



for Welding Excellence

IGBT BASED INVERTER TECHNOLOGY MIG / MAG WELDING MACHINES

INVAMIG 300 / 400 / 500 / 600

INVA series products are semi-automatic gas shielded metal arc- welding machines with IGBT inverter technology. The machine has the characteristics of stable welding process low spatter and good weld. The molten pool is easy to be controlled. Easy to operate.

Suitable for all position welding of mild steel, stainless steel, carbon steel , aluminum & its alloys etc, for both solid wire and flux-cored welding wire with the diameter of $\Phi 1.0 / \Phi 1.2 / \Phi 1.6$.

Features:

- Designed with high open circuit voltage and slow wire feeding speed for smooth and steady arc striking / initiation.
- Arc voltage and current feedback control circuit to make the welding process steady, strong adaptability for changes in the Arc length.
- Excellent FTT - Globule control circuit makes positive striking of arc.
- The function of crater filler ,to improve the quality at the end of weld.

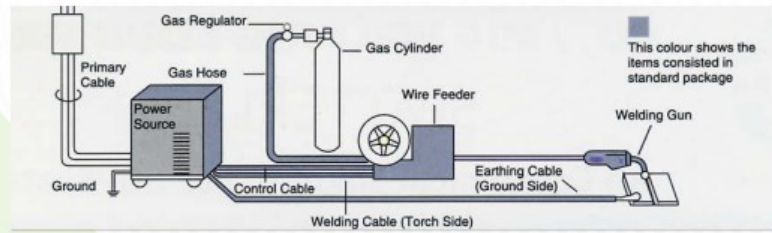
Functions:

- Soft – start ignition.
- Adjustable welding current / voltage, crater current / voltage, arc characteristics control.
- 2/4 step welding mode selection facility.
- Welding wire diameter selection facility.
- Welding voltage and welding current displayed digitally.
- Protective functions : over-temperature, over current, under / over voltage & single phasing etc.

INVA Series



Installation Diagram



Technical Specifications

MODEL / PARAMETER	INVAMIG - 300	INVAMIG - 400	INVAMIG - 500	INVAMIG - 600
Rated Input Voltage (VAC)	3 Ph, 415VAC \pm 10%, 50 /60 Hz			
Rated Input Current - A	14.5	23.5	34	38
Rated Input Capacity - KVA	10.5	16	23	30
No-load voltage (OCV)	74 VDC		80 VDC	
Output Current Range - A	60 ~ 300A	60 ~ 400A	60 ~ 500A	60 ~ 600A
Output Voltage Range - V DC	17 ~ 30V	16 ~ 34 V	16.5 ~ 39V	16 ~ 44V
Crater Current Range - A	60 ~ 300A	80 ~ 400A	80 ~ 500A	80 ~ 600A
Crater Voltage Range - V DC	17 ~ 30V	17 ~ 34 V	17 ~ 40V	17 ~ 44V
Duty Cycle	60%	60%	100%	60%
Power Factor	0.99			
Class of Insulation	F			
Shield Protection	IP21S			
Dimensions (L×W×H) mm	570 × 290 × 530	570 × 290 × 530	640 × 290 × 530	640 × 290 × 530
Weight	34Kg	44Kg	46Kg	48Kg

WIRE FEEDER	SK-INV-2	SK-INV-4	SK-INV-4	SK-INV-4
Input Supply (VDC)	24	24	24	24
Drive Roll	2 roll	4 roll	4 roll	4 roll
Wire Size (mm)	0.8, 1.2	0.8, 1.2	1.0, 1.2, 1.6	1.0, 1.2, 1.6
Dimension (approx.) (mm)	480 x 190 x 330			
Weight (approx.) (kg)	9.4kg.	10kg.	10kg.	10kg.
Applicable Spool Size	300 mm Dia. 15 kg (max.)			
WELDING TORCH	WT 3510	WT 3510	WT 5000	WT 5000
Max. Current Capacity (A)	350	350	500	500
Duty Cycle (%)	60 (CO ₂) / 30 (MAG)			
Cooling Type	Air cooled			
Length (mtr.)	3			
Wire Size (mm)	(0.8, 1.2)	(0.8, 1.2)	(1.2, 1.6)	(1.2, 1.6)
Weight (approx.) (kg)	2.7	2.7	3.4	3.4

Standard Scope of supply:

Power Source / Wire Feeder / Welding Torch	1 No. Each
Co ₂ Gas Regulator / Flowmeter / Pre Heater	1 Set
Welding Cable / Earthing Cable / Control Cable / Gas Hose	1 set of 3 mtr. each

*Standard supply covers roller / contact tips shown in the brackets. Others sizes are optional at extra cost.



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ISO 9001:2000

(In view of continuous development, we reserve the right to modify the design and / or dimensions without notice)