

Table 6-1. Troubleshooting Guide - (Cont)

PROBLEM	POSSIBLE CAUSE	ACTION
	(If used with a mechanized torch and remote current setting signal:)	
	b) (1) Current setting switch is in the panel position.	b) (1) Correct current setting switch to remote position.
	(2) Current setting 0-10 V dc signal is missing.	(2) Check for 0-10 V dc current setting signal.
4. Arc does not transfer to work.	(If open circuit voltage is okay between 300-325 V dc and there is pilot arc:)	
	a) Open connection between the power source positive output and the work.	a) Repair connection.
	b) Power source work clamp not properly connected to workpiece.	b) Make work clamp connection to clean bare metal of workpiece.
	(If open circuit voltage is okay but there is no pilot arc:)	
	b). (1) Pilot arc fuse F1 or F2 or both are open.	b) (1) Replace fuse(s).
	(2) Faulty pilot arc contactor.	(2) Replace pilot arc contactor.
	(3) Replace PCB #1 P/N 38020.	(3) Replace PCB #1 P/N 38020.
	(4) Remove jumper J1 from the interface control PCB P/N 38048.	(4) Remove jumper J1 from the interface control PCB P/N 38048.

D-35656-G

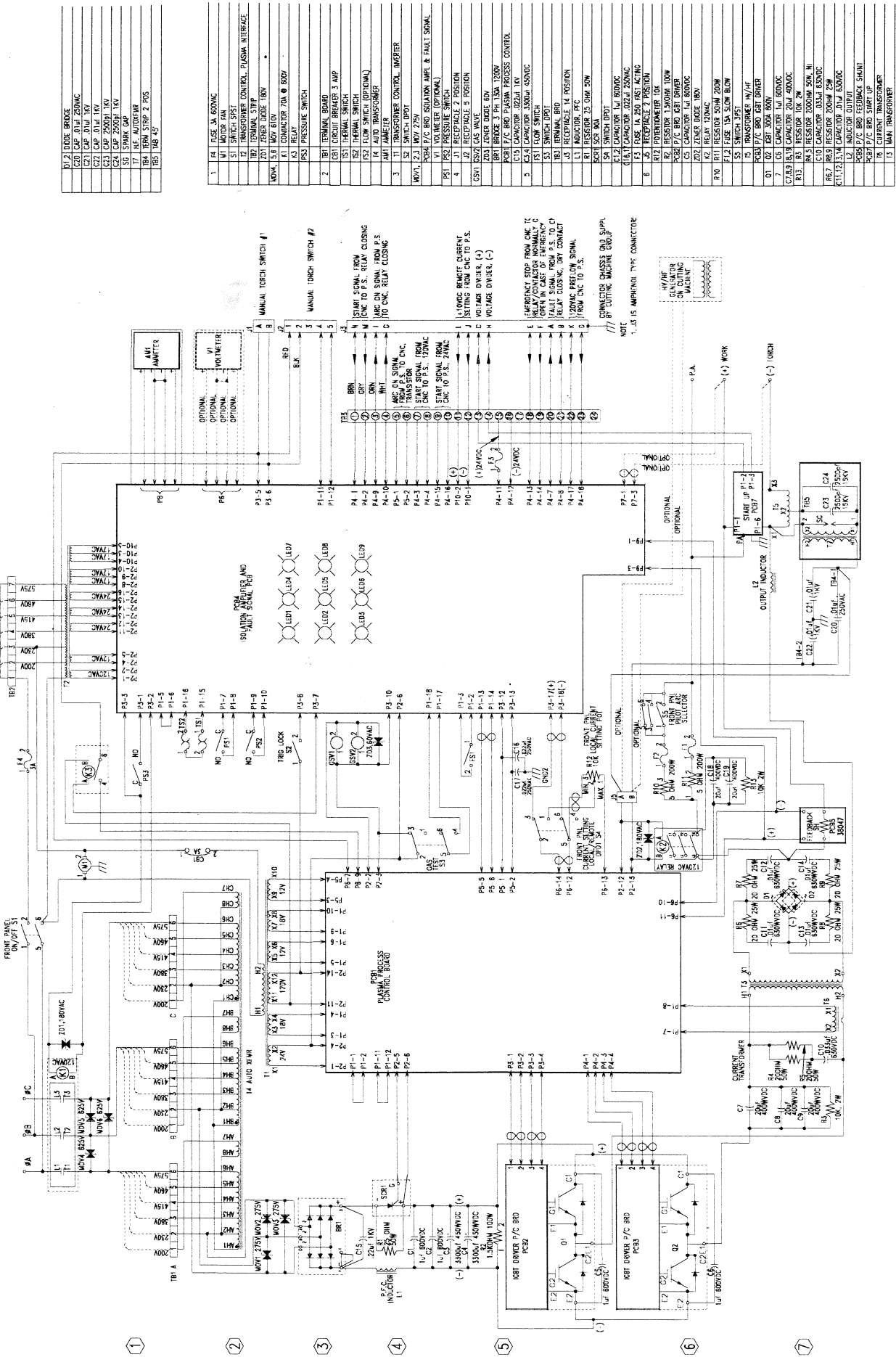


Figure 6-1. ESP-100i Schematic Diagram