



# OPERATING MANUAL

## PUK D6

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Lampert Werktechnik GmbH  
Fine welding device

Issue EN 2024/07



**Product :** Fine welding device  
**Type:** PUK D6

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# Contents

<b>1</b>	<b>About this operating manual .....</b>	<b>6</b>
1.1	General.....	6
1.2	Presentation of information.....	7
	Handling instructions .....	7
	Application tip .....	7
1.3	Structure of the warnings.....	8
<b>2</b>	<b>General safety regulations.....</b>	<b>10</b>
2.1	Principles.....	10
2.2	Intended use .....	10
2.3	Foreseeable misuse .....	11
2.4	Safety instructions.....	11
	General information .....	11
	Personal protective equipment.....	11
	Handling protective gas cylinders .....	12
	During transport .....	12
	During installation.....	12
	During commissioning.....	12
	During operation.....	13
	Maintenance and inspection work.....	13
	During disassembly .....	14
2.5	Residual risks for device operation .....	14
2.6	Selection and qualification of personnel .....	14
2.7	Safety devices.....	15
2.8	Safety signs .....	16
<b>3</b>	<b>Structure and function .....</b>	<b>17</b>
3.1	Functional description .....	17
	Scope of delivery.....	17
3.2	General overview.....	18

3.3	PUK D6 .....	19
3.4	Handpiece with connection cable .....	22
3.5	Optional electrode grinding motor (item number 100 858) .....	23
3.6	Optional foot switch (item number 100 850) .....	24
3.7	Type plate .....	25
<b>4</b>	<b>Transport and storage .....</b>	<b>26</b>
4.1	Transport .....	26
4.2	Storage .....	26
<b>5</b>	<b>Commissioning .....</b>	<b>27</b>
5.1	Setting up the device .....	27
5.2	Establishing supplies .....	27
5.3	Connect eye protection .....	28
5.4	Insert the electrode into the handpiece .....	28
5.5	Adjusting the electrode length .....	29
5.6	Connecting the handpiece .....	30
5.7	Connecting the contact clamp .....	30
5.8	Connecting optional accessories .....	30
<b>6</b>	<b>Graphical user interface .....</b>	<b>31</b>
6.1	Main menu .....	31
	Material selection .....	32
	Welding power and pulse duration .....	33
	Menu bar .....	35
	Geometry selection .....	36
	Speed levels .....	37
6.2	Micro mode .....	37
6.3	Retention mode .....	38
6.4	Fixation mode .....	39
6.5	Settings menu .....	41

6.6	Update menu.....	42
6.7	Standby mode .....	43
<b>7</b>	<b>Using the PUK D6 .....</b>	<b>44</b>
7.1	Switching on the PUK D6 .....	44
7.2	Adjusting the gas flow .....	45
7.3	Welding with the PUK D6.....	46
7.4	Switching off the PUK D6.....	48
7.5	Basic information and tips.....	48
<b>8</b>	<b>Help with faults .....</b>	<b>49</b>
<b>9</b>	<b>Care and inspection work .....</b>	<b>50</b>
9.1	Care and inspection schedule .....	50
9.2	Carry out care and inspection work .....	50
	Cleaning the PUK D6.....	50
	Regrinding electrodes .....	50
<b>10</b>	<b>Disposal and recycling .....</b>	<b>51</b>
<b>11</b>	<b>Dimensions and technical data .....</b>	<b>52</b>
11.1	Device dimensions.....	52
11.2	Technical data for the device .....	53
<b>12</b>	<b>Appendix.....</b>	<b>54</b>
12.1	Service address.....	54
12.2	Spare and wear parts .....	54
12.3	CE conformity.....	55
12.4	UKCA conformity .....	56

# 1 About this operating manual

Before operating the device for the first time or starting any other work on the device, you are required to read these operating instructions carefully.

Pay particular attention to the chapter 2 "General safety regulations".

## 1.1 General

These operating instructions are intended to help you get to know the device and use it as intended. They contain important information on how to operate the device safely and properly.

The operating instructions must

- be fully read and applied by any person assigned to work on the device.
- be stored in such a way that they are accessible at all times to all users at the place of use of the device.
- be handed over to third parties together with all necessary documents when the device is passed on.

Observance of the operating instructions helps

- to avoid dangers.
- to reduce repair costs and downtime.
- to increase the reliability and service life of the device.

In addition to the operating instructions, the accident prevention and environmental protection regulations applicable in the country of use and at the place of use must also be observed.

Safety and danger notices on the device must be kept in legible condition and must not be removed, covered or damaged.

## 1.2 Presentation of information

### Handling instructions

The instructions explain step by step which activities have to be carried out and how to proceed.

In these operating instructions, handling instructions are marked with the following symbols:

- The steps marked with this activity symbol may be carried out in any order.
- 1) Numbered steps **must be** carried out exactly in the given order.
- ✓ The result symbol describes the result or intermediate result of an action.

### Application tip

The "**TIP**" indicates additional information for easy and safe use of the device.

**TIP:** Note on the optimal use of the device.

## 1.3 Structure of the warnings

Signal word	Avoidance of ...	Possible consequences if the warning is not heeded:
<b>DANGER</b>	Personal injury (imminent danger)	Death or severe injuries!
<b>WARNING</b>	Personal injury (potentially hazardous situation)	Death or severe injuries!
<b>CAUTION</b>	Personal injury	Light or minor injuries!
<b>NOTE</b>	Property damage	Damage to the device or its immediate surroundings!

Tab. 1.1 Warning levels

The warnings are structured as follows:

- Warning sign with signal word in accordance with the warning level (see Tab 1.1)
- Type of hazard (description of the hazard)
- Consequences of the hazard (description of the consequences of the hazard)
- Hazard prevention (measures to prevent the hazard)



**DANGER!**

**Type of hazard**

Consequences of hazard

➤ Hazard prevention



**Warning sign** Special warnings are given at relevant points. They are marked with the following pictograms.

**General warning sign**

This sign warns of personal injury.

In the case of a clearly identifiable source of danger, it is preceded by one of the following pictograms.

**Electrical voltage**

Warning of possible electric shock, potentially with fatal consequences.

**Hand injuries**

Warning about the danger of hand injuries.

**Hot surfaces**

Warning of hot surfaces.

**Pressurised containers**

Warning of fire and explosion hazard.

**Optical radiation**

Warning of optical radiation.

**Hazard due to electromagnetic radiation**

Warning of electromagnetic fields.

## 2 General safety regulations

### 2.1 Principles

The device shall be used only when in flawless condition and is intended exclusively for work in accordance with the intended use.

### 2.2 Intended use

The device is intended for welding on all metals and alloys that are suitable for arc welding.

Intended use also includes

- the complete reading and following of all instructions in the operating manual.
- the complete reading and following of all safety and hazard instructions
- compliance with maintenance and servicing work.

The device is designed for use in industrial and commercial applications. The manufacturer is not liable for damage resulting from use outside this area of application.

Temperature range of the ambient air:

- during operation: -10 °C to + 40 °C (14 °F to 104 °F)
- during transport and storage: -20 °C to +55 °C (-4 °F to 131 °F)

Relative humidity:

- - up to 50 % at 40 °C (104 °F)
- - up to 90 % at 20 °C (68 °F)

The ambient air should be free of dust, acids, corrosive gases or substances.

## 2.3 Foreseeable misuse

The hardware and software of the device is designed in such a way that misuse is largely avoided or reduced to a minimum by safety features. Nevertheless, in exceptional cases, misuse by the user is possible and must be avoided when operating the device:

- Welding of non-weldable metals or alloys
- Use of an inappropriate shielding gas
- Exerting too much pressure on the electrode
- Use of the device without personal protective equipment

## 2.4 Safety instructions

### General information

- If the device shows signs of damage, it must be taken out of service.
- If malfunctions occur, the device must be taken out of service.

### Personal protective equipment

The personal protective equipment listed below must be worn during every welding operation:

- Gloves
- Eye protection
- Dry clothing (non-synthetic and flame retardant)

Furthermore, the workplace must be sufficiently ventilated. If this cannot be ensured by fresh air supply, an exhaust system must be installed.

## Handling protective gas cylinders

Observe the relevant precautions when handling gas cylinders, as well as the safety rules for handling gases.

In particular, gas cylinders must be secured against falling over and down and protected against heating (max. 50 °C), especially during prolonged exposure to sunlight and against severe frost.

## During transport

- Ensure that all connecting cables have been removed from the device to prevent the operator from tripping and damaging the device.
- When transporting the device, ensure that it is always securely packed and not dropped or knocked over.

## During installation

- The device must be placed in a stable and non-slip position at the workplace.
- The device must be placed on a non-combustible surface.

## During commissioning

- The device must not be connected to a circuit in which devices (e.g. TIG welders) that work with high frequency are operated at the same time. This may cause irreparable damage to the device. In the case of simultaneous operation with equipment that operates at high frequency, always ensure that the device is operated on a separate, individually fused circuit that is shielded and protected from high frequency input from other equipment. In addition, physical separation and a minimum distance of at least 5 metres
- s from devices that work with high frequency must always be maintained.
- The eye protection must be checked for correct fit and proper function. Follow the instructions in the operating manual of the respective eye protection system.
- Before each start-up of the device, make sure that the gas connection on the back of the device as well as the connection on the flow regulator have been hand-tightened without tools.

- If there are indications of leaks in the gas hose or gas connection (e.g. audible hissing or whistling noise or unusually rapid loss of pressure in the gas container), the device must be taken out of operation and defective components replaced.

## During operation

- Always wear gloves when welding. Do not touch the workpiece without gloves during or immediately after the welding process.
- During the welding process, parts of the skin must never be directly exposed to the UV radiation that is generated by the welding process.
- The contact clamp for fixation welding must be removed from the blue socket on the right hand side of the PUK D6 ( - ) again after fixation welding has been completed. In normal welding operation, always make sure that the contact clamp for fixation welding is not connected to the device.
- An extraction system must be installed at the workplace. In addition, the workplace should be sufficiently ventilated without creating draughts.
- The flow rate at the flow regulator must be between 2 - 3 litres/minute.

## Maintenance and inspection work

- Disconnect the device from the power supply before carrying out maintenance, inspection and cleaning work.
- The clamping nut on the handpiece must be hand-tightened after replacing the electrodes.
- When regrinding electrodes, wear protective gloves and do not touch the rotating grinding wheel.
- When regrinding electrodes, make sure that the resulting grinding dust is not inhaled.
- The device fuse may only be replaced by a qualified electrician and only the fuse approved by the manufacturer for the respective mains voltage may be used.

## During disassembly

- The valve on the gas cylinder must always be closed during decommissioning and dismantling.
- When dismantling the device, disconnect it from the power supply.
- When dismantling, remove the electrode from the handpiece to avoid puncture injuries.

## 2.5 Residual risks for device operation

In principle, it is not possible to exclude the following hazards:

- Puncture injury from electrode due to improper handling of the handpiece
- Danger from leaking or improperly connected protective gas cylinders
- Eye and skin damaging arc radiation on uncovered skin areas

## 2.6 Selection and qualification of personnel

The operator undertakes to only allow persons to work on the device who

- are familiar with the basic regulations on occupational safety and accident prevention and have been instructed in the handling of the device.
- have read and understood this operating manual, in particular the "General safety regulations" chapter.
- are trained with regard to the requirements for the work results.

The safety-conscious working of the personnel must be checked at regular intervals.

All persons who are instructed to work on the device undertake, before starting work, to

- observe the fundamental regulations governing occupational safety and accident prevention

- confirm with their signature that they have read and understood this operating manual, and in particular the chapter on “safety instructions”, and that they will observe this information.

## 2.7 Safety devices

- The device has a thermal cut-off device that is activated if the heat build-up is too high, preventing the device from overheating.

## 2.8 Safety signs

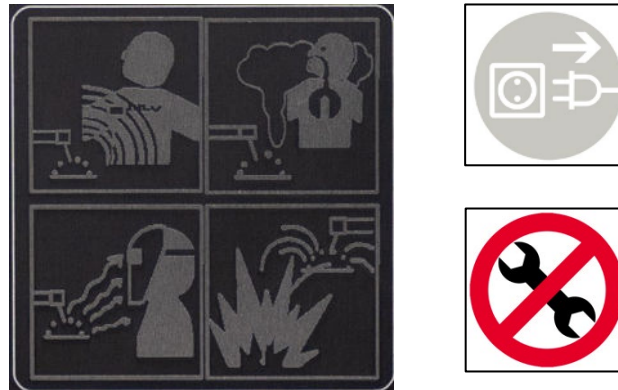


Fig. 2.1 Safety signs on the back of the device

Safety sign	Description
	Electromagnetic fields may impair the function of pacemakers.
	Inhaling welding fumes can endanger your health.
	Arcs can damage the eyes and injure the skin.
	Welding sparks may cause an explosion or fire.
	In case a qualified electrician needs to open the device, the main cable always needs to be unplugged before.
	The union nut of the protective gas hose may only be tightened by hand on the protective gas connection. The use of tools (e.g. wrenches) can damage the protective gas connection.

Tab. 2.1 Safety sign



## 3 Structure and function

### 3.1 Functional description

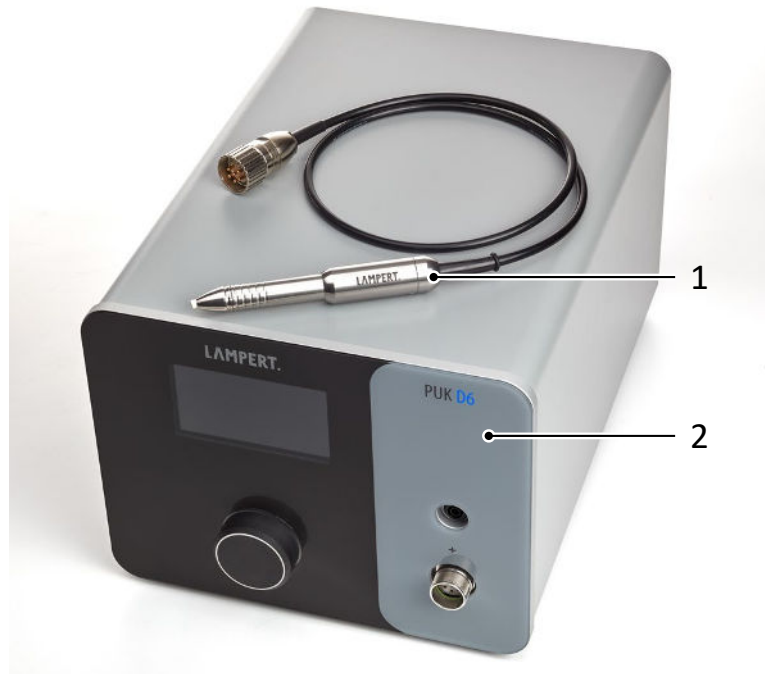
The PUK D6 is a micro-pulse TIG welder. The welding process is controlled by the central control and regulation unit of the PUK D6. For a precise welding process and a perfect result, the welding process is continuously monitored and the target parameters are adjusted as required using control algorithms. The energy pulses generated by the power source are transferred to the workpiece via the handpiece included in the scope of delivery and its electrode, thereby carrying out the welding process.

#### Scope of delivery

The scope of delivery of the device includes:

- Handpiece with connection cable
- Main cable
- 3 m gas connection hose
- Contact cable with contact clamp 1 m
- Pin welding adapter set
- Set of electrodes and one diamond grinding wheel

## 3.2 General overview



*Fig. 3.1 Overview of PUK D6 with handpiece*

1. Handpiece with connection cable
2. PUK D6

## 3.3 PUK D6



Fig. 3.2 PUK D6 Front

1. Display
2. Socket (+) for contacting tools such as contact clamps and holding pliers
3. Handpiece connection socket (-) for the welding handpiece
4. Turn-push controller with tilt function

**Display** Displays the user interface of the operating software.

**Socket (+) for contacting tools** For connecting contact elements such as contact terminals or clamps.

**Handpiece socket (-)** For connecting the handpiece.

**Turn-push controller** The Turn-push controller can be turned, tilted and pressed. Depending on the software dialogue, the following actions can be triggered:

- Turn: Changing the welding parameters or the operating mode
- Tilt: Navigating the user interface
- Press: Confirm the selected choice

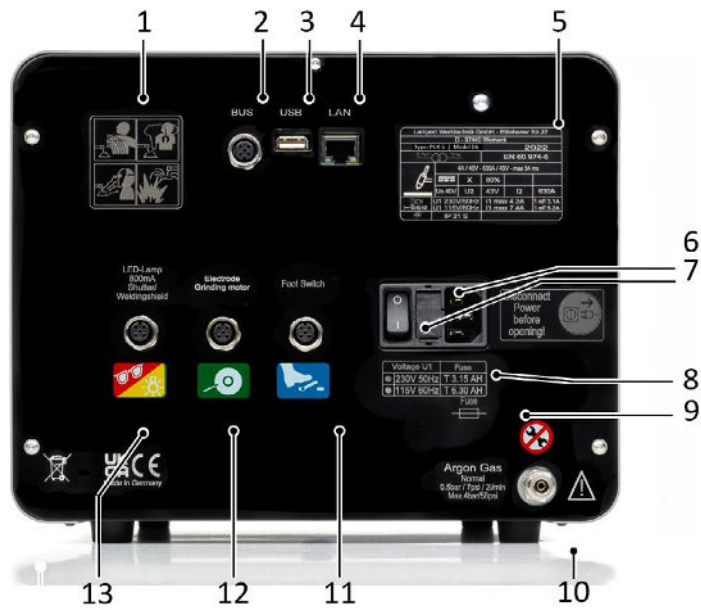


Fig. 3.3 PUK D6 Rear

1. Hazard warnings
2. Bus connection
3. USB connection
4. LAN connection
5. Type plate
6. Mains switch
7. Fuse compartment
8. IEC-60320 C14 socket
9. Mains voltage approved for this device
10. Protective gas connection
11. Connection socket for foot switch
12. Connection socket for electrode grinding motor
13. Connection socket for eye protection system

<b>Hazard warnings</b>	The hazard warnings indicate the hazards that can potentially arise from the device.
<b>Bus connection</b>	Currently without function.
<b>USB connection</b>	The USB port is used to update the device software via USB data carrier.
<b>LAN connection</b>	The LAN connection is used for device diagnostics or enables an external control of the device via Modbus protocol. This function depends on the model and software version of the welding device (not implemented as a standard).
<b>Type plate</b>	The type plate shows the most important technical data for the device.
<b>Mains switch</b>	The mains switch can be used to disconnect the device from the power supply.
<b>Fuse compartment</b>	The device fuse is located in the fuse compartment.
<b>IEC-60320 C14 socket</b>	The mains cable supplied is connected to the mains socket.
<b>Mains voltage approved for this device</b>	The permissible mains voltage for the device is marked with a red dot-shaped marking and must not be exceeded.
<b>Protective gas connection</b>	The gas connection allows the connection of argon inert gas. The gas hose must have a diameter of 6.0 mm and may carry a maximum pressure of 4 bar.
<b>Connection socket for foot switch</b>	A foot switch with M12 connection can be connected to this socket.
<b>Connection socket for electrode grinding motor</b>	A Lampert electrode grinding motor from the accessories range can be connected to this socket.
<b>Connection socket for eye protection system</b>	A Lampert eye protection system from the accessories range can be connected to this socket.

## 3.4 Handpiece with connection cable



Fig. 3.4 Handpiece with connection cable

1. Handpiece with argon nozzle
2. Connection cable
3. Handpiece plug

### **Handpiece with argon nozzle**

The handpiece holds the welding electrode and enables the user to move the welding electrode to the workpiece in a targeted manner. The handpiece can be guided freely (appropriate eye protection required) or clamped in a corresponding device (e.g. handpiece holding arm of a Lampert welding microscope). The nozzle with ceramic insert ensures the targeted gas supply at the welding location.

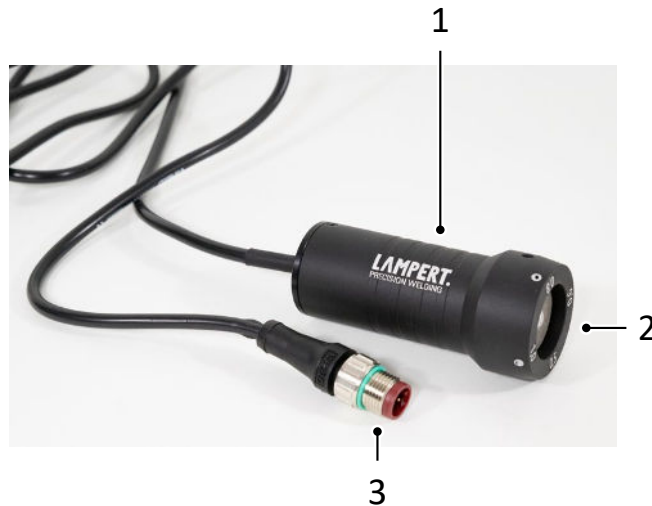
### **Connection cable**

The connection cable contains both the cable guide for the power transmission and the hose for the gas supply to the handpiece.

### **Handpiece plug**

The handpiece connector connects the handpiece firmly and gas-tight to the PUK welding device.

### 3.5 Optional electrode grinding motor (item number 100 858)



*Fig. 3.5 Electrode grinding motor*

1. Electrode grinding motor housing - base body
2. Diamond grinding wheel with flange
3. Connection cable with plug

<b>Electrode grinding motor - housing</b>	The electrode grinding motor housing consists of a housing with guide holes (15° angle, Ø 0.6, 0.8, 1.0, 1.3 mm) and an on/off button.
<b>Diamond grinding wheel with flange</b>	The diamond grinding wheel is used for grinding the electrodes and can be replaced if it shows signs of wear after prolonged use.
<b>Connection cable with plug</b>	The connection cable is screwed with the M12 plug to the corresponding socket on the rear of the welding device housing.

## 3.6 Optional foot switch (item number 100 850)



*Fig. 3.6 Foot switch*

1. Foot switch
2. Connection cable with M12 plug

**Foot switch** The welding process can alternatively be triggered by pressing the foot switch. When the foot switch is active, automatic triggering by electrical contact (workpiece contact) is deactivated. When the fixation welding mode is selected, the foot switch is permanently activated.

**Connection cable with M12 plug** The foot switch connection cable with M12 plug is screwed to the back of the welding device.



## 3.7 Type plate

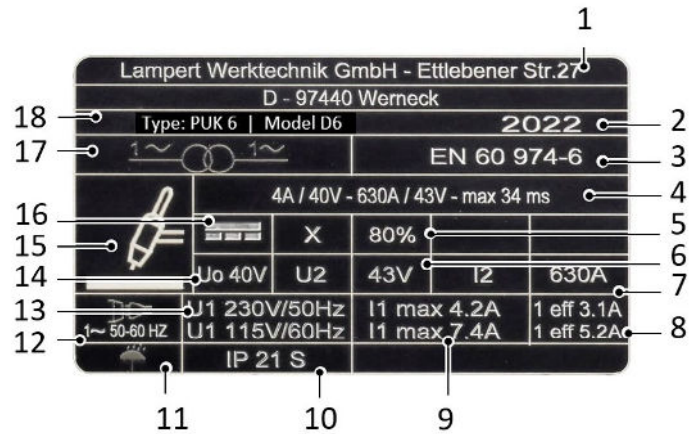


Fig. 3.7 Type plate

1. Manufacturer
2. Date of manufacture
3. Product standard
4. Minimum welding current and maximum welding current with corresponding standardised working voltage as well as maximum pulse duration.
5. Duty cycle in percent
6. Standardised working voltage
7. Standardised operating current
8. Maximum rated value of the mains current
9. RMS value of the largest mains current
10. Protection type
11. Keep away from precipitation
12. Mains circuit, rated frequency
13. Mains voltage and frequency
14. No-load peak value
15. Symbol for the welding process: Tungsten inert gas welding here
16. Symbol for the welding current: DC here
17. Welding current source symbol: Single-phase transformer here
18. Manufacturer's type designation

## 4 Transport and storage

### 4.1 Transport

In principle, the welder can be carried and transported by hand without any special precautions. For longer transport distances, however, we expressly recommend packing the device in the original box or a similar suitable container. To avoid scratches or damage to the surface, it is also advisable to line transport containers with soft, dry and scratch-free materials (e.g. foam).

### 4.2 Storage

For longer storage, disconnect the mains plug and cut off the gas supply.

The storage location of the device must be dry and dust-free and must not be subject to extreme temperatures (colder than -20 °C or hotter than +55 °C).

## 5 Commissioning

### 5.1 Setting up the device

#### Requirements for the location where being used

- The device must be free-standing and not covered with other objects.
- The ventilation openings of the device must be kept free.
- The device shall not be used outdoors.
- The device shall be used in dry rooms only.
- The device shall be used in a well-ventilated location.
- There shall be no direct draughts at the welding site.
- The device must be placed on a non-combustible surface.
- The device must be placed on a level (maximum angle of inclination 10°), stable and insulated surface

### 5.2 Establishing supplies

**Electrical supply** Plug the mains cable with the mains plug into the mains socket on the back of the device. Then plug the mains plug into a socket with a suitable mains voltage.

#### Inert gas supply



#### **WARNING**

#### **Pressurised containers**

Fire and explosion hazard

- Check the tightness of gas cylinders and supply lines.

- Fasten the appropriate flow regulator to the shielding gas cylinder with the corresponding tool. ATTENTION: In doing so, observe the separate operating instructions provided by the manufacturer.
- Use only inert gases as shielding gas, e.g. argon 4.6!

## 5.3 Connect eye protection

Warning! Only suitable original eye protection systems from Lampert may be connected to the welding system! Other eye protection systems can lead to permanent health damage or damage to the welding device. The operating instructions of the respective personal protective equipment (microscope) must be observed.

The eye protection must be checked for correct function each time it is put into operation. The performance of this functional test is explained in more detail in chapter 7.3.

## 5.4 Insert the electrode into the handpiece

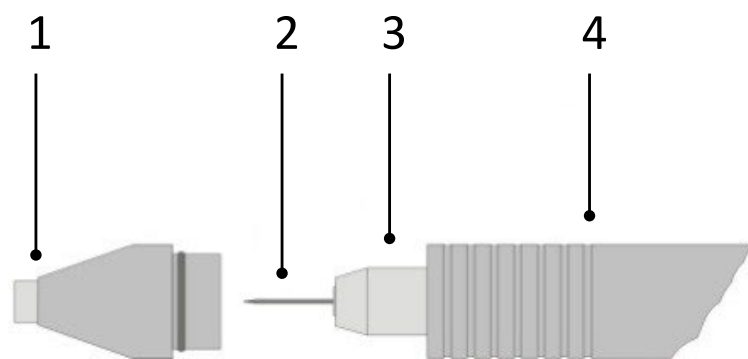


Fig. 5.1 Handpiece components

1. Argon nozzle
2. Tungsten electrode
3. Clamping nut with collet
4. Handpiece housing

**Argon nozzle** The argon nozzle with ceramic insert ensures the targeted gas supply at the welding location.

**Tungsten electrode** The tungsten electrode is used to make electrical contact with the workpiece. Since the arc created during the welding process is generated directly at the tungsten electrode, a well ground tungsten electrode must always be used to ensure an optimum welding result

**Clamping nut with collet**

The clamping nut inside the handpiece ensures the tungsten electrode fit snugly in the collet by hand-tightening. The collet chuck and clamping nut in the handpiece hold the electrode firmly in the handpiece.

**Handpiece housing** The handpiece housing is used to attach, grip or guide the handpiece.

## 5.5 Adjusting the electrode length

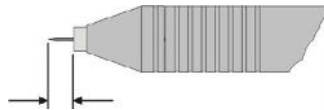
Only thorium oxide-free original electrodes may be used as electrodes.

When changing or inserting a new electrode, the following steps must be carried out:

- 1) Wait until the electrode has cooled down
  - 2) Gently rotate the argon nozzle back and forth while pulling it off the handpiece. The argon nozzle is plugged into place, not screwed on.
  - 3) Loosen the clamping nut counter-clockwise and remove the used tungsten electrode if necessary.
  - 4) If a different electrode diameter is to be used, the collet chuck might also have to be changed accordingly. To do this, completely loosen and remove the clamping nut and then pull the collet out and insert a matching collet. Screw the clamping nut back on.
    - Insert the new tungsten electrode into the collet and adjust to the correct length. If you have a Lampert welding microscope, you can measure the electrode length on the handpiece holding arm. To do this, insert the electrode into the milling on the right or left as far as it will go. The clamping nut must rest against the outer edge of the holding arm. Now hand-tighten the nut and fit the argon nozzle. (See Fig. 5.2)
    - If you do not have a Lampert welding microscope, clamp the tungsten electrode in the handpiece so that it protrudes approx. 4 - 6 mm beyond the nozzle. (See Fig. 5.3)
- ✓ Welding can now be resumed with the new electrode.



*Fig. 5.2 Adjusting electrode length with handpiece holding arm*



*Fig. 5.3 Electrode length adjustment*

## 5.6 Connecting the handpiece

Screw the connector plug of the handpiece into the handpiece socket on the front of the device. To do this, screw the nut on the handpiece connector hand-tight as far as the thread will allow. This is important to ensure proper electrical contact and that no gas can escape from the system.

## 5.7 Connecting the contact clamp

Insert the black contact clamp supplied into the socket marked plus on the front of the housing.

## 5.8 Connecting optional accessories

The optional accessories (e.g. grinding motor or foot switch) are connected via the M12 plug attached to the connection cable. The respective sockets on the back of the device are colour-coded for this. Always tighten the plugs only hand-tight.

## 6 Graphical user interface

The graphical user interface has the following basic functions:

- Setting the welding parameters
- Displaying recommended welding parameters
- Selecting different operating levels or functions
- Performing test functions
- Showing error messages

### 6.1 Main menu

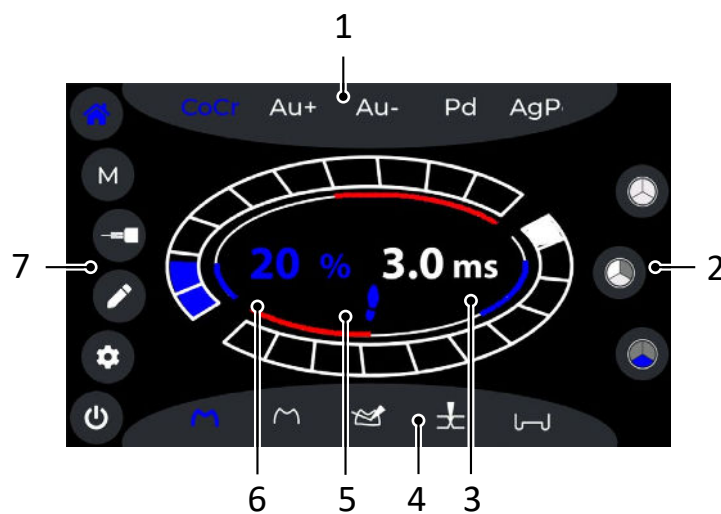


Fig. 6.1 Main menu

1. Material selection
2. Speed levels
3. Pulse duration in milliseconds
4. Geometry selection
5. Foot switch activated (optional)
6. Welding power (in percent)
7. Menu bar

## Material selection

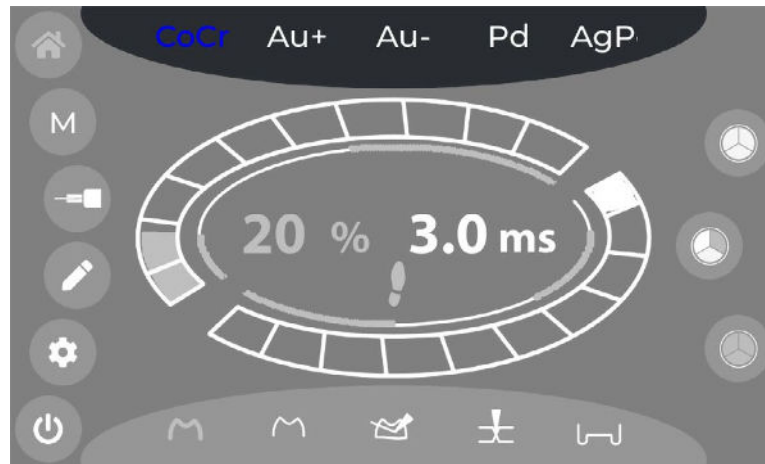


Fig. 6.2 Material selection

Here you select the material to be processed. The following materials are available for selection:

Abbreviation	Material designation
Uni	Universal
Au+	High-gold alloy
Au-	Reduced gold content
AgPd	Silver-palladium
Pd	Palladium-based
NiCr	Nickel-chromium
V2A	Stainless steel
Ti	Titanium
CoCr	Cobalt-chromium alloy
CoCr-Au	Cobalt-chromium alloy to precious metal

Tab. 6.1 Material selection



## Welding power and pulse duration

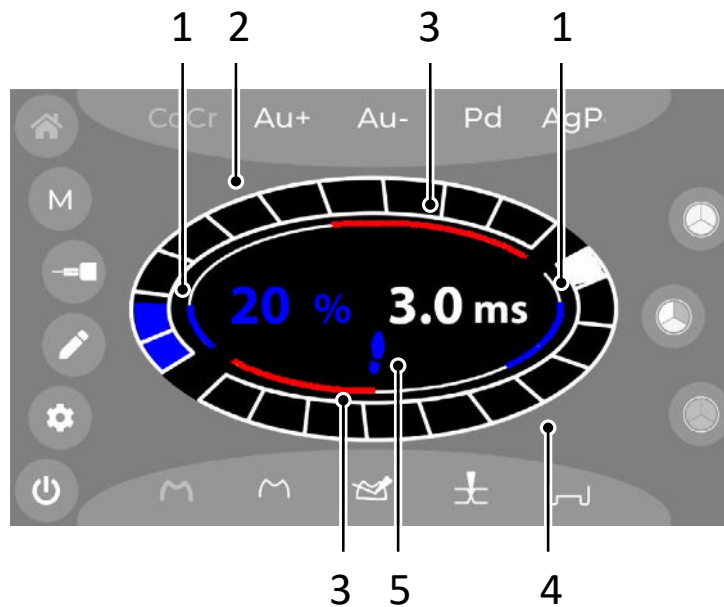


Fig. 6.3 Welding energy and pulse duration

1. Blue range
2. Welding power
3. Red range
4. Pulse duration
5. Foot switch activated (optional)

**Blue range** To make welding with the PUK D6 easier, a value range for the welding power and pulse duration is marked blue in the display as a recommendation for each material-geometry combination.

**Welding power** The welding power controls the size and intensity of the welding spots. The greater the power selected, the more energy the device uses for welding and the larger the weld spot. With very thin materials an excessive power level can damage the workpiece. If the material behaviour is unknown, it is therefore recommended to start with a welding power of 20 % and slowly work up to higher powers. To make welding with the PUK D6 easier, a value range for the welding power is marked blue in the display as a recommendation for each material-geometry combination.

**TIP:** For silver or other highly conductive alloys, it is NOT recommended to set the welding power higher than 50 %, otherwise liquefied material may be thrown out of the welding spot (spattering).

**TIP:** Welding power of more than 70 % is only recommended in special material and geometry-related applications. Otherwise, there is a risk of inhomogeneous welds. The use of higher welding powers in the red range is therefore only recommended for experienced users.

**TIP:** For fine welding, it is recommended to start with a lower welding power of less than 20 % with a very short pulse duration and to work up to the correct value by small changes of the welding parameters.

**Red range** The red range indicates the parameter range in which damage to the material to be welded may occur. The use of welding parameters in the red range is therefore only recommended for experienced users.

**Pulse duration** The pulse duration determines how long (in milliseconds) the welding energy acts. The longer the pulse duration selected, the longer and deeper the energy impact on the workpiece. At the same time, this also results in a higher heat generation.

**TIP:** With very thin materials or wires, it is advisable to select a shorter pulse duration.

**TIP:** When working close to acrylic or ceramic parts or other heat-sensitive materials, a pulse duration of less than 3 ms is recommended.

**TIP:** With many silver alloys or other conductive alloys, a longer pulse duration can be advantageous in order to avoid heat cracks.

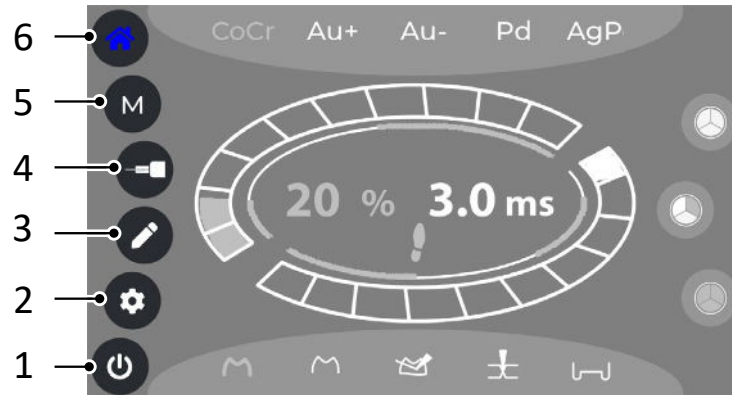
**TIP:** For successful work with the welding device, it is important to consider the power and pulse duration in a close context with each other in every case. The total energy introduced into the workpiece is always made up of both set parameters - these must be selected before a weld after a detailed analysis of the welding task, the material and the workpiece geometry.

**Foot switch (optional,  
item number 100 850)**

The foot switch is activated by pressing the connected foot switch for a longer time (approx. 3 seconds). The blue foot symbol on the display indicates that the foot switch is ready for operation. The welding process can now be triggered directly via the foot switch. In foot switch mode, the contact of the workpiece with the tungsten electrode is signalled by periodic dimming of the eye protection system.

## Menu bar

The menu bar can be used to switch to the various menu and setting levels.



*Fig. 6.4 Menu bar*

The menu bar consists of the following menu levels:

1. Standby mode
2. Settings menu
3. Fixation mode
4. Retention mode
5. Micro mode
6. Main menu

## Geometry selection

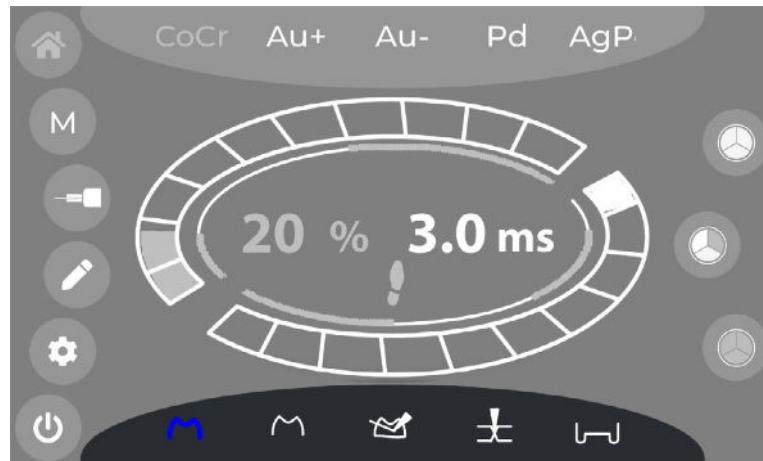


Fig. 6.5 Geometry selection



Universal setting for material thicknesses from approx. 0.3 mm.



Setting for thin or filigree parts equal to or thinner than approx. 0.3 mm. This setting offers very low development of heat, especially in combination with short pulse durations.



Melt welding wire. Use alloy-like wire with a diameter of 0.3 to 0.4 mm. A diameter of 0.35 mm is ideal.



Welding in sharp angles and tight joint situations. Here it is **IMPORTANT** to use short welding times.



Very low-energy melting for welding (orthodontic) bands or wires or generally very thin material.

## Speed levels

With the speed selection, the welding cycle can be set in 3 speed levels



A reduced welding cycle allows longer cooling times between the welding spots and thus results in a lower heat input into the workpiece.

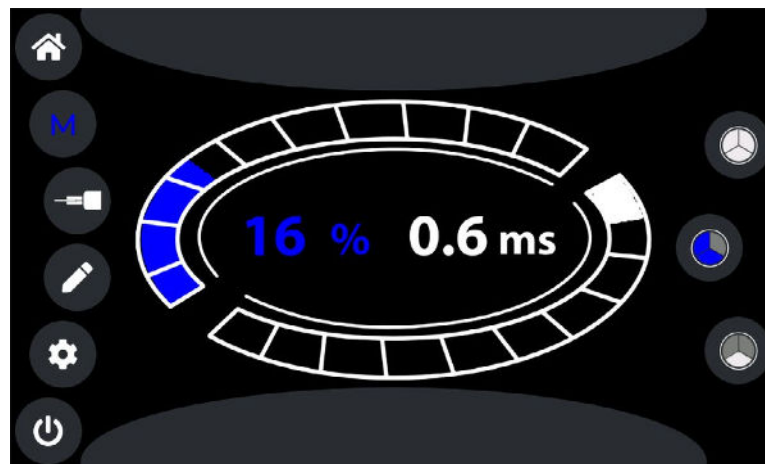


The standard welding cycle setting is universally suitable for numerous applications and is automatically preselected in most welding functions.



The fast-welding cycle (speed mode) enables faster work and prevents excessive cooling of the workpiece between the welding points. A faster welding cycle therefore results in a higher heat input into the workpiece.

## 6.2 Micro mode



*Fig. 6.6 Micro mode*

Micro mode is suitable for particularly sensitive materials and thin material thicknesses. In micro mode, the pulse duration is always preselected as the focus because it is critical for the introduction of heat into the workpiece. In micro mode, the pulse duration can be selected in even smaller steps of 0.1 ms. The shortest possible pulse duration is 0.1 ms.

## 6.3 Retention mode

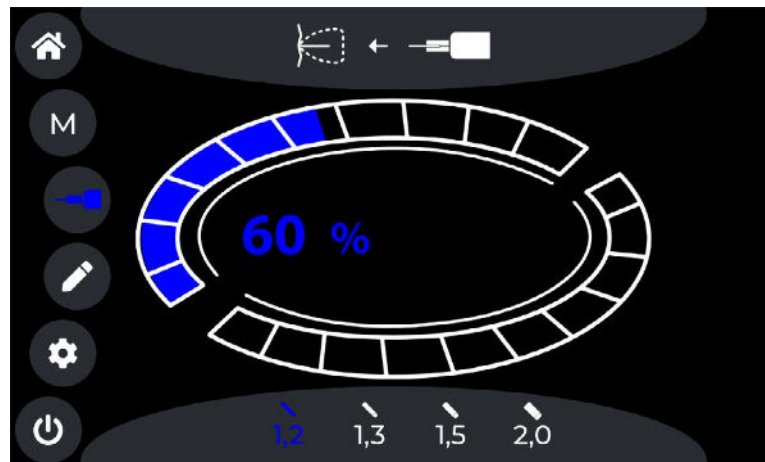


Fig. 6.7 Retention mode

This mode is used for welding on retention pins made of CoCr or NiCr alloys with the corresponding pin welding adapter ( $\varnothing$  1.2, 1.3, 1.5 or 2.0 mm, included in scope of delivery).

Please switch off the unit before changing the electrode or the adapter. This avoids an uncontrolled triggering of a weld. Remove the electrode, replace the clamping nut and collet with the pin welding adapter. Work without clamping nut and handpiece nozzle.

Then select the diameter of the adapter used by choosing the respective button in the display of the PUK D6. Now connect the workpiece to a terminal at a bare metal point. Insert a pin with the appropriate diameter into the pin welding adapter. No shielding gas flows out during the entire process.

### Without foot switch

The welding process itself runs automatically:

At the 1<sup>st</sup> light touch of the workpiece, the pin welding adapter retracts and a continuous tone sounds for approx. 3 seconds (with activated signal tone, see settings). At the 2<sup>nd</sup> light touch, the welding process is triggered (during the continuous tone).

### With foot switch

By pressing the foot switch for a long time (approx. 2 sec.) it is activated, followed by a blue foot symbol in the middle of the display.

At the 1<sup>st</sup> light touch of the workpiece, the pin welding adapter retracts.

At the 2<sup>nd</sup> light touch, the eye protection system (shutter) in the microscope flickers clearly visible.

If the foot switch is now actuated, the welding process is triggered.

By pressing the foot switch for a long time (approx. 2 sec., without contacting a workpiece), the foot switch is deactivated. The blue symbol in the display goes out.

A stable joint is characterised by a clearly audible welding noise. If the process runs silently, the connection is probably not strong enough.

**TIP:** A previous blasting or roughening of polished welds can have a positive effect on the welding behaviour during pin welding.

## 6.4 Fixation mode

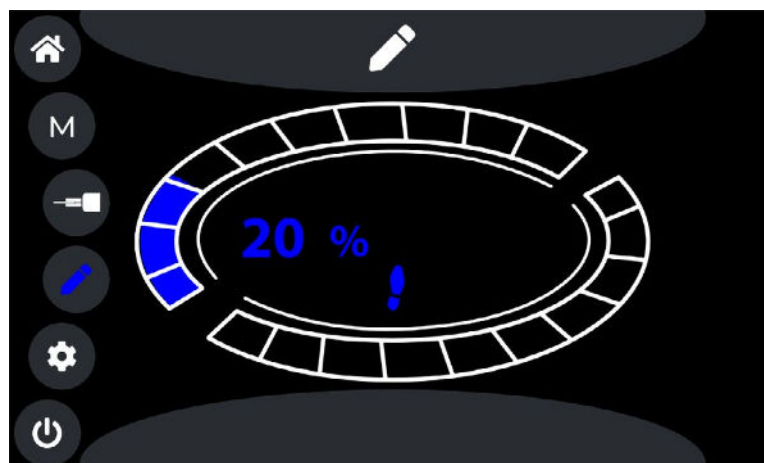
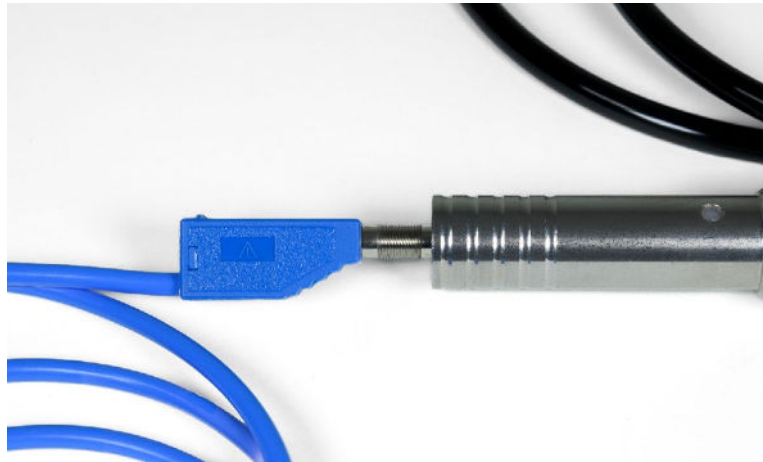


Fig. 6.8 Fixation mode

For fixation welding, the foot switch and an additional contact clamp are required (alternatively, the fixation welding set - optional accessory item number 100 845).

This mode is used for workpiece fixation.

**Attention!** The second connection cable may only be connected after this mode has been activated. Please switch off the unit before removing the electrode or the connecting cable.



*Fig. 6.8 Connection cable fixation mode*

Remove electrode, clamping nut and collet and replace with the plug (4mm) of the second connection cable with contact clamp. Work without clamping nut and handpiece nozzle.

Before leaving the fixation mode, the cable must be removed again to prevent faulty welding.

Connect both workpieces to be fixated at a bare metal point with one of the two contact clamps each. If the two workpieces touch, the welding process can be triggered with the foot switch.

The required welding power is determined by the strength of the connection desired as well as the workpiece geometry

During fixation welding, the foot switch is always active, and cannot be deactivated! The shielding gas flow is deactivated during fixation welding.

**TIP:** Fixation welding is particularly well suited for metals with low conductivity, for example titanium or stainless steel.

**Attention!** Fixation welding is not suitable for precious metal alloys.



## 6.5 Settings menu

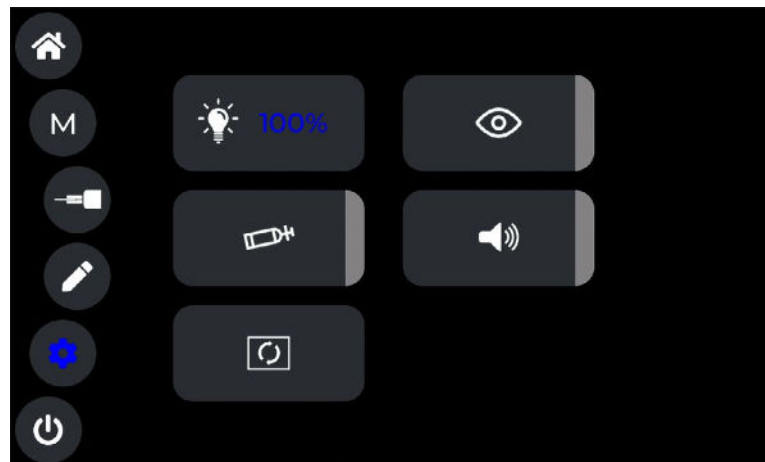
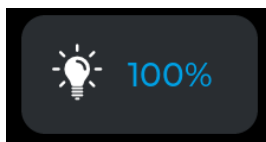


Fig. 6.9 Settings menu



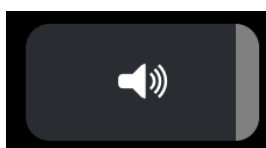
Here the brightness of the LED illumination in the microscope can be selected in the steps 0 %, 25 %, 50 %, 75 % and 100 % by pressing the rotary-push control.



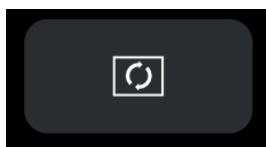
Here the eye protection filter is activated and thus darkened. With this function, the Lampert eye protection system can be checked for correct function.



Here the gas valve in the device is opened. This function is used to be able to set the gas flow correctly on the flow controller (recommended gas flow 2 – 3 l/min).



Here the welding tone to announce the start of the welding process is activated or deactivated.



This opens the update menu.

## 6.6 Update menu

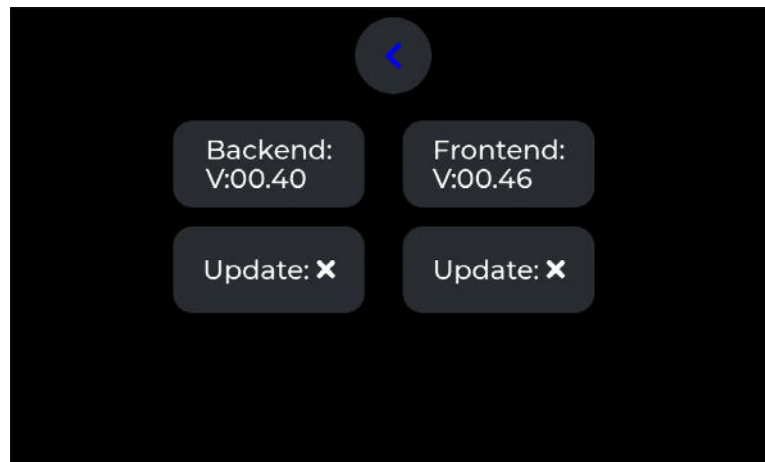


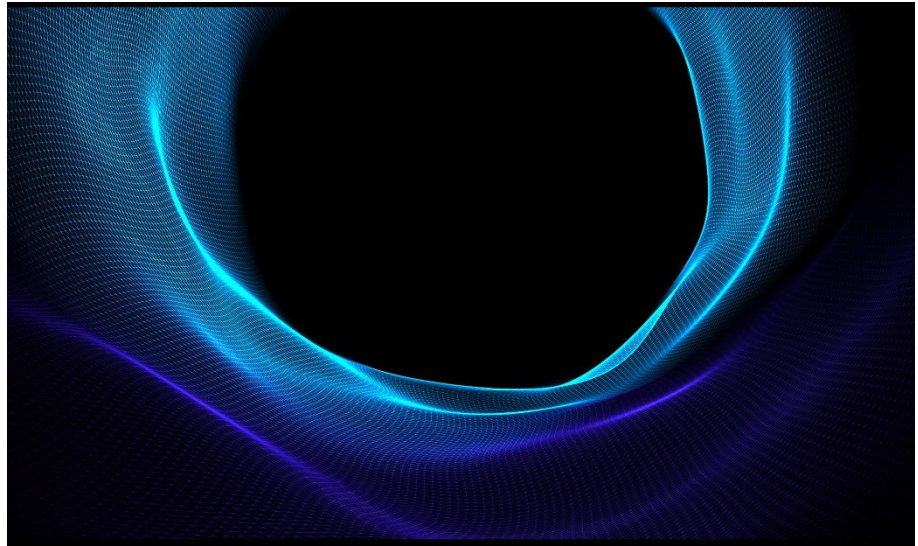
Fig. 6.10 Update menu

Proceed as follows to update the device software:

- 1) Transfer the update file to a USB data carrier. This should have a maximum of 16 GB memory capacity and be formatted in FAT32 format.
- 2) Switch off the welding device on the back of the device.
- 3) Insert the USB data carrier into the USB port on the back of the device.
- 4) Switch on the welding device on the back of the device.
- 5) In the settings menu, select the update button with the rotary-push control and confirm.
- 6) An update window opens as shown in Fig. 6.9. The update can be started with the "Start Update" button. The progress of the update is shown in percent on the display.
- 7) The device restarts after the update.
- 8) You can check whether the software version has been updated correctly in the update menu.
- 9) If the correct software version is installed, remove the USB data carrier.
- ✓ The device software is now updated.

If the update was not successful, the above steps must be repeated. If the update did not work even after repeated attempts, please contact customer service.

## 6.7 Standby mode



*Fig. 6.11 Standby mode*

Standby mode saves energy when the device is not used for welding for a short period. The settings are saved and no uncontrolled welds are possible. This means you do not have to switch off the device between two consecutive applications.

If you do not use the device for more than one hour between two applications, we always recommend that you switch the device off completely using the mains switch for optimum energy consumption.

## 7 Using the PUK D6

### 7.1 Switching on the PUK D6

**CAUTION!****Danger due to operating errors**

As soon as the device is switched on at the mains master switch, voltage is applied to the contact tools. If these come into contact with electrically conductive or earthed parts such as the casing this can lead to undesired erroneous welding.

- Keep electrically conductive parts and earthed housings away from the welding equipment.
-

**DANGER!****Hazard due to electromagnetic radiation**

Pacemakers and other medical implants can be damaged due to electromagnetic radiation. Cables carrying welding current must also not be wrapped around the body. Both can lead to the complete failure of medical implants.

- The device generates a strong electromagnetic field during operation. If you are a medical implant user, check with the implant manufacturer or an authorised medical professional before using the device. If use is possible, clarify the required minimum distance in advance and do not infringe upon this distance at any time when working with the device.

---

Proceed as follows:

- 1) Make sure that the mains cable is connected to the device and the socket.
  - 2) Check the gas connection and carefully open the gas cylinder valve.
  - 3) Set the power switch to "I".
  - 4) Read the safety instruction on the display and confirm it by pressing the rotary-push control.
- ✓ The device is now ready for operation

## 7.2 Adjusting the gas flow

Before the welding process can be started, the flow must be set correctly on the flow controller.

Proceed as follows:

- 1) Close the flow regulator. To do this, turn the black rotary knob counter-clockwise until it stops.
  - 2) Carefully open the main valve of the gas cylinder counter-clockwise with two hands.
  - 3) In the settings menu, select the button for opening the gas valve of the welding device and open the gas valve by pressing the control dial. Now the gas flow can be adjusted to a value between 2 and 3 litres/minute by turning the flow regulator clockwise. Please also refer to the separate operating instructions for the flow regulator. After setting the correct flow rate, close the gas valve by pressing the control knob again.
- ✓ The gas flow is now set correctly.

## 7.3 Welding with the PUK D6



### CAUTION

#### Hot surfaces

Danger of burns to the skin

- It is absolutely essential to wear gloves when welding
- 



### WARNING

#### Optical radiation

Danger of eye damage

- Suitable eye protection must always be worn during welding.
- 

Proceed as follows:

- 1) Check the function of the eye protection filter. To do this, connect the eye protection system to the welding device. Press the button for the eye protection test in the settings menu of the welding device. This darkens the field of vision. This can be checked by looking through the oculars. If the button for the eye protection test is pressed again, the LED illumination must be visible again when looking through the oculars.
- 2) Check the flow rate of the gas. The optimal flow rate is 2 - 3 litres/minute.
- 3) Select the welding parameters.
- 4) Free the workpiece from contamination with a suitable cleaner.
- 5) Connect a metallic blank section of the workpiece with the contact clamp.
- 6) Move the workpiece towards the electrode in the handpiece holding arm.
- 7) Establish contact between the workpiece and the electrode without exerting pressure on the electrode. The welding process now starts automatically.
- 8) Do not release the contact between the workpiece and the electrode until the welding process is finished.
- 9) By touching the workpiece again, you can trigger the next welding process.

The fine welding device is equipped with a function to prevent the electrode becoming welded to the workpiece by incorrectly pressing or pressing too hard. If a welding point has already been set and too much pressure has been exerted with the workpiece on the electrode when it comes into contact again, the welding process is not triggered; instead, a signal tone will indicate that no welding can be performed without contact interruption. The electrode's contact to the workpiece must be interrupted and the welding process must be started again. The welding process can be interrupted at any time by lifting the electrode away from the workpiece.

**TIP:** Always work with a well ground electrode.

**TIP:** Never weld "freehand", i.e. use the hand rests on the microscope. Even a slight trembling of the hands can impair the welding results.

## 7.4 Switching off the PUK D6

Proceed as follows:

- 1) Set the contact clamp down such that no accidental contact can take place.
  - 2) Switch off the device at the main switch on the back of the device.
  - 3) Close the valve on the gas cylinder.
- ✓ The device is switched off.

## 7.5 Basic information and tips

- The quality of the welding result depends essentially on the quality of the grinding of the electrode.
- Perfect electrical contact of the workpiece to the contact terminal must always be ensured, i.e. the workpiece should be connected to the terminal of the connecting cable or via a contacting tool at a metallicly bright point.
- Free-hand welding leads to poorer welding results due to uncontrollable movements of the hands.
- The pressure on the electrode tip should only be light.
- A gas flow rate of approx. 2-3 litres/minute is recommended. The gas flow should be checked regularly at the flow controller and readjusted if necessary.
- The angle at which the workpiece touches the electrode tip significantly influences the flow direction of the spot weld.
- For welding tasks at deeper lying spots, the electrode can be clamped in such a way that it protrudes slightly longer from the nozzle. The gas flow rate can be slightly increased in this case.
- In many cases, it is helpful to work with welding wire as a welding filler. The use of solder is not permitted.



## 8 Help with faults

No.	Fault	Possible cause	Fault rectification / solution
1	Main power switch on, but device does not start.	Mains cable interrupted	Check mains cable and mains voltage
		Device fuse blown	Replace device fuse with identical fuse
2	Device switched on, but welding process does not start	Cable connection interrupted	Check all cable connections
		Connection with the workpiece interrupted	Check connection to the workpiece
		Fault due to leakage current	Switch device off and on again. If the fault is not corrected, please contact customer service
3	Mains protection trips	Mains fuse rating too low	Fuse mains properly
		Mains protection trips while the device is in standby	Contact customer service
4	Poor welding characteristics	Incorrect shielding gas	Use inert shielding gas (e.g. Argon 4.6)
5	Poor ignition characteristics	Electrode clamped loosely in hand piece	Tighten the clamping nut on the hand-piece by hand
6	Oxidation and rusting	Excessive gas pressure	Reduce flow rate – approx. 2 l/min
7	Severe oxidation of the welding points	Incorrect shielding gas	Use inert shielding gas (e.g. Argon 4.6)
8	Tungsten embeddings in base material	Excessive pressure of the electrodes on the workpiece	Touch workpiece with extremely light pressure
9	Tungsten electrode welds to workpiece	Excessive pressure of the electrodes on the workpiece	Touch workpiece with extremely light pressure
10	Tungsten electrode melts off immediately	Electrode abraded ground too steeply	Use the recommended angle of abrasion grinding (approx. 15°)
11	Static discharge over the surface of the device	Special local conditions	Use special foot mat for the workspace
12	Device begins to weld immediately when touching the workpiece (no gas pre-flow)	Malfunction	Immediately put the device out of operation and contact customer service

Tab. 8.1 Causes of errors and fault rectification

## 9 Care and inspection work

The device must always be switched off before care and inspection work.

### 9.1 Care and inspection schedule

Interval	Care and inspection work	Comments
Daily	Check working environment	Clean if necessary
	Check the condition and cleanliness of the device	Clean if necessary
	Check the gas hose for leaks	
As required	Clean the screw connection of the electrode in the handpiece to ensure electrical contact.	
	The electrode can be reground.	Replace electrode when worn out.

Tab. 9.1 Care and inspection schedule

### 9.2 Carry out care and inspection work

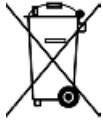
#### Cleaning the PUK D6

- Use a dry / slightly damp cloth to remove dust and carefully clean the surfaces of the device.
- A non-abrasive glass cleaner (e.g. spectacles cleaner) can be used for the screen on the front of the display.

#### Regrinding electrodes

- 1) Switch off the device.
  - 2) Remove the electrode from the handpiece.
  - 3) Use the electrode grinding motor with a fine or medium-fine grinding wheel to grind the electrode.
  - 4) Grind the electrode at a 15° angle. With the grinding motor from the PUK D6 original accessories, this angle is predetermined by the guide holes.
- ✓ Now the electrode can be reinserted into the handpiece.

## 10 Disposal and recycling



Render discarded devices unusable by removing the mains cable. Only for EU countries: In accordance with European directive 2012/19/EU regarding the disposal of used electrical and electronic equipment, discarded electrical devices must be separated and collected and sent for recovery in an environmentally friendly manner.

# 11 Dimensions and technical data

## 11.1 Device dimensions

Name		Value	Unit
Weight		10.4	kg
Dimensions	Length	392	mm
	Width	269	mm
	Height	216	mm

*Tab. 11.1 Machine dimensions*

## 11.2 Technical data for the device

Name	Value	Unit
<b>Electrical connection</b>		
Voltage (supply) L+N+PE	230	V AC
Frequency	50	Hz
Fuse/breaker protection provided by the operator Tripping characteristics:	B	
Power consumption	300	W
Power consumption stand-by mode	8 – 10	W
Max. current	4.4	A
Protection class per EN 61140:2016	Protection class I	
Closed circuit voltage	25 - 43	V
No-load voltage	43	V
Duty cycle	80 %	
<b>General data</b>		
Max. operating temperature	60	°C
Max. outside temperature	Transport/storage	-20 - +55 °C
	Operation	-10 - +40 °C
Relative humidity	Up to 50 % at 40 °C Up to 90 % at 20 °C	
Max. location altitude (above sea level)	1000	m
Protection type per EN 60529:2014	IP21S	
Shielding gas	argon	
Maximum gas pressure	4	bar

Tab. 11.2 Technical data for the machine

## 12 Appendix

### 12.1 Service address

If you have any problems with your PUK fine welding device, please contact your Lampert partner company or the Lampert dealer from whom you purchased the device.

In the event that you have not purchased the device via an authorised Lampert partner company or are unable to locate one, please contact the manufacturer directly:

Lampert Werktechnik GmbH  
Ettlebener Strasse 27  
97440 Werneck  
Germany  
+49 9722 9459 0  
mail@lampert.info

### 12.2 Spare and wear parts

Only original spare and wear parts may be used for your PUK D6. These are listed in the Lampert spare parts catalogue and on the manufacturer's website.

## 12.3 CE conformity

### EU declaration of conformity

in accordance with the Low-Voltage Directive 2014/35/EU, Annex IV

Original



**The manufacturer bears the sole responsibility for issuing this declaration of conformity**

Lampert Werktechnik GmbH

Ettlebener Straße 27

97440 Werneck

Germany

#### Object of this declaration

Product / Article	Microarc spot welding device
Serial number	680 000
Type	Microarc spot welding device
Commercial name	PUK D6 precision welding device
Model	PUK D6

**The object of the declaration described above meets the relevant harmonisation legislation of the European Union:**

2014/35/EU	Directive 2014/35/EU of the European Parliament and of the Council of 26 February 2014 on the harmonisation of the laws of the Member States relating to the making available on the market of electrical equipment designed for use within certain voltage limits Published in 2014/L 96/357 of 29.03.2014
2014/30/EU	Directive 2014/30/EU of the European Parliament and of the Council of 26 February 2014 on the harmonisation of the laws of the Member States relating to electromagnetic compatibility (recast) Published in 2014/L 96/79 of 29.03.2014
2011/65/EU	Corrigendum to Directive 2011/65/EU of the European Parliament and of the Council of 8 June 2011 on the restriction of the use of certain hazardous substances in electrical and electronic equipment Published in 2014/L 44/55 of 14.02.2014

#### Applied harmonised standards:

EN 60974-6:2016	Arc welding equipment – Part 6: Limited duty equipment
EN 61000-6-2:2005	Electromagnetic compatibility (EMC) – Part 6-2: Generic standards - Immunity for industrial environments
EN 61000-6-4:2007/A1:2011	Electromagnetic compatibility (EMC) - Part 6-4: Generic standards - Emission standard for industrial environments
EN 61000-3-2:2014	Electromagnetic compatibility (EMC) - Part 3-2: Limits - Limits for harmonic current emissions (equipment input current ≤ 16 A per phase)
EN 61000-3-3:2013	Electromagnetic compatibility (EMC) - Part 3-3: Limits - Limitation of voltage changes, voltage fluctuations and flicker in public low-voltage supply systems, for equipment with rated current ≤ 16 A per phase and not subject to conditional connection
EN 63000:2018	Technical documentation for the assessment of electrical and electronic products with respect to the restriction of hazardous substances

Additional information none

#### Signed for and on behalf of:

**LAMPERT.**  
PRECISION WELDING  
Lampert Werktechnik GmbH  
Werneck, D-97440 Werneck  
T +49-9722-9459-0 - F +49-9722-9459-100  
Place, Date, mail@lampert.info

Dr. Martin Plöckinger  
CEO

Jürgen Fuchs  
Head of Research and Development

## 12.4 UKCA conformity



### Declaration of conformity in accordance with UK Government guidance



#### The manufacturer bears the sole responsibility for issuing this declaration of conformity

Lampert Werktechnik GmbH  
 Eitlebener Straße 27  
 97440 Werneck  
 Germany

#### Object of this declaration

Product / Article	Microarc spot welding device
Serial number	680 000
Type	Microarc spot welding device
Commercial name	PUK D6 precision welding device
Model	PUK D6

#### The object of the declaration complies with the following statutory requirements and carries the UKCA marking accordingly:

UK SI 2016 No. 1101	The Electrical Equipment (Safety) Regulations 2016
UK SI 2016 No. 1091	The Electromagnetic Compatibility Regulations 2016
UK SI 2012 No. 3032	The Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations 2012


#### Standards applied:

EN 60974-6:2016	Arc welding equipment – Part 6: Limited duty equipment
EN 61000-6-2:2005	Electromagnetic compatibility (EMC) – Part 6-2: Generic standards - Immunity for industrial environments
EN 61000-6-4:2007/A1:2011	Electromagnetic compatibility (EMC) – Part 6-4: Generic standards - Emission standard for industrial environments
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EN 63000:2018	Technical documentation for the assessment of electrical and electronic products with respect to the restriction of hazardous substances

#### Signed for and on behalf of:

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website: www.lampert.info

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