

CO₂ MIG/MAG WELDING MACHINE

THYRISTORISED OR STEP CONTROL



PROCESS : Continuously feed wire in the form of spool is used as electrode and the arc is shielded under the cloud of inert gases such as Argon, Helium (MAG) or Mixture of active gases or most commonly used Gas CO₂.

- Fully thyristorised closed loop feedback control enables remote control of Welding current and voltage for thyristorised models
- Arc conditioned feedback system ensures constant arc length, eliminating need for highly skilled welder.
- Instantaneous Arc Starting.
- All position welding possible. High metal deposition rate. High welding speed. Low Hydrogen content wires possible..
- Very wide range of metals, such as mild steel, stainless steel, carbon steel, aluminium and their alloys with proper consumables and gases can be welded.
- Preflow of shielding gas interlock. 4T function with crater control which eliminates defects like cracks, gas entrapments.
- Globule formation at the top end of wire eliminated.
- Built in solid state devices protects the machine against single phasing and thermal overloading. Lamp indication for fault is provided on front panel.
- Facility for power source to trip in the event of shorting of output terminals accidentally for a period beyond the preset time, can be provided.

TECHNICAL SPECIFICATIONS

	STEP CONTROL			STEPLESS CONTROL		
A. Power Sources : Models	TCP 250	TCP 400	TCP 600	CPT 250	CPT 400	CPT 600
Input Supply Voltage	380to 415V, 3Ph, 50 Hz					
Max Welding Current (A)	250	400	600	250	400	600
Open Circuit Voltage (V) D.C.	22-28	18-54	18-54	36	54	68
No. of Steps (No.)	4	25	36	Stepless Thyristorised Control		
Max. Welding Current (A) :						
at 60% D.C.	250	400	600	250	400	600
at 100% D.C.	195	310	465	195	310	470
Insulation Class	H	H	H	H	H	H
Cooling	Forced Air			Forced Air		
Dimensions (WxDxH) mm approx.	600x900x800	650x1000x900	800x1100x900	600x900x800	650x1000x900	800x1100x900
Approx Weight (kgs.)	145	200	310	175	200	310
B. Wire Feeders Models	TC2/TC4 (2Roll or 4 Roll)			TC2/TC4 (2 Roll or 4 Roll)		
Wire Dia (mm) - Mild Steel	0.8 to 1.2	0.8 to 1.6	0.8 to 1.6	0.8 to 1.6	0.8 to 2.4	0.8 to 2.4
Wire Dia (mm) - Alu. & S. S.	1.2 to 1.6	1.2to1.6	1.2 to 1.6	1.2 to 1.6	1.2 to 1.6	1.2 to 1.6
Wire Drive Motor	D.C.	D.C.	D.C.	Serve Control Motor		
Drive System	2 roll or 4 roll			2 roll or 4 roll		
Wire feed speed control	Thyristorised			Thyristorised		
Wire feed speed m/min	1.0 to 18.5	1.0 to 18.5	1.0 to 18.5	1.0 to 18.5	1.0 to 18.5	1.0 to 18.5
Weight without spool (kg.)	7.0	8.0	9.0	7.0	8.0	9.0
C. Torch Models	TDG 250		TDG 400		TDG 600	
Rated current capacity at 60% duty cycle for CO ₂	250 A		400 A		600 A	
for MIG	200 A		300 A		500 A	
Cooling	Gas		Gas		Water	
Standard length (mtrs.)	3 mtrs.					

* All torches are supplied with accessories like, contact tips, nozzles etc. for Hardwires.

**Further details can be supplied on request.

OPTIONAL ACCESSORIES

1. Pressure regulator with flowmeter.
2. Co₂ Heater.
3. Gas or Water cooled torches with additional cable length.



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