



ORBITMASTER WeldHost Software
Version 1.66.3.43

Release Notes



Contents

DOCUMENT REVISION HISTORY 3

INTRODUCTION 3

WELDHOST VERSION 1.66.3.43 4

 NEW FEATURES 4

 • Hotwire GTAW welding wire pre-heating system compatibility 4

 IMPROVEMENTS 6

 FIXES 6

ASSOCIATED MATERIALS/DOCUMENTATION 8

SOFTWARE INSTALLATION INSTRUCTIONS 8

SOFTWARE ROLLBACK INSTRUCTIONS 9

QUESTIONS OR PROBLEMS? 10



DOCUMENT REVISION HISTORY

Revision	Date	Description
1	10/18/17	Initial release of 1.66 software (1.66.3.43)

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 1.66:

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

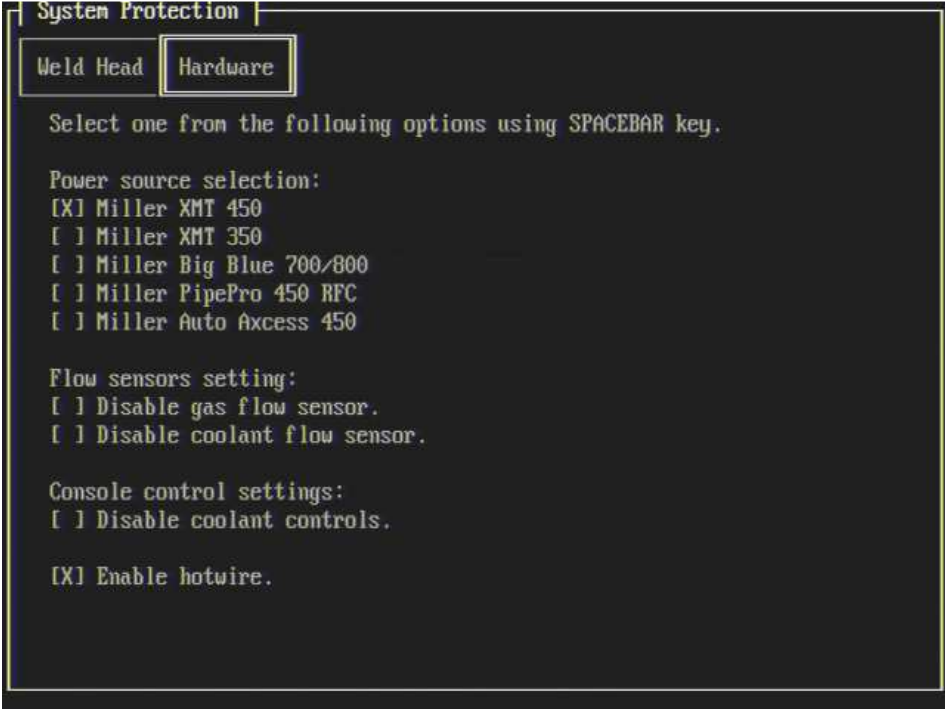


WELDHOST VERSION 1.66.3.43

NEW FEATURES

- Hotwire GTAW welding wire pre-heating system compatibility

Hotwire capability is now supported. This requires installation of a hardware kit into the OrbitMaster control console. Once installed, the feature must be enabled to be used.



Hotwire feature enable (Setup: System→Protections→Settings)

Wire is preheated by electrical current, with higher current heating the wire more. AC current and frequency are controlled via weld program command.



View factory software settings
Hardware (All weld types):

AVC	Oscillation	Weld power	Hotwire	Travel	Weld head	Wire feed
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Hotwire limitations:

Feature	Min	Max	Default	Unit
ID: U1000 105-8V	current 0.0	100.0		A
	frequency 250	400	400	Hz

Hotwire controller constants:

	Unit
Frequency command D-to-A scaling	10.00 counts/Hz
command offset frequency	0.00 Hz
Sensed current A-to-D scaling	110.000 counts/A
Sensed voltage A-to-D scaling	355.000 counts/V
Current loop coefficient	KV1 -0.2500 KV2 -0.3500 N/A

Hotwire parameters/settings (Setup: Factory→View→Min/max values→Hardware)

Weld Program
Directory: None (root) Program: ac_hotwire

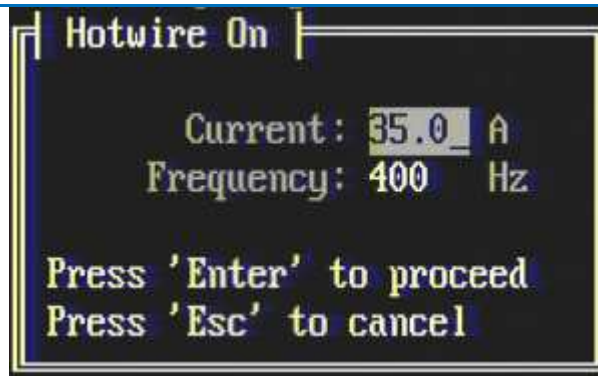
Program	Edit	Flow	Current	Movement	Wire	View
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Line	Start	Action
▶ 1		HotWire On: Ignition Settings
2	60	HotWire Off: Downslope Hotwire Stop

Hotwire On ▶
Hotwire Off ▶

- Slope (over a number of) degrees
- Slope (over a period of) time
- Slope (over) distance
- No Slope**

Hotwire command entry (Program Editor: Current→Hotwire)



Hotwire command parameter entry

IMPROVEMENTS

- WH-681: An alert is now displayed if a commanded travel velocity on a rotational track would exceed the maximum travel speed of the weld head.
- WH-1289: Pulsed travel now able to be simulated in test mode.
- WH-1295: Added new fault when arc is on and no gas is flowing.
- WH-1296: Printing now mimics the weld console directory structure but does not create a subdirectory for each program.
- WH-1299: Commanded travel speeds are now more precise.
- WH-1312: AVC raises and wire retracts a set distance to prevent wire/tungsten sticking when a Tungsten/Wire Touched fault occurs.
- WH-1331: Weld programs are now validated when loaded, whereas previously they were only validated on editing. This prevents programs with invalid commands or other parameters from being run.

FIXES

- WH-1121 – Fixed an issue where travel direction was reversed when speed was set to zero with a positive override commanded.
- WH-1290 – Fixed an issue with GMAW-P PPS overrides not being displayed properly in the program modifications screen.
- WH-1299 – Fixed an issue where override values would not match those found in pendant settings.
- WH-1300 – Fixed an issue where the weld head would sometimes continue to travel when downslope was pressed in a GTAW program.
- WH-1304 – Fixed an issue where incorrect units would sometimes be displayed in program notes.
- WH-1305 – Fixed an issue where the system units would sometimes be lost after a factory settings reset.
- WH-1311 – Fixed an issue with real-time data values locking up.
- WH-1313 – Fixed an issue where torch in commands would move slower than expected.
- WH-1314 – Fixed an issue where real time data travel speeds would update slower when using Metric units.
- WH-1315 – Fixed an issue where the travel calibration dialog would show incorrect values for travel encoder configuration 01.
- WH-1317 – Fixed issue with travel stopping while sloping over very long distances.



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- WH-1319 – Fixed issue with erroneous values displayed on pendant when overriding travel while sloping.
 - WH-1321 – Fixed an issue with oscillation when AutoSteer was used over long distances.
 - WH-1323 – Fixed an issue where the stop button had to be pressed before starting a weld.



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

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