



CalderSafe Weld Analyser

Instruction Manual

Software Version: 1.8.0



Helping you make the right connections.

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Со	ontents	Page
01.	Introduction	02
02.	Opening Weld Records for the First Time	02
	2.1 From Weld Analyser	03
	2.2 Double-click from Windows	03
	2.3 Drag and Drop	03
03.	Main View: Electrofusion	04
	3.1 Barcodes viewer	05
	3.2 Map Viewer (CalderSafe Mobile Only)	07
	3.3 Image Viewer (CalderSafe Mobile Only)	08
	3.4 Graph Viewer	10
	3.5 Chart Viewer	11
	3.6 Excel Export	12
	3.7 Printing Reports	12
04.	Gator View: Butt Fusion	15
	4.1 Details Tab	16
	4.2 Joint Parameters Tab	16
	4.3 Images Tab	17
	4.4 Printing Reports	18
	4.5 Global Settings	19
	4.6 Language Settings	19
	4.7 Printout Owner Details Settings	20

01. Introduction

The CalderSafe Weld Analyser aims to provide users with an accessible way to view weld records taken from their Caldervale welding units. From the detailed 124 point graph, to a variety of reports for archival purposes, Weld Analyser has been developed with the user's needs in mind.

This manual will walk you through every aspect of the Weld Analyser, moving from a look at the main view to examining specific features.

02. Opening Weld Records for the First Time

Weld Records can come in several formats, depending on the method used to capture them and/or the welding unit used.



When Caldersafe Mobile is used, the weld records will be emailed to the supervisor account (and any other recipients added by the supervisor) as specified within the app settings, as a .CZIP file.



When using USB export from all Caldervale Technology units, a .BIN file will be on the USB stick.



When using USB export from Fusion S-BOX or GATOR, an .RDF file will be on the USB stick.

In all cases, it is advisable to copy the file to a location on your PC/ laptop computer. Once done, there are several ways that the weld records can be opened.

Note: This manual was written for version 1.8.0. If you are on a later version of the Weld Analyser, then it is possible that new features may not be covered here. Contact your Caldervale Technology sales representative for an updated manual.

2.1 From Weld Analyser

Weld Analyser can be run, and from there, select either **'Import from Mobile'** or **'Import from USB'**, depending on what filetype it is. Browse to the location on your computer where the weld record is stored, and open it. Weld Analyser will then load the file.

2.2 Double-click from Windows

The file can be double-clicked from Windows which will automatically open Weld Analyser and load the file.

2.3 Drag-and-Drop

The file can be dragged over to the Caldersafe Weld Analyser icon and dropped, which will automatically open Weld Analyser and load the file.

All files opened with Weld Analyser for the first time will be added to the Caldersafe weld record library. This can be accessed by selecting Open Library. This library is used to load in related weld records, such as all weld records from a particular welding unit.



- In the case of .BIN files, these are added to a weld unit specific .CVT file.
- In the case of SBOX .RDF files, these are continually added onto as new .RDF files are opened over time.
- In the case of GATOR .RDF files, all records are added to an internal database and thus are not found via this method; instead use the GATOR viewer window.

03. Main View: Electrofusion

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An example of what the main view looks like once populated with a mobile CZIP file. Buttons are annotated with their function.

Once a weld record from an electrofusion unit is loaded, the main view will be populated with details of the weld. Depending on the source of the weld record, the view will differ:

- If CalderSafe Mobile was used to retrieve the weld record, there will be GPS data and images.
- If USB export was used to retrieve the weld record, there will be no GPS data or images.

Regardless of the method of retrieval, there will also be some slight differences between the data held in weld records from CalderTech and SBOX electrofusion units. The data shown, layout of the data, and number of plots on the graph will change automatically to reflect this.

With a loaded weld record, there are various data scopes that can be examined in further detail, as well as the ability to print or electronically save weld record information.

3.1 Barcodes viewer

If the weld in question has used barcodes, the 'Show Barcode' button will be active and able to be clicked. This will bring up a view detailing all barcodes scanned and a full breakdown of what each means. The view is capable of displaying and processing pertinent information conforming to the following standards:

- ISO13950 weld barcodes (24-digits)
- ISO12176-4 traceability barcodes (26-digits / 40-digits [pipe])
- ASTM F2897 15a traceability barcodes (16-digits)

The first barcode displayed and broken down will always be the welding barcode, with others below being any additional traceability barcodes scanned.



The full set of barcodes and their breakdowns can be saved as an image, a PDF, or printed out directly. All methods will have a resulting datasheet in this format:

CalderSat	fe Weld Analyser	
Scanned B	Barcodes Datasheet	
Owner Ovtalle 11 4. Owner Ovtalle 21 1537 Senter Wondler of 23 Anna Sature: Word Constrem	Weld Number 1423 Operator 1000 Weld Science (2002) 19 28 34 Job Strategies (2002) 19 28 34 Lectores -	
Sacial/Conference on the Sacial Sa Sacial Sacial S	Plang: 1744, 200m x 190m Velage: 151 V Notetame CV Revealance: 1750 D to Tanget Revealance: 1710 D trans 1 mm 0 x Revealance: 1710 N Temperature: Certificent -	
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In all formats, care has been taken to ensure that the barcodes can be scanned from the datasheet. This could be useful at a later date after the weld has been done, such as if needing to do verification or fault finding.

3.2 Map Viewer (CalderSafe Mobile only)

If a weld record has a valid set of co-ordinates, the location of the weld can be seen on a full screen map. This is accessed by clicking the **'Show Map'** button.



The map can be zoomed in by double-clicking, and zoomed out by right clicking. If it can, the closest address will be sourced and reported below the map.

The GPS co-ordinates are dependent on where the mobile device was at the time of the welds, so it is advised to keep the device as close as to the weld as possible when using CalderSafe Mobile.

3.3 Image Viewer (CalderSafe Mobile only)

Images associated with the weld record can be found as thumbnails in a column on the side of the window. To view them in full detail, they can be selected to expand them into a full screen view.



There are two options for export/printing present on this view:

The image can be saved externally by clicking on the **'Save'** button (to a location and with a filename of your choosing):



Or it can be printed as a document by clicking the $\ensuremath{^{\prime}\text{Print'}}$ button:



The image in both cases is overlaid with text displaying basic details of the weld record, such as weld number, operator, location, job reference, and fitting information.



An example of a saved image with overlay.

3.4 Graph Viewer

The graph is where, in detail, three series of recorded values from the weld can be seen: Input Voltage, Output Voltage and Output Current.



The **legend** to the side shows what colour is used for which data series, and if desired, individual data series can be toggled on and off by clicking on them.

Below the legend is **'Current Time Slice'**. This area shows data from all three nodes depending where the cursor is on the graph. In the above image, the cursor is at 6.35s.

If a data series is to be examined in greater detail, the **'Zoom In'** / **'Zoom Out'** functions can be used to expand the scale of the Y axes. If the data series in question goes out of view, the mouse's scroll wheel can be used on the relevant Y axis to scroll it back into view. To reset the view back to the standard zoom, click on **'Reset Zoom'**.

3.5 Chart Viewer

When multiple records are available from the same serial number, **'Show Chart'** can be clicked. This will display a chart view.

There are two chart styles to switch between; a bar chart and a pie chart. Using the dropdown, different aspects of the record data can be examined, such as the status of the welds or the operators.



An example of the bar chart, with 'Status' selected.



An example of the pie chart, with 'Operator' selected.

3.6 Excel Export

When multiple records are available from the same serial number, **'Export to Excel'** can be clicked. This will prompt to save an Excel file, and once saved, will automatically open.

This provides raw data about the units/welds, and thus can be further used internally.

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17 35 09 3017 14 44 50 0	CAS Test IR	111MAN TESTI	Manual	04	0.	20.4		6 797 Ohme Yes Yes	28.5 V	031	Douge Earland	20.8 10		
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18 16 09 101 108 16 10 1	Tart ill	TEST	Manual	24	24	20.4	20.4	O BAT (These Yes Yes	10.5.1	10.7181	Mald Complete	11.1.5		
10 16 00 1017 00 10 10 10	ab Rob loose	-	Manual	0.	1.	20.	30.4	A 785 Ohmer Ver Ver	10.5.1	40.03 kg	Wald Complete	11.5.50	1	
21 26 09 2017 09 24 03 1	ab Test ill	TEST	Matual	0.1	14	10.4	30.4	d 284 Ohme Yes Yes	29.5.1	34.4731	Weld Complete	20.8.10	0	
22 26 09 2017 09-26-15 1	h Test IB	TEST	Manual	0.	204.4	20.4	20.4	A 791 Ohms Yes Yes	19.5 V	36 34 11	Weld Complete	20.5.57		
23 26.09 2017 09:35:30 1	ab Bob Jones	TEST	Manual	0.1	0.1	20 1	11.1	6 297 Ohms Yes Yes	19.5 V	22.05 ki	Stop Buttop Press	# 21 M		
24 26.09.2017 09:41:27 L	ab Test III	TEST	Manual	05	1995.4	20.5	20.5	0.777 Ohms Yes Yes	28.5 V	45.9 14	Weld Comolete	21.1 %		
25 26 09 2017 10 22 18 1	ab Test IR	TEST	Manual	01	20.4	20.4	20.4	0.819 Ohms Yes Yes	29.5.V	19.631	Weld Comolete	24.6 %		
16. 16.09 1017 10134-14.1	the Tast IR	TEST	Manual	0.0	20.4	20.4	20.4	O STOCHES THE NET	29.5.1	10.4731	Wald Complete	34.8.37		
17 16 09 2017 10 29 58 1	ab Test ill	TEST	Matural	0.5	260.4	20.4	20.1	0.803 Ohms Yes Yes	22.5.1	10.63.61	Weld Complete	23.8.5	£	
28 26 09 2017 12:00:18 1	ab Robinses	TEST	Marcual	01	11	20.1	20.5	0 293 Ohms Yes Yes	19.5 V	29.79 ki	Weld Complete	24.3.5	-	
29 26 09 2017 12 08 47 1	ab Rob lones	TEST	Manual	01	34	20.4	20.1	6 779 Ohms Yes Yes	19.5 V	40.0211	Weld Complete	21.8 %	-	
30 26.09.2017 12:11:55 L	ab Robiones	TEST	Manual	0.5	12.5	20 1	20.5	0.786 Ohms Yes Yes	19.5 V	19.91 \$1	Weld Comolete	21.3 %		
11 26.09.2017 12:22:16 L	ab Rob Jones	TEST	Manual	01	51	20.5	20.5	0.785 Ohms Yes Yes	29.5 V	40.06 kJ	Weld Complete	20.8 *C		
32 26.09.2017 13:08:06 L	ab Rob Jones	TEST	Manual	01	61	20.1	201	0.786 Ohms Yes Yes	29.5 V	40.22 kJ	Weld Complete	22.2 %		
33 26.09.2017 13:15:21 L	ab Rob Jones	TEST	Manual	01	21.5	20.1	20.5	0.788 Ohms Yes Yes	29.5 V	40.17kJ	Weld Complete	22.3 %		
M 26.09.2017 13-22-08 L	ab Rob Jones	TEST	Marcual	01	11	20.1	20.1	0.788 Ohms Yes Yes	29.5 V	40.3 kJ	Weld Complete	22.3 °C		
35 26.09 2017 13 33 53 1	ab Rob Jones	TEST	Manual	05	95	20 s	20 s	0.789 Ohms Yes Yes	39.5 V	40.36 kJ	Weld Complete	22.8 %		
36 26.09.2017 13:40:21 L	ab Rob Jones	TEST	Manual	0.5	55	20 5	20.5	0.788 Ohms Yes Yes	39.5 V	40.25 kJ	Weld Complete	22.7 °C		
17 26.09.2017 13:46:57 L	ab Rob Jones	TEST	Manual	01	10.4	20.5	20 1	0.729 Ohms Yes Yes	19.5 V	40.1 kJ	Weld Complete	22.5 %		
38 26.09.2017 13:49:35 L	ab Rob Jones	TEST	Manual	0.5	51	20 5	20.5	0.795 Ohms Yes Yes	29.5 V	40.31 kJ	Weld Complete	22.3 %		
19 23 10 2017 07 46 24 L	ab Rob Jones	TEST	Manual	01	1525 s	600 s	600 s	0.836 Ohms Yes Yes	29.5 V	1050.22 k	Weld Complete	11.3 %		
40 23.10.2017 10:26:26 L	ab Rob Jones	TEST	Manual	01	2976	600 5	600.6	0.869 Ohms Yes Yes	29.5 V	1049.6 kJ	Weld Complete	26.3 %		
41 06 11 2017 09 41 48 1	ab Rob Jones	TEST	Manual	05	65	600 s	600 s	1.923 Ohms Yes Yes	48 V	691.7 kJ	Weld Complete	8.7°C		
42 06.11.2017 09:54:14 L	ab Rob Jones	TEST	Manual	05	95	1200 s	1200 5	2.003 Ohms Yes Yes	48 V	1380.64 k	Weld Complete	10.8 °C		
43 06.11.2017 10:15:51 L	ab Rob Jones	TEST	Manual	01	11 6	1800 s	1800 s	2.049 Ohms Yes Yes	48 V	2065.73 k	Weld Complete	14.8 °C		
44 06.11.2017 10.52.01 L	ab Rob Jones	TEST	Manual	05	23 5	1800 s	1800 s	2.027 Ohms Yes Yes	48 V	2066.16 kJ	Weld Complete	21.8 °C		
45 01.12.2017 14:37:24 L	ib Nick	TEST	Manual	05	21 5	20 5	20 5	2.012 Ohms Yes Yes	39.5 V	15.99 kJ	Weld Complete	26.6 %		
46 04.12.2017 14:55:45 L	ab Nick	TEST	Manual	0.5	45	20.4	20.5	2.018 Ohms Yes Yes	29.5 V	16.01 kJ	Weld Complete	27.3 %		
47 05.12.2017 09:11:24 L	b Nick	TEST	Manual	05	489.5	20.5	20.5	2.022 Ohms Yes Yes	29.5 V	16.01 kJ	Weld Complete	18.7°C		
World Date	0				2.000		12.20						-	-
CONTRACTOR OF THE OWNER											10000			

3.7 Printing Reports

There are a variety of reports that can be printed. These can be seen by clicking on 'Print Data', which will display the below menu:

CalderSafe Weld Analyser v 1.8.0 - (402-4444-1483-1809251527.dat) e: Weld Ultray: Data: Help		
		ter en la constante de la const
	Plat X	
	Details of Current Wildd Summary of all Vitrids	
	Print summary in range	

Once an option is selected, the report can be either exported as a PDF or printed directly.

'Details of Current Weld' – This option shows the full details of the currently viewed weld. The printout will contain the graph, and if the weld record was obtained via CalderSafe Mobile, images and map preview also.

	CalderSafe W	/eld Analyser	
	Details of Cu	urrent Weld	
	Owner Details 5: 4. Owner Details 2: TEST Serui Number: 422-4444	Firmware Western v2.21 Bluetouth Michaele 8804 Calibration Date: 04 Jun 2018 Calibration Dec: 04 Jun 2019	
	Status: Weld	1 Complete	
	Well Studies: 113 Des Treis 125 2019 125 201 all References Composition 2019 2019 125 201 composition 2019 2019 2019 2019 composition 2019 2019 2019 2019 2019 Composition 2019 Reference 1012 Patrings Tiffer, 2019 no. 102 no.	Encoder Windley Terror Stor encoder Store Store Store Store Store Store Store Store Store Windle Windle Store Store Windle Windle Store Windle S	
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'Summary of All Welds' and **'Print Summary in Range'** will generate a list of records associated with the current weld record's electrofusion unit's serial number, similar to the list of records on the main electrofusion window view although with more detail.

While **'Summary of All Welds'** will print all records associated, 'Print summary in range' allows for selection of a date range.





If a weld record from USB export is currently loaded, there will be an additional report option: **'Calibration Report'**. This displays the calibration details from the most recent calibration recorded.

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04. Gator View: Butt Fusion

While the GATOR record viewer will open when opening a GATOR weld record, it can also be accessed from the **'Open GATOR Viewer'** button on the main view.



All records that have been imported can be found on the side of the window, grouped by GATOR serial number. To expand them, the arrow next to the serial number can be clicked, or the serial number itself can be double clicked. Doing this will show all records found for that serial number, displaying the joint number and date/time of the joint. Specific records can be clicked on to view them.

Details about the GATOR unit, operator and project can be seen to the top of the window, while below are more in-depth details about the joint itself, on individual tabs.

00777 2 - 25/06/2018 10:10:52			Bu	tt Fusion	Joint Detail	s		~
8 - 17/09/2018 11:34:26 9 - 17/09/2018 12:21:34		5	erial Number O	ATORUTS	Owner	Service Due Date		
03275			tant Number Sc	Rware Version	Operating Voltage	Service Due Joint		
03459			HELDOOD1 v	10	230	3000		
1296			perator Pr	oject	Project Weld Number	Welding Standard		
cord selection			ocation 0	rtional 1	Optional 2	Optional 3		
	Tabbed panes				D	1.		
	Cetals Joint Parameters Images							
			Joint Status:			Joint Complete		
		General Datails						
		Isled Number	Inited Date/Timer	athute	Loophute			
			17/06/2018 12:21:34	\$12720525	+1450062			
		Joint/Pipe Details	(old Newster	50.0	-	lent	
		Pipe 1 Pipe straight	PE100	180.00	17.60	Back	50 m	
		Pipe 2 Pipe straight	PE 100	185.00	17.60	Back	45	

4.1 Details Tab

The Details tabbed pane lists general details about the joint and the pipe used. To the top of the pane, the joint status is displayed.

If ISO12176 has been used, there will be two sets of pipe data, detailing the component and length in addition.

	Joint Status:			oint Complete	
General Detail	\$				
Joint Number	Joint Date/Time:	Latitude	Longitude		
	and shake a state the				
	17082018 122134	33278585	1438062		
Joint/Pipe Det	oils	stations	508	Colore	Innoth
Joint/Pipe Det	oils	terial Diameter	508 1760	Colour	Length
Joint/Pipe Det Compose Pipe 1 Pipe 1	alls Component Ma PE100	terial Diameter 18000	508 17.60	Colour Back	Length 30 m

4.2 Joint Parameters Tab

The Joint Parameters tabbed pane lists all target and achieved parameters of the joint, such as pressure values, time values and drag values. Bead and Fusion PIT values will only appear if ISO12176 has been used, and Cool and Secondary Cool values will only appear if not null.

As with the previous tab, joint status is also displayed to the top of the pane.

	Joint	status:		Joint Complete
	Drag		Temperature	
Oynamic	5.9 bar		22.5 °C	
Peak	11.3 ber			
	Dwell Time	Heater Temperature		
Target	41	233 °C		
Achieved	1.7 s	235.9 °C		
	Bead Time	Bead Pressure	Bead Distance	Bead PIT:
Target	0.5	[11.3 +] 11 ber	200 µm	9.9 1
Achieved	26.1 s	22.5 ber	200 µm	9.9 5
	Soak Time	Soak Pressure		
Target	134 s	0 bar		
Achieved	134 s	0 bar		
	Fusion Time	Fusion Pressure	Fusion PIT:	
Target	402 s	(5.9 +) 11 ber	9.9 s	
Achieved	402 s	16.9 bar	9.9 1	
	Cool Time	Cool Pressure	Secondary Cool Time	Secondary Cool Pressure
Target	999.1	9.9 bar	999 1	9.9 ber
Achieved	999 s	9.9 bar	999 s	9.9 bar

An example of what an ISO12176 joint would appear as. Please note that certain values are erroneous and are not representative of a real-world joint.

4.3 Images Tab

The Images tabbed pane displays any images taken for the joint.



To examine the images in full screen view, they can be clicked on.



4.4 Printing Reports

A report detailing the GATOR joint can be printed or exported as a PDF. This can be accessed via the print menu by clicking the **'Print'** button, and selecting either **'Export to PDF'** or **'Print'**.



Both the PDF and Print will have the same layout. As with the data displayed in the GATOR record viewer, fields may or may not be printed depending on whether ISO12176 or cooldown has been used.

4.5 Global Settings

There are several settings that affect the entirety of the Weld Analyser application: the user interface **'Language'**, and the printout header **'Owner Details'**.

4.6 Language Settings

The user interface language can be changed by using the selector in the title bar of the Weld Analyser application. To browse available languages, the left and right arrows can be clicked (and held if needed) to scroll. To change language, click on the flag that best represents the required language.



The selected language will apply to all text throughout the Weld Analyser, both electrofusion and butt fusion views, and their relevant printouts.

When Weld Analyser is exited, whichever language was selected at the time will be saved as the user interface language.

Supported languages are:

- English
- Arabic
- Bulgarian
- Catalan
- Czech
- Danish
- German
- Persian/Farsi
- Greek

- Spanish
- Finnish
- French
- Croatian
- Hungarian
- Italian
- Dutch
- Polish
- Portuguese

- Romanian
- Russian
- Norwegian
- Slovak
- Swedish
- Turkish
- Chinese

4.7 Printout Owner Details Settings

There is the option to insert company or personal branding to the header of all printouts, alongside the existing Caldervale Technology branding. To access the settings, click **'File'** on the main electrofusion view, and select **'Set Printout Owner Details'**.

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	402-4444.CVT	Calibration Due

The owner details entry dialog will appear. Here the name of the company, address, and any other contact details (such as a phone number or email address) can be entered, as well as an image for the company logo.



Once all fields are filled in and an image selected, the 'Confirm' button will be able to be clicked. If all fields are required to be cleared, the **'Clear'** button can be clicked at any time.

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The entered details and company logo will show on all headers on reports throughout Weld Analyser.



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