

Thyristor controlled

AC/DC PULSE TIG WELDERS

Multi Mode. Full Function Arc Welding Machine for Tig, Tig Pulse and Stick Welding for any metal

- Smooth arc striking
- Best stability of arc
- Uniform penetration
- Best bead shape
- Easy portability
- Robust construction
- Welder friendly
- Composite unit compact and easy for handling



Seven Modes of Welding :

D. C. Pulse TIG welding	For Mild Steel
D. C. TIG Welding	S.S., Copper
D. C. Stick Welding	Titanium & their alloys
A. C. Pulse TIG Welding	For Aluminium,
A. C. TIG Welding	Manganese &
A. C. Stick Welding	their alloys
TIG ARC SPOT	For all metals

BUILT IN FUNCTIONS FOR HIGH QUALITY TIG WELDING

Initial Current Control: To prevent burn through for thin sheets and to confirm the ignition of the arc

Up - slope time control: To retain the weld quality at welding start by smooth changing from initial current with up slope control.

Pulse Current Control: Able to choose any pulse current as desired.

Pulse Frequency control: To change number of welding bead ripple and bead width.

Welding current control: The welding current and the crater can be continuously adjusted even during the welding from minimum current of 10 Amps to the rated current through the remote control unit or the potentiometer mounted on the power source.

Down Slope Time Control: Down slope time control for smooth and perfect finish of welding.

Crater Current Control: To prevent crater and defect in welding like crack, etc.

Post flow Timer for shielding Gas: To prevent oxidation of weld bead.

Choice of crater current: Arrangement to meet various critical applications.

Arc Spot Timer control: To ensure tack welding of the plates before the actual welding.

The input circuit is cut off automatically by the power saving circuit when welding is over, hence the energy is saved substantially.

AC Square wave ensures best arc stability.

Adjustable Cleaning width function (AC Balance control) ensures best bead shape and penetration in aluminium / manganese and their alloys.

Perfect Welding... Higher Productivity

SPECIFICATIONS FOR AC/DC PULSE TIG WELDING EQUIPMENT

MODEL		PULSE TIG 300 AC / DC	PULSE TIG 500 AC / DC
Input Voltage (2ph)		415 V, 1 Ph, 50Hz	
TIG Arc Starting Method		High Frequency	
Rated input (KVA)	TIG	30	48
	Stick	25	41
Rated Duty Cycle (%)		45	60
Max No Load Voltage (V)		75	75
Initial Voltage (DC TIG) (V)		95	95
DC Output Current range (Amp)	TIG	10 - 300	10 - 500
	Stick	20 - 300	30 - 500
AC Output Current range (Amp)	TIG	20 - 300	30 - 500
	Stick	20 - 300	30 - 500
Rated Load Voltage (V)	TIG	22	30
	Stick	32	40
Initial Crater filler Current (TIG) (Amp)	DC TIG	10 - 300	30 - 500
	AC TIG	20 - 300	30 - 500
Crater Filler control		ON, OFF, Repeat change over system	
Time interval (in Seconds)	Up-slope	0.1 - 5	
	Down slope	0.1 - 5	
	Gas pre flow	0.3	
	Gas post flow	3 - 20	3 - 50
	Arc spot timer	0.2 - 5	
Pulse TIG function (in Seconds)	Pulse	0.03 - 1.5	
	Base	0.05 - 3	
	Cleaning width adjustment	Adjusted by changing the A.C. balance spot	
Cooling		Forced Air	
Outside Dimensions W x D x H (mm)		930 x 430 x 950	935 x 530 x 1000
Mass (approx) (Kgs)		200	310
WELDING TORCH			
Rated welding Current (Amp)	DC	300	600
	AC	260	470
Duty Cycle (%)		100	100
Cooling Method		Gas	Water
Electrode Size (mm)		1.6, 2.0, 2.4, (3.2) 4.0	1.6, 2.0, 2.4, 3.2, (4.0) 4.8, 6.4



AUTO TIG FEEDER

MAIN ADVANTAGES :

- Eliminates welder's feeding skill
- TIG welding can be done at MIG speed
- Speed can be varied even during welding
- Great advantages for aluminium welding



REMOTE CONTROLLER

SPECIFICATIONS

Adjustment	0 to maximum current continuous variable
Cable Length	5 meters



WATER COOLING UNIT

SPECIFICATIONS

Input	230 volts, single 0.50 Hz.
Wire size	0.8, 1.2 & 1.6mm.
Speed	0.3 to 4 mtrs./ min.
Cable length	3 mtrs.
Vertical adjustment	± 5 mm
Swiveling wire	240°
Pulsing facility	0.6 to 6 sec.
Delay time for start	0.6 to 6 sec.

SPECIFICATIONS

Suitable for Input Supply	: 230 V
Tank capacity	: 75 Litrs.
Output signal	: No Contacts
Over all size	: Length 700 mm
	: Width 400 mm
	: Height 550 mm

Along with built in Radiator, cooling fan, pump motor and pressure switch.

STANDARD SCOPE OF SUPPLY

Power Source Cable	01 No.
Gas Cooled Torch 4m length of appropriate capacity	01 No.
Argon Regulator cum flow meter	01 No.
Gas Hose 2 mtrs. Length	01 No.
Welding Cable for earthing of 3 mtrs.	01 No.

OPTIONAL ACCESSORIES (AT EXTRA COST)

Remote Control Unit With 4 Mtr.
Water Cooling Unit
Water Colled Torch
Auto Tig Feeding System
Digital Meters

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



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