

INVERTER TIG WELDING MACHINES



Power Factor Correction

► **PFC** is an electrical or electronic circuit that increases the so-called power factor



Generator Friendly

► Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers



Multivoltage Einsatz weltweit

► Regulates the voltage from 110 V - 230 V



AC/DC Technology

► Welding with direct current or alternating current



DC PULSE

► **TIG DC** function = enables simple TIG welding



► **HF high-frequency ignition** ignites during **TIG** welding without touching the workpiece

Inverter TIG welding machines DC / DC Pulse

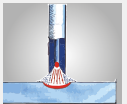
easytig® 181 DC / 201 DC PULSE

Inverter TIG welding machines. Portable TIG DC inverter for workshop and mobile use

- ▶ All appliances are built using modern inverter technology
- ▶ Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and generally also for outdoor work thanks to protection class IP21S
- ▶ Precise setting of welding parameters via digital display
- ▶ Universally applicable for welding all common electrode types
- ▶ Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- ▶ **HF high-frequency ignition** ignites during TIG welding without touching the workpiece
- ▶ The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle

EASY-TIG 201DC PULSE

- ▶ Adjustable welding curve
- ▶ Pulse up to 200 Hz



ELECTRODES



TIG



See our capabilities for yourself and request a personal consultation!



Contact: +49 (0) 951 96 555-501
beratung@schweisskraft.de



EASY-TIG 181 DC

Torch included SR17
(Easy-Tig 181DC)



EASY-TIG 201 DC PULSE

Torch included SR26
(Easy-Tig 201DC PULSE)



OPERATION

- 1 Operation indicator light (green)
- 2 Temperature indicator light (yellow)
- 3 Digital display
- 4 TIG 4T/2T/ MMA selector switch
- 5 Rotary knob for welding current preselection
- 6 Rotary knob for down slope
- 7 Rotary knob for post flow



EASY-TIG 181DC



EASY-TIG 201 DC PULSE

- 8 Electrode welding setting
- 9 MMA/LIFT/HF TIG selection button
- 10 TIG 2T/4T mode selection button
- 11 Digital display - Hot start - Welding current - Arc strength
- 12 TIG parameter setting
- 13 Parameter selection and setting button

TECHNICAL DATA:

Model		EASY-TIG 181 DC	EASY-TIG 201 DC PULSE
Art. no.		1074018	1074020
Technical data			
Setting range for TIG DC	A	10 – 180	5 – 200
Setting range for electrode	A	10 – 180	5 – 200
Weldable electrode Ø	mm	1.6 – 4.0	1.6 – 4.0
Sheet thicknesses	mm	0.5 – 8.0	0.5 – 10.0
No-load voltage	V	MMA 75.5 TIG 92.6	MMA 90.5 TIG 60.3
Duty cycle at I _{max} [40°C] Electrode	%	40	30
Current at 100% duty cycle [40°C] TIG DC	A	100	120
Current at 100% duty cycle [40°C] Electrode	A	100	120
Power factor	cos phi	0.6	0.6
Ignition		HF	HF
Torch cooling		gas-cooled	gas-cooled
Protection class		IP21S	IP21S
Power consumption TIG	kVA	3.9	4.5
Electrode power consumption	kVA	5.9	6.9
Pulse rate	Hz	–	0.5–200
Electrical connection ~50/60Hz AC	V	230 ±10%	230 ±10%
Dimensions (L x W x H) approx.	mm	430 x 150 x 280	430 x 150 x 280
Weight approx.	kg	7.3	9.7
Standards ¹⁾		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

SCOPE OF DELIVERY:

- Welding torch SR 17/4 m (EASY-TIG 181DC)
- Welding torch SR 26/4 m (EASY-TIG 201DC PULSE)
- Ground cable 16mm²/3m
- Gas hose 4 m incl. quick connector
- Welding cable 16 mm² with electrode holder, 3 m

All devices protection class IP21S

¹⁾ EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

ACCESSORIES



ACCESSORY for Easy-Tig 181DC

① TIG torch SR17/4 m, ED, gas-cooled,

Art. no.

1105044

① TIG torch SR17/8 m, ED, gas-cooled

1105048

ACCESSORY for Easy-Tig 201 DC PULS

TIG torch SR26/4 m, U/D, gas-cooled

1105014

TIG torch SR26/8 m, U/D, gas-cooled

1105018

① TIG torch SR26/4 m, ED, gas-cooled

1105004

① TIG torch SR26/8 m, ED, gas-cooled

1105008

② Wireless hand remote control

1174004

③ Foot remote control 5m

1174009

④ Wireless foot remote control

1174007

Control cable plug 12-pin incl. contact pins

1104012

ACCESSORIES

Adapter 1/4" external thread x M12x1 internal thread / union nut

1104001

Argon/CO₂ Pressure reducer, large

1700050

3-pin control cable connector

1174010

⑤ Ground cable 25 mm² 4m 13 mm with 400 A clamp

1250225

⑥ Wear parts set

1100152

consisting of:

1 x torch cap each short / medium / long, 1 x gas nozzle each size 5 / 8 mm, size 6 / 9.8 mm, size 7 / 11.2 mm, size 8 / 12.7 mm, size 10 / 15.7 mm, 1x clamping sleeve each 1.6 / 3.2 / 4.0 / 2.4 mm, 1x clamping sleeve housing each 1.6 / 2.4 / 3.2 / 4.0 mm, Teflon seal for nozzle

Wear parts set "Mini":

1100200

comprises:

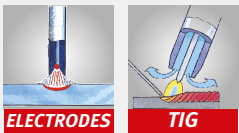
Teflon seal for nozzle, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2x clamping sleeve housing 1.0 mm, 2x gas nozzle d=9.8 mm, 1x torch cap medium/long/short, Teflon seal, 1x gas lens 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2 x gas nozzle gas lens gr. 6, 2x each tungsten electrode gold 1.6 mm, gold 2.4 mm, gold 3.2 mm

Inverter TIG welding machines DC PULSE

CRAFTIG® 201 DC P PULSE / 253 DC PULSE

Portable TIG DC inverter for professional and mobile workshop use

- ▶ Built using modern inverter technology
- ▶ Universally applicable for welding all common electrode types
- ▶ Ideally suited for assembly work thanks to protection class IP 21S, generally also for outdoor work
- ▶ Power factor correction PFC for problem-free use even on cable reels
- ▶ TIG pulsing enables welding with reduced heat input
- ▶ HF high-frequency ignition ignites during TIG welding without touching the workpiece
- ▶ Multi-voltage from 110 to 230 volts
- ▶ VRD for voltage reduction when idling
- ▶ The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle
- ▶ Precise setting and display of welding parameters via LC display
- ▶ Suitable for generators
- ▶ Adjustable welding curve
- ▶ CRAFT-TIG 201 DC P PULSE equipped with PFC (power factor correction), also enables optimum use on cable drums
- ▶ With multivoltage
- ▶ CRAFT-TIG 253 DC PULSE optionally with water cooling
- ▶ VRD operation and TIG pulsing
- ▶ Water cooling connection



Power Factor Correction

▶ PFC is an electrical or electronic circuit that increases the so-called power factor

Generator Friendly

Multivoltage Einsatz weltweit

HF

DC PULSE

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CRAFT-TIG 201 DC P PULSE



CRAFT-TIG 253 DC PULSE

Torch included SR26 (Craft-Tig 201 DC P Pulse)



OPERATION

- 1 Electrode welding setting
- 2 MMA/LIFT/HF TIG selection button
- 3 TIG 2T/4T mode selection button
- 4 Digital display Multifunctional display
- 5 TIG parameter setting
- 6 Parameter selection and setting button



CRAFT-TIG 201 DC P PULSE



CRAFT-TIG 253 DC PULSE

- 1 Gas or water-cooled selector button
- 2 Digital display, Multifunction display
- 3 Display MMA
- 4 TIG parameter setting
- 5 MMA/LIFT/HF TIG selection button
- 6 TIG 2T/4T mode selection button
- 7 Parameter selection and setting button

TECHNICAL DATA:

Model		CRAFT-TIG 201 DC P PULSE	CRAFT-TIG 253 DC PULSE
Art. no.		1074201	1074253
Technical data			
Setting range TIG / electrode	A	5 – 200	5 – 250
Weldable electrodes	mm	1.6 – 4.0	1.6 – 5.0
Duty cycle at I _{max.} [40°C] TIG / Electrode	%	50 / 30	60 / 60
Current at 100% duty cycle [40°C] TIG / Electrode	A	145 / 135	195 / 195
No-load voltage	V	TIG 66.5, MMA 66.7	Electrode 70.5 / TIG 60.5
Ignition		High frequency	High frequency
Torch cooling		gas-cooled	gas-cooled water-cooled
Power factor	cos phi	0.99	0.67
Current consumption TIG DC	A	19.7	13.5
Current consumption electrode DC	A	30.1	18.6
Pulse rate	Hz	0.5 – 200	0.5 – 200
Power consumption TIG / electrode	kVA	4.5 / 6.9	5 / 7.1
Required generator output	kVA	>6.9	>10.6
Overall performance	kVA	TIG 4.5/MMA 6.9	10.6/7.7
Electrical connection ~50/60Hz AC	V	230±10%	400±10%
Dimensions (L x W x H) approx.	mm	500 x 150 x 280	480 x 190 x 350
Weight approx.	kg	10	15
Standard		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.
All devices protection class IP21S

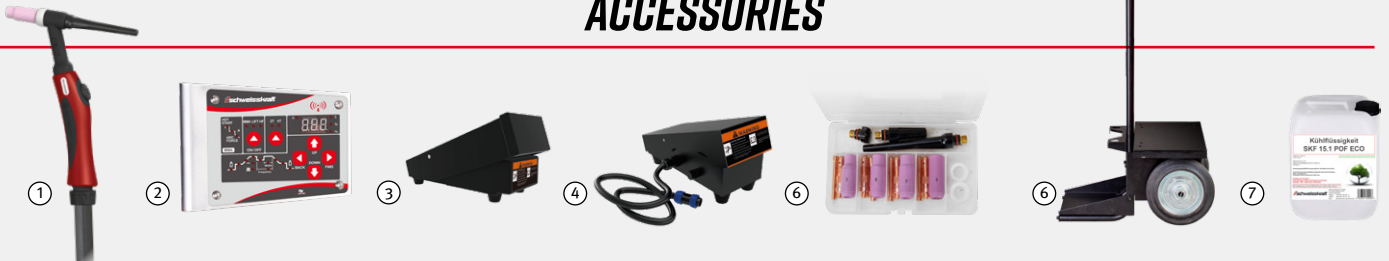
CRAFT-TIG 201 DC P PULSE SCOPE OF DELIVERY:

- Welding torch SR 26/ 4 m
- Pressure reducer
- Ground cable 16mm² / 3m
- Gas hose 4 m incl. quick connector
- Welding cable 16 mm² with electrode holder, 3 m

CRAFT-TIG 253 DC PULSE SCOPE OF DELIVERY:

- Ground cable 25mm² / 3m
- Gas hose 4 m incl. quick connector
- Hose clamp
- ! • Please remember to use the correct welding torch!

ACCESSORIES



ACCESSORY for CRAFT-TIG 253 DC PULSE

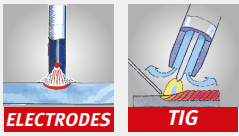
	Art. no.
TIG torch SR18, ED, water-cooled, 4 m	1105024
TIG torch SR18, ED, water-cooled, 8 m	1105028
TIG torch SR18, U/D, water-cooled, 4 m	1105034
TIG torch SR18, U/D, water-cooled, 8 m	1105038
⑥ Trolley	1174001
Cooling unit 400V / 4 l	1174006
⑦ Coolant SKF 15 10l - canister (ready-mixed)	1030110
ACCESSORIES	
③ TIG torch SR26, ED, gas-cooled, 4 m	1105004
③ TIG torch SR26, ED, gas-cooled, 8 m	1105008
TIG torch SR26, U/D, gas-cooled, 4 m	1105014
TIG torch SR26, U/D, gas-cooled, 8 m	1105018
② Wireless hand remote control	1174004
⑤ Wireless foot remote control	1174007
④ Foot remote control 5m	1174009
Control cable plug 12-pin incl. contact pins	1104012
Control cable complete with plug	1104011
Adapter 1/4" external thread x M12x1 internal thread / union nut	1104001
Argon/CO ₂ pressure reducer	1700050
Welding cable 4 m 25 mm ² , KS50/13 mm, electrode holder 260 A	1250361
⑥ Wear parts set	1100152
1 x torch cap each short / medium / long, 1 x gas nozzle each size 5 / 8 mm, size 6 / 9.8 mm, size 7 / 11.2 mm, size 8 / 12.7 mm, size 10 / 15.7 mm, 1x clamping sleeve each 1.6 / 3.2 / 4.0 / 2.4 mm, 1x clamping sleeve housing each 1.6 / 2.4 / 3.2 / 4.0 mm, Teflon seal for nozzle	
Wear parts set "Mini": Teflon seal for nozzle, 2 x clamping sleeves 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve housings 1.0 mm, 2 x gas nozzles d = 9.8 mm, 1x torch cap each medium/long/short, Teflon seal, 1x gas lens each 1.6 mm, 2.4 mm, 3.2 mm, 2x collet 1.6 mm, 2.4 mm, 3.2 mm, 2x gas nozzle gas lens size 6, 2x tungsten electrode gold 1.6 mm, gold 2.4 mm, gold 3.2 mm	1100200

Inverter TIG welding machines AC / DC Pulse

easytig® 201 AC/DC PULSE –

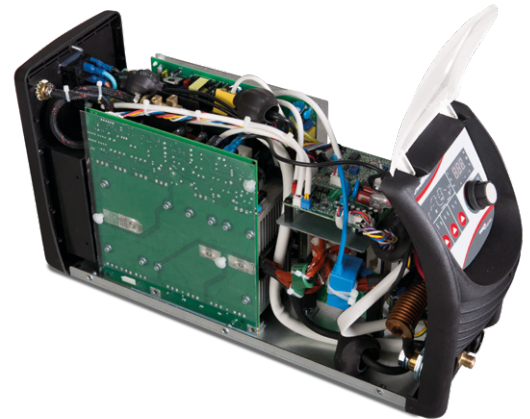
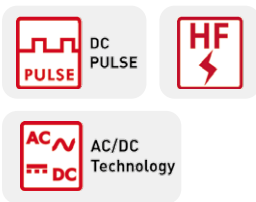
Portable TIG AC/DC inverter for workshop and mobile use

- ▶ All appliances are built using modern inverter technology
- ▶ Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and generally also for outdoor work thanks to protection class IP21S
- ▶ TIG DC function = enables simple TIG welding
- ▶ Precise setting of welding parameters via digital display
- ▶ Universally applicable for welding all common electrode types
- ▶ Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- ▶ Adjustable welding curve
- ▶ **HF high-frequency ignition** ignites during TIG-welding without touching the workpiece
- ▶ The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle



See our capabilities for yourself and request a personal consultation!

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beratung@schweisskraft.de



Torch included SR26



OPERATION

① MMA/LIFT/HF TIG selection button

② AC/DC selection button

③ TIG 2T/4T mode selection button



④ Parameter selection and setting button

⑤ TIG parameter setting

⑥ Display - Welding current

TECHNICAL DATA:

Model	EASY-TIG 201 AC/DC Pulse	
Art. no.	1074021	
Technical data		
Setting range for TIG DC	A	10 – 170
Setting range for electrode	A	10 – 170
Weldable electrode Ø	mm	1.6 – 4.0
Sheet thicknesses	mm	0.5 – 10
No-load voltage	V	AC TIG 73.4/DC TIG 69.8/AC MMA 69.3/DC MMA 69.3
Duty cycle at I_{max} [40°C] Electrode	%	30
Current at 100% duty cycle [40°C] TIG	A	110
Current at 100% duty cycle [40°C] Electrode	A	95
Power consumption TIG	kVA	4
Electrode power consumption	kVA	5.9
Ignition	HF	
Torch cooling	gas-cooled	
Protection class	IP21S	
Insulation class	H	
EMC - class	A	
Slow-blow fuse	A	16
Pulse rate	Hz	0.5~200
Required generator output	kVA	>9.5
Power factor	cos phi	0.6
Electrical connection ~50 Hz AC	V	230±10%
Dimensions (L x W x H) approx.	mm	460 x 150 x 280
Weight approx.	kg	9
Standards	DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system. All devices protection class IP21S

SCOPE OF DELIVERY:

- Welding torch SR 26/ 4 m
- Ground cable 25mm² / 3m
- Gas hose 4 m incl. quick connector

ACCESSORIES



ACCESSORIES

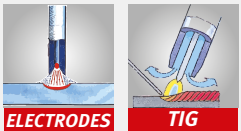
① TIG torch SR26, ED, gas-cooled, 4 m	1105004
① TIG torch SR26, ED, gas-cooled, 8 m	1105008
TIG torch SR26, U/D, gas-cooled, 4 m	1105014
TIG torch SR26, U/D, gas-cooled, 8 m	1105018
Adapter 1/4" external thread x M12x1 internal thread / union nut	1104001
② Pressure regulator with content and working pressure gauge, argon/CO ₂	1700050
③ Control cable complete with plug	1104011
Control cable plug 12-pin incl. contact pins	1104012
④ Foot remote control 5m	1174009
⑤ Welding cable 4 m 25 mm ² , KS50/13 mm, electrode holder 260 A	1250361
Ground cable 4m 25 mm ² 13 mm with 400 A clamp	1250225
⑥ Wear parts set	1100152
1 x torch cap each short / medium / long, 1 x gas nozzle each size 5 / 8 mm, size 6 / 9.8 mm, size 7 / 11.2 mm, size 8 / 12.7 mm, size 10 / 15.7 mm, 1x clamping sleeve each 1.6 / 3.2 / 4.0 / 2.4 mm, 1x clamping sleeve housing each 1.6 / 2.4 / 3.2 / 4.0 mm, Teflon seal for nozzle	
Wear parts set "Mini":	1100200
Teflon seal for nozzle, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2x clamping sleeve housing 1.0 mm, 2x gas nozzle d=9.8 mm, 1x torch cap medium/long/short, Teflon seal, 1x gas lens 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2 x gas nozzle gas lens gr. 6, 2x each tungsten electrode gold 1.6 mm, gold 2.4 mm, gold 3.2 mm	

Inverter TIG welding machines AC / DC Pulse

craftig® 201 AC/DC P PULSE

Portable TIG DC inverter for professional and mobile workshop use

- ▶ All appliances are built using modern inverter technology
- ▶ Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and generally also for outdoor work thanks to protection class IP21S
- ▶ Universally applicable for welding all common electrode types
- ▶ TIG pulsing enables welding with reduced heat input
- ▶ **HF high-frequency ignition** ignites during TIG-welding without touching the workpiece
- ▶ The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle
- ▶ Precise setting of welding parameters via digital display with job memory
- ▶ Adjustable welding curve
- ▶ Device with **PFC** (power factor correction) equipped enables the best use even on cable reels
- ▶ Optionally with water cooling
- ▶ With multi-voltage and suitable for generators
- ▶ 9 programmes can be saved



▶ **PFC** is an electrical or electronic circuit that increases the so-called power factor



Scope of delivery Factory assembly
 Article no. 9002805
€89.00 plus VAT
 Assembly and filling with coolant for the TIG welding unit
CRAFT-TIG 201 AC/DC P Pulse SET 2 (Art. no. 1074202SET2)
 before delivery



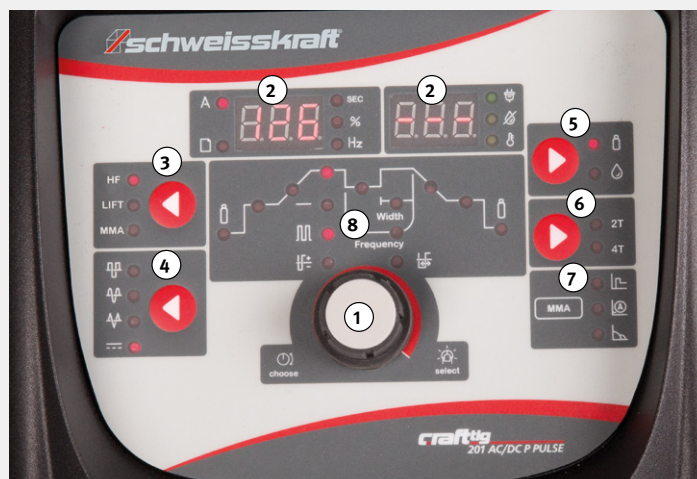
CRAFT-TIG 201 AC/DC P PULSE



CRAFT-TIG 201 AC/DC P PULSE SET 2

OPERATION

- ① Parameter selection and setting button
- ② Digital display, Multifunction display
- ③ WIGHF, Lift-Arc and MMA select button
- ④ AC/DC selector button



- ⑤ Gas or water-cooled selector button
- ⑥ TIG 2T/4T mode selection button
- ⑦ Display MMA
- ⑧ TIG parameter setting

TECHNICAL DATA:

Model		CRAFT-TIG 201 AC/DC P PULSE	CRAFT-TIG 201 AC/DC P Pulse Set2
Art. no.		1074202	1074202SET2
Technical data			
Setting range for TIG DC	A	5 – 200	
Setting range for electrode	A	5 – 200	
Weldable electrode Ø	mm	1.6 – 4.0	
Sheet thicknesses	mm	0.5 – 10	
No-load voltage	V	10.4 (MMA), 70 (TIG)	
TIG setting range		3 – 200 (230 V) 3 – 160 (110 V)	
Setting range for electrode		10 – 200 (230 V) 10 – 130 (110 V)	
Duty cycle max. current [40°C] TIG	%	60	
Duty cycle max. current [40°C] Electrode	%	35 (230 V) 60 (110 V)	
Current at 100% duty cycle [40°C] TIG DC	A	155 (230 V) 125 (110 V)	
Current at 100% duty cycle [40°C] Electrode	A	120 (230 V) 100 (110 V)	
Ignition		HF	
Torch cooling		gas-cooled	Watercooled
Protection class		IP21S	
Pulse rate	Hz	0.5 ~ 999	
Power factor	cos phi	0.99	
Current consumption TIG AC	A	(110 V / 230 V) 30.8 / 19.2	
Current consumption TIG DC	A	(110 V / 230 V) 33.8 / 20.5	
Current consumption electrode AC	A	(110 V/230 V) 35.8 / 27.5	
Current consumption electrode DC	A	(110 V/230 V) 39.0 / 30.0	
Required generator output	kVA	> 6.9	
Power consumption TIG	kVA	4.7	
Electrode power consumption	kVA	6.9	
Electrical connection ~ 50 Hz	V	90 ~ 275	
Dimensions (L x W x H) approx.	mm	580 x 190 x 350	580 x 630 x 1120
Weight approx.	kg	14.5	48.5
Standard*		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

SCOPE OF DELIVERY:

- Welding torch SR 26 / 4 m UP / Down gas-cooled
- Pressure reducer
- Ground cable 16mm² / 3m
- Gas hose 4 m incl. quick connector

SET 2 ADDITIONALLY INCLUDES:

- TIG torch SR18/ 4 m water-cooled
- VarioProtect XXL-W-2 TC welding helmet
- Basic L TIG welding glove
- Water cooling unit
- Trolley

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

ACCESSORIES



ACCESSORIES

TIG torch SR26, ED, gas-cooled, 4 m	1105004
TIG torch SR26, ED, gas-cooled, 8 m	1105008
TIG torch SR26, U/D, gas-cooled, 4 m	1105014
TIG torch SR26, U/D, gas-cooled, 8 m	1105018
① TIG torch SR18, ED, water-cooled, 4 m	1105024
① TIG torch SR18, ED, water-cooled, 8 m	1105028
① TIG torch SR18, U/D, water-cooled, 4 m	1105034
① TIG torch SR18, U/D, water-cooled, 8 m	1105038
Pressure reducer Argon/CO ₂	1700050
② Wireless hand remote control	1174003
③ Wireless foot remote control	1174007
④ Foot remote control 5m	1174009
⑤ Wireless handheld remote control	1174100
Control cable complete with plug	1104011
Control cable plug 12-pin incl. contact pins	1104012
⑥ SKF 15 coolant 10 l – canister (ready-mixed)	1030110
Adapter 1/4" external thread x M12x1 internal thread / union nut	1104001
⑦ 4 litre cooling unit, 230 V	1174002
⑧ Trolley	1174001
⑨ Wear parts set	1100152
1x short/medium/long torch cap each, 1x gas nozzle size 5/8 mm, size 6/9.8 mm, size 7/11.2 mm, size 8/12.7 mm, size 10/15.7 mm, 1x clamping sleeve 1.6/3.2/4.0/2.4 mm, 1x clamping sleeve housing 1.6/2.4/3.2/4.0 mm, Teflon seal for nozzle	
Wear parts set "Mini":	1100200
Teflon seal for nozzle, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2x clamping sleeve housing 1.0 mm, 2x gas nozzle d=9.8 mm, 1x torch cap medium/long/short, Teflon seal, 1x gas lens 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2 x gas nozzle gas lens gr. 6, 2x each tungsten electrode gold 1.6 mm, gold 2.4 mm, gold 3.2 mm	

Inverter TIG welding machines AC / DC Pulse

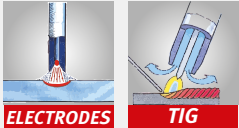
craftig® 323 AC/DC PULSE –

TIG DC pulse inverter for professional and mobile workshop use

- ▶ Built using modern inverter technology
- ▶ Ideally suited for assembly work thanks to protection class IP 21S, generally also for outdoor work
- ▶ Universally applicable for welding all common electrode types
- ▶ TIG pulsing enables welding with reduced heat input
- ▶ HF high-frequency ignition ignites during TIG

- welding without touching the workpiece
- ▶ The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle
- ▶ Precise setting of welding parameters via digital display with job memory
- ▶ 9 programmes can be saved
- ▶ AC triangle wave welding output: Reduced heat input for the same current setting,

- particularly useful for welding thin metal
- ▶ Alternating current sine wave welding output: Traditional AC TIG welding waveform, quieter, "softer" arc characteristics
- ▶ AC square wave: Focussed arc for maximum penetration, fast travel speed with optimum directional control
- ▶ Exclusively available including factory assembly, article number 9002800



- ▶ PFC is an electrical or electronic circuit that increases the so-called power factor



Including
Torch SR 18
Ground cable
Gas hose
Water cooling unit
Trolley

Scope of delivery Factory assembly
Article no. 9002800
115.00 € plus VAT
Assembly and filling with coolant for the TIG welding unit
CRAFT-TIG 323 AC/DC Pulse SET
(Art. no. 1074323SET)
before delivery

OPERATION



- ① Parameter selection and setting button
- ② Digital display, Multifunction display
- ③ WIGHF, Lift-Arc and MMA select button
- ④ AC/DC selector button

- ⑤ Gas or water-cooled selector button
- ⑥ TIG 2T/4T mode selection button
- ⑦ Display MMA
- ⑧ TIG parameter setting

TECHNICAL DATA:

Model	CRAFT-TIG 323 AC/DC PULSE	
Art. no.	1074323	
Setting range TIG / electrode	A	10 – 320
Weldable electrodes	mm	1.6 – 5.0
No-load voltage AC TIG / DC TIG	V	84.6 / 76.4
No-load voltage AC electrode / DC electrode	V	75.8 / 75.6
Duty cycle at max. current 40°C TIG DC	%	60
Duty cycle at max. current 40°C Electrode	%	60
Current at duty cycle 100% 40°C TIG DC	A	250
Current at duty cycle 100% 40°C Electrode	A	250
Power consumption TIG / electrode	kVA	4.8 / 6.5
Ignition	High frequency	
Torch cooling	gas-cooled Watercooled	
Pulse rate	Hz	0.5 – 250
Power factor	cos phi	0.65
Current consumption TIG AC / TIG DC	A	18.8 / 19.5
Current consumption electrode AC / electrode DC	A	24.3 / 25.8
Required generator output	kVA	>10.3
Electrical connection ~50/60 Hz	V	400 ±10%
Dimensions (L x W x H) approx.	mm	630 x 240 x 445
Weight approx.	kg	26
Standards*	DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	



1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

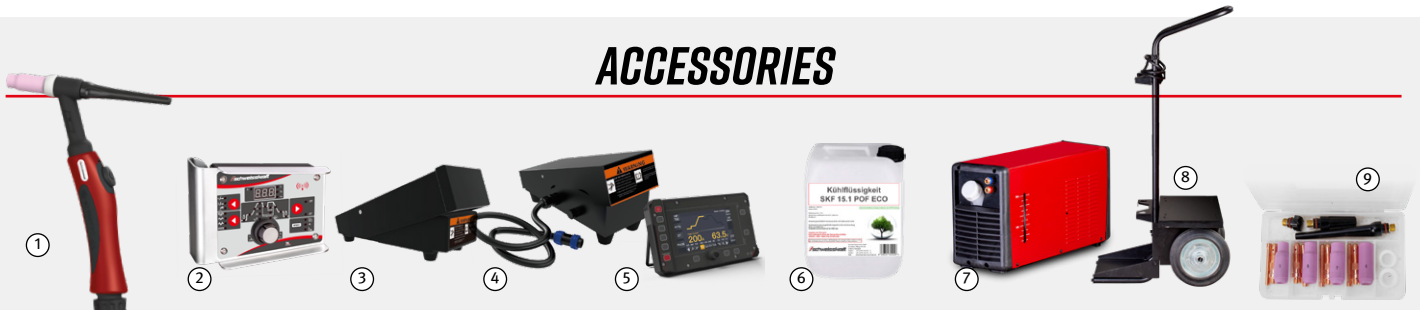
All devices protection class IP21S

SCOPE OF DELIVERY:

- Welding torch SR 18 4 m, water-cooled
- Ground cable 35mm²/3m
- Gas hose 4 m incl. quick connector
- Water cooling unit
- Trolley

- ! Without coolant
- ! Without pressure reducer

ACCESSORIES



ACCESSORIES

TIG torch SR26, ED, gas-cooled, 4 m	1105004
TIG torch SR26, ED, gas-cooled, 8 m	1105008
TIG torch SR26, U/D, gas-cooled, 4 m	1105014
TIG torch SR26, U/D, gas-cooled, 8 m	1105018
① TIG torch SR18, ED, water-cooled, 4 m	1105024
① TIG torch SR18, ED, water-cooled, 8 m	1105028
① TIG torch SR18, U/D, water-cooled, 4 m	1105034
① TIG torch SR18, U/D, water-cooled, 8 m	1105038
Pressure reducer Argon/CO ₂	1700050
② Wireless hand remote control	1174003
③ Wireless foot remote control	1174007
④ Foot remote control 5m	1174009
⑤ Wireless handheld remote control	1174100
Control cable complete with plug	1104011
Control cable plug 12-pin incl. contact pins	1104012
⑥ Coolant SKF 15 10l - canister (ready-mixed)	1030110
Adapter 1/4" external thread x M12x1 internal thread / union nut	1104001
⑦ 4 litre cooling unit, 230 V	1174002
⑧ Trolley	1174001
⑨ Wear parts set	1100152
1x short/medium/long torch cap, 1x gas nozzle size 5/8 mm, size 6/9.8 mm, size 7/11.2 mm, size 8/12.7 mm, size 10/15.7 mm, 1x clamping sleeve 1.6/3.2/4.0/2.4 mm, 1x clamping sleeve housing 1.6/2.4/3.2/4.0 mm, Teflon seal for nozzle	
Wear parts set "Mini":	1100200
Teflon seal for nozzle, 2 x clamping sleeves 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve housings 1.0 mm, 2 x gas nozzles d = 9.8 mm, 1 x torch cap medium/long/short, Teflon seal, 1 x gas lens 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2 x gas nozzle gas lens size 6, 2 x tungsten electrode gold 1.6 mm, gold 2.4 mm, gold 3.2 mm	

