



**ORBITMASTER WeldHost Software**  
Version 1.65.3.53

Release Notes



# Contents

**DOCUMENT REVISION HISTORY** ..... 3

**INTRODUCTION** ..... 3

**WELDHOST VERSION 1.65.3.48** ..... 4

    NEW FEATURES ..... 4

- Support for Metric Units of Measure ..... 4
- Support for Miller Auto-Axcess® 450 RMD processes ..... 5

    IMPROVEMENTS ..... 5

    FIXES ..... 5

    KNOWN LIMITATIONS ..... 7

**WELDHOST VERSION 1.65.3.51** ..... 8

    FIXES ..... 8

**WELDHOST VERSION 1.65.3.52** ..... 8

    FIXES ..... 8

**WELDHOST VERSION 1.65.3.53** ..... 8

    FIXES ..... 8

**ASSOCIATED MATERIALS/DOCUMENTATION** ..... 9

**SOFTWARE INSTALLATION INSTRUCTIONS** ..... 9

**SOFTWARE ROLLBACK INSTRUCTIONS** ..... 10

**QUESTIONS OR PROBLEMS?** ..... 10



---

## 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
3	9/4/15	Update for 1.65.3.52
4	5/10/16	Update for 1.65.3.53

## 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



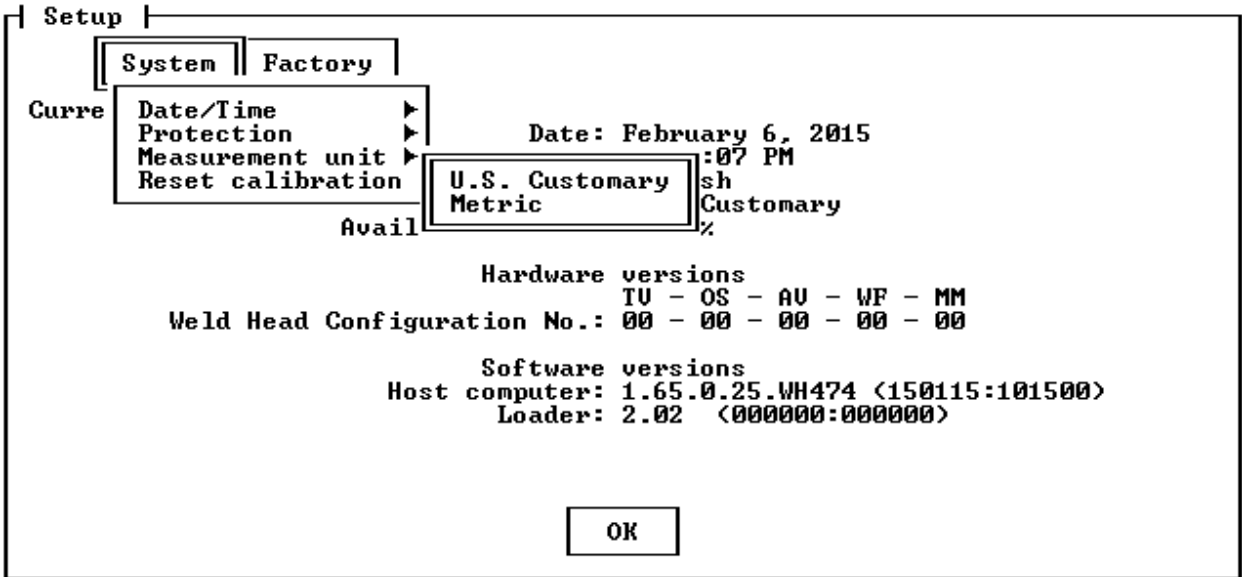
# WELDHOST VERSION 1.65.3.48

## NEW FEATURES

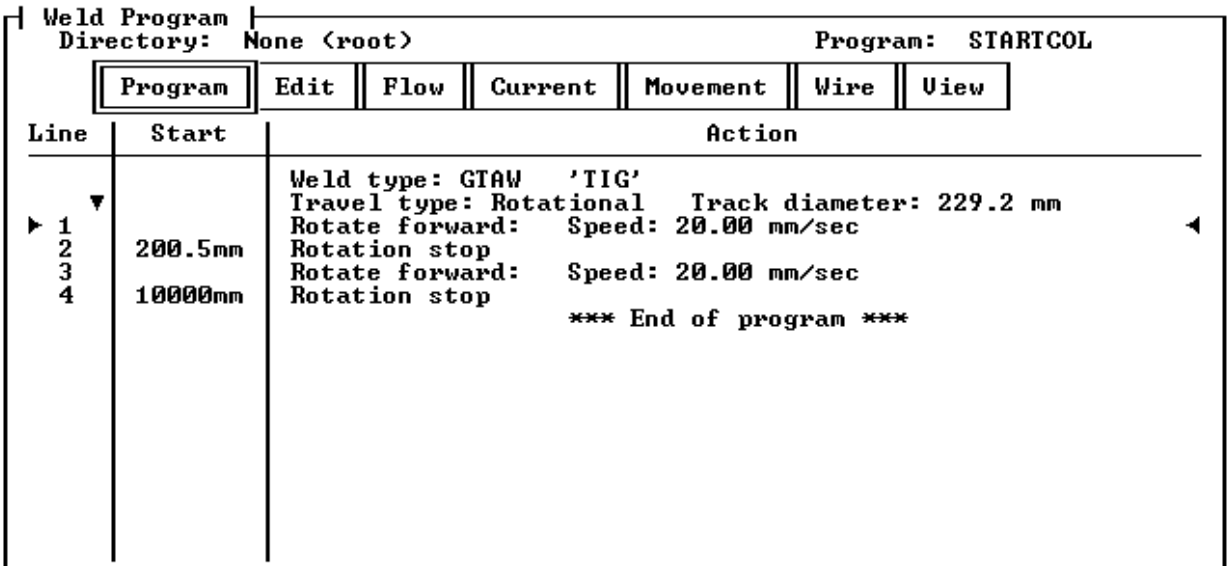
- Support for Metric Units of Measure (ref #: WH-474).

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.



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





- [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-Tv1Dist-M    Rot-SlpDist-M  test2
12inZigZagDemo3 Lin-Tv1Dist-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-Tv1Uel-M   Wire
gmawtest3       ProgMod-M        RTD-Tv1Uel-US  WP_1
GMAW_160        ProgMod-US       RTD-WireUel-M  ~HI_GMAW
GMAW_K          RMD              RTD-WireUel-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-Tv1Dist-M    Rot-SlpDist-M  test2
12inZigZagDemo3 Lin-Tv1Dist-US   Rot-SlpDist-US testk
154_N          LinearCal-M       Rot-Tv1Dist-M  testtest
12345678901
asdf
FCAW-Rot Me    Weld program units do not match system units.
FCAW_K         Press any key to proceed
GMAW-P_K
GMAW-SA Rot++  osc4-k           RTD-RotPos-US  WH967_test
GMAW-SA Rot    osc4             RTD-Tv1Uel-M   Wire
gmawtest3       ProgMod-M        RTD-Tv1Uel-US  WP_1
GMAW_160        ProgMod-US       RTD-WireUel-M  ~HI_GMAW
GMAW_K          RMD              RTD-WireUel-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.



---

## **WELDHOST VERSION 1.65.3.51**

### **FIXES**

- WH-1285: Fixed issue with metric weld programs, where travel commands that slope over a number of degrees would not complete.

## **WELDHOST VERSION 1.65.3.52**

### **FIXES**

- WH-1287: Fixed issue with program modification screen displaying incorrect values for overrides.

## **WELDHOST VERSION 1.65.3.53**

### **FIXES**

- WH-1301: Fixed issue with system locking up when using certain metric weld programs, which have very fast reverse travel speeds.





---

## 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.

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

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

Toll Free:	(800) 345-5015
Main Line:	(916) 288-6100
Email:	<a href="mailto:customer.service@tritool.com">customer.service@tritool.com</a>
Support Web Page:	<a href="http://adaptarcsupport@tritool.com">adaptarcsupport@tritool.com</a>
Company Web Page:	<a href="http://www.tritool.com">www.tritool.com</a>