



Thyristor controlled

DC PULSE TIG WELDER

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

**High Quality DC Tig and Tig Pulse Welding
for Stainless Steel, Copper Alloy, Nickel Alloy,
Mild Steel, Low Alloy Steel, Titanium, etc.**

**Low Spatter and High Performance
DC Stick Welding Machine for any
Steel and Stainless Steel.**



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 upslope 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 5 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 from 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 at the time of welding.

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.

Perfect Welding... Higher Productivity

TECHNICAL SPECIFICATIONS FOR DC PULSE TIG

MODEL	Pulse TIG 200	Pulse TIG 300	Pulse TIG 400
KVA @ Rated Output	10	16	23
Rated Input Voltage	415 V AC, ±10% 3 Ø, 50 Hz		
Rated Output Current:			
@ 60% Duty Cycle (Amps)	200	300	400
@ 100% Duty Cycle (Amps)	154	230	310
Initial/Crater/Welding Current Range (Amps)	5 - 200	5 - 300	5 - 400
Pulse / Base Current Range (Amps)	5 - 200	5 - 300	5 - 400
Open Circuit Voltage (V)	95		
Gas Preflow Time (Sec)	0.3		
Gas Post Flow Time (Sec)	2-30		
Up Slope Time (Sec)	0.2 - 10		
Down Slope Time (Sec)	0.2 - 10		
Pulse Width Ratio	50%		
Pulse Frequency (Hz)	0.5-15		
ARC Spot Timer (Sec)	0.5-5		
Crater Filler Operation	ON / OFF / REPEAT CHANGE OVER SYSTEM		
Hi Frequency Generation	IMPULSE GENERATOR TYPE		
Class of Insulation	"H"		
Cooling	Forced Air		
External Dimension (approx) W X D X H (mm)	460 x 700 x 700	460 x 760 x 700	510 x 800 x 700
Mass (approx) (Kg)	168	182	228
WELDING TORCH			
Capacity (Amps)	200	300	400
Cooling	Gas		
Duty cycle (%)	60		
Length (Mts.)	4		
Electrodes (mm)	0.5 - 3.2	0.5 - 4	0.5 - 6.3
Standard size of supply (mm)	2.4	3.15	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

SPECIFICATIONS

Input	230 volts, single Ø.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
Swivelling wire	240°
Pulsing facility	0.6 to 6 sec.
Delay time for start	0.6 to 6 sec.

WATER COOLING UNIT



SPECIFICATIONS

Suitable for Input Supply	: 230 V
Tank capacity	: 75 Ltrs.
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.

REMOTE CONTROLLER



SPECIFICATIONS

Adjustment	0 to maximum continuous variable
Cable Length	5 meters

STANDARD SCOPE OF SUPPLY

Power Source	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	
Water Cooling Unit	
Water Cooled Torch	
Auto Tig Feeding System	



MOGORA COSMIC PVT. LTD.

Office : 697, Mohan Nagar, Telco Road, Chinchwad, Pune- 411 019, India
 Phones : + 91 - 20 - 27474687, 27474897 Fax : + 91 - 020 - 27477253
 Email : mogora@vsnl.com., Website : www.mogorafinearc.com

