



## Newarc R4000cc



## Operational Manual

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NA9910212

## DECLARATION OF CONFORMITY

The Low voltage Directive 2014/35/EU  
The EMC Directive 2004/108/EC, entering into force 20 July 2007  
The RoHS Directive 2011/65/EU, entering into force 2 January 2013

**Type of Equipment**

Welding power source for MMA

**Brand name or trade mark**

Newarc

**Type designation etc.**

R4000CC

**Manufacturer or his authorised representative established within the EEA****Name, address, telephone no**

Newarc

Newcastle upon Tyne

Phone: +44 (0)191 295 0111

**The product has been designed to comply with the following harmonised standards:**

IEC 60974-1 - Arc welding Equipment Arc striking and stabilizing devices

EN 60974-10 - Arc Welding Equipment Electromagnetic compatibility

Additional information: restrictive use, Class A equipment, intended for use in locations other than residential

**We declare that the equipment named above has been designed to comply with the relevant sections of the above referenced specifications. The unit complies with applicable essential requirements of the directives.**

**Place and Date**

Newcastle upon Tyne, UK

14/06/2016

**WEEE Directive & Product Disposal**

*At the end of its serviceable life, this product should not be treated as household or general waste. It should be handed over to the applicable collection point for the recycling of electrical and electronic equipment, or returned to the supplier for disposal.*



# Safety Guidelines

These general safety guides cover both arc welding machines and plasma cutting machines unless otherwise noted. The equipment must only be used for the purpose it was designed for. Using it in any other way could result in damage or injury and in breach of the safety rules. Only suitably trained and competent persons should use the equipment. Operators should respect the safety of other persons.

## Prevention against electric shock

The equipment should be installed by a qualified person and in accordance with current standards in operation. It is the user's responsibility to ensure that the equipment is connected to a suitable power supply. Consult with your utility supplier if required. If earth grounding of the work piece is required, ground it directly with a separate cable. Do not use the equipment with the covers removed. Do not touch live electrical parts or parts which are electrically charged. Turn off all equipment when not in use. Cables (both primary supply and welding) should be regularly checked for damage and overheating. Do not use worn, damaged, under sized or poorly jointed cables. Ensure that you wear the correct protective clothing, gloves, head and eye protection. Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work ground. Never touch the electrode if you are in contact with the work ground, or another electrode from a different machine.

Do not wrap cables over your body. Ensure that you take additional safety precautions when you are welding in electrically hazardous conditions such as damp environments, wearing wet clothing, and metal structures. Try to avoid welding in cramped or restricted positions. Ensure that the equipment is well maintained. Repair or replace damaged or defective parts immediately. Carry out any regular maintenance in accordance with the manufacturer's instructions.

## Safety against fumes and welding gases

Locate the equipment in a well-ventilated position. Keep your head out of the fumes. Do not breathe the fumes. Ensure the welding zone is in a well-ventilated area. If this is not possible, provision should be made for suitable fume extraction. If ventilation is poor, wear an approved respirator. Read and understand the Material Safety Data Sheets (MSDS's) and the manufacturer's instructions for metals, consumable, coatings, cleaners, and de-greasers. Do not weld in locations near any de-greasing, cleaning, or spraying operations. Be aware that heat and rays of the arc can react with vapours to form highly toxic and irritating gases. Do not weld on coated metals, unless the coating is removed from the weld area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings on many metals can give off toxic fumes if welded.

## Prevention against burns and radiation

Arc rays from the welding process produce intense, visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Wear an approved welding helmet fitted with a proper shade of filter lens to protect your face and eyes when welding or watching. Wear approved safety glasses with side shields under your helmet. Never use broken or faulty welding helmets. Always ensure there are adequate protective screens or barriers to protect others from flash, glare and sparks from the welding area. Ensure that there are adequate warnings that welding or cutting is taking place.

Wear suitable protective flame resistant clothing. The sparks and spatter from welding, hot work pieces, and hot equipment can cause fires and burns. Welding on closed containers, such as tanks, drums, or pipes, can cause them to explode. Accidental contact of electrode to metal objects can cause arcs, explosion, overheating, or fire. Check and be sure the area is safe and clear of inflammable material before carrying out any welding.

### **Protection against noise**

Some welding and cutting operations may produce noise. Wear safety ear protection to protect your hearing.

### **Protection from moving parts**

When the machine is in operation, keep away from moving parts such as motors and fans. Moving parts, such as the fan, may cut fingers and hands and snag garments. Protections and coverings may be removed for maintenance and controls only by qualified personnel, after first disconnecting the power supply cable. Replace the coverings and protections and close all doors when the intervention is finished, and before starting the equipment. Take care to avoid getting fingers trapped when loading and feeding wire during set up and operation. When feeding wire be careful to avoid pointing it at other people or toward your body. Always ensure machine covers and protective devices are in operation.

### **Precautions against fire and explosion**

Avoid causing fires due to sparks and hot waste or molten metal. Ensure that appropriate fire safety devices are available near the cutting / welding area. Remove all flammable and combustible materials from the cutting / welding zone and surrounding areas. Do not cut/weld fuel and lubricant containers, even if empty. These must be carefully cleaned before they can be cut/welded. Always allow the cut/welded material to cool before touching it or placing it in contact with combustible or flammable material. Do not work in atmospheres with high concentrations of combustible fumes, flammable gases and dust. Always check the work area half an hour after cutting to make sure that no fires have begun.

### **Risks due to magnetic fields**

The magnetic fields created by high currents may affect the operation of pacemakers or electronically controlled medical equipment. Wearers of vital electronic equipment should consult their physician before beginning any arc welding, cutting, gouging or spot welding operations. Do not go near welding equipment with any sensitive electronic equipment as the magnetic fields may cause damage.

### **RF Declaration**

Equipment that complies with directive 2004/108/EC concerning electromagnetic compatibility (EMC) and the technical requirements of EN60974-10 is designed for use in industrial buildings and not those for domestic use where electricity is provided via the low voltage public distribution system. Difficulties may arise in assuring class A electromagnetic compatibility for systems installed in domestic locations due to conducted and radiated emissions. In the case of electromagnetic problems, it is the responsibility of the user to resolve the situation. It may be necessary to shield the equipment and fit suitable filters on the mains supply.

## LF Declaration

Consult the data plate on the equipment for the power supply requirements. Due to the elevated absorbency of the primary current from the power supply network, high power systems affect the quality of power provided by the network. Consequently, connection restrictions or maximum impedance requirements permitted by the network at the public network connection point must be applied to these systems. In this case the installer or the user is responsible for ensuring the equipment can be connected, consulting the electricity provider if necessary.

## Materials and their disposal

The equipment is manufactured with materials, which do not contain any toxic or poisonous materials dangerous to the operator. When the equipment is scrapped, it should be dismantled separating components according to the type of materials. Do not dispose of the equipment with normal waste. The European Directive 2002/96/EC on Waste Electrical and Electronic Equipment states the electrical equipment that has reached its end of life must be collected separately and returned to an environmentally compatible recycling facility.

## Handling of compressed gas cylinders and regulators

All cylinders and pressure regulators used in welding operations should be handled with care. Never allow the electrode, electrode holder or any other electrically "hot" parts to touch a cylinder. Keep your head and face away from the cylinder valve outlet when opening the cylinder valve. Always secure the cylinder safely. Never deface or alter any cylinder.



**The following signs and explanations are to remind the user of the potential risks involved and the dangers of misuse or mistreatment of the welding machine.**



### **RUNNING PARTS MAY BE DANGEROUS!**

Keep away from running components, including the fan.



### **ELECTRIC SHOCKS CAN KILL!**

Never touch electrical parts. Keep the equipment in good condition, replace damaged parts, undertake regular maintenance according to the instructions.



### **BE AWARE OF SPARKS AND SPATTER**

Wear protective clothing, such as leather gloves, Flame retardant overalls, boots and eyewear.



### **DO NOT TOUCH THERMAL COMPONENTS!**

Thermal components may cause severe burns when in contact with unprotected skin.

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# 1. Preface

## 1.1 General

### **Congratulations on choosing your Newarc R4000CC Inverter.**

Used correctly, our products can significantly increase the productivity of your welding, and provide years of economical service. This operating manual contains important information on the use, maintenance and safety of your Newarc product. Please read the manual carefully before using the equipment for the first time. For your own safety and that of your working environment, pay particular attention to the safety instructions in the manual.

For more information on Newarc products, contact an authorised Newarc dealer, or visit the Newarc website at [www.newarc.co.uk](http://www.newarc.co.uk). The specifications presented in this manual are subject to change without prior notice.

### **Important notes**

Items in the manual that require particular attention in order to minimise damage and personal harm are indicated with the '**NOTE!**' notation. Read these sections carefully and follow the instructions.

### **Disclaimer**

While every effort has been made to ensure that the information contained in this guide is accurate and complete, no liability can be accepted for any errors or omissions. We reserve the right to change the specification of the product described at any time without prior notice. Do not copy, record, reproduce or transmit the contents of this guide without prior permission.

## 1.2 Introduction

These heavy duty MMA D.C inverter power sources have been designed using the latest developments in power electronics. Electronic parts are enclosed in a separate sealed compartment for protection from the environment.

This portable, versatile inverter power source responds to changes in the welding arc much faster than conventional machines resulting in a more stable and controllable weld pool.

Due to the high efficiency and power factor these units provide energy and cost saving solutions.

### Features

- Powerful 400 and 500 amps advanced inverter power source
- Fabricated in robust external casing to withstand the most extreme environments
- Cooling on demand system minimizes power consumption and dust ingress
- Very high duty cycle even at high ambient temperatures
- Large overhead of voltage available for use with long interconnection cables

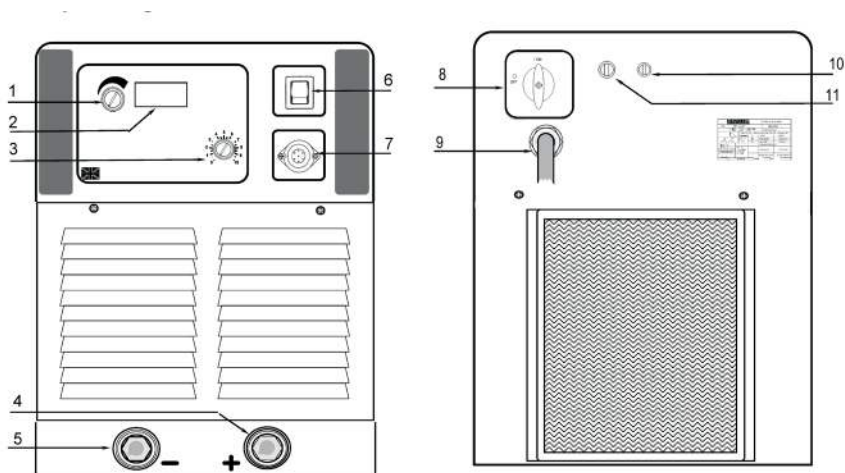


## 1.3 Technical Specifications

### Newarc R4000CC

Power voltage (V)	380-480 Volts 3 Phase 50/60Hz
Input Current at Max Output	24 amps
Power Consumption	18.5 KVA
Recommended Mains Fuse	32A slow blow or type C MCB
Mains Cable	4 x 4.0mm <sup>2</sup> flexible cable
Power Factor	0.95
Max Output Current	400 amps
Open Circuit Voltage	>80V
Current Control	20-400A Infinitely Variable
Duty Cycle at 40°C	60% @400A
	100% @350A
Electrode Size	1.6 – 6.3
Insulation Class	F
Dimensions (L x W x H) (mm)	570 x 310 x 450
Weight (kg)	33

## 1.4 Overview of Machine



### Front View

Power source front panel layout

1. Current control
2. Digital display
3. Arc force control
4. +ve weld terminal
5. -ve weld terminal
6. Off/On switch
7. Remote control socket

### Rear View

8. Main 3P Isolation switch
9. Mains Input
10. Remote fuse
11. Auxiliary transformer supply fuse

**1. Current control**

Adjusts the machines output current.

**2. Digital Display**

Indicates welding current in Amps, also gives an indication when the machine is over temperature.

**3. Arc force control**

Operates in MMA mode only. This control alters the welding dynamics of the machine to facilitate welding with different types of welding electrodes (e.g. general purpose, celulosic, low hydrogen and iron powder). Turning towards maximum will increase penetration at the expense of increased welding splatter, turning towards minimum will reduce penetration but the arc will be smoother and less fierce.

**4. +ve weld terminal**

Main welding power output connector, positive polarity.

**5. -ve weld terminal**

Main welding power output connector, negative polarity.

**6. Off/On switch**

Switches the machine on and off when the main 3 Phase isolation switched is in the on position. Upon switching on, the display will read "4000" or "5000" and the machines output will be inhibited, after 4 seconds display will clear and the machine is ready to use.

**7. Remote control socket**

For connection of external remote control or TIG300 external TIG control unit. There is no switch for remote operation, plugging an external unit into the socket automatically selects remote operation and disables the internal current control.

**8. Main 3P Isolation switch**

Switches the machine on and off.

**9. Mains Input**

Three phase mains cable.

**10. Remote fuse**

Protects the auxiliary supply from the remote control socket. Fuse type is 20 x 5mm glass body, 6.3A 'slow blow' rating.

**11. Auxiliary transformer supply fuse**

Fuse 3.15A slow blow, 32 x 6.3mm ceramic body.

## 2. Installation

### Unpacking

Check the packaging for any signs of damage. Carefully remove the machine and retain the packaging until the installation is complete.

### Positioning of the machine

Position the R4000/R5000 on a clean dry surface, preferable above ground level.

- Make sure there is at least 20cm clearance at the front, rear and right side of the machine to allow good circulation of the cooling air.
- Protect the machine from heavy rain and if used in hot climates, against direct sunlight.
- Ensure that the machine is positioned in such a way that particles created by grinding and cutting operations do not enter the machine.

**NOTE!** Damage caused by metal particles and water entering the machine will not be covered under warranty.

### Connecting to mains supply

**WARNING!** All electric shocks are potentially fatal, a competent electrician should carry out the fitting of the mains plug.

- Make sure that the mains supply is of the correct voltage and current capability for the machine.
- Make sure that any extension cables used are of sufficient current carrying capacity.
- Make sure that the mains plug and socket (if fitted) are in good condition and are of the correct current carrying capacity. If the machine is wired directly to the mains supply then an isolator switch must be fitted.

**NOTE!** See the technical specifications page for correct supply information



### Primary cable length

Long cable lengths may reduce the performance of the machine, the welding arc may become unstable, especially at higher currents. Ensure the mains cable is not coiled up during welding as this will reduce the input voltage to the machine and may cause over-heating and degradation of the cable.

### Setting supply voltage tapping

**WARNING!** All electric shocks are potentially fatal, a competent electrician should carry out any supply voltage tapping adjustments required.

- To enable the setting of the supply voltage tapping, the front panel display cover of the R4000/R5000 has to be removed.
- The photograph below shows the voltage tapping set to 415V, with the red wire from the fuse holder connected to the 415 terminal.
- This connector can be moved to the required voltage terminal to select the desired input voltage.

## 3. Operation

### **MMA Welding**

- For straight polarity welding, connect the electrode holder to the positive weld terminal and the earth return lead to the negative weld terminal. For reverse polarity welding, reverse these connections.
- Turn the mains switch to the on position, the digital will light and after a 4 second delay the machine is ready to weld.
- Adjust the current control to the recommended setting for the size and type of welding electrode to be used.
- Adjust the Arc Force control to your personal preference for the size and type of welding electrode to be used.
- The R4000CC/R5000CC is suitable for welding all types of electrodes within the current rating of the machine.

### **MMA Welding with remote control**

- Select welding polarity.
- Plug the control cable supplied with the remote control into the remote control socket on the front of the R4000/R5000.
- Turn the mains switch to the on position, the machine is ready to weld.
- Plug the remote control onto the other end of the control cable.
- Adjust the current control on the remote to the recommended setting for the type and size of welding electrode being used. (The standard Newarc RC300 remote does not have current settings but is marked 1 to 10, for the R4000CC allow 40A per division and for the R5000CC allow 50A per division).

### **TIG Welding with TIG Unit**

**IMPORTANT!** Do not use the TIG Unit until you have read and fully understood the TIG Unit manual.

- Connect the TIG unit to the R4000/R5000 and the shielding gas supply as per the diagrams in the TIG unit manual.
- Turn the mains switch on the R4000/R5000 to the on position, the digital displays on the R4000/R5000 and the TIG unit will light up, you are now ready to weld.
- Select welding mode and current by adjusting the controls on the TIG unit with reference to the manual.

## 4. Fault finding

Most problems with the R4000/R5000 can be overcome by following the procedures below.

### **No Digital Display on switch on**

- Check that the machine is attached to a working mains supply that it is correctly plugged in and any isolator switches are closed.
- Check the condition of the 2A fuse on the rear panel of the machine and replace if necessary.

**NOTE!** Note : make sure the fuse is replaced with one of the correct type and rating. It should be a 32 x 6.3mm (1¼" x ¼") ceramic bodied type with a rating of 2A 'slow blow'

Have a competent electrician check that there are no mains fuses or overload devices interrupted, that the mains plug is fitted correctly and that there are no loose wires or connections, check that there are no breaks in the mains cable.

### **Digital display lit but no output**

- Make sure that the display is not reading 'HOT'; if it is, it means that the R4000/R5000 has over-heated, normally by exceeding its 'Duty Cycle', and the power stages of the machine have been shut down. In this case, leave the machine switched on until it has cooled down, if you turn the machine off, the cooling fans will be turned off also and the cooling down period will be lengthened considerably.

**NOTE!** If the R4000/R5000 is overheating on a regular basis or at current settings below the maximum, this would usually indicate that the inside of the machine is choked with dust and therefore not being cooled correctly. For information about cleaning the dust out of the R4000CC/R5000CC please refer to the three monthly service schedule.

### **TIG unit is not working**

- Check the condition of the 6.3A fuse on the rear panel of the machine and replace if necessary.
- Check interconnection cables are correctly fitted. (Positive to positive, negative to negative).

**NOTE!** Make sure the fuse is replaced with one of the correct type and rating. It should be a 20 x 5mm glass bodied type with a rating of 6.3A 'slow blow'.

Any welding problems not covered above must be brought to the attention of a qualified welding engineer, if the problem still persists have the R4000/R5000 checked by a trained Newarc service engineer.

## 4.1 Welding problems

### **MMA**

If problems with the R4000/R5000's operation while welding are experienced, first refer to the information in the installation section and in the operating section and the fault finding procedure earlier in this section.

- Most problems with MMA welding are the result of not setting the correct welding parameters for the welding rod being used. All welding rod packets have information on them in symbolic format , giving suitable current range, polarity and type of weld (normally called 'position'). If you are in doubt about what these symbols mean, ask your welding rod supplier to explain them. Choose an initial current setting towards the middle of the quoted range and if necessary practice on a piece of scrap the same thickness as the job to be welded.

### **TIG**

- If problems are experienced whilst TIG welding, please consult the fault finding and maintenance section in the TIG unit instruction manual.
- Any welding problems not covered above must be brought to the attention of a qualified Welding Engineer, if the problem still persists have the R4000/R5000 checked by a trained Newarc service engineer.

## 5. Maintenance

### **Note!**

All Electric shocks are potentially fatal, switch off the machine and unplug from the mains supply before carrying out any maintenance work.

It is very important that the R4000/R5000 is regularly maintained. The amount of use and the working environment must be taken into account when scheduling the maintenance periods. Careful use and regular preventative maintenance will prolong the life of the machine and ensure trouble free operation.

### **Weekly**

- Clean the exterior of the machine.
- Inspect the machines exterior for obvious signs of damage.
- Check the condition of the welding cable, earth clamp and welding output connectors for damage and any sign of over-heating
- Check the condition of the mains cable and plug.



## 6. Warranty

### **Guarantee**

Newarc Ltd warrants that its goods and services are guaranteed to meet the specific performance under the stated conditions of use. Newarc cannot be held responsible for general wear and tear or for failure occurring due to misuse or abuse arising out of circumstances outside the stated conditions of use. The stated conditions of use are that considered normal industrial practice and are not exhaustive. Each machine is identified with a unique serial number and accompanied with the guarantee. Newarc reserve the right to a) Repair, b) Replace, c) Authorise the reasonable cost of repair or replacement at an approved Newarc service agent, d) Credit for any purchased equipment (less reasonable depreciation for actual use and condition) at its entire discretion. This in no way affects your rights as a consumer. The guarantee is enclosed with each machine.

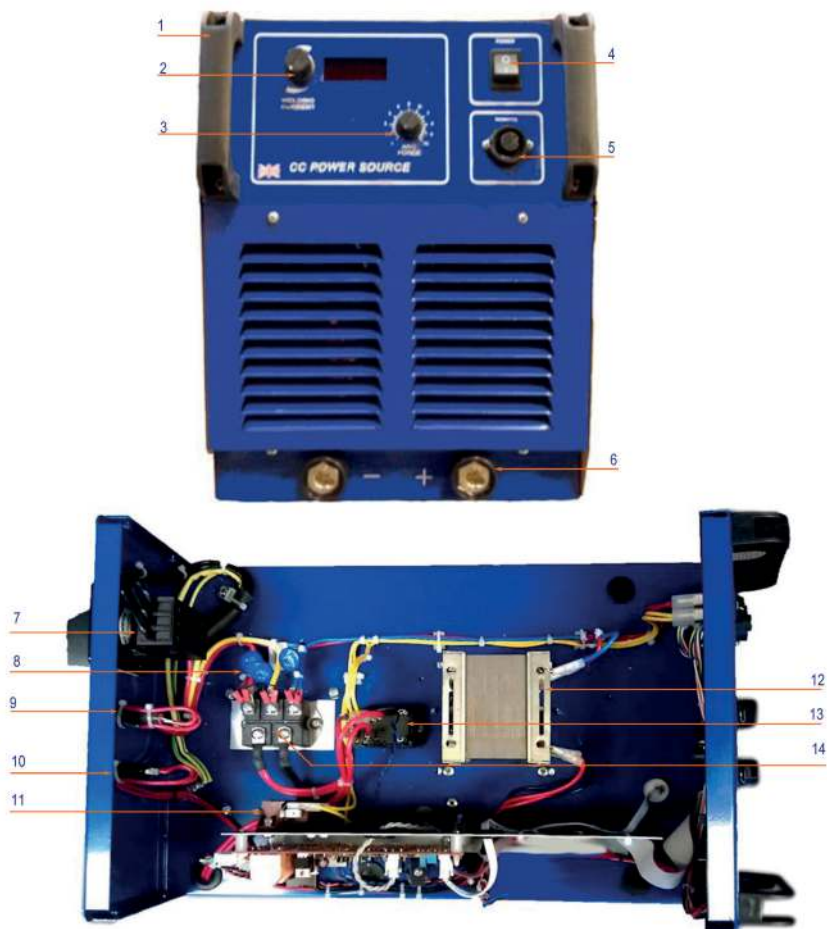
### **PLEASE NOTE**

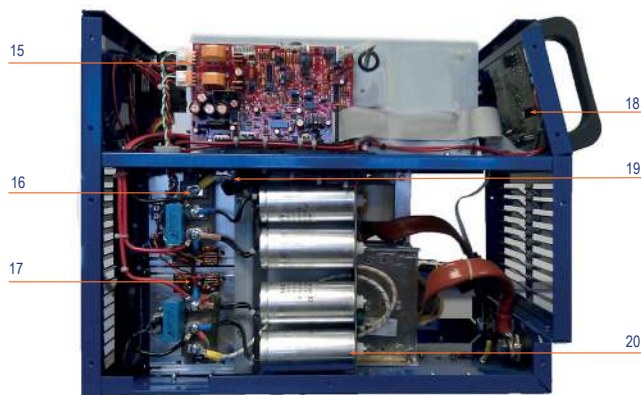
The manufacturer reserves the right to change and alter the equipment without prior notice. This includes but is not limited to: operating procedures, technical specifications, technical schematics and manuals

### **CAUTION**

- There are no user serviceable parts/modules inside this equipment.
- Removing lids or covers will/may expose hazardous voltages
- Removal of lids or covers WILL invalidate the warranty on this equipment.

# 7. Parts





## Ordering information

Item	Description	Part number
<b>1</b>	Front Bridge handle (2 per machine)	<b>NAM01393</b>
	Lid bridge handle (2 per machine)	<b>NAM01084</b>
<b>2</b>	24mm diameter knob	<b>NAM00464A</b>
<b>3</b>	20mm diameter knob	<b>NAM00033A</b>
<b>4</b>	On/Off front switch	<b>NAM70069A</b>
<b>5</b>	Remote socket assembly	<b>NAM90762</b>
<b>6</b>	70/90 panel mount Dix socket (x 2)	<b>EW7095PSW</b>
<b>7</b>	Mains Switch — 3 phase power	<b>NAM70071</b>
<b>8</b>	Filter Diac assembly	<b>NAM91123</b>
<b>9</b>	Fuse holder	<b>NAM01088</b>
	Fuse 3.15A slow blow, 32 x 6.3mm ceramic body	<b>NAM00020A</b>
<b>10</b>	Fuse holder	<b>NAM00273</b>
	Fuse 6.3A slow blow, 20 x 5mm glass body	<b>NAM00379</b>
<b>11</b>	Soft start resistor assembly	<b>NAM90765</b>
<b>12</b>	Auxiliary transformer	<b>NAM01408</b>
<b>13</b>	Soft start relay	<b>NAM70026</b>
<b>14</b>	Diode bridge	<b>NAM60057</b>
<b>15</b>	Control PCB	
	R4000CC	<b>NAM90744-R17-R4000CC</b>
	R5000CC	<b>NAM90744-R17-R5000CC</b>
<b>16</b>	IGBT (2 per machine)	
	R4000CC	<b>NAM60229</b>
	R5000CC	<b>NAM60229B</b>
<b>17</b>	IGBT gate drive assembly (1 per machine)	<b>NAM90843</b>
<b>18</b>	Display PCB	
	R4000CC	<b>NAM90746-R4000CC</b>
	R5000CC	<b>NAM90746-R5000CC</b>
<b>19</b>	Current transformer	<b>NAM01083</b>
<b>20</b>	Capacitor Assembly	<b>NAM90456</b>

When ordering spare components please quote the serial number of the unit for which the parts are intended.

## Ordering information Continued

Item	Description	Part number
<b>21</b>	Main inductor (Part number need when ordering)	
	R4000CC	<b>NAM10105</b>
	R5000CC	<b>NAM10106</b>
<b>22</b>	Current transducer	<b>NAM60112</b>
<b>23</b>	Main transformer (Part number need when ordering)	
	R4000CC	<b>NAM10102</b>
	R5000CC	<b>NAM10103</b>
<b>24</b>	De-coupling capacitor	<b>NAM90818</b>
<b>25</b>	Diode module (4 per machine)	<b>NAM60121</b>
<b>26</b>	Cooling fan (2 per machine)	<b>NAM00354</b>
<b>27</b>	Rear Filter grill assembly	<b>NAM91157</b>

*When ordering spare components please quote the serial number of the unit for which the parts are intended.*

## Notes

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