



## TIG 400 DC

### Application :

Tube Mills  
 Pressure Vessel  
 Pipe & Tube Fabrication  
 Rail Coach

### Processes :

GTAW (TIG)  
 GTAW-P (Pulsed TIG)  
 SMAW (Stick)



### Features :

IGBT Inverter Technology.  
 Digital Microprocessor Controlled Function.  
 HF arc ignition.  
 Pre & Post Gas Flow Function 0.1 to 10 sec.  
 Up & Down Slope Function 0.1 to 10 sec.  
 Initial & Crater Current Selction.  
 Pulse Frequency 0.5 to 12 Hz.  
 % ON Time 5 to 95%  
 Base Current 0 to 400 Amps  
 2T / 4T Function.  
 Water Cooled Torch with water cooling unit option.

### Technical Data :

Input Voltage	Input Power	Output Range	Rated Output	OCV	Dimension	Weight
374 - 457 V	19 kVA	20 - 400 A	400 A @ 60% duty cycle	80 VDC	L : 650 mm W : 320 mm H : 545 mm	38.5 Kg.

### Control Panel - Pulse TIG Data :

Pulse Frequency	% Duty Ratio	Base Current
0.5 - 12 Hz	5 - 95%	10 - 400 A

### Control Panel - Sequencer Data :

Gas Pre-flow	Up Slope Time	Initial Current	Crater Current	Down Slope Time	Gas Post-flow
0.1 - 10 sec	0.1 - 10 sec	10 - 400 A	10 - 400 A	0.1 - 10 sec	0.1 - 10 sec

### Standard Package :

CC Power Source - 3 m Earthing Cable with Clamp - 4 m Water Cooled TIG Torch - Argon Regulator with Flowmeter.