

## RITMO Elektra EF Welder Series – Error Codes

### ALARM CODES AND THEIR MEANING

The welding cycle is interrupted whenever an error code is displayed. The interruption may jeopardize the fitting to be welded. In no event shall Ritmo S.p.A be liable for any direct, indirect, incidental, or consequential damages of any whatsoever with respect to the use of pipes/ fittings involved in the welding cycles resulting in error codes.

#### 5 – POWER SOURCE VOLTAGE

Probable cause: Power source voltage out of range

Solution: check the power source and make sure it is suitable to the machine features and requirements.

#### 10 – POWER SOURCE FREQUENCY

Probable cause: Power source frequency out of the range

Solution: check the power source and make sure it is suitable to the machine features and requirements.

#### 15 – VOLTAGE ON THE WELDING LEADS IN STANDBY MODE

Probable cause: Hardware failure

Solution: contact an authorized service center.

#### 20 – AMBIENT TEMPERATURE OUT OF THE RANGE

Probable cause: Ambient temperature is out of range

Solution: Protect the working site where the welding is taking place in order to get a suitable ambient temperature.

#### 25 – CURRENT SENSOR

Probable cause: Broken sensor.

Solution: contact an authorized service center.

#### 30 – WELDING VOLTAGE OUT OF CONTROL

Probable cause: The power source is supplying an out-of-range voltage.

Solution: check the power source and make sure it is suitable to the machine features and requirements.

35 e 40 –MACHINE OVERHEATED

Probable cause: the machine overcomes its maximum working temperature in the last welding

Solution: Wait until the machine has cooled off.

45 – CURRENT EXCEEDS MAXIMUM LIMIT

Probable cause: The heating wires inside the coupler made a short circuit

Probable cause: The coupler diameter is bigger than allowed

Solution: Repeat the welding with another coupler

50 – CURRENT BELOW MINIMUM VALUE

Probable cause: One or both welding cables were unplugged during the welding

Solution: Reconnect the welding cables and repeat the procedure

Probable cause: The heating wires inside the coupler are interrupted

Solution: Repeat the welding with another coupler

Probable cause: The coupler is too small (the electrical resistance is too high)

Solution: Repeat the welding with a compatible coupler

55 – WELDING CYCLE ABORTED BY THE OPERATOR

Probable cause: The operator pressed the STOP push button

Solution: Repeat the welding

60 – SHORT CIRCUIT

Probable cause: The coupler is damaged

Solution: Repeat the welding with another coupler

65 – LACK OF VOLTAGE AT THE POWER SOURCE

Probable cause: Power supply cable unplugged

Solution: Plug the power supply cable

Probable cause: The voltage supply was interrupted

Solution: Wait until the service is restored

Probable cause: The safety micro switch has pop out

Solution: Engage the safety micro switch

70 –HARDWARE ERROR

Solution: Contact an authorized service center

#### 75 – COUPLER RESISTANCE ERROR

Solution: Repeat the welding with another coupler

#### 80 – OVERHAUL EXPIRED

Solution: Contact an authorized service center

#### 85 – REPORT MEMORY FULL

Solution: download all the welding data reports stored in the machine.

Type in OTHER FUNCTIONS the code on page 20 to delete the stored reports.

If you do not delete the reports and continue to use the machine, the last report will replace the first one in the memory, then the second report will be replaced, and so forth.

#### 90 – UNSTABLE CURRENT WITHDRAWAL BY THE COUPLER

Probable cause: The coupler coils can be damaged, or the cable leads can be loose.

Solution: check the leads and try to replace the coupler. This error does not appear in the very beginning of the welding cycle.

#### 95 - INTERNAL MEMORY

Probable cause: Hardware error.

Solution: Contact the service center. Press 'STOP' to proceed anyway.

#### 100 – HARDWARE ERROR WHEN WELDING STARTS

Probable cause: The coupler coils can be damaged or the cable, leads can be lose/damaged.

Solution: check the leads and try to replace the coupler. This error only appears in the very beginning of the welding cycle.

#### 110 – POWER OVERLOAD

Probable cause: the fitting requires too much power.

Solution: Use a fitting that requires less power