Auto Deltaweld Web Interface

1 | SETUP HOME / LANDING PAGE

Configuration & Field Reference Guide

PURPOSE Provide a practical visual reference to the Auto Deltaweld embedded web interface. Use this guide to identify the major configuration pages, understand what each page controls, and locate settings used during commissioning, robot integration, weld-memory setup, diagnostics, machine cloning, and MQTT data collection.

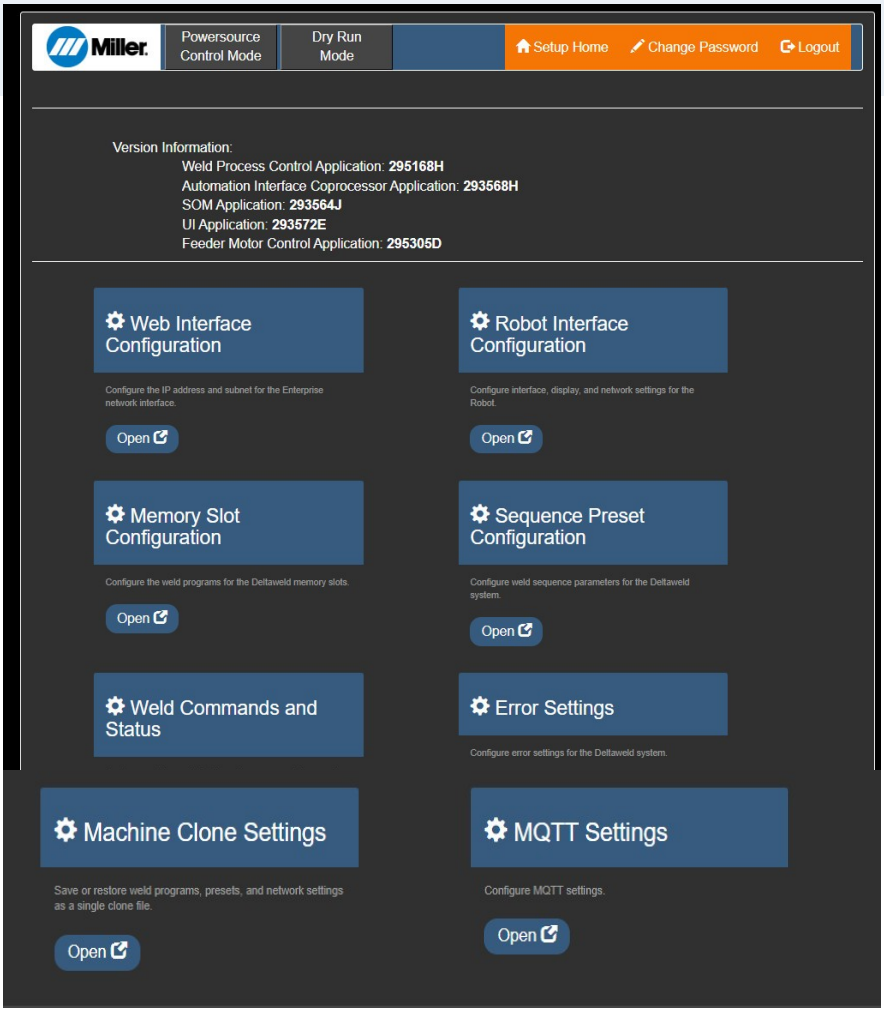

Figure 1. Auto Deltaweld Setup Home page.

Before You Start

- Connect to the Auto Deltaweld web interface using the machine/network address 169.253.1.32 (default)
- **The first time you enter the webpages, you will be asked to input/create a password.**
- Pages and available controls can vary with software/firmware revision and system configuration. Treat the machine's current interface and Miller documentation as the controlling reference.

2 | WEB INTERFACE / NETWORK CONFIGURATION FRONT PANEL PORT

WHAT THIS PAGE DOES Displays the machine network identity and allows the web-interface IP configuration to be established. These values determine how a laptop, plant network, or automation network reaches the embedded web interface.

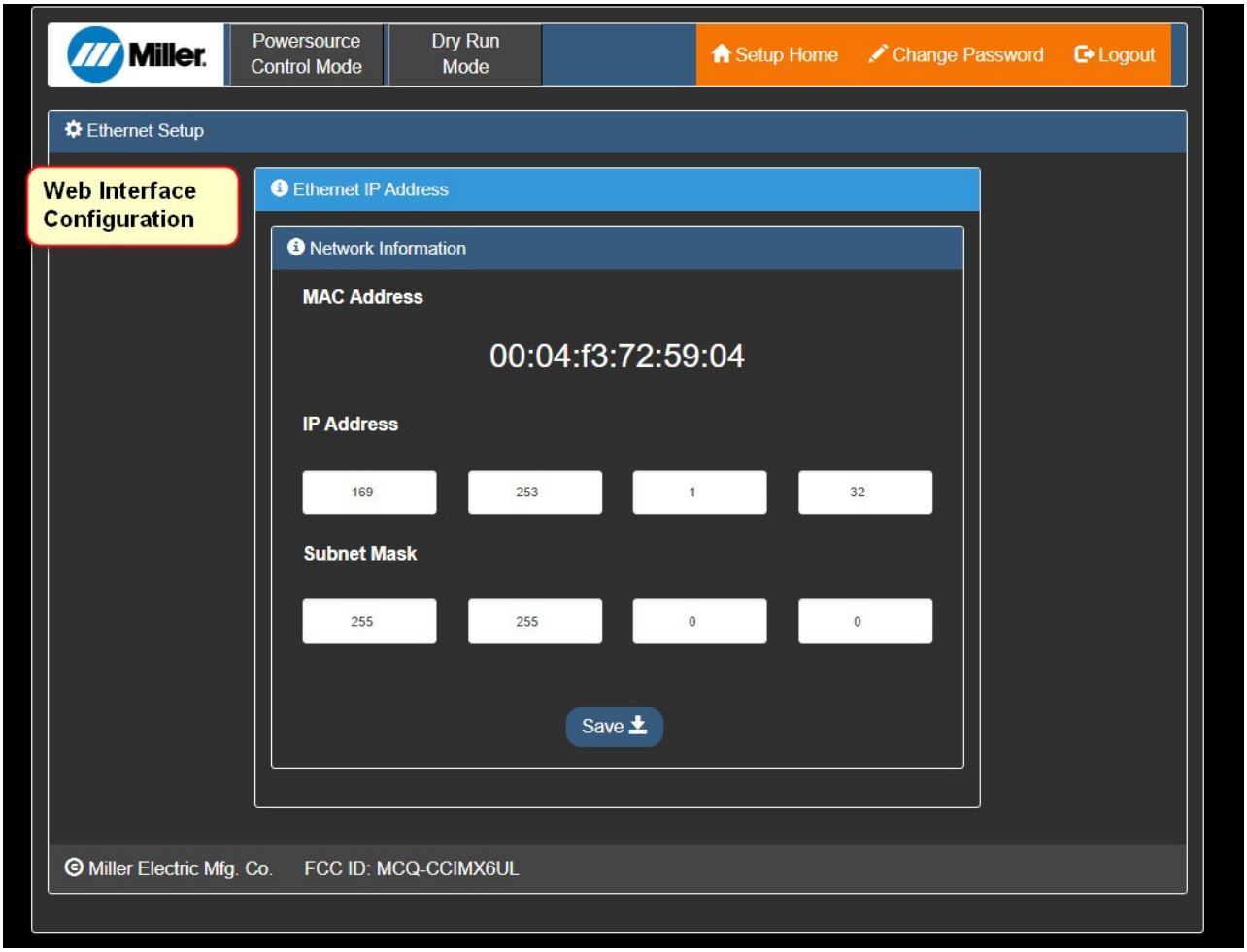

Figure 2. Web Interface / Network Configuration.

FIELD NOTE Before changing an IP address, record the current address and subnet. After saving a new address, the browser session may disconnect and you will need to reconnect using the new address.

3 | ROBOT INTERFACE CONFIGURATION

WHAT THIS PAGE DOES Configures how the power source exchanges commands and status with an automation controller or robot. This is a commissioning page: settings here establish the communication method and the robot-side control behavior. You can also set the date and time.

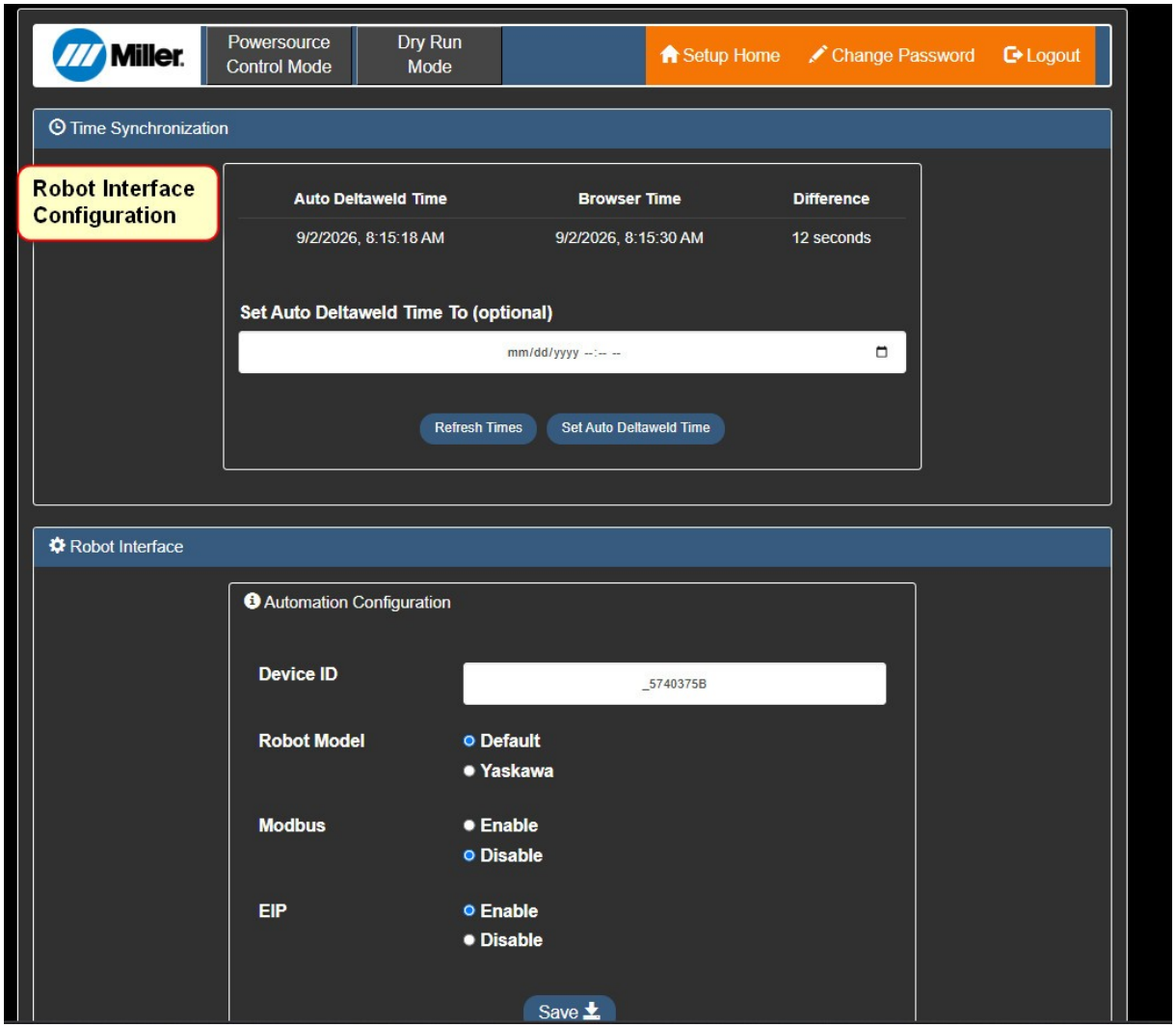

Figure 3. Robot Interface Configuration.

FIELD NOTE Robot-interface changes should be coordinated with the robot/PLC program. A mismatch between the welder configuration and automation program can prevent weld enable, schedule selection, or status feedback.

3 | ROBOT INTERFACE CONFIGURATION - CONTINUED

Additional robot-interface parameters

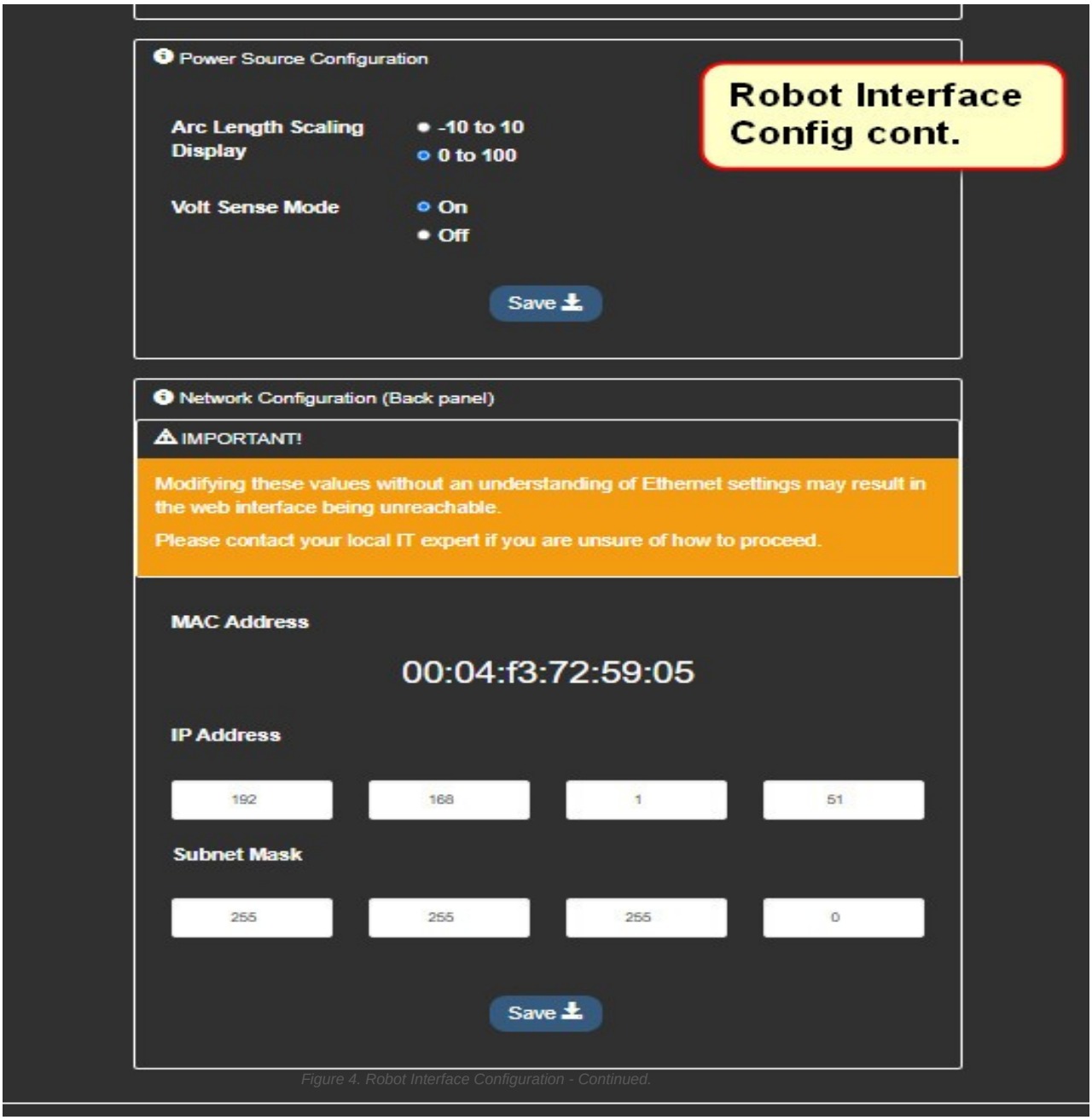

Figure 4. Robot Interface Configuration - Continued.

Fig 4

- Set the Arc Length display type and select your preferred volt sense method.
- Set the IP address and subnet mask. (The robot port and front panel port **cannot be** on the same subnet for example: front is 169.253.1.32 the robot port in the back can not be 169.253.xxx.xxx.) Use something like 192.168.1.xxx for robot port but it needs to be on the same subnet as the robot EIP Scanner or PLC.

4 | MEMORY SLOT CONFIGURATION

WHAT THIS PAGE DOES Manages active weld memories and allows memory content to be selected or synchronized for production use. This page is useful when a robot or external controller calls specific weld memories.

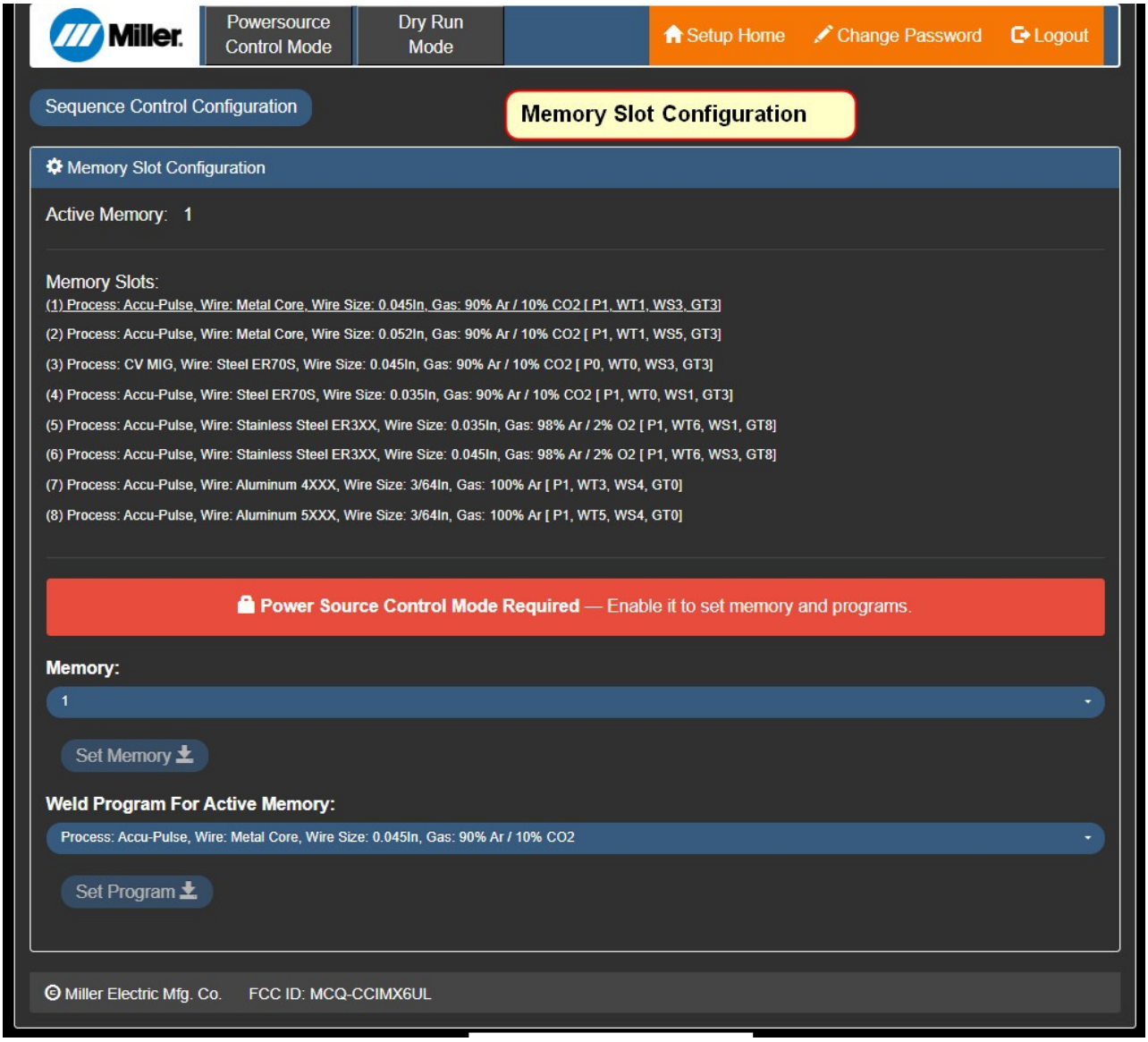

Figure 5. Memory Slot Configuration.

Key Controls / Information

- Active Memory shows the program active on the Auto Deltaweld.
- Before changing the programs loaded into a memory slot, put the power source in CONTROL MODE first.
- To change the program selected for a particular memory, set the memory slot to be changed as the active memory using the drop down list and select SET MEMORY.
- Next choose the weld program to store in the active memory by selecting the desired weld program in the weld program selection drop-down and then clicking SET PROGRAM.
- Only the weld programs available in the model of power source being used will be available in the weld program selection drop-down.

WHAT THIS PAGE DOES Provides preset values for weld-sequence stages. The interface can expose parameters for the main weld and other sequence segments so the automation system starts, welds, and finishes consistently.

Figure 6. Sequence Preset Configuration.

Key Controls / Information

- Profile Pulse Parameter Settings
- Run-In parameters (this is the speed at which the wire will feed until it touches the work piece and start the arc.
- Retract: parameters that control wire retract after the arc is turned off.

6 | WELD COMMANDS AND STATUS

WHAT THIS PAGE DOES Allows for certain actions to be manually turned off or on, and displays the actual weld voltage, amperage, and wire feed speed. You can also set a command voltage/Arc Length, and Wire Feed Speed for manual control of the power supply. The power supply must first be in POWER SOURCE CONTROL. The Power Source will only execute the contactor on/off from the robot or plc.

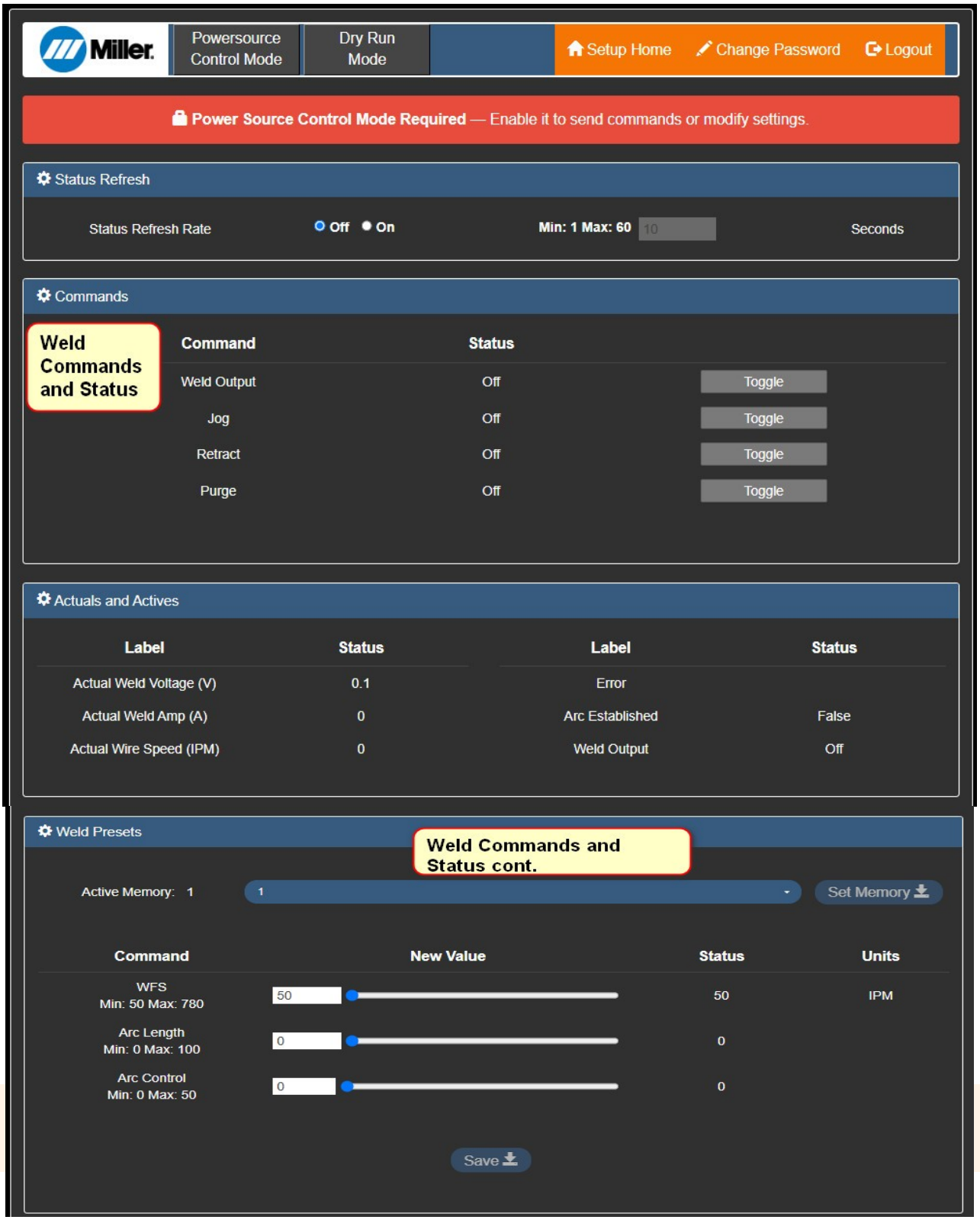

Figure 7. Weld Commands and Status.

7 | ERROR SETTINGS

WHAT THIS PAGE DOES Controls selected fault-response behavior exposed by the web interface. The example page shows the Wire Loss Fault setting and its stored state.

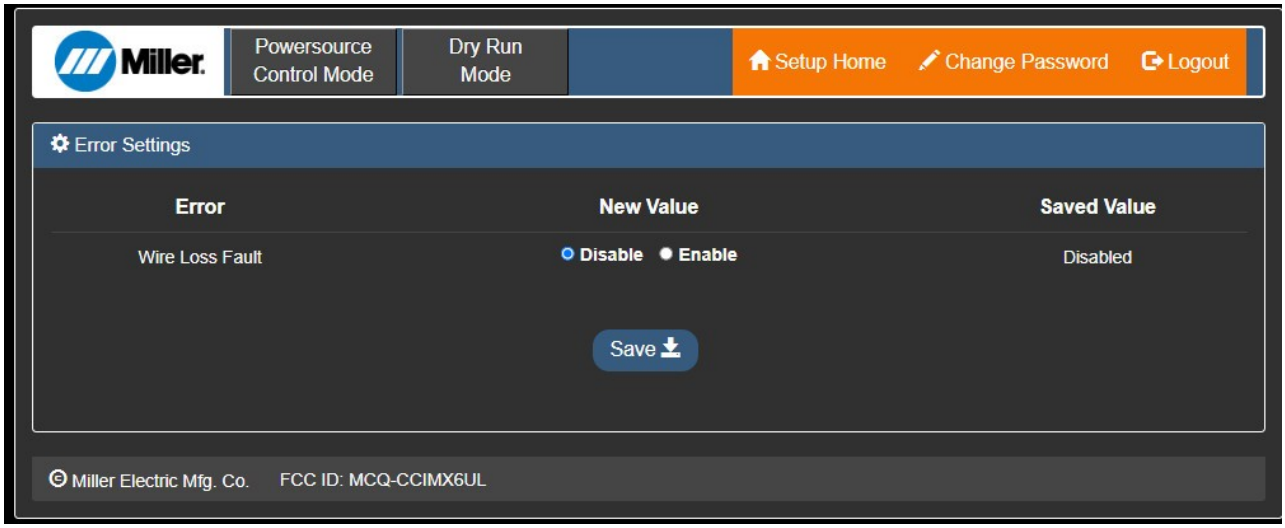

Figure 8. Error Settings.

8 | MACHINE CLONE SETTINGS

WHAT THIS PAGE DOES Provides a method to save machine settings to a file and restore settings to a machine. This can reduce setup time when commissioning similar systems or recovering a known configuration. IP ADDRESSES will not be copied over.

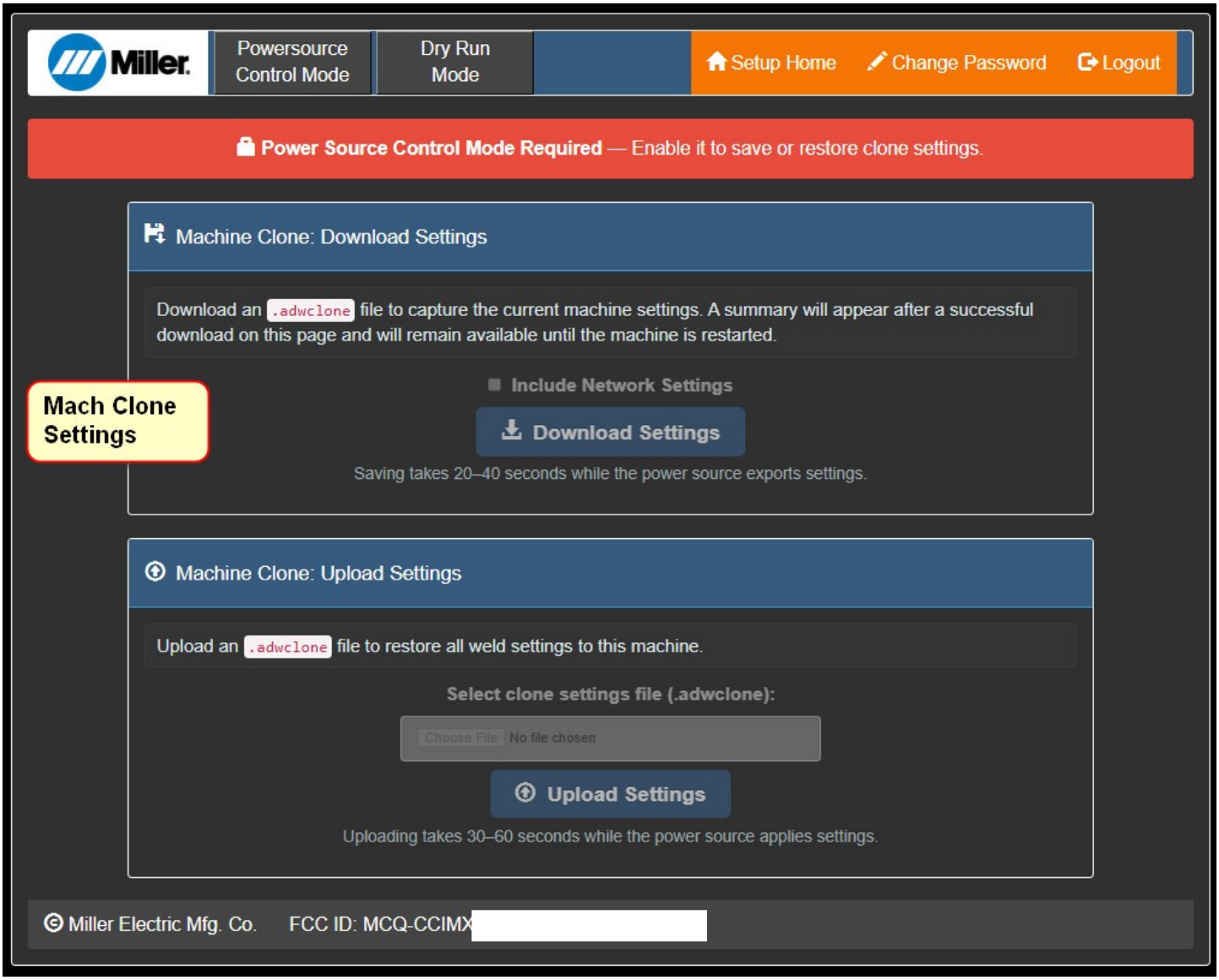

Figure 9. Machine Clone Settings.

9 | MQTT BROKER & CLIENT SETTINGS

WHAT THIS PAGE DOES Defines how the welder connects to the MQTT broker and how frequently messages are handled. These values must match the network and broker used by the data-collection system.

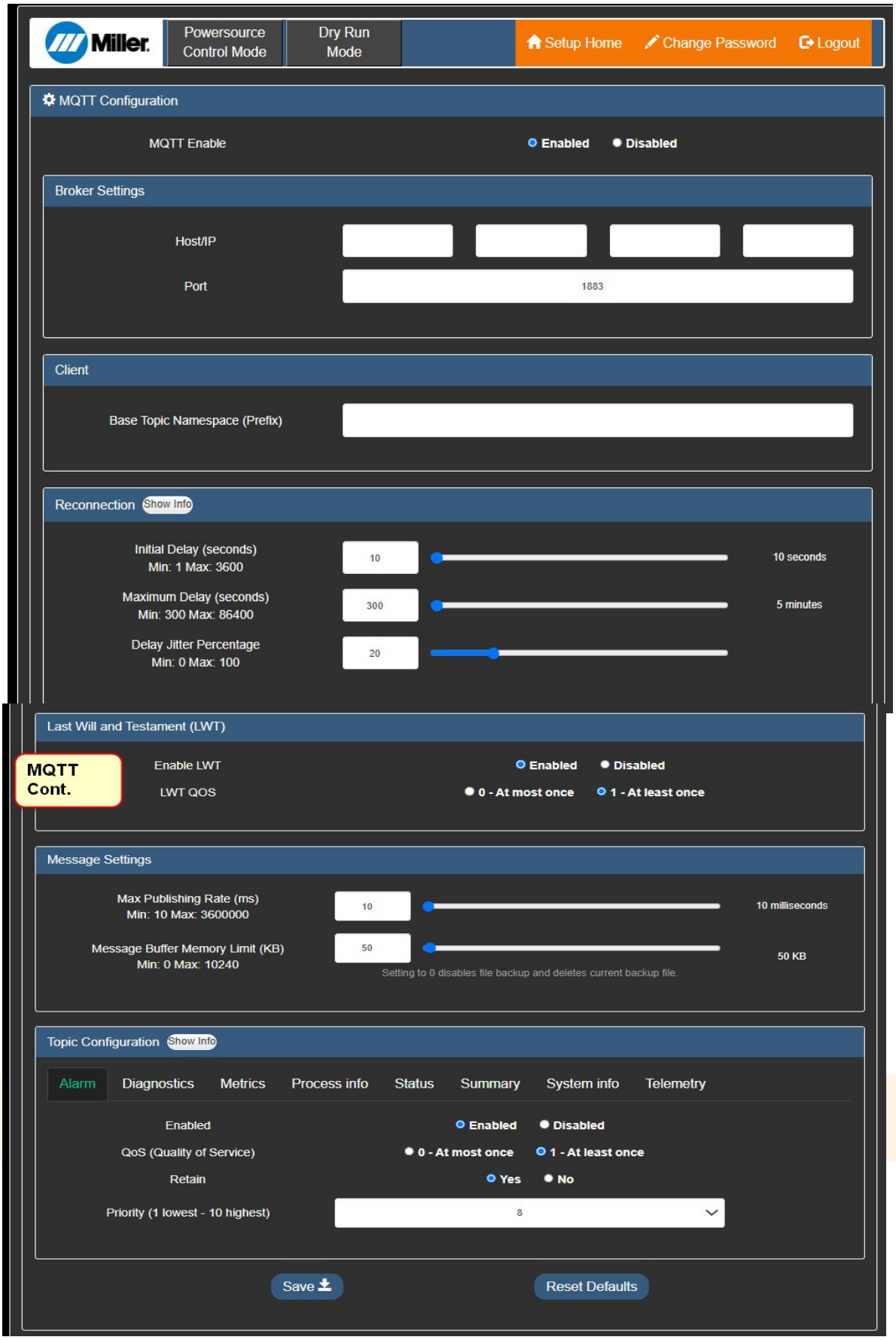

Figure 10. MQTT Broker & Client Settings.

10 | COMMISSIONING & TROUBLESHOOTING QUICK REFERENCE

Task / Symptom	Start Here
Cannot reach the web interface	Web Interface / Network Configuration - verify IP address, subnet, physical network connection, and PC network settings.
Robot will not enable or start weld	Weld Commands and Status - confirm the expected command changes state; then verify Robot Interface Configuration.
Wrong weld schedule is active	Memory Slot Configuration - confirm active memory and the memory being called by the robot/controller.
Start/end behavior is incorrect	Sequence Preset Configuration - verify run-in, weld, crater/retract, and other sequence values used by the application.
Need to duplicate or back up a machine	Machine Clone Settings - download a backup before making changes.
MQTT dashboard has no data	MQTT Enable/Disable -> Broker & Client Settings -> Message & Topic Configuration; verify each layer in that order.
Power Supply not responding correctly to robot commands	Put the welder into power source control and set appropriate arc length/voltage, wfs, and arc control. Run the Robot in automatic mode and see if the welder performs better. If so, there could be an issue with the robot setup or comms.