

APPLICATION NOTE 700158L ERROR CODES*

ERROR CODE	Reason or Cause
01	Temperature limit exceeded (TLS open). / Incorrect b.5. or P.O. programmed.
02	FS1 & FS7 are both active.
03	FS1 & FS11 are both active.
04	Weld initiated while in PROGRAM mode.
05	FS1, FS3, FS7, or FS11 is active upon power up.
06	BACK-STEP is active too long. / Input switch closed. / Incorrect b.5. or P.O. programmed.
07	FS1 still active after weld.
08	FS3 still active after weld.
09	FS7 still active after weld.
10	FS11 still active after weld.
11	Control Relay still active after weld.
12	Hardware error is detected.
13	Full conduction is detected.
14	EEPROM error is detected (refer to Application Note 700127).
14 - flashing	Invalid data in EEPROM (refer to Application Note 700127).
15	Pressure Switch is open too long.
16	Emergency Stop is active.
17	Nominal AVC reading is too low.
18	Nominal AVC reading is too high.
19	AVC reading is too low.
20	AVC reading is too high.
21	+5 VDC is out of range.
22	+18 VDC is out of range.
23	Maximum firing angle exceeded during AVC correction.
24	Minimum firing angle exceeded during AVC correction.
25	Power factor measured as zero.
26	Sense input active while not welding. / Shorted SCRs. / Incorrect wiring or missing L2.
27	Retraction not active upon initiation.
28	Front Panel NO WELD switch is active for P.O.=10 or for <i>EN1000/EN1001 Cascade only</i> P.O.=33 .
29	Schedule out of range for 5.5.=03 when using S49 or S99 option.
30	Over current (<i>EN1200 and EN1201 only</i>).
31	IIC Error.
32 - flashing	Invalid data in EEPROM (refer to Application Note 700127).
33	MM2 is not found. Memory Module required.
34	Downloading data from MM2 Checksum Error.
35	Copy data to MM2 Checksum Error.
36	Pressure Sense input is too low or too high.
37	Calibration data out of range (<i>EN1001 only</i>).
38	DC bus voltage is too low (<i>EN1200 and EN1201 only</i>).
39	DC bus voltage is too high (<i>EN1200 and EN1201 only</i>).
40	Control with programmed ID not found on the RS485 network (<i>RT4 only</i>).
41	Message is not received from the control (<i>RT4 only</i>).
42	Communication Error (<i>RT4 only</i>).
43	Checksum Error in data bytes (<i>RT4 only</i>).
44	DC bus voltage is too high. Send signal to Circuit Breaker Shunt Trip (<i>EN1200 and EN1201 only</i>).
45	One or two of the three phases are missing (<i>EN1200 and EN1201 only</i>).
46	Setup failed. Control failed to adjust for signal level (<i>EN1001/EN1001 Cascade only</i>).
47	Over current from Primary Current Sensor (<i>EN1200 and EN1201 only</i>).
48	SCR's Firing Board is not ready for weld (<i>EN1200 and EN1201 only</i>).
90	Error Output from control to ENLINK, High.
91	Error Output from control to ENLINK, Low.
d.o.u.n.	VCC power supply voltage below safe operating range.
H. i. or L.o.	Flashing on DATA display if control is unable to correct and maintain constant current during weld. Generally shown after weld for P.O.=12, 13, 14, 22, 23, 24 or 25 (<i>EN1001 and EN1201 only</i>).
E.5. - flashing	Emergency Stop is active.