



SIGMA¹ software history

Note: not for SD card

BASIC and ADVANCED and SYNERGIC boxes		
PCB TYPE	DOWNLOAD Software version	DOWNLOAD Flash tool
Wire feed PCB Control software	10001300 1.09.1 10001302 2.05.1 10001303 3.23.1 - C3	MigaFlash
Wire feed PCB welding programs	10645 401 10645401 b2 (Use only with version 2.xx) 10645 402 10645402 B2 (Use only with version 3.xx)	
DSPC PCB	10001400 1.08.1 10001402 2.04.1 10001403 3.16.1 - B6	Softbaugh Boot Flash (SUP 2000) v. 01.00.04
RoboFeeder PCB control software	10020105 1.07- A7	Use MigaFlash v.3.0
Robot Interface control software	10020104 1.06- A6	Use MigaFlash v

Order numbers:

MigaFlash tool MFT1 - 71613490
 Softbaugh SUP2000 - 18600102
 USB-Serial converter - 98710093

Date	Wire feed #1 10001303	DSPC #3 10001403
23-09-2010	3.28.1 (c8) <ul style="list-style-type: none"> The wire inching speed is now again 8.0 meter/minut when sequense function is chossen. 	3.17.1 (b7) <ul style="list-style-type: none"> No change.
08-09-2010	3.27.1 (c7) <ul style="list-style-type: none"> The control box does not "freeze" anymore, when the torch control potmeter is turned to maximum. 	3.17.1 (b7) <ul style="list-style-type: none"> No change.

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07-06-2010	<p style="text-align: center;">3.26.1 (c6)</p> <ul style="list-style-type: none"> • Sigma MK1 can now work with Robofeeder MK2. 	<p style="text-align: center;">3.17.1 (b7)</p> <ul style="list-style-type: none"> • No change.
09-09-2009	<p style="text-align: center;">3.25.1 (c5)</p> <ul style="list-style-type: none"> • Phase error detection. When the "3." phase in the supply is missing, because a fuse is blown, and you are welding with more than 60A, the arc will now turn off and the display is showing E11-28. 	<p style="text-align: center;">3.17.1 (b7)</p> <ul style="list-style-type: none"> • Phase error detection. When the "3." phase in the supply is missing, because a fuse is blown, and you are welding with more than 60A, the arc will now turn off and the display is showing E11-28. • Overheat in MMA idle mode has been solved by letting the fan run all the time with minimum 25% speed when the machine is set to MMA mode. • E11-24 will not show up any more when welding is started on AIMg.
02-04-2009	<p style="text-align: center;">3.24.1</p> <ul style="list-style-type: none"> • No change. 	<p style="text-align: center;">3.16.1</p> <ul style="list-style-type: none"> • Error E 16-01 does not appear anymore when the machine is set to MMA mode.
30-03-2009	<p style="text-align: center;">3.24.1</p> <ul style="list-style-type: none"> • CAN error E-02-04 has been fixed when used with Robot interface • The control box can now show the welding program number when a Robot interface is connected. • The torch regulation potmeter has been slowed down so it works like on RWF. When regulating on the potmeter the display reading looks smooth and nice. 	<p style="text-align: center;">3.15.1</p> <ul style="list-style-type: none"> • The display readout of current and voltage is now shown faster and with more stability. • On systems with robot interface, the robot will now receive a "zero" signal on the current and voltage feedback signals from the robot interface, when not welding. Previously the feedback signals stayed on the last measured values on the feedback.
19-01-2009	<p style="text-align: center;">3.23.1</p> <ul style="list-style-type: none"> • The minimum current could change automatically when changing between puls and non puls in the sequence program. 	<p style="text-align: center;">3.14.1</p> <ul style="list-style-type: none"> • No change.
31-10-2008	<p style="text-align: center;">3.22.1</p>	<p style="text-align: center;">3.14.1</p>

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	<ul style="list-style-type: none"> Wire inching is modified. The torch regulation potmeter will no longer be able to change the wire speed when the wire inch button is activated. 	<ul style="list-style-type: none"> No change.
21-08-2008	<p style="text-align: center;">3.21.1</p> <ul style="list-style-type: none"> Keylock has been added. See operation manual page 8. Motor control software has been altered; consequently a more precise speed control is obtained in the very low range around 1 - 2 m/min. 	<p style="text-align: center;">3.14.1</p> <ul style="list-style-type: none"> No change.
23-05-2008	<p style="text-align: center;">3.20.1</p> <ul style="list-style-type: none"> No change. 	<p style="text-align: center;">3.14.1</p> <ul style="list-style-type: none"> Significant better start of the welding has been implemented by reducing the oscillation time for the arc. Welding program packet 10645402 - B2 shall be used to gain full advantage of the improvements
09-05-2008	<p style="text-align: center;">3.20</p> <ul style="list-style-type: none"> Watercooling can no longer be turned off by accident. Now function F51 appears when the watercooling button is held for more than 5 secs, and the value is then set at "0" to switch off the pump. See instructions page 8. Reading of software version for RoboFeeder 2 (#7) is shown correctly. 	<p style="text-align: center;">3.13</p> <ul style="list-style-type: none"> Error E-11-24 in MMA. When the machine is in position Electrode, it no longer shows error E-11-24. For that reason the OCV is lowered to ca. 70V in MMA mode.
31-01-2008	<p style="text-align: center;">3.19</p> <p>In version 3.18 the handle control could not be adjusted to maximum (eg. 400A on a Sigma 400). Instead it leapt to minimum value. This is corrected in version 3.19</p>	<p style="text-align: center;">3.12</p> <p style="text-align: center;">No alteration</p>
25-01-2008	<p style="text-align: center;">3.18</p> <p style="text-align: center;">New features:</p> <ul style="list-style-type: none"> Version codes can be displayed for all connected units: 1 : MWF 2 : Welding program 3 : DSPC 4 : MIGManager 	<p style="text-align: center;">3.12</p> <ul style="list-style-type: none"> Reaction time on the arc detect signal, which is sent to the robotinterface, is reduced from 1 sec. to 100 ms. The machine can no longer lock in connection with error code E11-101.

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	<p>5 : Robotinterface 6 : RoboFeeder 1 7 : RoboFeeder 2.</p> <ul style="list-style-type: none">• Max wire feed speed is altered from 24 m/min to 30 m/min. <p>Modifications related to Robot Interface:</p> <ul style="list-style-type: none">• Upgrading of display after inching from robotinterface has been added.• Program switch from robotinterface only selects MIG programs, where binary code 1 selects program 002, and binary code 2 selects program 003.• Sequence cannot be changed with short-trig with the robotinterface connected.• Program number cannot be selected/seen on the machine, when the robotinterface has selected a program.• In order to see or select program number on the machine, the robotinterface shall select binary code 0.	
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Date	Welding program#2 10645402
16-10-2008	<p>402 b4</p> <p>P312 Ø1.0 mm AlMg5 Ar: the dip transfer range has been extended P591 Ø1.2 mm Inconel 718 ArHeCO² has been added to the program package.</p>
10-09-2008	<p>402 b3</p> <p>P583 Ø1.2 mm Inconel 625 ArHe(85/15), addition of pulse function P584 Ø1.6 mm Inconel 626 ArHe(85/15). addition of programme (replaces P595) P364 Ø1,6 mm Al 99,5 Ar, addition of programme P153 Ø1.2 mm Fe ArCO² PowerArc, the programme has been removed (the programme can be found in 10645403)</p>
26-05-2008	<p>402 b2</p> <p>Ignition characteristics have been considerably improved. Together with new DSPC software 3.14 the ignition characteristics are considerably improved. Together with older DSPC software there will be improvement of the ignition characteristics, but not to the same extent.</p>
21-01-2008	<p>402 b1</p> <p>This version may ONLY be used on DSPC PCB with version D6 or later.</p> <p>Following programs have become improved welding characteristics P101,P102,P103,P111,P112,P113,P125,P201,P202,P203,P312,P313,P316,P317,P423</p> <ul style="list-style-type: none"> • Added program. P263 - Ø 1,2 mm Duplex 2509 ArCO² 98/2 DC/P + P493 - Ø 1,2 mm FCW CrNi 309/316L CO² 100 DC + P573 - Ø 1,2 mm CuAl8 Ar 100 DC/P + <p>Default tack-parameter changed in all programs.</p>
21-11-2007	<p>402 b0</p> <ul style="list-style-type: none"> • The machine no longer locks when program P372 or P373 is chosen..

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Date	Robot Interface #5 10020104
10-11-2009	1.06 (a6) <ul style="list-style-type: none"> • Handling of errors and machine-status are changed after wish from Service/Automation. Handling of Pulse, Quattro and WirefeederSelect are changed after wish from Service/Automation. • Miscellaneous fixes to support Sigma Mk2 better.
26-03-2009	1.05 <ul style="list-style-type: none"> • When Sigma2 is used with RobotInterface will the RoboFeeder again be enabled the moment the machine is being switched on, if the RWF input is activated. The RobotInterface now behaves equally on Sigma1 and Sigma2.
26-02-2008	1.04 <ul style="list-style-type: none"> • Trigger signal "overrules" gas and inching signals
11-01-2008	1.03 <ul style="list-style-type: none"> • Error codes E-07-02 and E-02-04 no longer occur unintentionally. • Sekvens skift funktionen fungerer som tilsigtet.
12-12-2007	1.02 <ul style="list-style-type: none"> • Inaccuracies on analogue inlets have been removed. • The feeder in the compact machine is now activated with binary code 0 or 3. • When the robot report error and thereby activates MACHINE STATUS = ON, the machine cannot be triggered via the interface.

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Date	Robo Feeder #6 / #7 10020105
Impl. 8-9-2010	1.07 <ul style="list-style-type: none"> Automatically disableing of torch control when torch is disconnected, has been removed.
Impl. 19-3-2009	1.06 <ul style="list-style-type: none"> The torch potmeter control stays active even after the trigger wires has been disconnected shortly. Like after a bad connection in the ZA connector.
Impl. 16-4-2008	1.05 <ul style="list-style-type: none"> The display does not turn off anymore, when a torch without regulation potmeter is used.
7-2-2008	1.04 <ul style="list-style-type: none"> Error code E-07-04 does not occur unintentionally anylonger.
12-12-2007	1.03 <ul style="list-style-type: none"> LED on front of the robofeeder blinks, if CAN communication is not established. Torches without control can now be used. LEDs on PCB 71613471 now have following functions: D2 Green ON = torch switch active. D7 Green CAN - Alive D9 Green CPU runs when it blinks

See service manual for software installation instructions