

VSM Welder Issue - Cracked Welds

Common Solutions to issues with Cracked Welds

Contents

VSM 30/20-P Welder - Heavy and Large Sash (Patios)

Comments

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Symptoms

- Cracked Welds on one corner on heavy or wide profiles
- Patio Sash catching setting plates
- End of the setting plate catching the inside of the profile and stopping the heads moving into the correct position

Solutions

1. Put the machine into service technician mode
2. Step through the welding process, one step at a time.
3. Look at the profile welding data and decrease the loading position for height and width.