

T300 AC/DC Firmware changelog

Note

Please read the update instructions carefully before updating the machine. Failure to follow the update procedure correctly may result in machine damage.

Version history

Only major changes that affect the machine's functionality are reported here. Please note that minor bug fixes and internal improvements may also be included in each update.

Version numbers not listed here are pre-production, test, beta, or special versions. If your machine has one of these, contact service for information before updating.

Version 1.00 – Initial Release

Version 1.01 – February 2024

- Minor internal improvements.

Version 1.02 – March 2024

- Fixed a bug in the TIG HotStart: the machine now performs the correct HotStart sequence;
- Fixed the direction description of the remote control;
- Minor graphical improvements.

Version 1.03 – March 2024

- Fixed the behavior of LIFT PIPE/LIFT PIPE SMART in 2T mode (no pedal) when the initial/final time is greater than 0;
- Fixed an issue with double pulse frequency: the minimum regulation for the high-speed pulse is now 20Hz (it should be at least twice the maximum low-speed frequency, which is 10Hz);
- Removed unused gas leds and parameters in LIFT PIPE/LIFT PIPE SMART.

Version 1.04 – April 2024

- Extended the zero crossing current range to 120A (AUTO still 80A);
- Fixed a bug that used to occur with PFC software 1.05: every time the machine was turned on, the current settings were clamped to the maximum allowed at 120V (for some milliseconds, the new PFC software detected 120V at startup). This issue is now resolved;
- Fixed a graphical bug where two text elements overlapped in the overtemperature message;

Version 1.05 – May 2024

- Special version only for internal testing;

Version 1.06 – June 2024

- Fixed a bug affecting the maximum current limitation in Dynamic Power mode.

Version 1.07 – September 2024

- Improved precision in current reading (better handling of rounding at 0.5A);
- Improved the alignment of the AC symbol on the main screen under certain conditions;
- Removed the wording "PFC OK" from the overtemperature screen if the machine is a single-voltage version;
- Fixed a potential bug that could randomly occur when welding at a certain frequency, increasing the frequency, and then starting a new weld. Sometimes, a small delay could cause poor arc ignition;
- Improved diagnostics when the VbusOK signal is not okay (the machine won't move past the splash screen in this case);
- AUTO HotStart is now set to 70A for all diameters;
- Replaced "AUTO" in Zero Crossing Current with "DEFAULT" (80A).

Version 1.08 – October 2024

- Improved the message displayed during machine shutdown. It no longer shows "ERROR";
- Changed "AUTO" to "DEFAULT (70A)" in the Hotstart setting.

Version 1.09 – October 2024

- The white line highlighting the selected key is now slightly thicker for better visibility.
- Fixed graphical glitches occurring when switching between jobs using the "trigger job" function;
- Removed "Current" from "Zero crossing Current" to avoid overlap with "default (80A)".
- Added a unique ID value in the "Info" screen to serve as an identifier for the board. This will be useful for future features or machine/board tracking.

Version 1.10 – January 2025

- Fixed a bug that allowed AC asymmetry regulation in "Basic" mode, even though it was (correctly) not shown on the display;
- Fixed a bug that caused the current to briefly jump to 250A when using the pedal and with a slope-up greater than 0.1s;
- Fixed a bug that caused the logo screen to reappear briefly when accessing the job screen immediately after turning on the machine;
- Fixed a bug where the right key was still active in the first screen of the process menu, while only the encoder should have been functional;
- Fixed a rare issue that could prevent the machine from turning on properly, signaling abnormal conditions (e.g., overtemperature, low 24V);
- Fixed a possible issue that caused problems starting the arc with very quick welding spots (e.g., in multispot-fastack with low off-time);
- Fixed a possible issue when trying to re-ignite the arc immediately after the end of slope-down in TIG;
- Improved detection of the "AC safety error," so the message appears less frequently;
- Reduced the display time of the "AC safety error" message, which now disappears in about 2 seconds;
- Disabled the "Jobs Trigger" function (quick recall of programs with the torch trigger);
- Extended the number of memory job slots to 16;
- Added the ability to erase a single job (to save a job, you now have to press the encoder);
- Improved diagnostic messages in case of issues during USB updates;
- Added a "VRD ON" label when the VRD is active.

Version 1.11 – April 2025

- Enabled automatic backlight reduction after one minute of idle time, like other STEL machines;
- Slightly adjusted the stick start sequence to prevent instabilities caused by internal machine production variations.

Version 1.12 – May 2025

- Moved the "Minimum Amps" setting for TIG into the TIG Settings menu (previously in the Machine Setup menu);
- Internal improvements;
- Enabled an experimental feature in AC crossing ;

Version 1.13 – October 2025

- Default postgas in TIG is now 7 seconds;
- Default HotStart in STICK is now 15%;
- Corrected wording for polarity inversion in STICK ;
- Internal improvements;
- Disabled the experimental AC-crossing feature introduced in version 1.12, as it proved not useful;

Version 1.14 – November 2025

- Internal improvements for compatibility with updated PCB components;