NEW!

ALUTIG-200P/200MV

Quick Specs

CE

Light industrial Application:
Metal fabrication workshops
Shipyards and offshore industry
Chemical and process industry
Mechanized welding

PROCESS:
DC TIG (GTAW)
AC TIG (GTAW)
MIX TIG (GTAW)
Stick (SMAW)

Input Power: 200P:230V , 1-Phase
200MV:110-220V,1-Phase
Amperage Range: 5-200A
Rated Out put at 40°C (104°F):
200A at 18V @60% Duty Cycle
Weight : 23 KG

For TIG and Stick Welding

Aluminum welding expert, precise and efficient

ALUTIG-200P AC/DC offers to the TIG welding professionals the necessary control to meet their exacting needs. Whatever the application, enjoy the performance.
ALUTIG-200P AC/DC is a precise aluminum welding specialist that suits all welded materials. Modular design allows you to build the package that best suits your needs.
Easy operation and full functions: from the control panel allowing fast adjustment of all necessary controls for DC, AC and MIX TIG welding with either HF or contact ignition. It's also very convenient to store or call out the welding parameters from the memory channels.

Specialist Features

Precision Arc Performance:

- **DC+/DC-:** Improved TIG starting. Now starts DC(-) to maintain a sharp tungsten.
- **Lift-Arc start** provides AC or DC arc starting without the use of high frequency.
- **Adjustable AC output frequency** allows the operator to focus the arc minimizing the heat affected zone.
- **Extended AC Balance Control** helps maintain a pointed tungsten to direct the arc in the weld joint.
- **Independent amplitude/amperage control** allows EP and EN amperages to be set independently to precisely control heat input to the work and electrode.
- **Multiple Waveshapes:**
  Standard Squarewave for fast travel speeds and excellent puddle control,
  Soft squarewave for a soft buttery arc with maximum puddle control and good wetting action,
  Sine wave for a traditional softer sounding arc,
  Triangular wave to reduce the heat input into the weld at low amperage.
- **MIX TIG:** we can get an excellent Arc Concentration, can be carried out the excellent welding performance from thin to thick plate.

1 Phase | CC | AC/DC | ECO 100%

Professional Features:

- Program memory features 10 independent program memories that maintain/save your parameters.
- Voltage Reduction Device (VRD). When enabled from the set up menu reduces the open circuit voltage in STICK mode for use in electrically hazardous conditions or when the use of a VRD is required.
- Auto-reconnects for single phase 115/230V 50/60 Hz input allows the flexibility to weld in the shop or take in the field where 230V may not be available.
- Weighs in at a mere 16 kg making it easy to carry around the shop or job site.

Outstanding Quality:

- Newly designed using the latest power electronic technology for improved reliability.
- CE Certified.
- One-Year Warranty on parts.

Technical specifications

Item No			ALUTIG-200P	ALUTIG-200MV
Rated Input Voltage			1PH ~ 230V ±15%	1PH ~ 115-230V ±15%
Max. Load Power Capacity			TIG: 5.62KVA	TIG: 5.62KVA
			MMA: 6.60KVA	MMA: 6.60KVA
Rated Duty Cycle(40℃)	60%		TIG: 200A/18V	TIG: 200A/18V
			MMA: 160A/26.4V	MMA: 160A/26.4V
	100%		TIG: 160A/16.4V	TIG: 160A/16.4V
			MMA: 130A/25.2V	MMA: 130A/25.2V
Welding Current/Voltage Range			TIG: 5A/10.2V~200A/18V	TIG: 5A/10.2V~200A/18V
			MMA:20A/20.8V~160A/26.4V	MMA:20A/20.8V~160A/26.4V
Open Circuit Voltage			70V~80V	70V~80V
Power Factor			0.8	0.8
Efficiency			80%	80%
TIG	Pulse	Peak Current	5A~200A	5A~200A
		Pulse Frequency	0.2Hz~200Hz	0.2Hz~200Hz
		Pulse Width (Ratio)	1~100%	1~100%
	AC TIG	AC Frequency Range	20Hz~250Hz	20Hz~250Hz
		AC Clean Width (AC Balance)	+40~-40	+40~-40
		AC Clean Ratio (AC Bias) %	+30~-50	+30~-50
	MIX TIG	MIX Frequency:	1Hz~5Hz	1Hz~5Hz
		DC Balance: (%)	20~80	20~80
	Arc-starting Current		5A~200A	5A~200A
	Crater-filling Current		5A~200A	5A~200A
	Current Up-slope Time		0.1S~15S	0.1S~15S
	Current Down-slop Time		0.1S-15S	0.1S-15S
	Pre-Gas Time		0.1S-15S	0.1S-15S
	Flow-Gas Time		0.1S-15S	0.1S-15S
	Spot Arc Time		0.1S-10S	0.1S-10S
MMA	Arc Force		10A~160A	10A~160A
	Hot Start Time		0.1~3S	0.1~3S
	Hot Start Current		10A~160A	10A~160A
Dimension (LxWxH)			490X230X385mm	490X230X385mm
Weight (KG)			23KG	23KG

Water-cooling Unit: WC-100 (optional)	
Operating Voltage	230V 50/60Hz
Rated Power	260W
Cooling Power	1.5KW(1L/MIN)
Maximum Pressure	0.3MPA/60HZ
Recommended Cooling Liquid	20%~40% ethanol/water
Tank Volume	6.5L

4 kinds of wave shapes

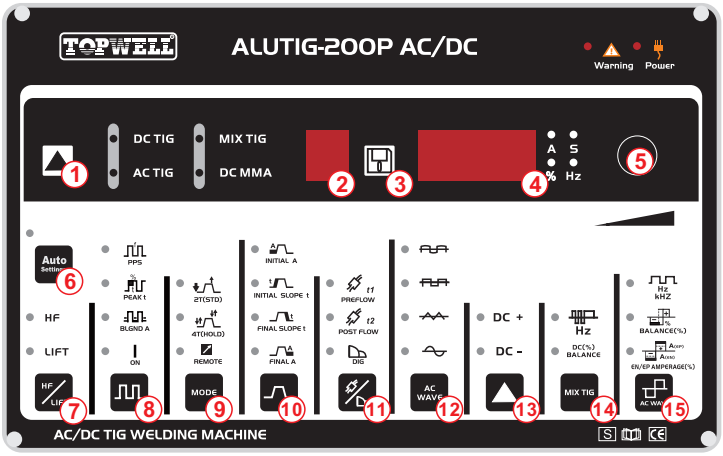

Soft Square wave


Standard Square wave


Triangular wave


Soft wave

General View of Control Panel



Control Panel Parameter Values

1.Welding Process DC TIG
AC TIG
MIX TIG
DC MMA

2.Memory Display

3.Memory

4.Ammeter/Voltmeter Display

5.Encoder Control

6.Simple Setting Mode

7.Arc Ignition type HF Impulse
LIFT Arc

8.Pulser Control
Peak Current 5A~200A
Base Current 5A~200A
Pulse Frequency 0.2Hz~200Hz
Pulse Width (Ratio) 1~100%

9.Mode 2T(STD)
4T(HOLD)
REMOTE

10.Sequencer Control
Arc-starting Current: 10A~160A
Crater-filling Current: 5A~200A
Current Up-slope Time: 0.1S~10S
Current Down-slop Time:0.1S~15S

11.Pre-Gas Time:0.1S~10S
Flow-Gas Time:0.1S~15S

12.AC Waveshape types
Advanced Squarewave
Soft Squarewave
Triangular Wave
Sine Wave

13.Arc Ignition Polarity DC+/DC-

14.MIX TIG MIX Frequency: 0.1Hz~5Hz
DC Balance: (%) 10~90

15.AC Waveshape
AC Frequency Range 20Hz~200Hz
AC Clean Width (AC Balance) +40~-40
AC Clean Ratio (AC Bias) % +30~-50

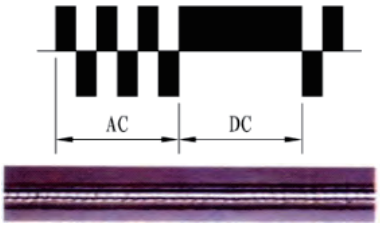
MIX TIG Control

Features of MIX TIG:

The AC current can get a very good clearance, and DC current can get a deeper penetration. Use the MIX TIG we can get an excellent Arc Concentration, can be carried out the excellent welding performance from thin to thick plate.
1) Nice weld appearance, deep penetration.
2) Excellet Arc Concentration.
3) Substantially reduce the electrode consumption.

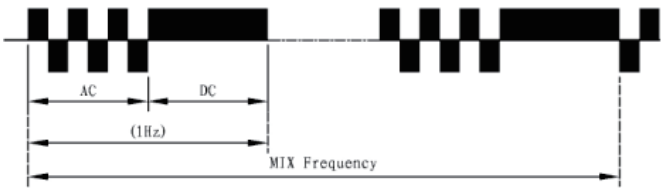

MIX TIG


AC TIG



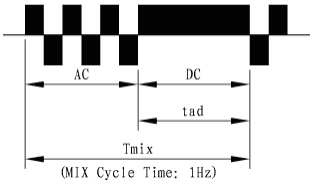
MIX TIG Frequency (Hz):

the cycle time of MIX
TIG in 1 second. Adjustable range: 0.1-10Hz.



MIX TIG Balance (DC) %:

DC Balance (%) = (tad/Tmix) x 100

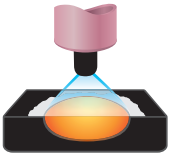


AC Waveshape Controls

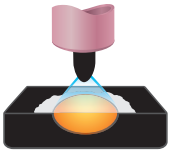
AC Frequency control

Controls the width of the arc cone. Increasing the AC Frequency provides a more focused arc with increased directional control.

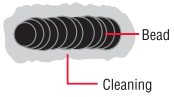
Note: Decreasing the AC Frequency softens the arc and broadens the weld puddle for a wider weld bead.



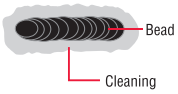
Wider bead,good penetration ideal for buildup work



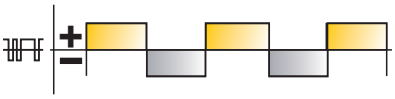
Narrower bead for fillet welds and automated applications

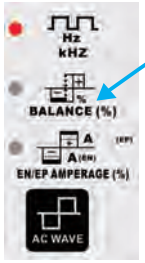


Wider bead and cleaning acting



Wider bead and cleaning acting

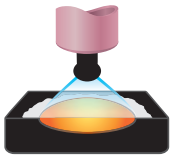




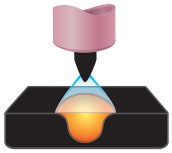
AC Balance Control

Controls arc cleaning action. Adjusting the % EN of the AC wave controls the width of the etching zone surrounding the weld.

Note: Set the AC Balance control for adequate arc cleaning action at the sides and in front of the weld puddle. AC Balance should be fine tuned according to how heavy or thick the oxides are.



Wider bead,good penetration ideal for buildup work



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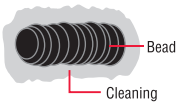
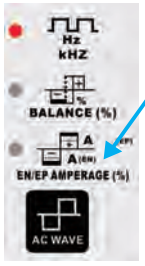


Wider bead and cleaning action

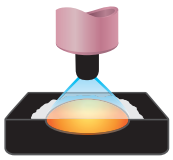
Narrow bead, with no visible cleaning



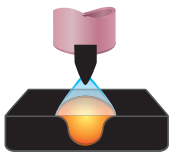
Independent AC Amperage Control

Allows the EN and EP amperage values to be set independently. Adjusts the ratio of EN to EP amperage to precisely control heat input to the work and the electrode.

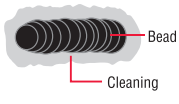
EN amperage controls the level of penetration, while EP amperage dramatically effects the arc cleaning action along with the AC Balance control.



More current in EP than EN: Shallower penetration

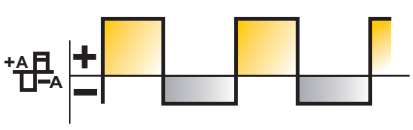


More current in EN than EP: Deeper penetration and faster travel speeds



Wider bead and cleaning action

Narrow bead, with no visible cleaning



Accessories

For Standard accessories

TIG torch: TIG-26
Gas connector:M16
Cable length 4M
5-pin control coupler

Electrode holder with cable 2M
Earth clamp with cable 2M

For Optional accessories

Argon gas regular

Water-cooling unit: WC-100
Operating Voltage:230V 50/60Hz
Rated Power:260W
Cooling Power:1.5KW(1L/MIN)
Tank Volume:6.5L

TIG torch: TIG-25
Cooling: Water Cooled
Duty100%DC: 250AMP
Duty100%AC: 220AMP
Electrode Size: 0.5-3.2mm

Foot Pedal
Model No.:FX-390B
Serial No.:12D36
Input Voltage: + 15V
Output Voltage:0-13V

Trolley:ST-7

Hand-hold Remote Controller for TIG torch
Dimensions: 110x27x30mm
Material: ABS
Weight: 30g
Resistance: 10K / 0.5W