S400 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 – December 2023

- Fixed an issue with arc ignition when using a simple wire feeder suitcase with analog control, which caused the wire to touch and push the torch before starting the arc.

Version 1.02 – January 2024

- Improved the start in MIG 2TS/4TS, particularly at medium to high wire feed speeds.

Version 1.03 – February 2024

- Added three pulsed programs for Mild Steel wires with M20 gas (requires an F40 with firmware version 1.07 or later to recall these programs);
- Enhanced the double-pulsed process, especially at low speeds.

Version 1.04 – July 2024

- Fixed an issue in torch calibration that caused the calibration correction not be applied in certain cases;
- Fixed the voltage reading in pulsed mode: now the machine shows the correct arc voltage.

Version 1.05 – March 2025

- Improved arc start in STICK mode by reducing the initial short-circuit time;
- Added the ability to switch to standalone mode for STICK/TIG/GOUGE welding from the wire feeder (requires F40 firmware version 1.09 or later);
- Enabled wire retraction at the end of welding (requires F40 firmware version 1.09 and a compatible hardware revision; see notes in the F40 changelog);
- Slightly improved the accuracy of the current reading sent to the wire feeder.

Version 1.06 – October 2025

- Enabled automatic wire retraction at the start of welding when the wire touches the workpiece, to prevent spatter (requires F40 firmware version 1.09 or higher and a compatible hardware revision; see notes in the F40 changelog);
- Added a new mechanism to properly stop welding in case of an alarm signal coming from the F40.

Version 1.07 – February 2026

- Added the new “Pulse Dynamics” feature, which provides an additional level of adjustability for MIG pulsed programs to accommodate specific conditions or welder preferences. Requires F40 version 1.13 or higher;
- Fixed a bug that caused the “ArcOn 3” signal on the F40 to report an incorrect state when using pulsed MIG with “Voltage Reading” set to “Arc”. The “ArcOn 3” signal is used by the Modbus protocol to provide Cobot/PLC systems with information about the arc status.

Version 1.08 – July 2026

- Added i-Cold programs for 1.0 mm and 1.2 mm mild steel (displayed only on compatible wire feeders);
- Added the ability to manually enter MIG CV mode, allowing the use of simple wire feeders without remote control, powered by the machine's output voltage and equipped with a contactor.