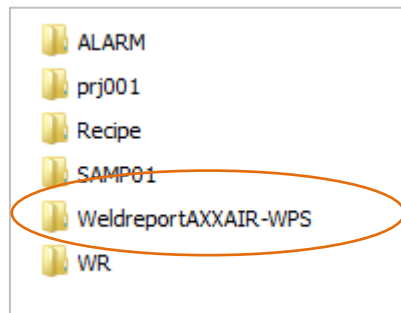


WELDREPORT-WPS FOR SAXX
Installation and guidelines

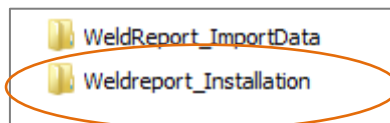
IMPORTANT : Please note that this software can not work until you've made some welds and an exportation of data to the USB key, as described in the user's manual, section 4.x Adjustment Menu/USB Key

Installation

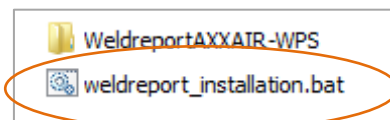
- Insert the USB key delivered with your power source on your PC
- Open the directory **WeldreportAXXAIR-WPS**



- Open the directory **Weldreport_installation**



- Launch the program **weldereport_installation.bat**



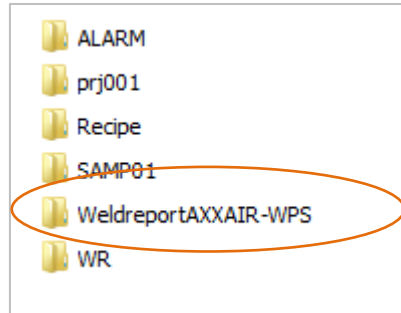
The necessary files will be copied to your hard disk, on the directory **C:/WeldreportAXXAIR-WPS**

Re installation

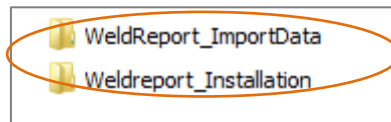
In case the program fails and if you cannot launch it again , then you'll have to reinstall the program and import the data

Guidelines

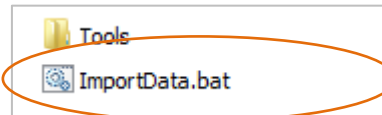
- Insert the USB key delivered with your power source on your PC
- Open the directory *WeldreportAXXAIR-WPS*



- Open the directory *Weldreport_ImportData*

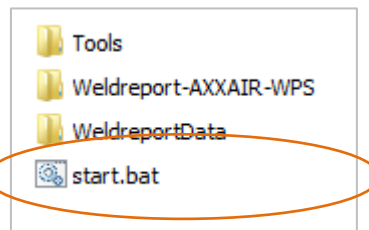


- Launch the program *ImportData.bat*



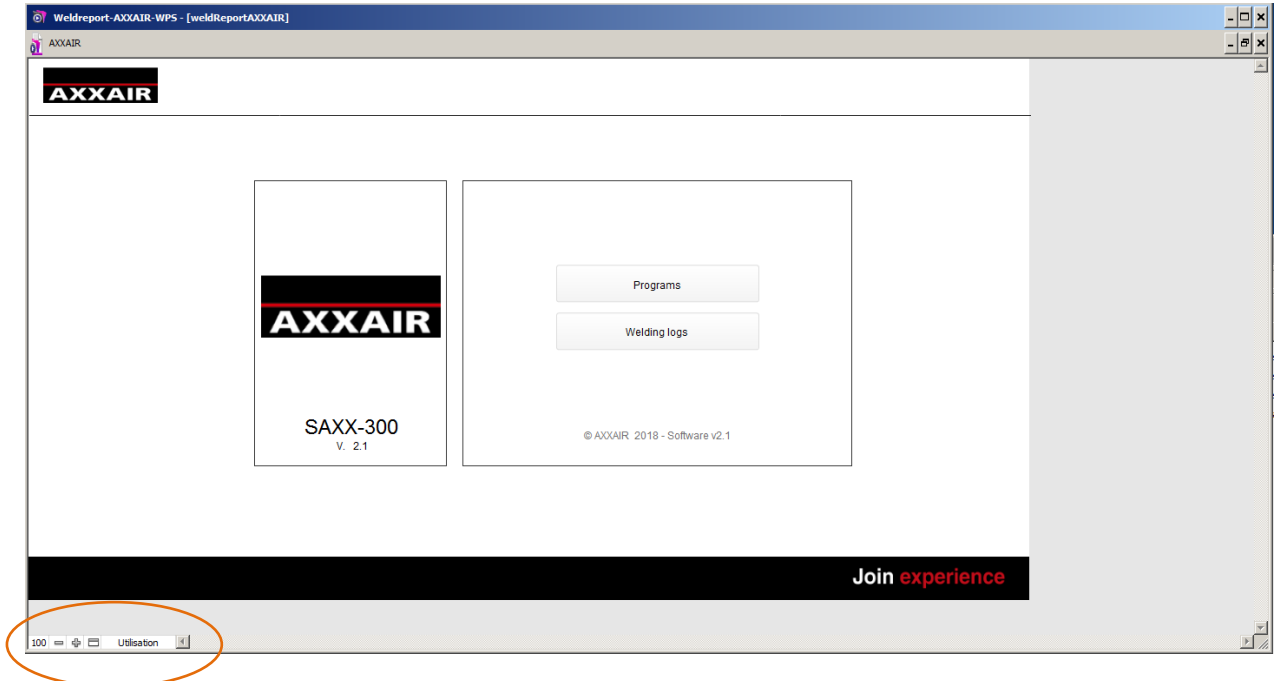
The data files will be copied onto your hardisk and the AXXAIR software will start automatically

- If you need to start the AXXAIR program directly from your PC, open the directory *C:/WeldreportAXXAIR-WPS* and launch the program *start.bat*



The data displayed will be the one from the latest import. THIS METHOD DOES NOT IMPORT DATA FROM THE USB KEY

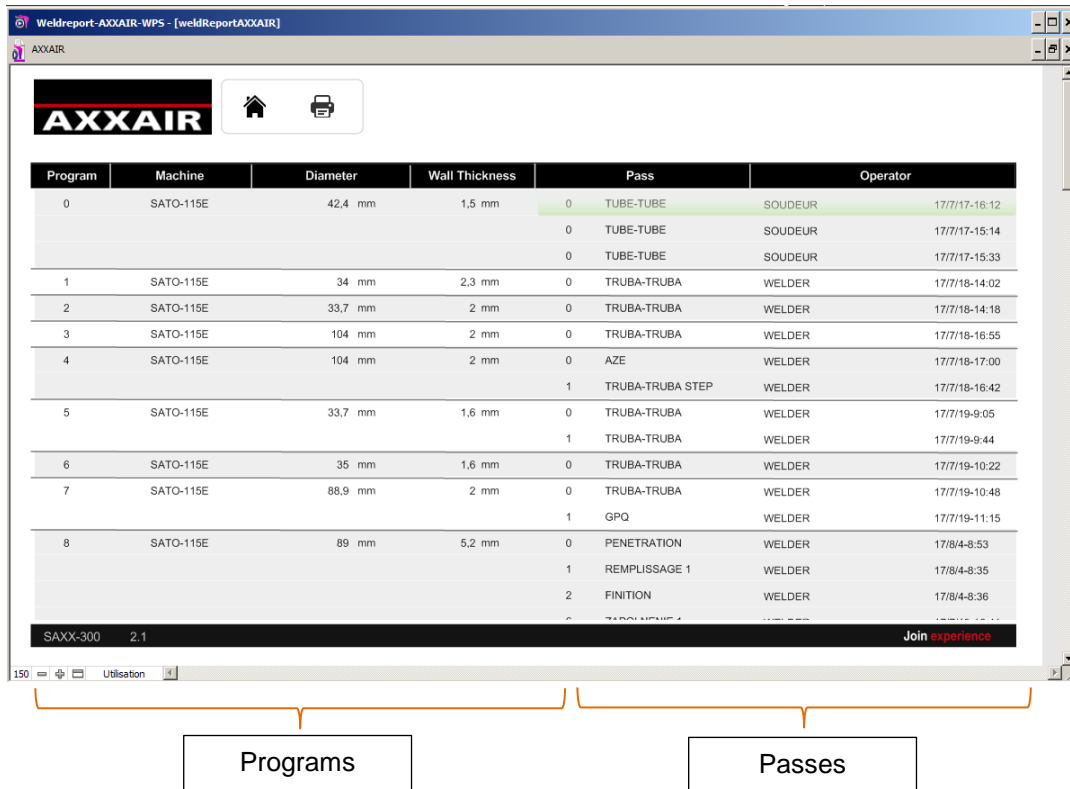
- The data are loaded and the home page is displayed



Zoom adjustment

Programs


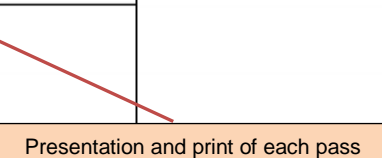
This page shows the programs and the associated passes



Program	Machine	Diameter	Wall Thickness	Pass	Operator
0	SATO-115E	42,4 mm	1,5 mm	0 TUBE-TUBE	SOUDEUR
				0 TUBE-TUBE	SOUDEUR
				0 TUBE-TUBE	SOUDEUR
1	SATO-115E	34 mm	2,3 mm	0 TRUBA-TRUBA	WELDER
				0 TRUBA-TRUBA	WELDER
2	SATO-115E	33,7 mm	2 mm	0 TRUBA-TRUBA	WELDER
3	SATO-115E	104 mm	2 mm	0 TRUBA-TRUBA	WELDER
4	SATO-115E	104 mm	2 mm	0 AZE	WELDER
				1 TRUBA-TRUBA STEP	WELDER
5	SATO-115E	33,7 mm	1,6 mm	0 TRUBA-TRUBA	WELDER
				1 TRUBA-TRUBA	WELDER
6	SATO-115E	35 mm	1,6 mm	0 TRUBA-TRUBA	WELDER
7	SATO-115E	88,9 mm	2 mm	0 TRUBA-TRUBA	WELDER
				1 GPQ	WELDER
8	SATO-115E	89 mm	5,2 mm	0 PENETRATION	WELDER
				1 REMPLISSAGE 1	WELDER
				2 FINITION	WELDER

Select a program or a pass to show the associated page

Programs – Program details

AXXAIR		Welding Procedure Specification			WPS N°
Machine: SAXX-200		Name: AG0A1611018		Version: 2.23	
Address	AXXAIR ZI LES BOSSES 26800 ETOILE	Welder	BRUNO	Machine	SXMF-17
WPQR N°		WQ		Calibration	
Base metal 1		Base metal 2		Filler metal	
Grade	STAINLESS	Grade	STAINLESS	Grade	
Standard Specification		Standard Specification		Standard Specification	
		Group/subgroup		Number	
Wall thickness	1,25 mm	Wall Thickness	1,25 mm	Wire Diameter	0,0 mm
Od Tube	12,70 mm	Od Tube	12,70 mm		
PV Number		PV Number		PV Number	
Type of joint AT		Configuration	Tube-Tube		
					
Preparation		Cleaning / Degreasing			
Program 0			Passes		
Pass	0	TUBE-TUBE		142	
Time /Heat Input					
Current / Assembly		DC(-)		in. (ft)	
					

Programs listing

Presentation and print of all the passes

Presentation and print of each pass

- The green fields are to be manually filled in according to your processes.
- The address come from the machine but can be modified if needed. It is a global address for all programs and welds.
- The Welder is the name of the one who created or modified the program.



Pass pages

AXXAIR		Program n°: 2	Pass n°: 0	Machine: SAUX-200 AGOA1611018 2.21				AXXAIR ZI LES BOSSES 26800 ETOILE													
Start Position																					
Rad Clearance	mm	1,6																			
Arc Gap	mm	1,0																			
Electrode Angle	°	20																			
Material		WCL(1/1%)																			
Angle Rod Position	°	90																			
Stick Out	mm																				
Nozzle Diam.	mm	0,0																			
Wire Angle	°	0																			
Torch Gas	%	Ar : 100	He : 0	N2 : 0	H2 : 0																
Arc Gas Flow Rate	L/min	25																			
Back Gas	%	Ar : 100	He : 0	N2 : 0	H2 : 0																
Back gas flow rate	L/min	10																			
Joint Tracking System		Without																			
AVC																					
Chacification		No																			
Clearing Between Pass																					
% Dynamic Operator	%	0																			
Chacification																					
Cac Moving Time	sec	0,00																			
Cac Stop Time	sec	Left: 0,00	Right: 0,00																		
Cac Amplitude	mm	0,00																			
Synchronization		No																			
Info Start																					
Preheat Time	sec	25,0																			
Preheating	sec	0,5																			
Options	A	26,6																			
Upstroke Time	sec	0,5																			
Wire Start Delay	sec	0,0																			
Level		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Weld Low Speed	mm/min	600,0	600,0	600,0	600,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
Weld High Speed	mm/min	600,0	600,0	600,0	600,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
Angle	°	30,0	30,0	30,0	30,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
High Current	A	43,0	41,0	39,0	37,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
Low Current	A	12,9	12,9	12,9	12,9	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
High Voltage	V	11,7	11,6	11,6	11,5	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
Low Voltage	V	10,5	10,5	10,5	10,5	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
High Pulse Time	sec	0,1	0,1	0,1	0,1	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
Low Pulse Time	sec	0,1	0,1	0,1	0,1	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
Wire High Speed	cm/min	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
Wire Low Speed	cm/min	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0	0,0
Overlapping																					
Weld Low Speed	mm/min	600,0																			
Weld High Speed	mm/min	600,0																			
Angle	°	10,0																			
High Current	A	36,0																			
Low Current	A	12,9																			
High Voltage	V	11,4																			
Low Voltage	V	10,5																			
High Pulse Time	sec	0,1																			
Low Pulse Time	sec	0,1																			
Wire High Speed	cm/min	0,0																			
Wire Low Speed	cm/min	0,0																			
Wire Stop Delay	sec	0,0																			
Come Back Wire	sec	0,0																			
Downslope																					
Dowstroke Time	sec	3,0																			
Post Welding Time	sec	0,1																			
Post Welding Current	A	7,2																			
Torch Postage	sec	20,0																			
Temperature Information																					
Inlet Air Temp.	°C	< 150 °C																			
Heat Input	J/mm																				
Heat Treatment after welding	°C																				
Preheat Temp.	°C																				
Maintain Temp.	°C																				
Postheat Temp.	°C																				

- The green fields are to be manually filled in according to your processes

Welding logs - Welding list (1000 seconds max)

Day selection

Date	19/02/22	Operator	BRUNO	Od Tube	114.30 mm	Program	2	Pass	0
Hour	12:55:40 - (SA00001.CS0)	Machine	SAJXX-200	Wall Thickness	1.00 mm	Welding Mode	Fusion		
Address	AXXAIR ZI LES BOSSES 26800 ETOILE	AGOA1611018 2.23		Material	INOXYDABLE	Heat Input	19 J/mm		

Hour	Step	Level	High Current	High Voltage	Low Current	Low Voltage	Weld Low Speed	Weld High Speed	Wire Low Speed	Wire High Speed	Angle	Arc Gas Flow Rate	Back gas flow rate	Alarm
			(A)	(V)	(A)	(V)	(mm/min)	(mm/min)	(cm/min)	(cm/min)	(°)			
12:54:15			0.0	0.0	0.0	0.0	0	0			0	0.0	0.0	-
12:54:16	Pre Torchgas						0	0			0	23.1	0.0	-
12:54:17	Pre Torchgas						0	0			0	21.1	0.0	-
12:54:18	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	20.3	0.0	-
12:54:19	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	20.0	0.0	-
12:54:20	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	20.0	0.0	-
12:54:21	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	19.9	0.0	-
12:54:22	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	19.9	0.0	-
12:54:23	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	19.9	0.0	-
12:54:24	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	19.9	0.0	-
12:54:25	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	20.0	0.0	-
12:54:26	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	25.2	0.0	-
12:54:27	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	32.0	0.0	-
12:54:28	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	36.0	0.0	-
12:54:29	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	36.3	0.0	-
12:54:30	Pre Torchgas		0.0	0.0	0.0	0.0	0	0			0	31.7	0.0	-

Hour selection

Join experience

- The pass and program number are the one recorded during the welding.
- The address is the one indicated on the program.
- The operator is the name of the one who made the weld.