

TIG inverter

**CRAFT-TIG PRO 323 AC/DC PULSE**

built in modern inverter technology

**Article number**

1364324

**Brand**

Craftweld



AC/DC technology



Suitable for generators



High-frequency ignition

☐ Ordering: from 1 units

**Description**

- Powerful TIG AC/DC welding machine, designed for heavy-duty use
- With 60% duty cycle at 320A, also suitable for continuous use at the power limit
- Intelligent ignition management with synergy characteristics ensures consistently good ignition behavior even in AC mode
- Extremely simple operation via high-resolution color display with graphic illustration of the welding curve and setting options
- Arc selection, adjustable balance and frequency in AC mode - welding characteristics can be adapted to the respective requirements
- Spot function
- Program memory with 10 memory locations
- Supports wireless foot pedal and remote control

## Delivery content

- Earth cable 35 mm<sup>2</sup> 4 m with 300 A electrode holder
- TIG torch SR18, 4 m
- Gas hose 4 m
- Pressure reducer
- trolley
- Cooling unit

## Technical data

### Dimensions and weights

|                               |         |
|-------------------------------|---------|
| Length (product) approx.      | 570 mm  |
| Width/depth (product) approx. | 200 mm  |
| Height (product) approx.      | 355 mm  |
| Net weight approx.            | 18.5 kg |

### Duty cycle

|                                              |       |
|----------------------------------------------|-------|
| Duty cycle at I <sub>max</sub> . 40°C TIG DC | 60 %  |
| Duty cycle at max. current 40°C Electrode    | 60 %  |
| Current at 100% DC 40°C TIG DC               | 250 A |
| Current at ED 100% 40°C Electrode            | 250 A |

### Electrode

|                     |            |
|---------------------|------------|
| Weldable electrodes | 1.6-5.0 mm |
|---------------------|------------|

### Setting range

|                         |            |
|-------------------------|------------|
| Setting range TIG       | 5-320 A    |
| Setting range electrode | 10 – 320 A |

### Electrical Data

|                            |               |
|----------------------------|---------------|
| Supply voltage             | 400 V         |
| Phase(s)                   | 3 Ph          |
| Current type               | AC            |
| Mains frequency            | 50 Hz         |
| Power factor               | 0.726 cos phi |
| Total output               | 10.5 kVA      |
| Input current TIG AC       | 17.8 A        |
| Input current TIG DC       | 18.9 A        |
| Input current electrode AC | 23 A          |
| Input current electrode DC | 24.3 A        |

### Device data

|                       |                |
|-----------------------|----------------|
| Operating temperature | -10 – 40 °C    |
| Pulse rate            | 0.5 – 999 Hz   |
| Ignition              | high frequency |
| Torch cooling         | gas / water    |

## Standards and certifications

|                       |                                                                                                                                                  |
|-----------------------|--------------------------------------------------------------------------------------------------------------------------------------------------|
| Standard              | EN 60974-1:2012, EN 60974-10:2014                                                                                                                |
| Degree of protection  | IP21S                                                                                                                                            |
| Insulation class      | H                                                                                                                                                |
| EMC class             | A                                                                                                                                                |
| Explanation EMC class | This Class A welding equipment is not intended for use in residential areas where power is supplied by a public low-voltage power supply system. |
| Marking               | CE                                                                                                                                               |

## Electrical connections

|                                  |                              |
|----------------------------------|------------------------------|
| Fuse (slow blowing)              | 16 A                         |
| Required generator output        | >9.8 kVA                     |
| Positive mains voltage tolerance | 10 %                         |
| Negative mains voltage tolerance | 10 %                         |
| Open circuit voltage             | MMA AC/DC 14, TIG AC/DC 14 V |
| Connection cable length          | 4.3 m                        |
| Power consumption in idle mode   | < 50 W                       |

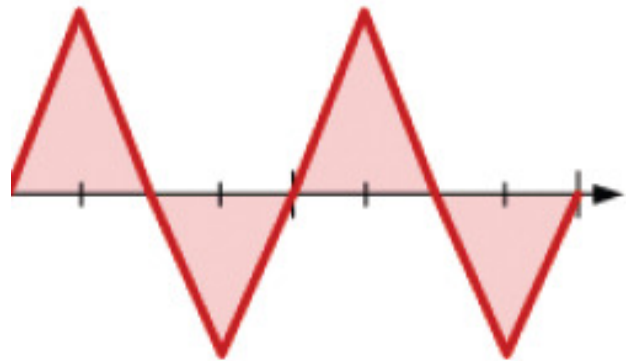
## Input

|                                |          |
|--------------------------------|----------|
| Power consumption TIG AC       | 12.4 kVA |
| Power consumption TIG DC       | 12.8 kVA |
| Power consumption electrode AC | 15.9 kVA |
| Power consumption electrode DC | 16.8 kVA |
| Efficiency                     | 86.03 %  |

## Manufacturer infos

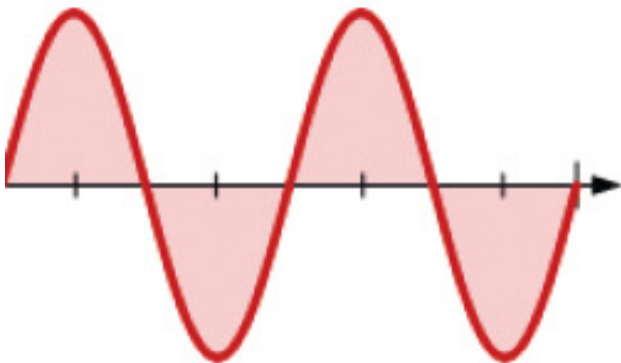
|              |                                                      |
|--------------|------------------------------------------------------|
| Manufacturer | Stürmer Maschinen GmbH                               |
| Address      | Dr.-Robert-Pfleger-Str. 26, 96103 Hallstadt, Germany |
| E-Mail       | info@stuermer-maschinen.de                           |

## Media informations



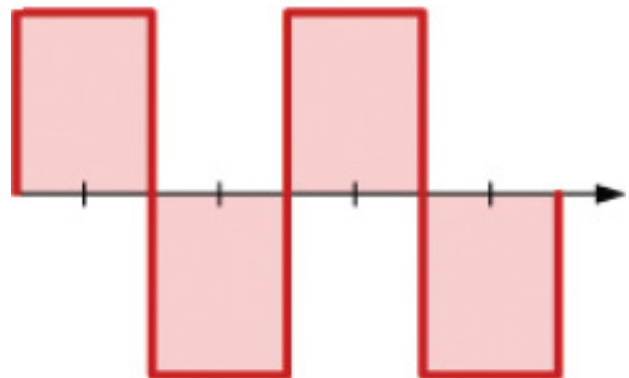
### AC delta wave welding output

- Reduced heat input for the same current setting
- Especially useful for welding thin metal



### AC sine wave welding output

- Traditional AC TIG welding waveform
- Quieter, "soft" arc characteristics



### AC square wave

- Focused arc for maximum penetration
- Fast welding speed with best directional control



# Equipment

## Equipment

|                      |                                                                                           |
|----------------------|-------------------------------------------------------------------------------------------|
| Process MMA          | ✓                                                                                         |
| Process TIG pulsing  | ✓                                                                                         |
| LC display           | ✓                                                                                         |
| Water cooling device | ✓                                                                                         |
| Trolley              | with two swivel castors at the front, two fixed castors at the rear and gas bottle holder |
| Single Spot          | ✓                                                                                         |
| AC delta wave        | ✓                                                                                         |
| AC square wave       | ✓                                                                                         |
| AC frequency         | ✓                                                                                         |
| Programs storable    | ✓                                                                                         |

# Shipping informations

| Packaging Metrics |     | Weights |         | Delivery |             | Other   |      |
|-------------------|-----|---------|---------|----------|-------------|---------|------|
| Length            | n/a | Net     | 46,7 kg | Delivery | Carrier     | DualUse | Nein |
| Width             | n/a | Gross   | 59 kg   | Content  | 1 undefined | SCIP    |      |
| Height            | n/a |         |         |          |             | SVHC    | Nein |

# Manufacturer

Stürmer Maschinen GmbH  
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info@stuermer-maschinen.de

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