and steel alloy parts use less than 4% by weight of each homogeneous component.

Aluminium and aluminium alloy parts use less than 4% by weight of each homogeneous component.

8.2 WEEE Statement



Only dispose off in authorised sites for electrical and electronic waste do not dispose of with general refuse or landfill waste.

WEEE (Waste Electrical & Electronic Equipment) 2012/19/EU

In relation to implementing the legislation, Parweld has established relevant recycling and recovery methods. We have been fully compliant against the marking requirements since August 2005. Parweld is registered in the UK with the Environment agency as detailed below. For WEE compliance outside the UK please contact your supplier/Importer

Parweld is registered with a compliance scheme Official registration number is WEE/FD0255QV

When your equipment reaches the end of its service life you should return it to Parweld where it will be reconditioned or processed for recycling.

8.3 Statement of Warranty

Limited Warranty:

Parweld Ltd, hereafter, “Parweld” warrants its customers that its products will be free of defects in workmanship or material. Should any failure to conform to this warranty appear within the time period applicable to the Parweld products as stated below, Parweld shall, upon notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with Parweld’s specifications, instructions, recommendations and recognized standard industry practice, and not subject to misuse, repair, neglect, alteration, or accident, correct such defects by suitable repair or replacement, at Parweld’s sole option, of any components or parts of the product determined by Parweld to be defective.

Parweld makes no other warranty, express or implied. This warranty is exclusive and in lieu of all others, including, but not limited to any warranty of merchantability or fitness for any particular purpose.

Limitation of Liability:

Parweld shall not under any circumstances be liable for special, indirect or consequential damages, such as, but not limited to, lost profits and business interruption. The remedies of the purchaser set forth herein are exclusive and the liability of Parweld with respect to any contract, or anything done in connection therewith such as the performance or breach thereof, or from the manufacture, sale, delivery, resale, or use of any goods covered by or furnished by Parweld whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not, except as expressly provided herein, exceed the price of the goods upon which such liability is based. No employee, agent, or representative of Parweld is authorized to change this warranty in any way or grant any other warranty.

Purchaser’s rights under this warranty are void if replacement parts or accessories are used which in Parweld’s sole judgement may impair the safety or performance of any Parweld product.

Purchaser’s rights under this warranty are void if the product is sold to purchaser by non-authorized persons.

The warranty is effective for the time stated below beginning on the date that the authorized Distributor delivers the products to the purchaser. Notwithstanding the foregoing, in no event shall the warranty period extend more than the time stated plus one year from the date Parweld delivered the product to the authorized distributor.

Parweld Limited
Bewdley Business Park
Long Bank
Bewdley
Worcestershire
England
DY12 2TZ

tel. +44 1299 266800
fax. +44 1299 266900

www.parweld.com
info@parweld.co.uk