



PI 200-250/Zeta 40-60 software history

PI 200 MMA	10005201 (not incl. on SD card)	1.04
Pi 250 MMA	10005101 (not incl. on SD card)	1.03
Pi 200-250	10005001 (not incl. on SD card)	1.38
Zeta 40-60	10005301 (not incl. on SD card)	1.02

Version no.	Following improvements have been implemented in the current version
1,03 29-11-2005	<ul style="list-style-type: none"> Production test software has been added
1,05 16-6-2006	<ul style="list-style-type: none"> Arc ignition is improved.
1,06 20-6-2006	<ul style="list-style-type: none"> HF ignition is improved. This happened by delaying the HF spark 70mS from they key being pressed. It ensures that there is 80V open-circuit voltage at the time of ignition instead of 65V as on previous software. Detection of short-circuit between + and – has been improved.
1,10 3-8-2006	<ul style="list-style-type: none"> New software is implemented to support the remote control function in the new generation of Pi machines
1,12 5-12-2006	<ul style="list-style-type: none"> Stop current can be adjusted down to 1%. The software has taken over registration of possible water errors which was previously registered by water control PCB 71613479 version C and previous. The new software will therefore also function with water control PCB version D. Water error can be reset by pressing the MMA/TIG button. Menu for remote control has been removed. This means that machines delivered as default with remote control are activated, also when remote control kit is not fitted. Input level is 0V - 10V. Service functions H20-test/GAS-test/FAN-test have now become hold function when the A button is pressed.
1,20 19-11-2007	<p>SOLVED BUG:</p> <ul style="list-style-type: none"> Spot time is now ALWAYS disabled in MMA regardless of previous setting in TIG. <p>IMPROVEMENTS: See operation manual for further information</p> <ul style="list-style-type: none"> Resetting of the program in use shall now be done by holding down the program button for 5 sec. (display blinks when the program is reset) Cooling error is now shown with blinking 'H2O' USER MENU is implemented Gas purge is implemented (GAS) Panel lock is implemented (PA.L); Program lock is possible from (PG.L.) P3 to P10 in all programs D.O.C. is moved to user menu Possibility of choosing 3 different taste-/slope-down functions (Mode4T) in UserMenu is implemented
1,21 18-02-2008	<p>SOLVED BUG:</p> <ul style="list-style-type: none"> When we introduced the 3 different trigger/slope methods in version 1.20, an error slipped in. Now the error has been corrected. When triggering in 4T, you had to release the trigger again before slope up began. The correct Migatron standard function has been brought back so when you trigger in 4T, slope up must begin at once. <p>IMPROVEMENTS:</p> <ul style="list-style-type: none"> Minimum welding current is now 5Amps. Welding timer is now adjusted in steps of 10msec. Minimum TIG START current can now be adjusted to 1%. DC Pulse frequency has been increased up to 523Hz.

PI 200-250/Zeta 40-60 software history

	<ul style="list-style-type: none"> Reverse polarity in MMA AC mode ONLY is now possible by adjusting the AC frequency to 0HZ. This method can be used instead of reversing the welding cables.
1,22 25-11-2009	<p>IMPROVEMENTS:</p> <ul style="list-style-type: none"> TIG-A-TACK function is implemented (0.01 – 2.50 seconds). Postflow is now set to 6 seconds from the factory.
1,23 30-08-2010	<p>IMPROVEMENTS:</p> <ul style="list-style-type: none"> Display readout after finishing welding is now showing the last welding current for 60 seconds. H2O error does not show any more when the torch is not mounted and the machine is switched on.
1,28 27-06-2011	<p>IMPROVEMENTS:</p> <ul style="list-style-type: none"> 4 stroke repeat function is implemented. See Instruction manual – user menu – 4 t.o. mode 3. In MMA mode the fan on time has been increased. On time 120s and pause time 120s in order to avoid thermal cut out on the inverter.
1,30 30-09-2012	<p>IMPROVEMENTS:</p> <ul style="list-style-type: none"> Updated AC preheat indexes 1 to 6 for a smoother ignition on small thickness Arc voltage reading by pressing 'A' for 3sec only for TIG-DC and MMA-DC (due to hardware limits if arc voltage is greater than 70v display will indicate 'HI').
1,32 18-11-2014	<ul style="list-style-type: none"> Changed default Pre-flow setting from 0 to 0.2s. The machine must be reset to factory settings after software update.
1,33 10-06-2015	<ul style="list-style-type: none"> It is possible to enable/disable TIG-A-TACK with the potentiometer on the torch if the "t.r.c" menu has been set to 1. The potentiometer is used to set the current (as normal) if "t.r.c" is set to 0 (the factory default setting)
1,34 27-11-2015	<ul style="list-style-type: none"> Pre-gas is now adjustable in TIG-A-TACK also. Now pre-gas in TIG-A-TACK is the same as in the actual chosen program.
1,35 14-04-2016	<ul style="list-style-type: none"> Four stroke function #4 is implemented in order to simulate Rehm functionality. It works like starting on function #3 and ending on function #1. Four stroke function #5 is implemented due to wishes from Swedish customers. It works like starting on function #3 and ending on function #0.
1,36 (B13) 01.12-2016	<ul style="list-style-type: none"> Added software for UP / DOWN torch trigger function.
1,37 (B14) 26.02-2018	<ul style="list-style-type: none"> Max current calibration limits are changed from +/-5% to +/-7%.
1,38 (B15) 22.11-2018	<ul style="list-style-type: none"> TIG-A-TAK current surges will no longer occur. New 4 stroke trigger mode. Stop welding is now possible with a short press on the trigger. Only when secondary current is set to 100%.