# Operating instructions

TIG welding equipment

**ENESKAimpulse 230**

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# 1 Introduction

## 1.1 Foreword

Dear customer, thank you for supporting the joke brand.

By purchasing an joke TIG welding system you are making an investment in your business and ensuring the delivery of quality welding projects.

joke TIG welding machines are German made. Ensuring the right solution for our industry, backed by only the highest quality components.

At joke we aim to ignite the future of welding by connecting the Smart + Simple and we thank you for the confidence you have placed in our products.

To enable a long service life even under the toughest conditions all joke equipment is manufactured using only parts that comply with our strict quality demands.

The ENESKAimpulse has been developed and designed with technology and safe operation in mind. All relevant legal regulations have been observed and complied with. Conformity is declared and is marked with the CE symbol.

joke welding systems are manufactured in Germany and therefore bear the "Made in Germany" quality label.

At joke we have the passion to elevate the future of our industry.

Building trust and partnering with our customers to deliver the result, achieved through innovative, efficient and turnkey welding solutions.

We never compromise on quality and provide certainty through simplicity.

## 1.2 General description

**Fig.1** ENESKAimpulse

### 1.2.1 Principle of the TIG welding process

In TIG welding the arc burns freely between a tungsten electrode and the workpiece. The inert gas is a noble gas such as argon, helium or a mixture of these.

One pole of the power source is connected to the tungsten electrode, the other to the workpiece. The electrode is the current conductor and arc carrier (continuous electrode). The filler material is introduced in the form of a rod or wire by hand or a separate cold wire feed unit. The tungsten electrode, the weld pool and the molten end of the filler material are protected against the ingress of atmospheric oxygen by inert shielding gas that escapes from the protective gas nozzle arranged concentrically around the electrode.

### 1.2.2 Scope of application of TIG welding equipment

ENESKAimpulse DC welding machines are DC sources. They are suitable for welding all carbon and alloy steels, stainless steels and non-ferrous metals.

ENESKAimpulse AC/DC welding machines are AC and DC sources. They can be used for processing all carbon and alloy steels, stainless steels, non-ferrous metals, aluminium and aluminium alloys.

### 1.2.3 Intended use

ENESKAimpulse welding machines may be used only for TIG welding as intended.

joke welding devices are designed for welding various different metallic materials such as unalloyed and alloyed steels, stainless steels, copper, titanium and aluminium.
Please also observe the special rules that apply to your applications.

joke welding machines are designed for use in hand-held and machine-guided operation.

joke welding machines are, except when this is expressly stated in writing by joke, only for sale to commercial / industrial users and are only intended to be used by commercial / industrial users. The machines may only be operated by persons who trained in the use and maintenance of welding equipment.

Welding power sources may not be installed in areas with increased electrical risk.

This manual contains rules and guidelines for the intended use of your system.
Only compliance with these guidelines shall be considered as proper use. Risks and damages incurred due to any other use is the responsibility of the operator. Use under special requirements may necessitate the observance of particular regulations.

If in doubt, ask your competent safety officer or contact the joke customer service department.

The special instructions listed in the supplier documentation for intended use must be observed.

National regulations also apply without restriction to the operation of the system.

Welding power sources may not be used to defrost pipes.

Intended use also includes compliance with the prescribed assembly, disassembly and reassembly, commissioning, use, maintenance and disposal measures. Please make particular note of the information in Section 2 Safety information and Section 15.4 Proper disposal.

The system may only be operated under the aforementioned conditions. Any other use is considered unintended use. The consequences of unintended use rests with the operator.

## 1.3 Symbols used

**Typographic distinctions**

- Enumerations proceeded by a bullet point: General enumerations

❒ Enumerations proceeded by a square: Work or maintenance steps that must be performed in the order listed.

➔ **Section 2.2, Warning symbols on the system**
Cross-reference: Here to Section 2.2 Warning symbols on the **system**, warning symbols on the system

**Bold text** is used for emphasis

**Note!**

**... indicates practical tips and other particularly useful information.**

**Safety symbols**

The safety symbols used in this manual:➔ **Section 2.1**

# 2 Safety information

## 2.1 Warning symbols in these operating instructions

**Warnings and symbols**

**This or a symbol that more accurately specifies the risk can be found in all of the safety instructions given in these operating instructions where there is danger to life and limb.**

**One of the signal words below (Danger!, Warning!, Caution!) is used to indicate the severity of the risk:**

**Danger! …warning of immediate danger.**

**Death or serious injury may result if the warning if not heeded.**

**Warning! ... of a potentially dangerous situation.**

**Death or serious injury may result if the warning is not heeded.**

**Caution! … warns of a potentially harmful situation.**

**Slight or minor injuries or property damage may result if the warning is not heeded.**

**Important!**

**Notice of a potentially harmful situation. The product or an object in the vicinity may be damaged if the warning is not heeded.**

**Materials that are hazardous to health or the environment. Materials/operating materials that must be handled or disposed of in a legally conformant way.**

## 2.2 Warning symbols on the system

identify hazards and hazards on the system.

**Danger!**

**Risk of electrical shock!**

**Non-observance mas result in death or injury.**

## 2.3 Notes and requirements

**Hazards of non-compliance**

The system was developed and designed by the generally accepted rules of technology.

Nevertheless, residual dangers to the life and limb of the operator or the risk of damage to the system or other property may still arise in the use of the system.

Safety equipment must never be dismantled or put out of operation as this will result in dangerous hazards and the intended use of the system is no longer guaranteed. The dismantling of safety devices for equipping, repairing and maintenance is described in detail. The safety devices must be refitted immediately on completion of such work.

When using external aids and agents (for example, solvents for cleaning) the user of the system is responsible for ensuring the safety of the unit.

All safety instructions and warnings and the nameplate on / near the system must be kept visible and legible.

**Safety instruction**

The occupational safety and health regulations serve as safety references. They must be observed.

The special safety instructions given in the main text must also be observed in addition to the safety instructions given in this section.

Beside the advice given in these operating instructions, the general safety and accident prevention regulations (in Germany, among others UVV BGV A3, TRBS 2131 and BGR 500 Chapter 2:26 (previously VGB 15) "Welding, cutting and allied processes" and particularly the conditions for arc welding and cutting contained therein or the corresponding national regulations) must be observed.

Also observe the safety information signs on the factory floor of the operator.

**Applications**

joke welding machines are, except when this is expressly stated in writing by joke, only for sale to commercial / industrial users and are only intended to be used by commercial / industrial users.
ENESKAimpulse TIG inert gas welding systems may only be used

- as intended
- in an absolutely perfect condition

ENESKAimpulse inert gas welding equipment is designed in accordance with EN 60974-1 Arc welding equipment - welding power sources for overvoltage category III and pollution degree 3 and in accordance with EN 60974-10 Arc welding equipment - electromagnetic compatibility (EMC) for Group 2 Class A and should be suitable for use in all areas, except residential areas that are connected directly to a public low-voltage supply system. It may possibly be difficult to ensure electromagnetic compatibility in these areas due to both conducted and radiated interference. For this purpose the use of appropriate measures to meet the requirements (filters for mains connection, shields such as shielded cables, the shortest possible welding cables, earthing of the workpiece, potential equalization) and assessment of the environment (such as computers, controllers, radio and television broadcasters, adjacent people, for example required in the use of cardiac pacemakers) are required. The responsibility for any fault lies with the user. For more information and recommendations, see, inter alia, DIN EN60974-10: 2008-09, Annex A.

**Environmental conditions**

Operation and storage of the unit outside the specified range is considered to be improper. The manufacturer is not liable for any resulting damage.

Ambient air temperature range:

- In operation: -10°C to +40°C (14 °F to 104 °F)
- During transport and storage: -20°C to +55°C (-4 °F to 131 °F)

Relative humidity:

- to 50% at 40°C (104 °F)
- to 90% at 20°C (68 °F)

Ambient air:

Free of unusual amounts of dust, acids, corrosive gases or substances, etc., unless they are produced during welding.

Altitude above sea level: Up to 2000m (6500 ft)

**Requirements on the mains supply**

The unit may be connected and operated from a single phase 2-wire system with earthed neutral conductor.

For **ENESKAimpulse 230 AC/DC**
The unit complies with IEC61000-3-12.

**Qualification of the operating personnel**

joke welding equipment should be operated only by persons who are trained and instructed in the use and maintenance of welding equipment. Only qualified, assigned and trained personnel may work on and with the system.

**Purpose of the document**

These operating instructions contain important information on how this unit can be operated safely, properly and economically. A copy of the operating instructions must be constantly at hand in a suitable place at the site of use of the system. Before using the system be sure to read the information compiled in these operating instructions. These include important instructions on use of the equipment that enable the full technical advantages of the Joke equipment to be exploited. See also the information on repair and maintenance, operating safety and functional reliability.

These operating instructions are not a substitute for the practical teaching by the joke service personnel.

Documentation for any additional operation that may be present must also be observed.

**Changes to the system**

Changes to the system or the mounting or incorporation of additional equipment is not permitted. Doing so will invalidate any warranty and liability claims.

Third-party intervention and putting out of operation of safety devices invalidates all warranty claims.

# 3 Unit description

**ENESKAimpulse - without water cooling**


**Fig.2 Unit description**

| No. | Symbol | Function / description |
|---|---|---|
| 1 | | Control panel - See "Description of controls" |
| 2 | | Control panel push and rotary encoder |
| 3 |  | Shielding gas connection - TIG welding torch |
| 4 |  | Current socket "negative"<br>TIG: TIG welding torch<br>Electrode: Workpiece |
| 5 |  | Torch / remote control jack |
| 6 |  | Current socket "positive"<br>TIG: workpiece |
| 7 | | Cooling air inlet |
| 8 | | Main switch - On / Off |
| 9 | | Power cable |
| 10 |  | Shield gas feed connection - shield gas cylinder |

**Table 1 Equipment labelling on the front and back**

# 4 Function description

## 4.1 Overview of the operating panel


**Fig.3 ENESKAimpulse operating panel**

## 4.2 Operation description

### 4.2.1 Controls

<table>
<tr><th>Controls</th><th>Function</th></tr>
<tr><td> 

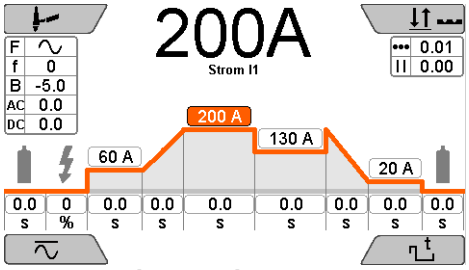
Fig.4 Quick program buttons</td><td>Quick program buttons P1-P4</td></tr>
<tr><td> 

Fig.5 Main screen</td><td>Main screen<br><br>Operation via rotary encoder with push-knob and buttons for menu selection in the 4 corners of the screen</td></tr>
<tr><td>  <br>Fig.6 Function buttons</td><td>Function buttons (from left to right)
<table>
<tr><td>Button</td><td>Submenu “Submenu”</td><td>List of all submenus</td></tr>
<tr><td>Button</td><td>Main screen “Home”</td><td>Jumps directly to the first screen page</td></tr>
<tr><td>Button</td><td>Back “Back”</td><td>Always jumps back one level</td></tr>
</table></td></tr>
<tr><td>  <br>Fig.7 Corner function buttons</td><td>Corner menu selection buttons<br><br>Direct menu buttons for the selection menus located in the 4 screen corners; arranged around the rotary encoder.</td></tr>
<tr><td>  <br>Fig.8 Push and rotary encoder</td><td>Rotary encoder with push-knob<br><br>Moves the pointer (cursor) on the screen clockwise or counter clockwise. Positions reached are highlighted in colour and are activated by pressing the rotary encoder knob.</td></tr>
</table>

### 4.2.2 Operating functions

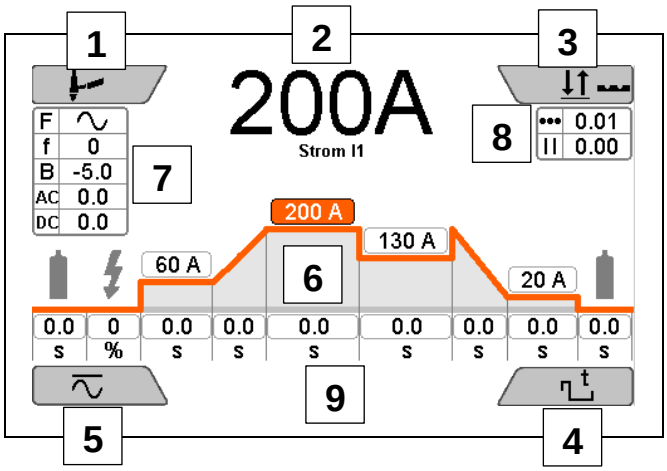
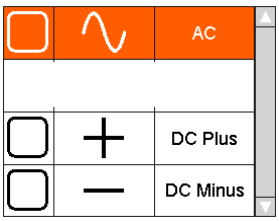
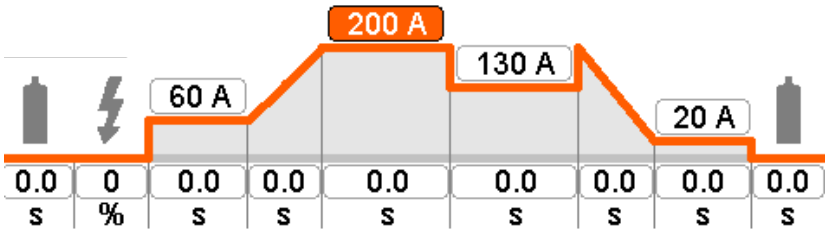
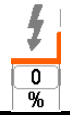
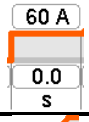
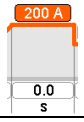



**Fig.9 Screen functions**

| No. | Symbols | Description / function | AC/DC | | | |
|---|---|---|---|---|---|---|
| **BF1** | | **Corner menu welding processes** | | | | |
| | | TIG welding | ✓ | | | |
| | | | | | | |
| | | | | | | |
| **BF2** | | **Main display panel with function text**<br>200A<br>Strom I1 | ✓ | | | |
| **BF3** | | **Corner menu operating modes**<br>HF<br>HF<br>LiftArc<br>LiftArc<br>HF | | | | |
| | | 2 cycle: LiftArc or with HF ignition | ✓ | | | |
| | | 4 cycle: LiftArc or with HF ignition | ✓ | | | |
| | | Spot welding with HF | ✓ | | | |
| | | Interval with HF | ✓ | | | |
| **BF4** | | **Corner menu pulse**<br>Pulse off<br>HyperPuls | | | | |

| No. | Symbols | Description / function | AC/DC | | | |
|---|---|---|---|---|---|---|
| | | Pulse off | ✓ | | | |
| | | | ✓ | | | |
| | f | High-frequency pulse (hyper pulse) | ✓ | | | |
| **BF5** | | **Corner menu polarity**<br>  | | | | |
| | | Alternating current (AC) | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | — | DC negative pole (DC-) | ✓ | | | |
| **BF6** | | **TIG welding parameter curve** | | | | |
| | |  <br>The following shows the setting possibilities from left to right | | | | |
| |  | Gas pre-flow time | ✓ | | | |
| |  | Ignition power | ✓ | | | |
| |  | Starting current and starting current time | ✓ | | | |
| |  | Slope-up time | ✓ | | | |
| |  | Welding current I1 and hyperpulse frequency | ✓ | | | |

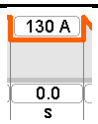
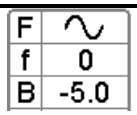
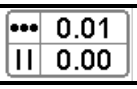
| No. | Symbols | Description / function | Smart AC/DC | Smart DC | Edge AC/DC | Edge DC |
|---|---|---|---|---|---|---|
| |  | Welding current I2 and hyperpulse frequency | ✓ | | | |
| |  | Slope-down time | ✓ | | | |
| |  | End-crater current<br>End-crater current time | ✓<br>✓ | | | |
| |  | Gas post flow time | ✓ | | | |
| **BF7** | | **Menu AC settings** | | | | |
| |  | **F** AC waveform (adjustable)<br>**f** AC frequency (adjustable)<br>**B** AC balance (adjustable) | All<br>✓<br>✓ | | | |
| **BF8** | | **Menu spot welding and interval** | | | | |
| |  | Spot time<br>Pause time (only in interval mode) | ✓<br>✓ | | | |
| **BF9** | | **Status line** | ✓ | | | |

**Table 2 Operating panel main screen**

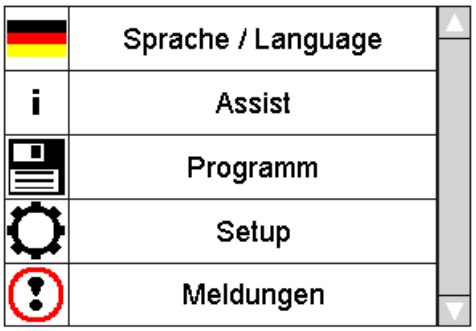
| No. | Symbols | Description / function | Smart AC/DC | Smart DC | Edge AC/DC | Edge DC |
|---|---|---|---|---|---|---|
| **BF10** |  | **Sub menu buttons** | ✓ | ✓ | ✓ | ✓ |
| | |  | | | | |
| **BF11** |  | Back button “Home” and “Back” | ✓ | ✓ | ✓ | ✓ |
| **BF12** | i | Function Assist see Chap. 7.2 | ✓ | ✓ | – | – |
| **BF13** | | Function program (Jobs) see Chap. 7.3 | ✓ | ✓ | – | – |
| **BF14** | | Settings (Setup) see Chap. 8 | ✓ | ✓ | ✓ | ✓ |
| **BF15** | | Error message see Chap. 9 and 14.3 | ✓ | ✓ | ✓ | ✓ |
| | | | | | | |
| **BF16** | | Left in the status line: Operating and temperature displays | ✓ | ✓ | ✓ | ✓ |
| **BF17** | | Right in the status line: Remote control display | ✓ | ✓ | ✓ | ✓ |

**Table 3 Other control functions and submenus**

## 4.3 Switch on

The ENESKAimpulse welding system is started with the mains switch. The screen shows the joke logo and the unit type for approximately 10 seconds. The display then switches to the main screen [**Fig.5 Main screen**. The last active welding parameters are set. The unit is then ready for operation.

## 4.4 Peculiarities of the operating panel

The processor control provides active support to facilitate faster and easier operation:

All set parameters are saved when the unit is switched off. When the unit is switched back on the stored parameters are automatically activated. An arc must be struck for any changes to the parameters to be saved when the unit is switched off.

The currently set parameters and settings are always displayed.

If the rotary encoder [**Fig.8**] or button is not actuated for 20 seconds, then the unit returns automatically to welding current I1. The basic state therefore always displays the most important values; current I1 and the same starting position when operating.

# 5 Corner menu functions

## 5.1 Corner menu welding processes (top left)

The corner menu [BF1] is used to select the welding processes

- TIG welding

Turning and pressing the rotary encoder [**Fig.8**] selects and confirms the process. Pressing the button [**Fig.6**] "Back" or "joke" returns to the main screen [**Fig.5**].

The setting of the welding parameters for TIG welding is performed as described in Section 6, Parameter settings.

## 5.2 Corner menu operating mode (top right)

The menu Operating modes [BF3] is activated by pressing the button at the top right of the keypad **Fig.8**. This allows the selection of the operating modes

1. 2 cycle with HF ignition (see Section 5.3)
2. 4 cycle with HF ignition (see Section 5.3)
3. 2 cycle without HF LiftArc
4. 4 cycle without HF LiftArc
5. Spot
6. Interval

.
Functions may be limited depending of the equipment features.

### 5.2.1 2 cycle operating mode

The 2 cycle mode is recommended for fast, controlled tacking and manual spot welding.

- 1. cycle: Actuate the torch trigger

The protective gas solenoid valve opens
After the set gas pre-flow time has expired the arc is ignited
The welding current automatically adjusts to the selected slope-up time, starting from the set starting current and rising to the preselected value for $I_1$.

- 2. cycle: Release the torch trigger

The current reduces to the set end crater value at the preselected current slope-down time and then automatically switches off.
The inert gas flow is according to the selected gas post-flow value.

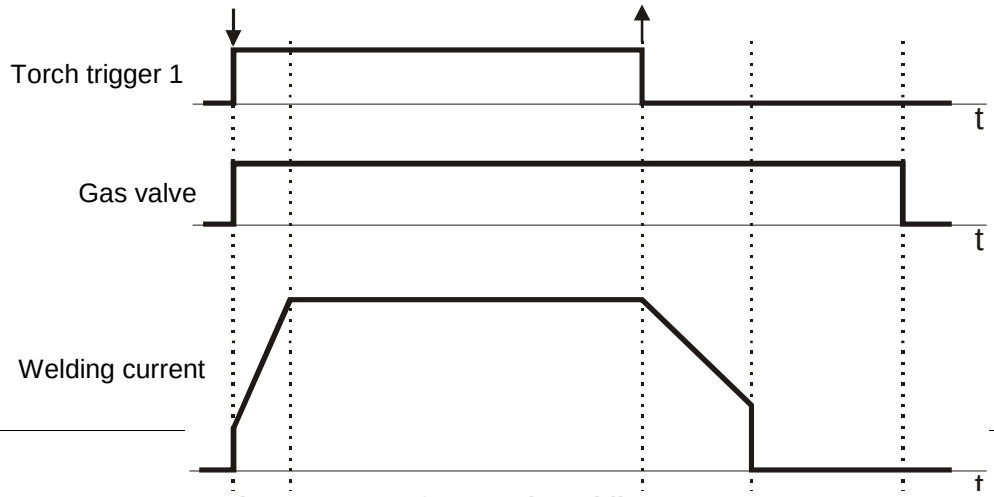



**Fig.10 Process for 2 cycle welding**

Peculiarities:

to the 2nd cycle Actuating the torch trigger a second time during slope-down of the welding current jumps the welding current back to $I_1$. This process is also known as manual pulsing (see Section 6.1.8). Actuating the torch trigger 2 (BT2) extinguishes the arc.

### 5.2.2 4 cycle operating mode

In the 4 cycle operating mode the need to permanently actuate the trigger is omitted, enabling the torch to be guided for a longer period without fatigue.

Sequence of the 4 cycle operating mode:

- 1. cycle – operate the torch trigger

The protective gas solenoid valve opens
After the set gas pre-flow time has expired the arc is ignited
The welding current is at the value set for the starting current

- 2. cycle: Release the torch trigger

The welding current automatically reaches the preset values for $I_1$ after the selected slope-up time.

- 3. cycle: Actuate the torch trigger

The current reduces to the set end crater value at the preselected current slope-down time.
The welding current flow is at the set end crater value

- 4. cycle: Release the torch trigger

The arc extinguishes
The inert gas flow is according to the selected gas post-flow value.

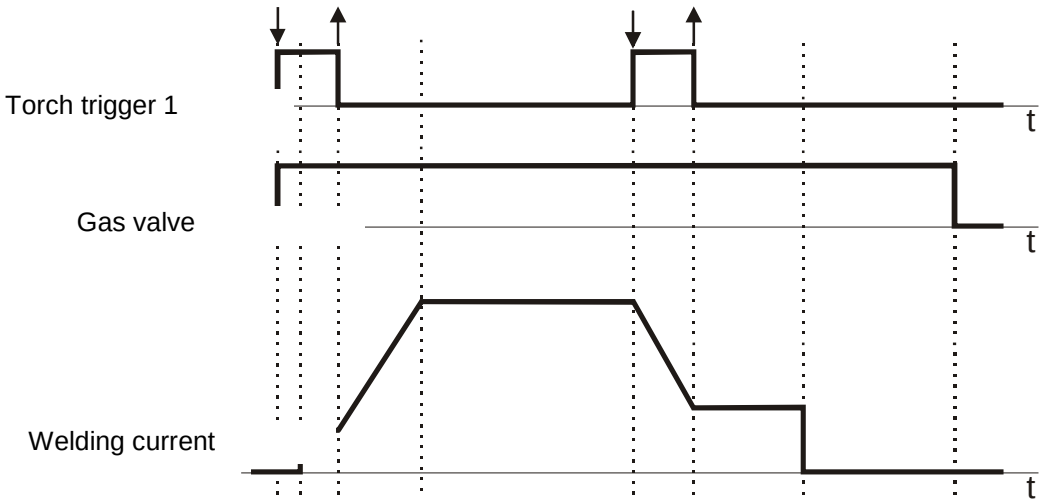



**Fig.11 Process for 4 cycle welding**

to the 2nd cycle Actuating the torch trigger a second time during slope-up of the current extinguishes the arc and the protective gas continues to flow according to the selected gas post-flow time.

to the 3rd Cycle The arc can be switched off during the slope-down period. Releasing the torch trigger before reaching the end crater current extinguishes the arc and the protective gas continues to flow for the set post flow time.

### 5.2.3 TIG spot welding

The spot welding mode is recommended for welding with a fixed spot welding time from 0.01 seconds.

The stationary welding process runs with a fixed spot welding time, unless the trigger is released prematurely during the welding.

The program runs to the end after expiry of the set spot welding time or after releasing the torch trigger during the welding.

The lower heat input into the materials being welded enables TIG welding with low distortion and only slight discolouration.

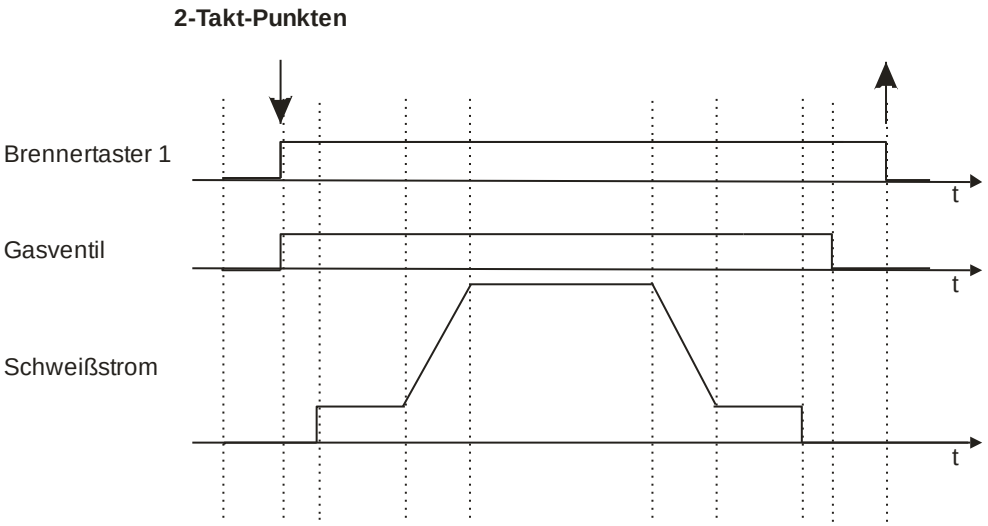



**Fig.12 TIG spot welding**

- 1. cycle Operate the torch trigger

The set gas pre-flow time expires, the gas valve opens. After the gas pre-flow time has expired the arc is ignited. The welding current automatically adjusts to the starting current. After expiration of the current slope-up time the welding current reaches the preselected value I1. The set spot welding time expires. After the spot welding time expires the current reduces according to the preselected slope-down time to the value set for the end crater current and automatically switches off after expiry of the end current time.

- 2. cycle Release the torch trigger

The inert gas flow is in accordance with the selected gas post-flow value.

### 5.2.4 TIG interval

Interval welding is defined as spot welding with defined pause times. This makes possible the application of the thinnest filler material.
Interval welding is only possible in the 2 cycle operating mode.
Welding in the interval welding mode is recommended for welding with a fixed break welding time from 0.01 seconds.

In TIG interval mode the pause time between the single intervals can be adjusted and the cooling of the base material guaranteed, which means less warpage.

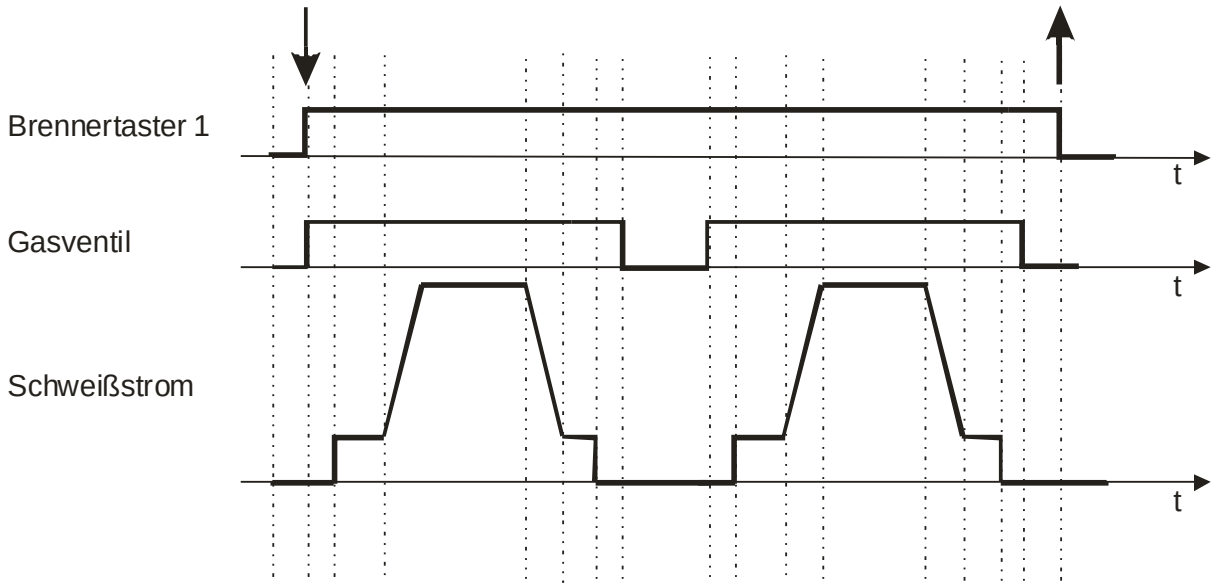



**Fig.13 Process for 2 cycle interval**

- 1 cycle: Actuate the torch trigger

  The set gas pre-flow time expires, the gas valve opens. After the gas pre-flow time has expired the arc is ignited.
  The welding current automatically adjusts to the starting current. After expiration of the current slope-up time the welding current reaches the preselected value I1. The set interval welding time expires.
  After the interval welding time expires the current reduces according to the preselected slope-down time to the value set for the end crater current and automatically switches off after expiry of the end current time, i.e. the welding current goes to 0A. The inert gas flow is according to the chosen gas post-flow time, and the pause time.
  The welding current then reverts to the preselected starting current and the welding process continues as described.

- 2 cycle: Release the torch trigger

  Interval welding ceases.

## 5.3 High-frequency (HF) ignition

The corner button operating modes [BF3] is used to activate the 2 and 4 cycle processes with HF ignition.

### 5.3.1 Welding with HF ignition

joke TIG welding machines are equipped with RF igniter.

HF ignition makes contact-free ignition of the arc between the electrode and workpiece through pre-ionization of the air gap for DC and AC welding possible, whereby tungsten inclusions and therefore welding defects are prevented. In either case, the HF ignition unit is automatically switched off again after ignition. Re-ignition of the arc described in Section 6.2.2 when AC welding is performed

without using the HF ignition unit. This reduces the electrical noise emission and even enables AC welding without HF ignition, as is already known for DC welding (see Section 5.3.2).

The HF igniter is operational when set to RF On "↯". To ignite the arc, the electrode is kept approx. 3-5 mm above the workpiece. By actuating the torch trigger the path is ionized by a high-voltage pulse and arcing occurs. Contactless ignition enables the prevention of tungsten inclusions in the welded seam. When welding the HF ignition is automatically switched off after ignition.

### 5.3.2 Welding without HF ignition

When welding with direct or alternating current contact ignition (LiftArc ) can be used. For this the high frequency is turned off. To ignite the arc, the electrode is placed on the workpiece and the torch trigger actuated. On lifting the electrode the arc program-controlled ignition takes place without wear occurring to the pointed electrode. This option can be used to advantage when working on sensitive electronic devices (for example, in hospitals, repair welding on CNC machines), where there is the risk of interference originating from high voltage pulses.

## 5.4 Corner menu welding process (bottom right)

The corner menu welding process [BF4] is used to select:

- Hyper-Pulsen®
- Pulse off

### 5.4.1 Hyper pulses

**Pulses with a pulse frequency of 10 Hz to 15 kHz.**

The flow of the welding current is the same as conventional pulsing. However, the periods during which current I1 and I2 are active are always the same. As this period is very small a description with pulse frequency is expedient and customary.

The following correlations apply for the conversion of the pulse frequency for the each of pulse time t1 and t2:

Total pulse time = I1 pulse time t1 + I2-pulse time t2 = 1 / pulse frequency
I1 pulse time t1 = I2-pulse time t2 = 0.5 * total pulse time

Example:

Pulse frequency = 50 Hz

Total pulse time= I1 pulse time t1 + I2-pulse time t2 = 1 / 50 Hz = 20 ms = 0.02 s

I1-pulse time t1 = 0.5 * total pulse time = 0.01s

I2-pulse time t2 = 0.5 * total pulse time = 0.01s

This means that the current when welding has the value current I1 for 0.01 s (= 10 ms), then for 0.01 s (= 10 ms) the value current I2, then once again for 0.01 s (= 10 ms) the value current I1, etc.

Pulses of such short duration bring about a more narrow and concentrated arc and deeper penetration.

## 5.5 Corner menu polarity (bottom left)

The bottom left corner button (**Fig.7 Corner function buttons**), is used to select the polarity:

| | |
|---|---|
| • Alternating current (AC) | ∿ |
| | |
| | |
| • DC negative pole | — |

After exiting the menu, the selected polarity is displayed in the corner button field 5,**Fig.9**.

When electrode welding it must be noted that on all ENESKAimpulse DC welding systems the left output socket is always negative.
Insert the electrode holder in the output socket in accordance with the electrode manufacturer's instructions and adjust.

### 5.5.1 Alternating current (~)

When AC welding the polarity at the output terminals is constantly changing back and forth between positive and negative polarity. When TIG welding the torch is normally connected to the left output socket. The use of alternating current enables the welding of aluminium and aluminium alloys.

DC negative pole (-)

In TIG welding with negative pole the negative pole is applied to the left output socket for the TIG torch. TIG welding with direct current is usually welded with this set-up.

# 6 Parameter settings

The selection and processing of the welding parameters is carried out for the most part directly in the illustrated welding wave using the push and rotate encoder [**Fig.8**].
The representation and setting options depend on the device type and the preselected welding process.

The default position of the cursor (pointer) is the current value I1. The cursor automatically jumps to this position if it is not actuated for a short time.

The cursor can be moved clockwise or counter clockwise. The main display always shows the value and function of the cursor position.

## 6.1 Setting the TIG welding parameters

For processing, a parameter field is activated by rotating the rotary encoder [BF5] to the adjustable value field [parameter field] in the screen display and activating this field by pressing the encoder. The background colour of the field changes (is highlighted).

If the parameter field is active, the set value appears as a large display in the main display field [BF2]**Fig.9** item 2 of the screen.
In addition, a bar display appears in the status field **Fig.9** item 9, which shows the set value in the permissible value range.

Below the welding parameters are detailed in the order according to the parameter curve TIG welding [BF6].

### 6.1.1 Gas pre-flow time

The gas pre-flow time is the period of time after activating the torch trigger of torch to start the welding process and the opening of the protective gas valve before the arc is ignited. Then the arc is ignited in the protective gas mantle, whereby the electrode and the workpiece is protected from burning out.

If the welding process is restarted during the gas post flow time, then the gas pre-flow time is automatically set to 0 seconds by the processor control. This speeds up the reignition, which helps to save time.

### 6.1.2 Ignition power

The ignition energy can be infinitely adjusted between 10 and 100% when igniting for high-frequency or LiftArc.

The processor control always sets a preselection for the required ignition process irrespective of the value selected for ignition energy.
This preselection can be adapted to the particular electrode (type and diameter) and the respective welding task by adjusting the ignition energy.

A low ignition energy should be selected when welding thin material and with small electrode diameters.

With AC welding systems from an ignition energy setting of 90% a “power ignition” is performed, whereby ignition is facilitated in harsh environments.

### 6.1.3 Starting current

The starting current is the welding current that is first set after the ignition process. The setting is infinitely variable between 10% and 200% of the selected welding and pulse current $I_1$.
The value range is limited by the maximum unit flow.

Example: Start current 40% and welding current $I_1$ 100A
results in a start current of 40A.

The adjustment of the starting current allows:

- A reduction of the electrode load by a gradual increasing of the current.
- A search arc for 4 cycle welding for approaching the start of the seam
- Reduction of heat input
  at the beginning of the seam for edges or sires of heat accumulation.
- An increase in heat input

  at values above 100%

### 6.1.4 Slope-up time

The current slope-up time is the period in which the welding current increases linearly from the start current to the preselected welding current $I_1$.
During 2 cycle welding the current slope-up time begins immediately after the arc is ignited.
During 4 cycle welding the slope-up time begins with the release of the torch trigger with the start of current phase.

### 6.1.5 Welding current $I_1$ and pulse time $t_1$

The setting range for welding or pulse current $I_1$ depends on the selected mode and type of machine.

**Twin-current control:**

With twin-current control the user can work with 2 different, pre-set currents when using a torch with 2 triggers. Its is possible to switch between the two values $I_1$ and $I_2$ during welding.

Switching to $I_2$ is effective for as long as torch trigger 2 is actuated. When released the system immediately switches back to $I_1$.

Switching example:

- From high-current to low-current or vice-versa, for example when changing the welding position.
- Manual pulsing (see Section 6.1.8)
- Starting at high current $I_1$ for warming the workpiece, then welding with low-current $I_2$
- Starting with low-current $I_1$ at an edge on the workpiece, then welding with high-current $I_2$.

Switching is possible in both 2 and 4 cycle modes without pulsing.

The current $I_2$ is set either by activating the setting option $I_2$, or also very quickly and easily by actuating torch trigger 2 before the welding process. When the torch trigger 2 is held down the current value $I_2$ is shown in the - display and can be altered by turning the rotary encode.

### 6.1.6 Automatic pulsing

1. **Hyper pulsing** with pulse frequencies between 10 Hz and 17.5 Hz.

The currents $I_1$ and $I_2$ can be freely set, so that in deviation to the representation **Fig.14** alternative $I_2$ can result in a higher pulse current.

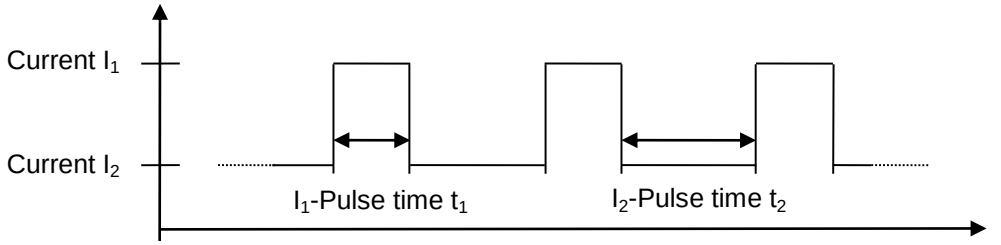



**Fig.14 Pulsing $I_1$, $I_2$**

During welding the pulse can be switched off and switched back on by actuating the torch trigger 2.
If torch trigger 2 is actuated during pulsing welding current the pulses are switched off and welding continues with welding current $I_2$.
As an example, this can be used so that the lower welding current $I_2$ is used until a new additional material has taken hold and the welding is continued with pulsing welding current by actuating the torch trigger 2 a second time.

**High frequency pulsing**: **with a pulse frequency of 10 Hz to 17.5 Hz.**

The flow of the welding current is the same as conventional pulsing. However, the periods during which current $I_1$ and $I_2$ are active are always the same. As this period is very small a description with pulse frequency is expedient and customary.

The following correlations apply for the conversion of the pulse frequency for the each of pulse time t 1 and t 2:

Total pulse time = $I_1$-pulse time $t_1$ + $I_2$-pulse time $t_2$ = 1 / pulse frequency

$I_1$-pulse time $t_1$ + $I_2$-pulse time $t_2$ = 0.5 * total pulse time

Example:

Pulse frequency = 50 Hz

Total pulse time = $I_1$-pulse time $t_1$ + $I_2$-pulse time $t_2$ = 1 / Hz = 20 ms = 0.02 s

$I_1$-pulse time $t_1$ = 0.5 * total pulse time = 0.01s

$I_2$-pulse time $t_2$ = 0.5 * total pulse time = 0.01s

This means that the current when welding has the value current $I_1$ for 0.01 s (= 10 ms), then for 0.01 s (= 10 ms) the value current $I_2$, then once again for 0.01 s (= 10 ms) the value current $I_1$, etc.

Pulses of such short duration bring about a more narrow arc and deeper penetration.

The current average value is always shown in the main display field because of the rapid alternations. This means that for welding current $I_1$ = 100A and $I_2$ = 50A the indicator shows 75A.

### 6.1.7 Manual pulsing

If, with the TIG 2 cycle function, torch trigger 1 is actuated during the slope-down time, then the welding current immediately jumps to the value used for welding. The average energy is infinitely variable and can be directly selected depending on the time at which the torch trigger is actuated during slope-down.

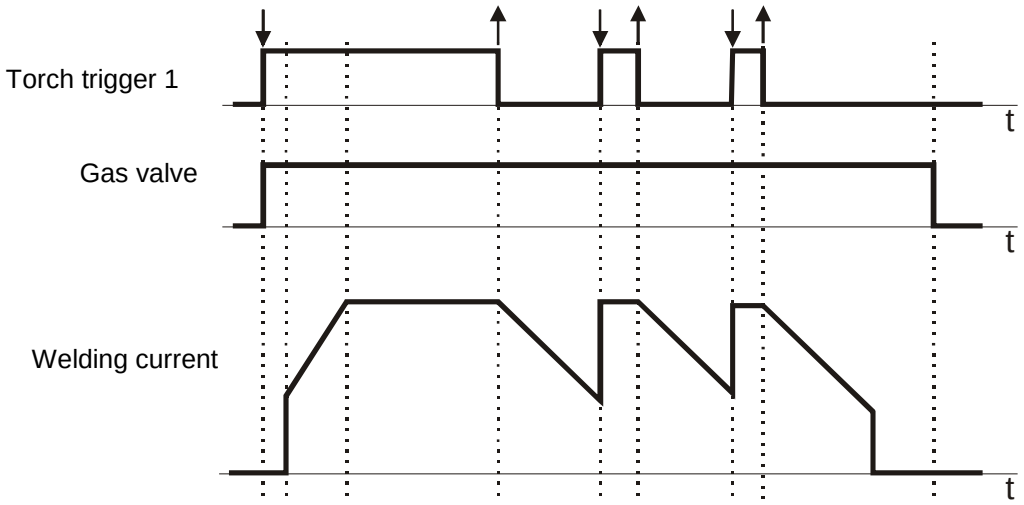



**Fig. 15**: **Flow diagram Manual Pulse**

### 6.1.8 Slope-down time

The current slope-down time is the period in which the welding current decreases linearly to the end-crater current. With 2 cycle welding the current slope-down time begins immediately after release of torch trigger 1.
With 4 cycle welding the slope-down time begins during welding with the actuation of torch trigger 1. The slow slope-down of the welding current prevents the occurrence of end craters.

### 6.1.9 End crater current $I_e$

The end crater current is the welding current to which the welding current is reduced when the welding process is ended. The setting is infinitely variable between 10% and 100% of the selected current $I_1$(for example:

Example: End crater current 40% and welding current $I_1$ 100A
results in an end crater current of 40A.

Selecting the appropriate end crater current enables:

- Prevention of notches and end crater cracks at the end of the weld seam due to rapid cooling of the weld pool
- Manual pulsing (see Section 6.1.8)
- Welding with reduced current at the end of the weld seam at edges or for heat accumulation

### 6.1.10 Gas post flow time

The gas post flow time is the time after the arc extinguishes before the protective gas valve closes.
The post flow of protective gas protects the workpiece and the tungsten needle from attack by oxygen in the atmosphere until they have cooled down. The pre-selected gas post flow time is, however, only effective when welding has taken place. The accidental actuation of the torch trigger does not result in the running of the gas post flow. This gas management function reduces gas consumption.

## 6.2 AC settings menu

The AC settings menu [BF7] is only visible on AC devices.
Depending on the equipment variant, further functions are restricted, (**Table 2**).

### 6.2.1 AC waveform

Selection between sinus, rectangle and triangle waveforms.
In the **Auto** setting, the waveform is set automatically.

### 6.2.2 AC frequency (Hz)

The frequency value determines how fast the output polarity reversal takes place one after the other. The setting range extends from 30 Hz to 300 Hz.
For example, at a frequency of 200 Hz the polarity reversal at the output socket from plus to minus and back occurs every 5ms (=0.005 seconds).
The welding current drops to zero with every polarity reversal, ignites again in the opposite direction and increases to the set welding current.
The adjustable frequency when AC welding, results in a considerable noise reduction and improvements in the alternating current welding.

The joke patented automatic frequency control can be selected as a special feature for TIG AC current welding.
The frequency is set to "Auto" for activation.

The automatic frequency control developed by joke combines the benefits of a very stable arc in the lower welding current range with the benefits of a high electrode capacity in the high current range.
The AC frequency is automatically adjusted to the actual momentary value of the welding current.

Normally, the selection of automatic frequency control makes setting the frequency superfluous. This setting option provides unlimited flexibility other than a few special application-specific cases where it is desirable to use a frequency that is different to that selected by the automatic frequency control.

### 6.2.3 AC balance ( )

The AC balance setting option is only available with AC current welding with TIG.
It ranges from -5 to +5 and enables the arc to be influenced as well as the penetration and cleaning when welding aluminium over a very large range.
In the centre position (0) the negative and positive welding current is equally distributed over time.

With an increasing positive value the share of the positive welding current increases (up to +5) and the negative share reduces. The cleaning of the weld pool is improved by the positive share. The arc is wider and heat penetration less deep.

With an increasing negative value the share of the negative welding current increases (up to -5) and the positive share reduces. This makes the arc more narrow and generates a deeper weld penetration at the same time as a low electrode load.

The use of the highest possible negative value whilst maintaining a sufficient cleaning effect is recommended.

## 6.3 Menu spot welding and interval

### 6.3.1 Spot time

The setting menu spot welding time [BF8] appears when the spot welding function is selected in the corner menu [BF3]. The spot welding time can be set in the range 0.01s to 30.0s.

### 6.3.2 Pause time

The setting menu spot, pause time [BF8] appears when the interval welding function is selected in the corner menu [BF3]. The spot welding time can be set in the range 0.01s to 30.0s.

# 7 Submenus

Pressing the "List submenus" button [BF10] accesses a selection list (drop down list) for the existing submenu.
The following menus can be selected from this list:

1. Language selection
2. Assist
3. Save and load programs
4. Special parameters (setup)
5. Error messages and error memory

The submenus can be exited in 3 ways, with the return button [BF11]:

1. One level back by acknowledging a setting
2. One level back by pressing the **"Back"** button
3. Completely back to the main screen with the button "**Main menu**" (*joke or Home*).

## 7.1 Language menu

The available languages are displayed as flags in a selection list.
Use the cursor to select a language and confirm by pressing the rotary encoder.
The language becomes active immediately.
The selected language is illustrated by a box with cross.

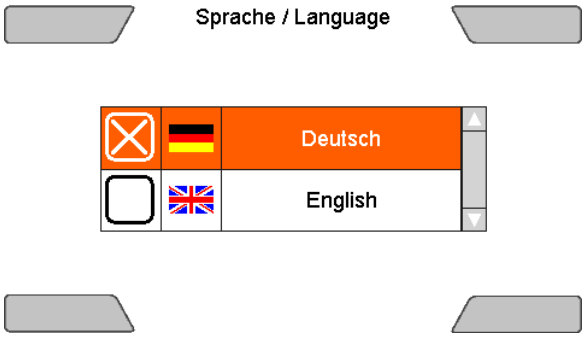



**Fig.16 Submenu language selection**

## 7.2 Assist

The Assist submenu is an assistant program that provides help with welding settings for specific welding tasks.

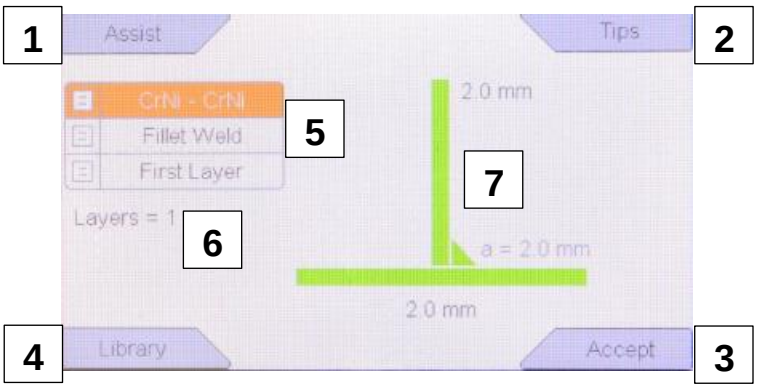



**Fig.17 Main screen Assist**

| | |
|---|---|
| **Corner menu** **1** | |
| Assist | Indicates that you are in Assist |
| **Corner menu** **2** | |
| **Tip** | Display and recommendations for the welding task other than the TIG or electrode settings:<br>• Number of positions<br>• Type of gas<br>• Gas flow rate<br>• Gas nozzle size<br>• Preheat temperature<br>• Diameter of filler material<br>• Electrode type<br>• Electrode diameter<br>• Grinding angle<br>• … |
| **Corner menu** **3** | |
| **OK** | Accept settings<br>The message "Accepted" appears in the status window |
| **Corner menu** **4** | |
| Library | Submenu Additional information:<br>• TIG electrodes<br>• Filler materials<br>• Gases<br>• Welding positions<br>The folder can be searched when the library folder is opened by rotating and pressing the **Fig.8** encoder. Return with the "Back" button. |
| **Screen settings** **5** | |
| Material | Available options:<br>• AL - AL<br>• Steel - Steel<br>• Steel - CrNi<br>• CrNi - CrNi |
| Weld shape | Available options:<br>• Butt weld<br>• Fillet weld |
| Layer | Available options:<br>• First Layer<br>• Further Layers |
| **Screen display** **6** | |
| No. of Layers | Display Layer 1, 2, … |

| **Workpiece view** 7 | |
|---|---|
| Workpiece | Select the workpiece with the rotary encoder, confirm by pressing and set the material thickness.<br><br>Displays: - Material thickness<br>- Grinding angle (only with butt seam)<br>- A dimension (only for fillet welds)<br>- Required number of layers<br><br>Alerts: An alert is given for inapplicable settings. |

## 7.3 Save and load programs

### 7.3.1 Quick program buttons P1 … P4

Buttons P1 to P4 (**Fig.4**) are used to call welding specific settings (see section 5 and 6) by pressing the P button and to save specific settings by holding the P button for a minimum of 2 seconds.

After active welding (torch button 1 pressed) the active device configuration remains stored after power off and is available as soon as the unit is restarted.

The memory location for the fast program buttons for programs 1 to 4 is a total of 99 programs in the subprogram.
These cannot be overwritten or edited there.

### 7.3.2 Memory programs 5 to 99

Programs lists and programs can be edited in the submenu Programs:

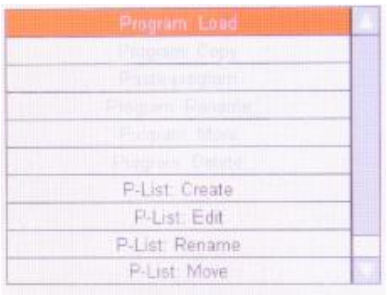



**Fig.18 Edit program lists**

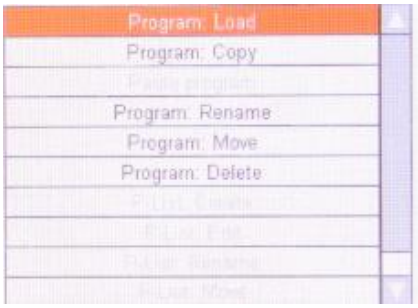



**Fig.19 Edit program lists**

Program lists are equivalent to folders. A total of 99 programs can be managed in a maximum of 99 parameter lists.
The directory name is freely selectable (for example, the name of an employee, a customer or the material to be processed).

Therefore, once the unit settings are determined for recurring welding tasks they can be recalled at the welding units in seconds. This saves time and ensures consistent quality.

The individual welding unit base settings such as the start and end crater current, ignition energy, etc., for use by multiple people can be saved for each person and quickly duplicated.

### 7.3.3 Manage parameter lists (folders)

Initially, the overview of the existing program lists appears in the program submenu, as shown in **Fig.22**.
If you select a program list, you can edit it using the corner menu (button at the bottom left next to the press/rotary encoder).


**Fig.20 Actual P list screen section**

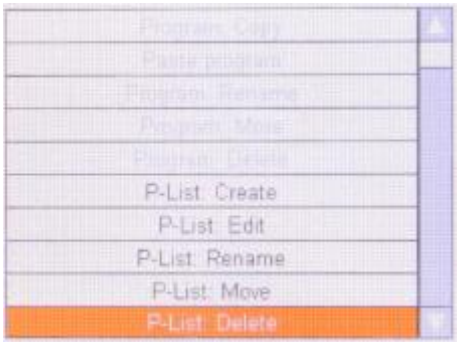



**Fig.21 Edit menu program lists**

**Creating a new folder**

In the submenu program lists

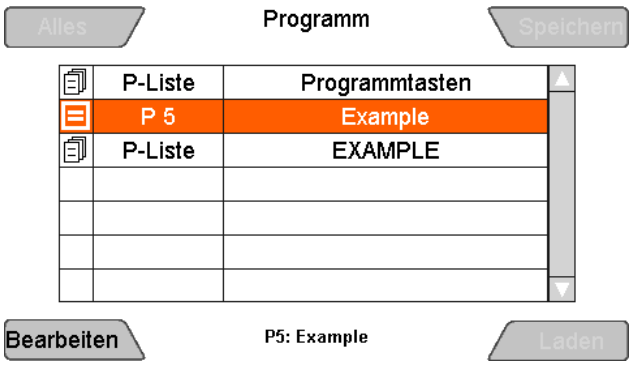



**Fig.22 Submenu program lists**

The following is a representative example of how to create a program list.

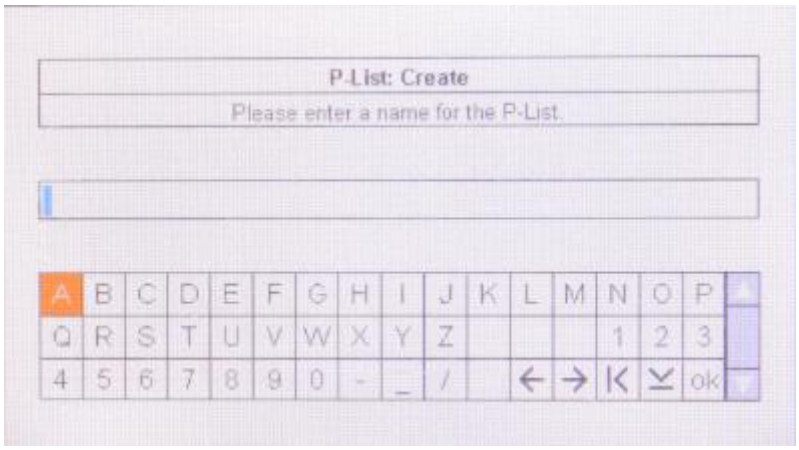



**Fig.23 Example creation of a P list**

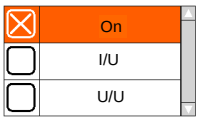
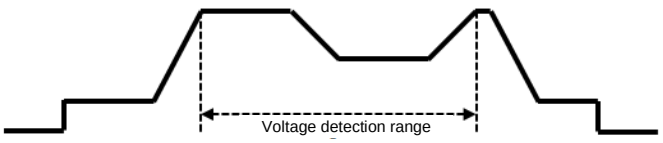
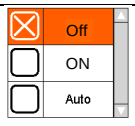
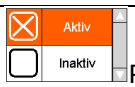
## 7.4 Optional water cooling unit

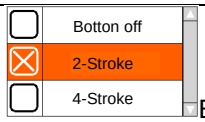
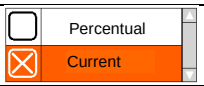
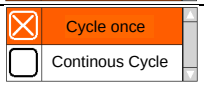
The ENESKAimpulse can be equipped with the joke water cooling unit as an option. The ENESKAimpulse is connected to the water cooling unit with a plug-in connection cable with 9-pin plug (see fig. 27)

**Caution:**
The joke water cooling unit is only available in combination with the optional cooling unit connection. The cooling unit connection must be installed by joke at the factory.

# 8 Setup / special parameters


| | |
|---|---|
| | |
| | |

| | | | |
|---|---|---|---|
| Current display |  <br>0ff Voltage indicator off<br>I/U Display of the average voltage after welding has stopped.<br>U/U Display of the average voltage<br><br>- during welding<br><br>- at the end of welding<br>The average value is updated every 2 seconds.<br><br>  | | |
| Water cooling unit mode |  | ON<br>OFF<br>Auto | Pump and fan are off<br><br>Pump and fan are running<br>Pump and fan are automatically switched on when welding or when the coolant temperature is greater than 30°C. |
| | | | |
| Possibility to adjust the potentiometer from the torch |  Potentiometer in the torch is active | | |

| | |
|---|---|
| Function torch button2 (BT2) |  BT2 mode of operation:<br>On/Off button operation or 4 stroke |
| Start current display<br>End current display |  Depending on the welding current I1 by %<br>Fix according to the setting in A |
| Mode in the Program List menu (folder) |  Stopps at the end of the list<br>Jumps at the end of the list to the first progr. |
| Default position main screen | If no settings are made, the cursor on the main screen automatically goes to current position $I_1$.<br>Factory setting is 20 seconds |
| | |

Factory settings

All settings (parameters) are reset to the factory settings.
This does not affect: Special parameters and programs.


| **Welding parameters** | **Factory settings** |
|---|---|
| Gas pre-flow time | 0.1 s |
| Ignition current | 50% |
| Starting current | 50% |
| Slope-up time | 0.1 s |
| Current $I_1$ | 100 A. |
| Current $I_2$ | 80 A. |
| Pulse time $t_1$ | 0.3 s |
| Pulse time $t_2$ | 0.3 s |
| Slope-down time | 0.1 s |
| End-crater current | 20% |
| Gas post flow time | 5.0 s |
| AC frequency* | Automatic |
| AC balance* | 0 |
| Ignition | HF on |
| Operating mode | 2 cycle |
| Polarity* | DC negative |
| EL current $I_1$ | 150 A |
| Pulse type | Pulse off |
| Pulse frequency | 500 Hz. |
| TIG spot welding | 0.1 s |
| | |

# 9 Error memory


Error message display

- Number of errors
- Error text
- Welding time
- Operating time

# 10 Indicating symbol

| | |
|---|---|
| | The **REMOTE CONTROL** AKTIVE symbol [BF17]appears on the right of the status line [BF9] and indicates the remote controller as active. |
| | The control lamp BETRIEB Symbol [BF16] in green indicates that there is an open circuit voltage at the torch.<br>The display is on the left in the status line.<br>The same display in red indicates an overtemperature fault. |
| | The power section is switched off and there is no output voltage as long as this symbol is displayed. With TIG welding the gas post flow time runs when the power section is switched off. Once the unit has cooled the LED goes out and welding can commence automatically. |

# 11 Accessories

## 11.1 Optional water cooling unit

The joke water cooling unit (see Section 7.4) is adapted to the ENESKAimpulse with respect to the performance data and the design and allows the use of water-cooled TIG torches. The water cooling unit, together with the ENESKAimpulse, forms a single unit.

**CAUTION:**

The joke water cooling unit is only available in combination with the optional cooling unit connection. The cooling unit connection must be installed by joke at the factory.

# 12 Commissioning

## 12.1 Safety information

Carefully read the operating instructions, in particular the Section **2 Safety** information, before commissioning and before beginning work with this welding current source.

**Warning!**

**joke welding equipment should be operated only by persons who are trained and instructed in the use, maintenance and the safety regulations concerning welding systems.**

**When welding always wear protective clothing and take care to avoid other persons who may be in the vicinity being endangered by the UV radiation emitted by the welding arc.**

## 12.2 Working under increased electrical hazard (IEC 874, EN 60974-1, TRBS 2131 and BGR 500 KAP. 2.26)

joke TIG welding systems meet the regulations for working under increased electrical hazard in accordance with IEC 874, EN 60974-1, TRBS 2131 and BGR 500 KAP. 2.26)

For AC welding a safety unit is built into the electronic control. When AC welding this ensures that the arc is always only ignited with DC voltage and the change to AC current is only made after the welding current is flowing. The machine automatically switches off the HF and the welding current if the arc is suddenly torn away when welding. The machine is then in the basic condition.

It must be noted that for work under increased electrical hazard, the welding current source must not be placed in this area. Regulations EN 60974-1, TRBS 2131 and BGR 500 KAP 2.26 must be observed .

## 12.3 Placement and transportation of the welding unit.

Place the joke welding system so that the welder has sufficient space in front of unit to adjust and operate the controls. Secure the unit so that it is prevented from tipping over or falling down.

Transport the unit only under compliance with the applicable accident prevention regulations.

**Instructions for placement and transport:**

- Transport and operation only in the upright position!
- Transport the unit using only the grips and carrying strap provided.
- Place, operate and transport the unit on a firm, stable and level base
- Safety against tipping is ensured up to an angle of 10° (in compliance with the Standard IEC 60974-1)
- Avoid ambient air containing salt (sea air)!
- Keep entry and exit ports for cooling air free from obstruction!
- Maintain a minimum distance of 0.5m from obstacles!
- The unit is not suitable for crane transport.

**Danger! Electrical voltage!**

**Do not use the welding unit in the open in the rain or snow!**

## 12.4 Connecting the welding unit

Only connect the joke welding current source to the power supply in accordance with the applicable VDE regulations and also observe the regulations of the respective professional associations.

When connecting the unit observe the instructions concerning the power supply voltage and local mains fuse. Automatic circuit breakers and fuses must always be sized for the stated source current. The necessary information can be found on the rating plate of your unit.

Always switch off the unit when not in use.

Screw the bottle pressure reducer tightly on the thread and check the connection for tightness. Always close the bottle valve after completing work. Observe the regulations of the respective professional associations.

## 12.5 Cooling the welding unit

Place the joke welding unit so that the air entry and exit ports are not obstructed. The power section can only achieve the specified duty cycle with sufficient ventilation (see “Technical data”). Ensure that no grinding chips, dust or other metallic dust of foreign objects can enter the unit.

## 12.6 Guidelines for working with welding current sources

Only qualified or specially instructed persons who are familiar with the equipment and the process may be assigned with welding work. When welding always wear protective clothing and take care to avoid other persons who may be in the vicinity from being endangered. After finishing the welding work the unit should be left switched on for a few minutes so that the fan continues to run and residual heat is removed from the unit.

## 12.7 Connecting the welding leads and the torch

joke TIG welding systems are equipped with quick connection devices for connecting the grounding cable and the TIG welding torch. The connection is made by inserting and turning to the right. The protective gas hose is connected to the welding unit via a quick coupling. The torch trigger connector is inserted into the 19 pole socket.

**Important!**

To prevent unnecessary energy loss during welding ensure that all welding line connections are tightened and well insulated.

## 12.8 Connection of external components

The connection of external components is achieved via the standard 19 pole remote control socket on the front side of the ENESKAimpulse. joke accessories are available for this purpose as described in Section **Fehler! Verweisquelle konnte nicht gefunden werden.**.

Only external components listed in this guide may be used. If external components other than those listed are used, the manufacturer's warranty is void.

**Important!**

When using the 19 pole remote control socket ensure that the guidelines for the use of serial bus systems are met. Particularly the regulations on electromagnetic compatibility (EMC). Use only the accessories provided by joke.

To ensure that the initialisation of the external connections is always reliable, first the ENESKAimpulse power supply switch and then the external devices are switched on.

# 13 Operation

## 13.1 Safety information

Carefully read the operating instructions, in particular the ➔ Section 2, before commissioning and before beginning work with this welding current source.

**Warning!**

**joke welding equipment should be operated only by persons who are trained and instructed in the use, maintenance and the safety regulations concerning welding systems.**

Working with and maintaining electric welding units is always associated with possible hazards. Persons who are not familiar with this type of system can injure themselves and others. For this reason operating personnel must be made aware of the following potential hazards and the safety measures to prevent possible damage or injury. Irrespective of this, the operator of a welding unit must inform themselves of the safety regulations applicable to the respective operation before starting work.

## 13.2 Electrical hazard

Connecting and maintenance works on the welding unit and their accessories may only be performed in agreement with the applicable VDE regulations and the regulations of the respective professional association.

- Never make contact with live metal parts with the naked skin or wet clothing
- When welding always wear gloves and a welder's hood with an approved protective filter.
- Ensure that everything that you must come into contact with when working, such as your clothing, your work area, the welding torch, and the welding unit are always dry. Never work in wet surroundings.
- Ensure good insulation by only wearing dry gloves and rubber soled shoes and stand on a dry, insulated base, in particular if you stand on metal when working or you are in an area of increased electrical hazard.
- Never use worn or damaged welding cables. Ensure that the welding cables are not overloaded. Only use equipment in a perfect condition.
- Switch off the welding unit during longer periods of interruption.
- Do not wind the welding cables around parts of the housing and do not leave them wound into rings.
- Never leave a powered-up welding unit unattended.

## 13.3 Instructions for your personal safety

The effects of radiation from the electrical arc and the hot metal can result in serious injury to unprotected skin and eyes.

- Only use a welder's hood in perfect condition or automatic welding masks with an approved filter and leather gloves to protect eyes and skin from sparks and radiation from the arc (see TRBS 2131 and BGR 500 SEC. 2.26) Also wear similar protection even if you are only observing the welding work.

- Notify persons in the vicinity of the danger of arc radiation as well as hot metal sputter and parts and protect against these with non-flammable screens.
- Pressurised gas bottles are also a potential hazard. Therefore strictly comply with the safety instructions of the respective professional association and the supplier. Secure protective gas bottles from falling over. Never transport protective gas bottles without a protective cap
- During welding work noise levels of over 70 dBA can occur depending on the process and the environment, this can cause permanent hearing damage. Persons who remain in the working area must, if necessary, wear suitable hearing protection.

## 13.4 Fire protection

Hot slag or sparks can start a fire if they come into contact with combustible materials, fluids or gasses. Remove all combustible materials from the welding area and make sure that a fire extinguisher is at hand.

## 13.5 Ventilation

Workplaces must be setup under consideration of the processes, materials and conditions of use so that the air breathed by the user is kept free of substances harmful to health (see TRBS 2131 and BGR 500 KAP. 2.26)

Ensure that the welding area is perfectly ventilated either by natural or artificial ventilation.

Never perform welding work on workpieces treated with paint or degreasing agents that can result in harmful vapours.

## 13.6 Checks before switching on

It is preconditioned that

- the system is properly placed in accordance with ➔ **Section 12 Commissioning**,
- all connections (protective gas, torch connection) are properly made in accordance with➔ **Section 12, Commissioning**,
- the scheduled periodic maintenance work has been performed in accordance with **Section 15**, **Maintenance**,
- the safety equipment and the system components (in particular the torch connection hoses) have been checked by the operator, are functional and ready for use,
- the operator and the assisting persons are wearing the appropriate protective clothing and the securing of the work area has been completed so that no uninvolved persons are placed in danger.

## 13.7 Connecting the grounding cable

**Warning!**

**➔ Section 13.2, Electrical hazard. Ensure that the welding current cannot flow through lifting device chains, crane cables or other electrical conductors.**

**➔ Section 13.2, Electrical hazard. Ensure that grounding cables are connected to the workpiece as close as possible to the welding site. Grounding cables that are connected to distant points reduce the effectiveness and increase the risk of electrical shock and vagrant currents.**

## 13.8 Practical instructions for use

The practical instructions for use listed below can only provide an overview of the uses for joke TIG welding systems. In the event of questions concerning special welding tasks, materials, protective gases or welding fixtures refer to topic-specific publications or specialist recommendations for manufacturers.

With TIG welding a differentiation is made between those materials that can be welded using DC current and those materials that can be welded using AC current. Besides non-alloy, alloy and high-alloy steel DC current can also be used to weld copper, nickel, titanium and their alloys. AC current is generally used to weld aluminium and its alloys.

Various types of tungsten electrodes are offered and used for TIG welding. The difference between them is the share of doping elements in the tungsten electrode. Their compositions are listed in DIN EN ISO 6848 (previously EN 26848) and usually consist of thorium oxide, cerium oxide, zirconium oxide or lanthanum oxide. The advantages of oxide-containing tungsten electrodes are:

- improved ignition properties
- more stable arc
- higher current carrying capacity
- longer lifetime

joke supply its torches with WC 20 (grey) tungsten electrodes as standard.

The most frequently used electrode diameter and their capacities can be found in the relevant specialist publications. Please consider that the values given are mainly established by machines, which do not have by far the balance range of joke TIG units. All guidelines state that a specific electrode is exposed to a current that is too high if it drips or takes on a brush-like appearance. You have the choice between lower current or, with AC operation, using a larger minus portion in the balance setting.

When welding with DC the electrode is ground to a point.

With the joke TIG welding system it is also possible to work in the AC range with balance adjustments in the negative range using a pointed electrode. This offers the advantage that the arc is even more concentrated and effective. In most cases this increases the welding speed.

When grinding the electrode take care that the direction of grinding is in the longitudinal direction of the electrode. For this task use a hazard-reducing grinding apparatus with extraction.

In TIG welding the protective gas is mainly argon. Helium, argon-helium mixture, or argon-hydrogen mixture is used for special applications. Igniting the arc becomes more difficult and the thermal input increases with an increasing portion of helium. The quantity of protective gas required depends on the electrode diameter, size of the gas nozzle, welding current strength and the movement of air depending on the working place. With a workpiece of 4 mm thickness using argon as a protective gas an example reference value for aluminium is approximately 8 litres/minute and for steel and chrome-nickel steel approximately 6 litres/minute. If helium is used the required quantity is significantly higher.

The standard length of the TIG welding torch is 4m and 8m. However, longer torches can be used with these machines. The matching tungsten electrode, clamping sleeve and gas nozzle must be selected depending on the welding task and the current strength. When using a torch with two triggers it is possible to switch the current between the two adjustable values during welding.

Welding additives are added in rod form when welding manually. The correct tungsten must be selected depending on the base material. However, excellent results can be achieved if the weld pool of two parts is allowed to run together, as in the case of corner seams.

With AC welding the negative pole is usually on the electrode. The negative pole is the cooler pole, this means that the current capacity and the service life of the tungsten electrodes is significantly longer than with positive pole welding.

With AC welding the capacity of the electrode is strongly affected by the balance setting. The balance setting is used to distribute the positive and negative share of the welding current between the electrode and the workpiece. During the positive half-wave the aluminium oxide skin is destroyed and a high temperature occurs on the electrode. During the negative half-wave the electrode cools down and the aluminium is heated. As only a short plus pulse is required to break the aluminium oxide skin, the joke TIG system can be worked with a high negative share.

This has many advantages:

1. The temperature load on the electrode is reduced
2. The electrode can be subject to a stronger current
3. The electrode current range increases
4. Welding can take place with a pointed electrode
5. The arc is narrower
6. The penetration is deeper
7. The thermal influence zone of the weld seam is lower
8. The weld speed is higher
9. The thermal input into the workpiece is reduced

A high-voltage ignition device is installed in the joke ENESKAimpulse 2 systems as standard for contactless ignition of the welding arc. The high-voltage causes the path between the tungsten electrode and the workpiece to become so electrically ionised that the welding arc can jump the gap. A higher oxide content in the electrode and a closer distance to the workpiece positively influence the ignition response.
With DC and AC welding the arc can be ignited by the installed program control both with and without high-voltage. Proceed as follows:

The HF setting is positioned at “Off”, the tungsten electrode is brought into contact with the workpiece, then the torch trigger is actuated and the electrode is lifted from the workpiece by tipping the torch over the gas nozzle. The ignition of the arc without high-voltage is an advantage if, for example, welding is necessary in a crankcase or repair welding is to be performed on an electronically controlled machine, on which the high-voltage ignition equipment could cause a fault to the control sequence.

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# 14 Faults TIG welding unit

## 14.1 Safety information

**Warning!**

**If a fault occurs that represents a hazard to persons, systems and/or the environment, switch off the system immediately and secure against restarting.**

**Only restart operations with the system after the fault has been eliminated and no hazard exists for persons, machines and/or the environment.**

**Faults must only be eliminated by qualified persons under the observance of all safety instructions. ➔ Section 2**

**Before restarting the system must be released by qualified personnel.**

## 14.2 Table of faults

**joke control panel is not working**
**The - display instrument has no display and no LEDs illuminate.**

| Cause: | Remedy: |
|---|---|
| Mains power supply is missing (possible mains fuse) | Check the mains voltage |
| Mains cable of plug is defective | Check |

**Current slope-up time & current slope-down time are at “0.0” and cannot be altered.**

| Cause: | Remedy: |
|---|---|
| Remote foot control is plugged in controller. | Times are controlled by the remote Unplug the remote controller. |

**Current slope-up time & current slope-down times are not complied with**

| Cause: | Remedy: |
|---|---|
| Starting current is set at 100% | Reduce starting current |
| End crater current is set at 100% | Reduce the end crater current value |

**4 cycle cannot be set**

| Cause: | Remedy: |
|---|---|
| Remote foot control is plugged in | Unplug the remote foot control |

**Balance and frequency cannot be selected**

| Cause: | Remedy: |
|---|---|
| Polarity is not "~" | Only adjustable in the AC range |

**When switched on the system has different parameters than those when it was switched off**

| Cause: | Remedy: |
|---|---|
| Values are only saved after a successful welding process. | Execute welding process |

**No protective gas flows**

| Cause: | Remedy: |
|---|---|
| Bottle is empty or the gas hose is kinked. | Check |
| Pressure reduced is defective. | Check |
| Gas value on the machine is defective. | Service call |
| Blade terminal on the gas valve is loose. | Check |

**Rotation of the fan is not audible**

| Cause: | Remedy: |
|---|---|
| Fan speed level is dependent on demand when at low temperature the fan runs at lower speed or switches off. | Check whether the fan is running at higher speed under higher loads. |
| Fan defective. | Service call |

**No high voltage pulse**

| Cause: | Remedy: |
|---|---|
| HF ignition is set to off | Switch on the HF ignition |
| No protective gas present | Check |
| Grounding cable poorly connected | Check |
| Electrode dirty | Grind |
| Electrode not suitable | Change electrode |
| Gas pre-flow time too long until time expires. | Reduce gas pre-flow time or wait |
| High-voltage flashover in the torch | Change the torch |
| Connection between the torch and the grounding cable reversed | Connect correctly |

**Welding current does not reach the set value or the arc does not burn.**

| Cause: | Remedy: |
|---|---|
| Grounding cable poorly connected | Check |
| Foot controller connected and not actuated. | Check |
| Hand remote control connected | Set the current on the remote control |
| No or incorrect protective gas | Check |

**Arc sputters and jumps**

| Cause: | Remedy: |
|---|---|
| Electrode is poorly sharpened | Grind electrode |
| Electrode not suitable | Change electrode |

**Arc has a strange colour**

| Cause: | Remedy: |
|---|---|
| No or too little protective gas | Check |
| Electrode dirty | Grind |

**Electrode burns off**

| Cause: | Remedy: |
|---|---|
| No protective gas | Check |
| Current load too high | Use a thicker electrode |
| Pulse share too high with AC current welding | Increase the negative share using balance |
| Connection between the torch and the grounding cable reversed | Connect correctly |
| Electrode welding is set | Set TIG welding |

**System does not pulse**

| Cause: | Remedy: |
|---|---|
| Pulse is not switched on | Set pulse time T1 and / or T2 |
| Values for T1 and T2 are equal | Change the values |

**Arc breaks away on ignition**

| Cause: | Remedy: |
|---|---|
| Ignition energy set loo low | Set the ignition energy or use thinner electrode |
| Electrode is consumed or dirty | Grind electrode |

## 14.3 Error messages

| Error | Acknowledge A | B | C | Error | Cause | Elimination |
|---|---|---|---|---|---|---|
| 2 | ✓ | - | - | Mains voltage | Mains voltage outside the tolerance range | Switch the unit off and check the mains voltage |
| 18 | - | ✓ | - | Condensation moisture | Condensation / moisture on the inside of the unit | Wait until the condensation / moisture has disappeared from the inside of the unit. |
| 19 | - | - | ✓ | Remote foot controller | The foot controller is removed during welding. | Do not remove the foot controller during welding. |
| 21 | - | ✓ | - | TIG torch in EL mode | EL mode active with a TIG torch connected | Remove the TIG torch<br>Switch to TIG mode |
| 22 | - | - | ✓ | Secondary short circuit | | Eliminate the short circuit on the welding socket Eliminate the fault. |
| 23 | ✓ | - | - | Primary short circuit | A short circuit is present on the welding socket when switching on.<br>Internal short circuit | Eliminate the short circuit on the welding socket.<br><br>Service call |
| 33 | - | - | ✓ | Reversing pole current or reversing pole power is too high | Welding circuit inductance too high | Change the torch and grounding cable run. No loops and windings. |
| 34 | - | ✓ | - | Remote control connected to the torch socket | Connected torch is not detected. | Use a joke torch<br>Defective torch. |
| 35 | - | ✓ | - | Coolant overtemperature | Temperature of the coolant > 65°C | Let the water cooler cool down<br>Top-up coolant |
| 48* | - | - | ✓ | Coolant flow | Coolant monitor detects low coolant flow<br>Coolant monitor blocked by dirt | Immediately switch off the current source<br>Check that the connecting cable is plugged in<br>Check the coolant level<br>Check the connections on the water cooled torch<br>Eliminate interruptions in the coolant circuit<br>Bleed the coolant circuit<br>Check the pump |
| > 51 | | | | Service call | An analysis of the cause can be made by the service technician | |

* Only for ENESKAimpulse with an integrated water cooling unit

Acknowledge legend

A Fault message can be reset by switching off and back on again.

B Fault message will go out automatically when the fault is eliminated

C Fault message will go out when the fault is eliminated and the push and rotatory encoder [**Fig.8**] is actuated. If the fault is still present the fault message will reappear in the display screen [**Fig.5**] after 2 seconds.

# 15 Maintenance work

## 15.1 Safety information

**Warning!**

**Maintenance and repair work may only be performed by persons who have been trained by joke. Please contact your joke dealer. When replacing parts only use joke original spare parts.**

**If maintenance or repair work is performed on this unit by persons who have not been trained and authorised to carry out the work by joke, then claims against joke become void.**

**Before beginning cleaning work the unit must be switched off and disconnected from the mains supply.**

**Before maintenance work the welding system must be switched off and disconnected from the mains supply and secured against unintended reconnection.**

**Supply lines must be shut off and vented free of pressure.**

**The warning notices listed in ➔Section 2 “Safety” must be observed.**

The welding system and its components must be maintained in accordance with the requirements of the operating and maintenance instructions.

Insufficient or improper maintenance or repair may result in operating faults. Periodic maintenance of the system is therefore essential. No constructive change or additions may be made to the system.

## 15.2 Maintenance table

The maintenance intervals are recommended by joke for standard requirements (for example, single shift operation, use in a clean and dry environment). The precise maintenance intervals are specified by your safety officer.

| **Activity** | **Interval** |
|---|---|
| Cleaning the inside of the unit | depending on the conditions of use |
| Functional test of the safety equipment by operating personnel | Daily |
| Visual system check, particularly the torch hoses | Daily |

| Activity | Interval |
|---|---|
| Check the function of the residual current circuit breaker | Daily<br>(in flying constructions)<br>otherwise monthly |
| Have the connecting lines and torch hoses checked by qualified personnel; log the checks in the logbook provided.<br>**Perform checks more regularly depending on the country-specific laws.** | Every six months |
| Have the complete welding system checked by qualified personnel; log the checks in the logbook provided.<br>**Perform checks more regularly depending on the country-specific laws.** | Annually |

## 15.3 Cleaning the inside of the unit

If the joke welding unit is used in a dusty environment the inside of the unit must be cleaned at regular intervals by blowing out or vacuuming.

The frequency of this cleaning depends on the respective conditions of use. Only use clean, dry air to blow out the unit or use a vacuum cleaner.

If maintenance or repair work is performed on this unit by persons who have not been trained and authorised to carry out the work by joke, then and claims against joke become void.

## 15.4 Proper disposal

Only for EU countries

Do not dispose of electric appliances in domestic waste!

In accordance with the European Directive 2002/96/EC concerning old electrical and electronic devices and its transposition into national law, used electrical appliances must be collected separately and recycled in an environmentally friendly manner.

# 16 Technical data

| | | 230 AC/DC |
|---|---|---|
| Mains voltage *U1* *[1] | | 1 x 230 V |
| Mains voltage tolerance<br>without water cooling | | 90V .. 265 V |
| with water cooling | | -15% / +10% |
| Mains frequency | | 50 Hz / 60 Hz |
| Mains fuse | | 16 A slow-blow |
| Effective primary current $I1_{Eff}$ | | 18.7 A |
| Max. primary current $I1_{max}$ | | 25.3 A |
| Max. power at $I1_{max}$ | | 5.8 kVA |
| cos φ | | 0.99 |
| Recommended residual current circuit breaker | | Type B |
| Open-circuit voltage *U2* *[2] | | 95 V |
| Setting range *I2*<br>*TIG* | | 4 A – 230 A |
| | | |
| | | |
| Duty cycle (ED) at 40°C<br>*35% ED* | | 225 A |
| TIG *40% ED* | | |
| TIG *60% ED* | | 180 A |
| TIG *100% ED* | | 160 A |
| | | |
| | | |
| | | |
| | | |
| Standard operating voltage *TIG* | | 10.2 V – 19.0 V |
| | | |
| Peak voltage HF $U_p$ | | 9.7 kV |
| Generator power for $I2_{max}$ | | 8.2kVA |
| Generator type | | Synchronous, asynchronous, inverter |
| Protection type *[3] | | IP 23 S |

| | | 230 AC/DC |
|---|---|---|
| Protection class | | |
| without water cooling *[4] | | 2 |
| with water cooling | | 1 |
| Insulation class *[5] | | F |
| EMV emissions class | | A |
| Cooling type | | AF |
| Overvoltage category | | III |
| Torch cooling | | |
| without water cooling | | Gas |
| with water cooling | | Water |
| Noise emission *[6] | | < 70dB(A) |
| Maximum protective gas pressure | | 6 Bar (87.02 psi) |
| Dimensions L x B x H | | |
| without water cooling | | 480x160x320 mm |
| with water cooling | | 480x215x530 mm |
| Weight (without coolant) | | |
| without water cooling | | 7.9 kg |
| with water cooling | | 16.4 kg |
| Standards | | 60974-1<br>60974-2<br>60974-9<br>60974-10<br>CE |

| **Water cooling*** | |
|---|---|
| Cooling power | |
| at 1 l/min (25°C) | 600 W |
| at 1 l/min (40°C) | 330 W |
| Max (25°C) | 1000 W |
| Max (40°C) | 500 W |
| Maximum flow rate | 2.5 l/min |
| Maximum pump pressure | 4.0 Bar<br>58.0 psi |
| EMC protection class | A |
| Tank content | 1.5 l |
| Pump | Centrifugal pump |
| Monitoring flow | Error message below 0.5 l/min |
| Monitoring coolant | Error message above 65°C |
| Fuse | 10 A slow-blow |

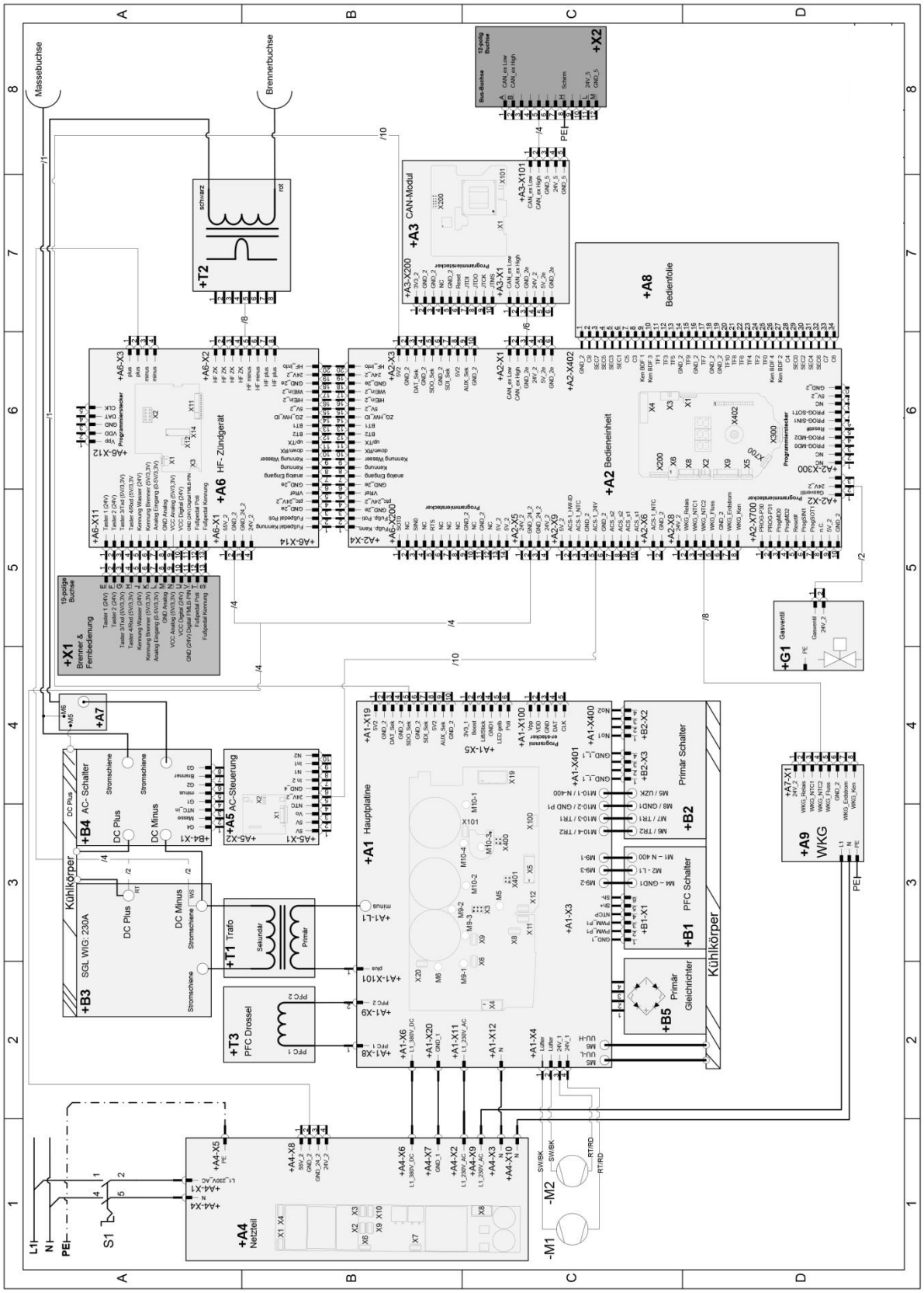
* for a separately available water cooling unit

| | | |
|---|---|---|
| 1 | Mains voltage | The unit may only be operated and connected with a grounded mains (grounded neutral and protective conductor). |
| 2 | Open-circuit voltage U2 | Measured open-circuit voltages, which are below the permissible tolerance according to EN60974-4 for voltages, less than the open-circuit voltage specified on the type plate, pose no danger and do not change the welding properties. |
| 3 | Protection type | Protection type IP23 S<br>- Protection of the unit against ingress of solid foreign bodies ∅ larger than 12 mm<br>- Protection of the unit against spray water up to an angle of 60° from the vertical.<br><br>The unit should be placed and operated outdoors in accordance with the protection class.<br>The device must not to be operated, transported and stored in rain or snow. |
| 4 | Protection class | Protection class 2:<br>The PE connection serves as EMC discharge and must be connected.<br>The continuity test for the PE should be omitted for tests according to protection class 1, as the PE connection is not placed on housing components in the case of a device of protection class 2. |
| 5 | Insulation class | Class of insulation materials used and their maximum permissible continuous temperature (F = maximum permissible continuous temperature 155°) |
| 6 | Noise emission | Idle and operating with a standard load according to IEC 60974-1, at the maximum working point. |

Subject to technical changes through further development.

# 17 Circuit diagrams

Circuit diagram ENESKAimpulse 230 AC/DC



Circuit diagram ENESKAimpulse water cooling unit

# 18 INDEX

## "



## A



## C



## D



## F



## G



## I



## M

## O



## P



## R



## S



## T

**EC declaration of conformity**

For the following named products

# TIG - protective gas - welding machine

| | |
|---|---|
| **ENESKAimpulse 230 DC** | **ENESKAimpulse 230 AC/DC** |

it is hereby confirmed that they comply with the essential protection requirements which are laid down in the Directive **2004/108/EU** (EMC Directive) of the council on the approximation of the laws of the Member States relating to electromagnetic compatibility and in the Directive **2006/95/EU** relating to electrical equipment designed for use within certain voltage limits.

The above products comply with the requirements of this directive and comply with the safety requirements for arc welding devices in accordance with the following product standards:

**EN 60 974-1: 2013-06**
Arc welding equipment - Part 1: Welding power source

**EN 60 974-2: 2013-11**
Arc welding equipment - Part 2: Liquid cooling systems

**EN 60 974-3: 2014-09**
Arc welding equipment - Part 3: Arc striking and stabilizing devices

**EN 60974-10: 2008-09**
Arc welding equipment - Part 10: Electromagnetic compatibility (EMC) requirements

according to the EC. Directive 2006/42/EC article 1, paragraph 2 the above mentioned products fall exclusively within the scope of the directive 2006/95/EC relating to electrical equipment designed for use within certain voltage limits.

This declaration is given for the manufacturer:
Joke Technology GmbH
Asselborner Weg 14-16
51429 Bergisch Gladbach
Germany

August 2022

submitted by

Udo Fielenbach

Managing Director