



# *WeldComputer*

## **Presenting WeldComputer Corporation's L-Series Resistance Welding Control**

The WeldComputer® L-Series Resistance Welding Control provides precise heat control for all single and three phase resistance welding applications. The PC-based system is fully programmable and includes the following standard features:

- ✓ a patented precision heat control/ line compensation system
- ✓ eight optically isolated industry standard 110 Volt AC input and eight output modules (other AC and DC voltage I/O modules are also available)
- ✓ a safety relay to protect the operator by physically disabling weld valve and forge valve voltage when no weld initiation signal is present
- ✓ a frequency fluctuation compensation system that accommodates severe variation
- ✓ sentinel systems that prohibit welding and notify the operator when severe power line anomalies occur
- ✓ a NEMA 12 enclosure to protect the control electronics from the factory environment
- ✓ fractional forge delay control programmable with 0.1 cycle resolution
- ✓ virtually unlimited storage capacity for weld schedules on removable media
- ✓ a choice of operator interfaces



Options available:

- ✓ Digital Programmable Air Systems for setting cylinder pressures from the weld schedule ( 0.1 or 0.5 PSI resolution)
- ✓ Programmable Motor Control
- ✓ Brown-out Monitor to stop the welding process and alert the operator if plant line voltage sags
- ✓ SCR/ Firing Systems
- ✓ 24 VDC Power Supplies for DC IO Modules
- ✓ High speed on-line storage upgrade for rapid access of 100 weld schedules

**WeldComputer® technology is protected by the following U.S. Patents:  
4,714,913 4,742,473 4,803,331. Other Patents Pending.  
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## **L-Series Control Welding Sentinels and Brownout Monitor Upgrade**

The following welding sentinels are part of the basic L-Series Control functionality:

**Condition:** An individual delivered heat pulse is less than 50% of its intended value.

**Action:** Welding is prohibited and the message “Abnormal Power Condition” is displayed on the data terminal. Pressing the “enter” key resets the system and enables welding.

**Condition:** The control cannot compensate for the line voltage.

**Action:** Welding is prohibited and the message “Compensation range exceeded” is displayed on the data terminal. Pressing the “enter” key resets the system and enables welding.

### **Optional Brownout Monitor**

The L-Series Control Brownout Monitor Upgrade is designed to stop the welding process and alert the operator when plant line voltage sags. The monitor detects the following condition and takes the corresponding action:

**Condition:** Line voltage drops by 20%.

**Action:** Welding is prohibited, Output 7 optionally turns “on”, and the message “Brown-out limit exceeded” is displayed on the data terminal. Pressing the “enter” key resets the system and enables welding.