



## PROTIG 400 AC/DC



TIG / STICK Welding Power Source

### Industrial Applications:

Pipe & Tube Fabrication  
Aerospace  
Aluminum Ship Repair  
Maintenance & Repair

### Processes:

TIG (GTAW)  
Pulse TIG (GTAW-P)  
Stick (SMAW)

**Input Power:** 3 Phase

**Amperage Range:** 15-400 Amps

**Rated Output DC TIG:** 400A @ 60%

**AC TIG:** 380A @ 60%

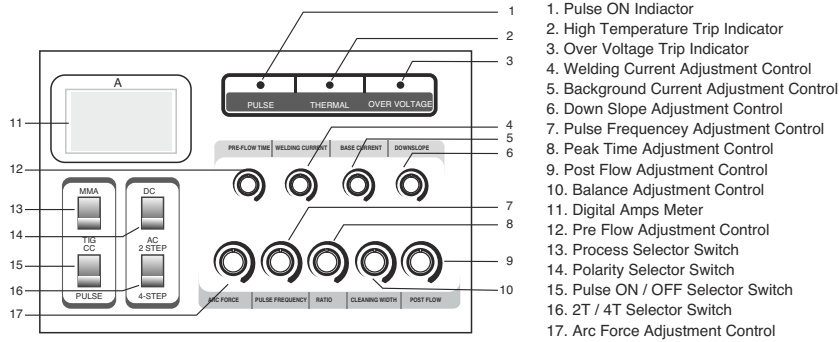
**Weight:** 76 kg



### Features Description

- IGBT Inverter AC-DC HF TIG / Pulse TIG / Stick Welder
- Input Voltage Compensation of  $\pm 15\%$
- HF & Lift Arc Start Ignition
- Stepless Current Setting
- Digital Display for Amperage
- 2T / 4T adjustment available on panel
- Full features for TIG welding available on Panel
- Power & Thermal Protection Indicator on Panel
- PC Boards are coated for protection against contaminants
- Suitable for welding with Basic, Rutile & Cellulosic Electrodes

## Control Panel



1. Pulse ON Indicator
2. High Temperature Trip Indicator
3. Over Voltage Trip Indicator
4. Welding Current Adjustment Control
5. Background Current Adjustment Control
6. Down Slope Adjustment Control
7. Pulse Frequency Adjustment Control
8. Peak Time Adjustment Control
9. Post Flow Adjustment Control
10. Balance Adjustment Control
11. Digital Amps Meter
12. Pre Flow Adjustment Control
13. Process Selector Switch
14. Polarity Selector Switch
15. Pulse ON / OFF Selector Switch
16. 2T / 4T Selector Switch
17. Arc Force Adjustment Control

## Package



## Main Specification

ITEM		PROTIG 400 AC/DC
<b>Input Supply</b>		
Voltage / Frequency	VOLTS / Hz	415, ±20% / 50 - 60
Phase	NO.	3
Power @ 60% Duty Cycle	Kva	18.3
Efficiency	%η	85
<b>Output Power</b>		
Open Circuit Voltage	VOLTS	80
Welding Current Range	AMPS	15 - 400
Welding Current (at 40°C & 10 Min)		
At 60% Duty Cycle - DC TIG	AMPS	400
At 60% Duty Cycle - AC TIG	AMPS	380
At 100% Duty Cycle - DC TIG	AMPS	310
At 100% Duty Cycle - AC TIG	AMPS	295
<b>Pulse Tig Parameters</b>		
% On Time	%	10 - 90
Pulse Frequency	Hz	.5 - 5
Background Current	AMPS	20 - 400
<b>General</b>		
Current Upslope Time	SEC	0 - 10
Current Downslope Time	SEC	0 - 6
Gas Pre Flow Time	SEC	0 - 6
Gas Post Flow Time	SEC	1 - 10
Protection	CLASS	IP21S
Insulation	CLASS	H
Cooling	TYPE	FAN, AIR FORCED
Dimension (L X W X H)	mm	655 x 325 x 670
Weight	Kg	60
<b>Package Information</b>		
Standard Power Source		
Weld Cable With Electrode Holder		
Earth Cable With Earth Clamp		
<b>Warranty: One Year</b>		
In view of continuous development, Praxair India Private Limited reserves the right to modify / change the design and / or specification without any prior notice.		



© Copyright 2014 Praxair Technology, Inc.  
All rights reserved.

Praxair, the flowing Airstream design, Making our planet more productive, are trademarks or registered trademarks of Praxair Technology, Inc. in the United States and/or other countries. Other trademarks used herein are the registered trademarks of their respective owners.

Praxair India Private Limited,  
Mercury 2B Block, 6<sup>th</sup> Floor,  
Prestige Technology Park, Outer Ring Road,  
Marathahalli, Bangalore - 560 103.

www.praxair.co.in  
info\_india@praxair.com

Date 1/15  
P-020103

Telephone:  
+91 80 3069 1000 - 03

Fax:  
+91 80 2844 0156