ORBITMASTER WeldHost Software
Version 1.65.3.51

Release Notes

Contents

DOCUMENT REVISION HISTORY

Revision	Date	Description
1	7/31/15	Initial release of 1.65 software (v.1.65.3.48)
2	8/19/15	Update for 1.65.3.51

INTRODUCTION

WeldHost is the software that runs on the ORBITMASTER welding control console. The WeldHost team continues to add and improve features. These Release Notes document the following aspects of version 1.65:

- New features
- Improvements
- Fixed defects
- Known issues
- Pre-installation evaluation of the equipment
- Installation instructions
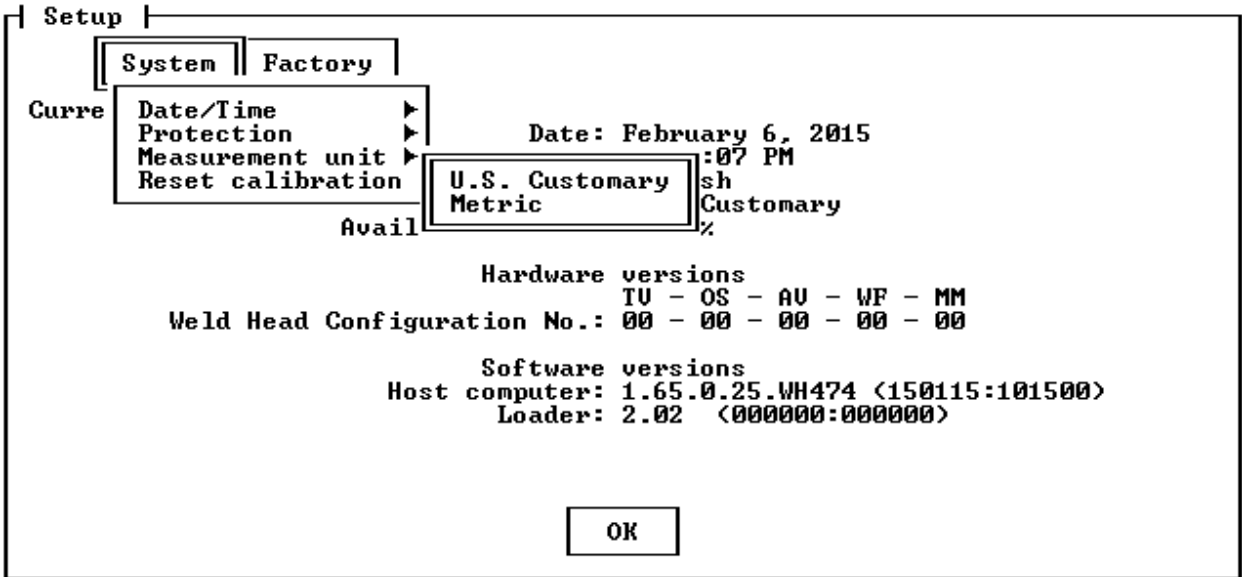- Instructions to re-install a previous software release

WELDHOST VERSION 1.65.3.51
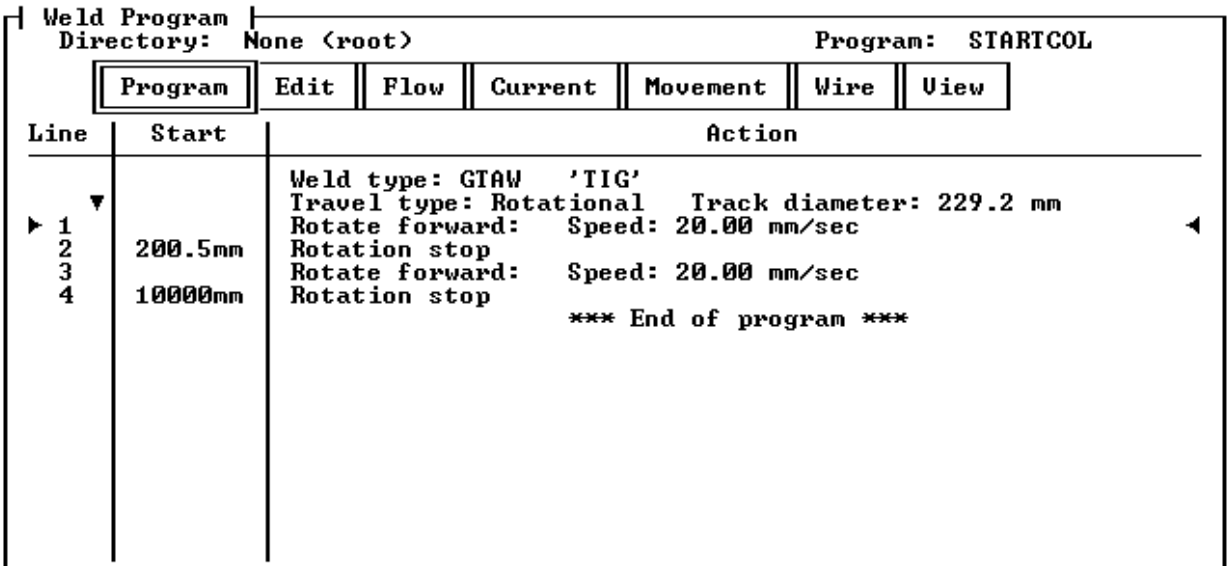
NEW FEATURES

- **Support for Metric Units of Measure** (ref #: WH-474).

  The OrbitMaster welding control console now supports metric units of measure.

  Change measurement units from U.S. Customary (default) to Metric from the Setup screen via the System→Measurement unit menu.

```
┌┤ Setup ├─────────────────────────────────────────────────────────────┐
│     ┌────────�╥────────┐                                               │
│     │ System ║ Factory │                                              │
│ Curre│ Date/Time        ▶                                             │
│      │ Protection       ▶        Date: February 6, 2015               │
│      │ Measurement unit ▶┌─────────────────┐:07 PM                    │
│      │ Reset calibration │ U.S. Customary  │sh                        │
│      │                   │ Metric          │Customary                 │
│              Avail└──────└─────────────────┘%                         │
│                                                                       │
│                     Hardware versions                                 │
│                         TV - OS - AV - WF - MM                        │
│          Weld Head Configuration No.: 00 - 00 - 00 - 00 - 00          │
│                                                                       │
│                     Software versions                                 │
│          Host computer: 1.65.0.25.WH474 (150115:101500)              │
│                 Loader: 2.02  (000000:000000)                         │
│                                                                       │
│                          ┌──────┐                                     │
│                          │  OK  │                                     │
│                          └──────┘                                     │
└───────────────────────────────────────────────────────────────────────┘
```

Metric measurements are in millimeters (mm) for distance and millimeters per second (mm/sec) for velocity measurements.

```
┌┤ Weld Program ├──────────────────────────────────────────────────────┐
│   Directory:  None (root)                        Program:  STARTCOL   │
│     ┌─────────╥──────╥──────╥─────────╥──────────╥──────╥──────┐      │
│     │ Program ║ Edit ║ Flow ║ Current ║ Movement ║ Wire ║ View │      │
│   Line │  Start │                    Action                          │
│   ─────────────────────────────────────────────────────────────      │
│        ▼     Weld type: GTAW   'TIG'                                  │
│   ▶ 1        Travel type: Rotational   Track diameter: 229.2 mm    ◀  │
│     2        Rotate forward:    Speed: 20.00 mm/sec                   │
│     3 200.5mm Rotation stop                                           │
│     4 10000mm Rotate forward:    Speed: 20.00 mm/sec                  │
│              Rotation stop                                            │
│                        *** End of program ***                        │
│                                                                       │
└───────────────────────────────────────────────────────────────────────┘
```

- Support for Miller Auto-Axcess® 450 RMD processes (ref #: WH-1186).

  The Miller Auto-Axcess power source is now supported, allowing use of Miller's RMD process with this power source. Requires power source harness PN 79-0307.

```
┌┤ System Protection ├───────────────────────────────────────────┐
│ ┌──────────┐┌──────────┐                                        │
│ │ Weld Head ││ Hardware │                                       │
│ └──────────┘└──────────┘                                        │
│   Select one from the following options using SPACEBAR key.     │
│                                                                 │
│   Power source selection:                                       │
│   [ ] Miller XMT 450                                            │
│   [ ] Miller XMT 350                                            │
│   [ ] Miller Big Blue 700/800                                   │
│   [ ] Miller PipePro 450 RFC                                    │
│   [X] Miller Auto Axcess 450                                    │
│                                                                 │
│   Flow sensors setting:                                         │
│   [ ] Disable gas flow sensor.                                  │
│   [ ] Disable coolant flow sensor.                              │
│                                                                 │
│   Console control settings:                                     │
│   [ ] Disable coolant controls.                                 │
│                                                                 │
│                                                                 │
└─────────────────────────────────────────────────────────────────┘
```

IMPROVEMENTS

- WH-1189: Miller RMD™ programs now have process specific default override values.
- WH-1205: Miller Big Blue® 700 power source is now supported.
- WH-1275: 2G sample weld programs now provided for 6" schedule 40 with counter bore using GMAW-S root and GMAW-P cap.
- WH-1278: Printed files now appear in appropriate sub-directories in the 'Print' folder of external memory.

FIXES

- WH-1234: Fixed issue with erroneous text in the real-time data screen.
- WH-1236: Fixed issue with end time of first weld of chained weld programs displaying in program modifications instead of end time of the last program in the chain.
- WH-1250: Fixed issue with occasional downslope errors in GMAW-P programs.
- WH-1267: Fixed occasional system lock-up when entering program notes.
- WH-1269: Fixed issue with RMD override defaults not always loading properly.
- WH-1272: Fixed issue with incorrect sign on travel overrides in program modifications with parameter protection active.
- WH-1274: Fixed issue with "CRC checking error…" message appearing when opening older weld programs.
- WH-1276: Fixed issue with incorrect pendant display when performing fine travel axis overrides.

- WH-1280: Fixed issue with occasional incorrect text for Torch/Tungsten Up/Down commands when printing weld programs.
- WH-1284: Fixed issue with travel axis motion instability in certain conditions.

KNOWN LIMITATIONS

- Units of Measure Interoperability

  Weld programs created in a unit of measure other than that currently selected cannot be loaded. When an attempt to do so is made, the following message is displayed.

```
┤ Library ├──────┤ Directory: None <root> ├─────────────────────┤ System memory ├
    ┌─────────┬──────────┬───────────────────┬──────────┐
    │   Edit  ║   View   ║  External memory  ║   Print  │
    └─────────┴──────────┴───────────────────┴──────────┘

  2HotGT                KCM_PPro_Test_01     rmdDales2          SlpDist-US
  3FillFCFwd            Lin-IndxTst-M        Rot-IndxTst-M      Test
  4FillGT               Lin-IndxTst-US       Rot-IndxTst-US     test1
  12inZigZagDavid       Lin-TvlDist-M        Rot-SlpDist-M      test2
  12inZigZagDemo3       Lin-TvlDist-US       Rot-SlpDist-US     testk
    ┌──────────────────────────────────────────────────────────────────┐
    │ WARNING: System Unit of Measure Mismatch!                          │
    │         To open the selected weld program, change the current units│
    │         via the System->Measurement unit menu in the Setup screen. │
    │                                                                    │
    │ Press any key to proceed                                           │
    └──────────────────────────────────────────────────────────────────┘
  GMAW-SA Rot           osc4                 RTD-TvlVel-M       Wire
  gmawtest3             ProgMod-M            RTD-TvlVel-US      WP_1
  GMAW_160              ProgMod-US           RTD-WireVel-M      ~HI_GMAW
  GMAW_K                RMD                  RTD-WireVel-US     ~HI_RMD
  GTAW_K                RMD1                 Sample-M           ~HI_TIG
  KCM_PipePro_02        RMD2                 Sample-US          <1.60>
  KCM_PipePro_03        RMD3                 SlpDist-M          <6Sc80T6GT35-m>
```

  When the user attempts to access such a mismatched program from the pendant, the following message will appear on the console accompanied by a "Unit Mismatch" error on the pendant.

```
┤ Library ├──────┤ Directory: None <root> ├─────────────────────┤ System memory ├
    ┌─────────┬──────────┬───────────────────┬──────────┐
    │   Edit  ║   View   ║  External memory  ║   Print  │
    └─────────┴──────────┴───────────────────┴──────────┘

  2HotGT                KCM_PPro_Test_01     rmdDales2          SlpDist-US
  3FillFCFwd            Lin-IndxTst-M        Rot-IndxTst-M      Test
  4FillGT               Lin-IndxTst-US       Rot-IndxTst-US     test1
  12inZigZagDavid       Lin-TvlDist-M        Rot-SlpDist-M      test2
  12inZigZagDemo3       Lin-TvlDist-US       Rot-SlpDist-US     testk
  154_N                 LinearCal-M          Rot-TvlDist-M      testtest
  12345678901┌──────────────────────────────────────────────────┐D
  asdf       │   Weld program units do not match system units.   │
  FCAW-Rot Me│                                                    │-M
  FCAW_K     │   Press any key to proceed                         │-US
  GMAW-P_K   └──────────────────────────────────────────────────┘
  GMAW-SA Rot++         osc4-k               RTD-RotPos-US      WH967_test
  GMAW-SA Rot           osc4                 RTD-TvlVel-M       Wire
  gmawtest3             ProgMod-M            RTD-TvlVel-US      WP_1
  GMAW_160              ProgMod-US           RTD-WireVel-M      ~HI_GMAW
  GMAW_K                RMD                  RTD-WireVel-US     ~HI_RMD
  GTAW_K                RMD1                 Sample-M           ~HI_TIG
  KCM_PipePro_02        RMD2                 Sample-US          <1.60>
  KCM_PipePro_03        RMD3                 SlpDist-M          <6Sc80T6GT35-m>
```

  Currently, weld programs must be manually converted between units of measure.

ASSOCIATED MATERIALS/DOCUMENTATION

- WeldHost Software, PN 69-0150
- ORBITMASTER Manual, PN 92-1250

SOFTWARE INSTALLATION INSTRUCTIONS

BACK UP ALL WELD PROGRAMS BEFORE PERFORMING A SOFTWARE UPDATE.

Customers, who have multiple ORBITMASTER control consoles, must install the software update on one system and verify that the issues, presented in the UPGRADE CONSIDERATIONS section, do not cause problems before they update all of their systems.

Install the software update by doing the following:

1. Obtain installation files from your Tri Tool customer support representative.
2. Copy the following files/folders into the root (not a sub-folder) of a USB flash drive:
   - Weldhost.RTB
   - Hostload.RTB
   - Factr.dat
   - Wprog (folder)
3. With the ORBITMASTER control console powered down, plug the USB flash drive into the USB port that is on the top of the device.
4. Power-up the ORBITMASTER control console and wait for the system to boot. This will install software onto the system.

   <u>**Do not power down the system or remove USB flash drive until system boot-up is complete.**</u>

5. Press the Escape key after the "What do you want to do?" screen is displayed to dismiss it. Verify that the software version number displayed matches the update version number.

   If software version number is not updated, ensure that the files are correct and are in the USB flash drive root, and retry. If problems persist, contact Tri Tool for technical support.

6. Update the sample program files.
   a. Navigate to the Weld Program Library.
   b. Select "External memory".
   c. Highlight all folders by highlighting the first folder, and then hold Shift down and press the down arrow key until all folders are highlighted.
   d. Select Edit→Copy (or press Ctrl+C) to copy the folders.
   e. Select "System memory".
   f. Select Edit→Paste (or press Ctrl+P) to paste the selected folders. This overwrites the existing folders and the existing programs with updated programs.

SOFTWARE ROLLBACK INSTRUCTIONS

Consult with Tri Tool customer service before you perform a Software rollback (re-installing a previous software release).

Some software releases require changes to the weld program file versions. Therefore, programs edited or created after the release is installed cannot be opened by older software releases. To perform a software rollback do the following:

1. Obtain previous release installation files from your Tri Tool customer support representative.
2. Follow steps 2-6 in SOFTWARE INSTALLATION INSTRUCTIONS.
3. Copy any backup weld programs onto the system as described in Step 6 in SOFTWARE INSTALLATION INSTRUCTIONS.

QUESTIONS OR PROBLEMS?

Contact Tri Tool Today

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