

# ALUTIG-200HD

All TIG functions in one package



## Quick Specs

### ◆ Processes:

DC TIG,  
AC TIG,  
MIX TIG,  
MMA(Stick)

### ◆ Input Power:

200-240V/1-PH/50-60Hz

### ◆ Rated Output at 40°C (104°F):

200HD: 200A at 18V @60%  
Duty Cycle

### ◆ Applications:

Metal Fabrication  
Maintenance and Repair  
Auto Body  
Light Industrial

## TOP Features:

✓ **DC TIG Features** With the Pulse function, it can reduce heat input and increase control of the weld puddle, penetration and distortion.

### ✓ AC TIG Features

#### 4 AC Waveforms



#### Standard Square Wave

fast freezing puddle, deep penetration and fast travel speeds.



#### Sine Wave

For customers that like a traditional arc. Quiet with good wetting.



#### Soft Square Wave

For a soft buttery arc with maximum puddle control and good wetting action.



#### Triangle Wave

Reduces the heat input and is good on thin aluminum. Fast travel speeds.

#### 3 AC Waveshape Controls

• **Balance control** provides adjustable oxide removal which is essential for creating the highest quality aluminum welds.

• **Frequency controls** the width of the arc cone and can improve directional control of the arc.

• **Amplitude controls** the heat input to the work piece and the electrode.

✓ **MIX TIG Features** AC current and DC current in one duty cycle, easily get an excellent arc concentration and reduce heat input.

✓ HF start and Lift-Arc start are both available

✓ DC+/DC-: Improved TIG starting

✓ Pre-flow and post-flow adjustment

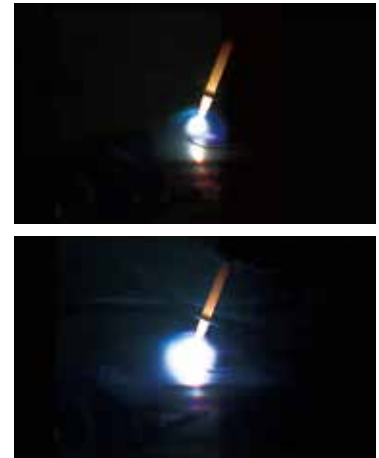
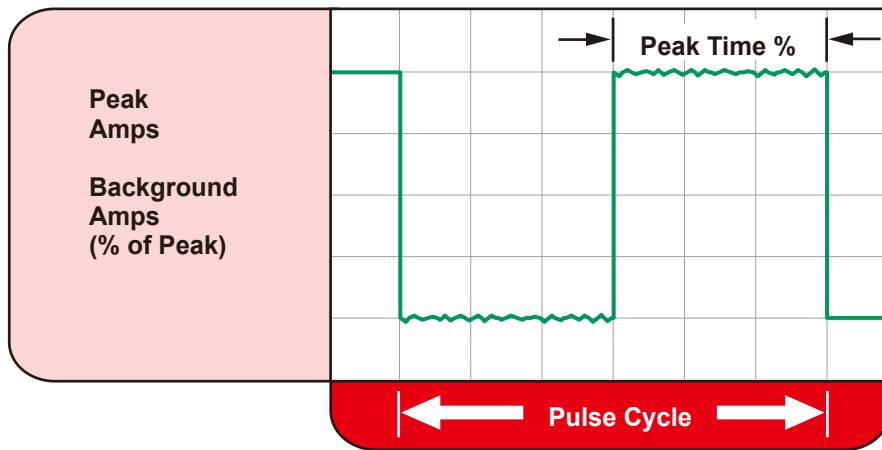
✓ 2T and 4T selection

✓ Capable to remote control

✓ 10 channels memory capacity

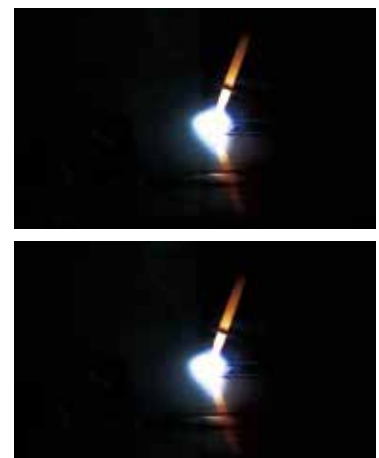
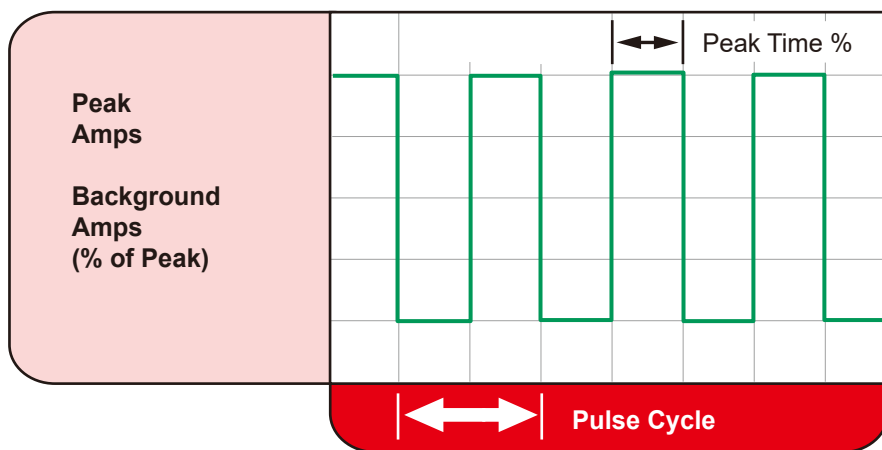
# Pulse TIG

## ◆ Conventional Pulsed TIG



Typically from 0.2 to 10 PPS. Provides a heating and cooling effect on the weld puddle and can reduce distortion by lowering the average amperage. This heating and cooling effect also produces a distinct ripple pattern in the weld bead. The relationship between pulse frequency and travel speed determines the distance between the ripples. Slow pulsing can also be coordinated with filler metal addition and can increase overall control of the weld puddle.

## ◆ High Speed Pulsed TIG



In excess of 40 PPS, Pulsed TIG becomes more audible than visible—causing increased puddle agitation for a better as-welded microstructure. Pulsing the weld current at high speeds — between a high Peak and a low Background amperage — can also constrict and focus the arc. This results in maximum arc stability, increased penetration and increased travel speeds.

# AC Waveforms

## ◆ Standard Square Wave

The Standard Square Wave offers fast transitions between EN and EP for a responsive, dynamic, and focused arc with better directional control. It forms a fast-freezing puddle with deep penetration and fast travel speeds.

## ◆ Soft Square Wave

The Soft Square Wave provides a smooth, soft, "buttery" arc with a fluid puddle and good wetting action. The puddle is more fluid than with standard square wave and more controllable than with sine wave.

## ◆ Sine Wave

The Sine Wave a soft arc with the feel of a conventional power source. It provides good wetting action and actually sounds quieter than other waves. Its fast transition through the zero amperage point also eliminates the need for continuous high frequency.

## ◆ Triangle Wave

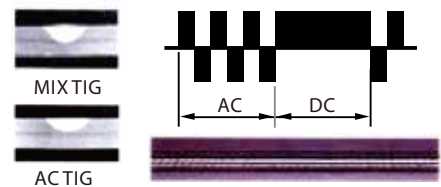
The Triangular Wave peak amperage while reducing overall heat input into the weld. This leads to quick puddle formation, low weld distortion, and fast travel speeds. It is especially good for welding thin aluminum.

# MIX TIG Control

## ◆ Features of MIX TIG:

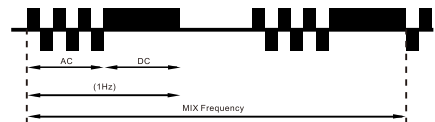
The AC current can get a very good clearance, and DC current can get a deeper penetration. Use the MIX TIG we can get an excellent Arc Concentration, can be carried out the excellent welding performance from thin to thick plate.

- 1) Nice weld appearance, deep penetration.
- 2) Excellent Arc Concentration.
- 3) Substantially reduce the electrode consumption.



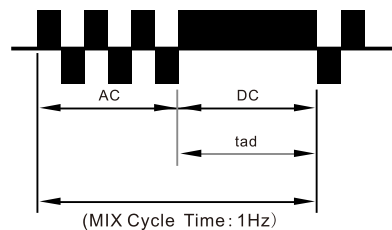
## ◆ MIX TIG Frequency (Hz):

the cycle time of MIX TIG in 1 second. Adjustable range: 1-5Hz.

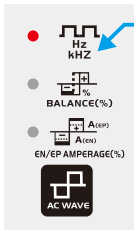


## ◆ MIX TIG Balance (DC) %:

DC Balance (%) =  $(t_{ad}/T_{mix}) \times 100$

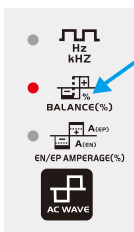
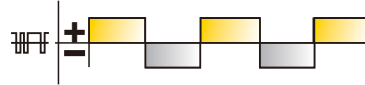
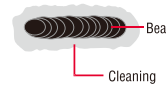
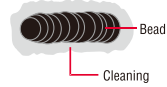
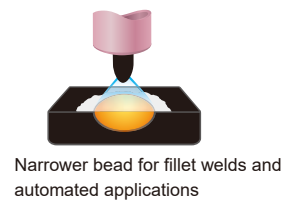
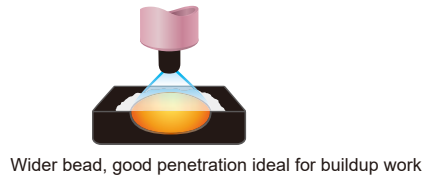


# AC Waveshape Controls



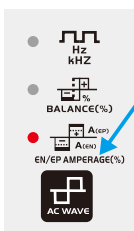
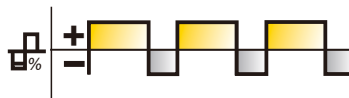
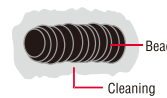
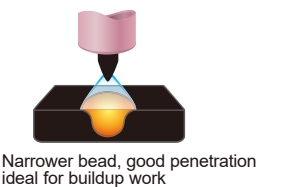
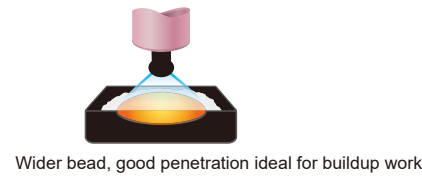
**AC Frequency control**  
Controls the width of the arc cone. Increasing the AC Frequency provides a more focused arc with increased directional control.

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



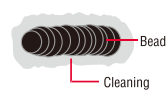
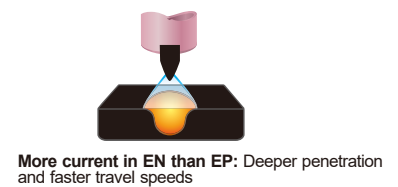
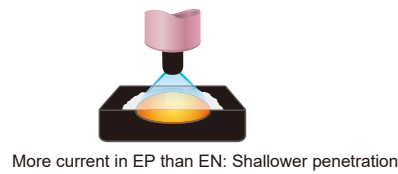
**AC Balance Control**  
Controls arc cleaning action. Adjusting the % EN of the AC wave controls the width of the etching zone surrounding the weld.

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.



**Amplitude Control**  
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.



## Technical Specifications

Item No		ALUTIG-200HD
Rated Input Voltage		1PH ~ 230V ±15%
Max. Load Power Capacity		TIG: 5.63KVA MMA: 6.60KVA
Rated Duty Cycle(40°C) 60%		TIG: 200A/18V MMA: 160A/26.4V
100%		TIG: 160A/16.4V MMA: 130A/25.2V
Welding Current/Voltage Range		TIG: 5A/10.2V~200A/18V MMA: 20A/20.8V~160A/26.4V
Open Circuit Voltage		70V~80V
Power Factor		0.8
Efficiency		80%
TIG	Pulse	Peak Current 5A~250A
		Pulse Frequency 0.2Hz~200Hz
		Pulse Width (Ratio) 1~100%
	AC TIG	AC Frequency Range 20Hz~250Hz
		AC Clean Width (AC Balance) +40~-40
		AC Clean Ratio (AC Bias) % +30~-50
	MIX TIG	MIX Frequency 1Hz~5Hz
		DC Balance (%) 20~80
		Arc-starting Current 5A~200A
		Crater-filling Current 5A~200A
		Current Up-slope Time 0.1S~15S
		Current Down-slop Time 0.1S~15S
		Pre-Gas Time 0.1S~15S
		Flow-Gas Time 0.1S~15S
		Spot Arc Time 0.1S~10S
MMA	Arc Force	10A~160A
	Hot Start Time	0.1~3S
	Hot Start Current	10A~160A
Dimension (LxWxH)		540x240x480mm
Weight (KG)		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

# Accessories

## Standard accessories



**TIG-26**



Technical data (EN 60 974-7):	
Type of cooling:	Gas cooled
Rating:	180A DC
	150AAC
Duty cycle:	35%
Tungsten electrodes:	Ø 0.5–4 mm

### Consumables:

-  Back cap
-  Collet
-  Insulating ring/Adaptor
-  Collet body
-  Gas nozzle, ceramic


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


## Optional accessories


**BINZEL ABITIG® GRIP 26**



Technical data (EN 60 974-7):	
Type of cooling:	air cooled
Rating:	180A DC
	130AAC
Duty cycle:	35%
Tungsten electrodes:	Ø 0.5–4.0 mm

-  Argon gas regular

-  Trolley:WT-100

-  Water-cooling unit: WC-100

-  Foot Pedal