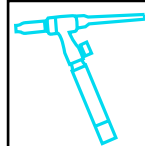


WELDING EQUIPMENT GAS TUNGSTEN ARC WELDING



SECTION ONE

TRANSARC 131i/Tool Box Kit

● Light Industrial



130 AMP

CC

DC

1 PHASE

240 V

SPECIFICATIONS

SUPPLY VOLTAGE:

220/240 volt

1 phase 50Hz

SUPPLY LEAD AND PLUG:

10 amp

COOLING:

Fan Cooled

MINIMUM RECOMMENDED GENERATOR:

8.0 kVA for maximum welding current

WELDING CURRENT RANGE:

5 - 130 amps

DUTY CYCLES:

40% @ 130 amps (STICK)

50% @ 130 amps (TIG)

DUTY CYCLE TEST PERIOD:

5 & 10 minutes

POWER SOURCE WEIGHT:

5.2kg

POWER SOURCE DIMENSIONS:

H245mm x W110mm x D205mm



The Transarc 131i Tool Box Kit is the complete portable, professional kit. Including the lightweight 130 amp inverter power plant that will run from any 10 amp standard domestic outlet. This unit provides the latest in inverter technology with excellent DC welding characteristics for manual arc welding with the capabilities of scratch start TIG welding.

Features:

- ▲ Designed to operate on a 10 amp 240 volt power point
- ▲ Compact, lightweight & portable
- ▲ Excellent DC welding characteristics
- ▲ Infinitely Variable Welding Current Control from 5 to 130 amps

Transarc 131i Plant Contents:

Transarc 131i Power Source, Operating Instructions, Primary lead for factory preset supply voltage, complete lead set, helmet, chipping hammer and wire brush in a robust tool box.

Transarc 131i Power Source Contents:

Transarc 131i Power Source, Operating Instructions, Primary lead for factory preset supply voltage, 25mm² dinse connectors.

Ordering Information:

Transarc 131i/ Plant (Tool Box Kit) Part No. 625757

Transarc 131i (Power Source only) Part No. 625755

Refer to Easyfind page 22 for optimum setup

Recommended Process:

DC Stick

DC GTAW – Scratch Start

Optional Accessories:

Hiderok Helmet	Part No. 453833
Wire Brush (4 row)	Part No. 646363
TIG Torch Accessories Kit	Part No. BGSAK2
150 amp TIG Torch	Part No. 305710402
Torch Gas Hose Kit (includes fittings)	Part No. 700433
Flowmeter / Regulator	Part No. 301526
TIG welding kit (refer page 118)	Part No. 700706

*Supplied with Plant Contents
For the full accessory range turn to the accessories section of this book.

TRANSARC 161i/Tool Box Kit

● Light Industrial



160 AMP

CC

DC

1 PHASE

240 V

SPECIFICATIONS

SUPPLY VOLTAGE:

220/240 volt

1 phase 50Hz

SUPPLY LEAD AND PLUG:

15 amp

COOLING:

Fan Cooled

MINIMUM RECOMMENDED GENERATOR:

8.0 kVA for maximum welding current

WELDING CURRENT RANGE:

5 - 160 amps

DUTY CYCLES:

50% @ 160 amps (STICK)

60% @ 160 amps (TIG)

DUTY CYCLE TEST PERIOD:

5 & 10 minutes

POWER SOURCE WEIGHT:

5.4kg

POWER SOURCE DIMENSIONS:

H290mm x W130mm x D215mm

NEW



The Transarc 161i Tool Box Kit is the complete portable, professional kit. Including the lightweight 160 amp inverter power plant that will run from any 15 amp standard domestic outlet. This unit provides the latest in inverter technology with excellent DC welding characteristics for manual arc welding with the capabilities of scratch start TIG welding.

Features:

- ▲ Designed to operate on a 15 amp 240 volt power point
- ▲ Compact, lightweight & portable
- ▲ Excellent DC welding characteristics
- ▲ Infinitely Variable Welding Current Control from 5 to 160 amps

Transarc 161i Plant Contents:

Transarc 161i Power Source, Operating Instructions, Primary lead for factory preset supply voltage, complete lead set, helmet, chipping hammer and wire brush in a robust tool box.

Transarc 161i Power Source Contents:

Transarc 161i Power Source, Operating Instructions, Primary lead for factory preset supply voltage, 25mm² dinse connectors.

Ordering Information:

Transarc 161i/ Plant (Tool Box Kit) Part No. 625801

Transarc 161i (Power Source only) Part No. 625800

Refer to Easyfind page 22 for optimum setup

Recommended Process:

DC Stick

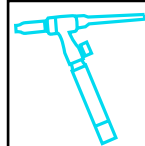
DC GTAW – Scratch Start

Optional Accessories:

Hiderok Helmet	Part No. 453833
Wire Brush (4 row)	Part No. 646363
TIG Torch Accessories Kit	Part No. BGSAK2
150 amp TIG Torch	Part No. 305710402
Torch Gas Hose Kit (includes fittings)	Part No. 700433
Flowmeter / Regulator	Part No. 301526
TIG welding kit (Refer page 118)	Part No. 700706

*Supplied with Plant Contents
For the full accessory range turn to the accessories section of this book.

WELDING EQUIPMENT GAS TUNGSTEN ARC WELDING



TRANSTIG 200Pi

● Light Industrial



200 AMP



DC

1 PHASE

240 V

SPECIFICATIONS
SUPPLY VOLTAGE:
 240 volt
 1 phase 50Hz
MINIMUM RECOMMENDED GENERATOR:
 10 kVA for maximum welding current

WELDING CURRENT RANGE:
 5-200 amps (TIG)
 5-160 amps (STICK)
SUPPLY PLUG AND LEAD:
 15 amp

DUTY CYCLES:
 20% at 200 amps
DUTY CYCLE TEST PERIOD:
 5 & 10 minutes

PACKED WEIGHT:
 8kg
POWER SOURCE DIMENSIONS:
 H260mm x W130mm x D340mm



Part No. 700720



Part No. 700730

The Transtig 200Pi is a brand new release, 240 volt, 15 amp, full digital control, DC stick-lift TIG-HF TIG power source. With features like high frequency start, lift arc start, up/down slope, pulse DC, repeat (latch) function, DC pulse and spot in HF TIG mode you've got the ultimate unit designed for precision TIG welding of stainless steel and other DC weldable materials. The unit also has an integrated Voltage Reduction Device (VRD) for improved operator safety.

Features:

- ▲ Standards compliant integrated Voltage Reduction Device
- ▲ Embedded micro processor with digital controls
- ▲ Exceptional DC welding characteristics
- ▲ All welding parameters are adjustable
- ▲ Easy to use digital display and panel controls
- ▲ HF starts TIG, Lift TIG & Stick weld operations
- ▲ 2T, 4T with up/down slope and repeat modes
- ▲ Self diagnostic control
- ▲ Single index control knob
- ▲ Compact, lightweight & portable

Transtig 200Pi Plant Contents:

Transtig 200Pi Power Source, product bag, two dinse plug connectors, shoulder strap, 8 pin plug, inlet gas fitting, operation manual, TIG torch, accessory torch kit, regulator/flowmeter, gas hose, electrode & work leads

Transtig 200Pi Power Source Contents:

Transtig 200Pi Power Source, two dinse plug connectors, shoulder strap, 8 pin plug, inlet gas fitting, operation manual

Ordering Information:

Transtig 200Pi Plant Part No. 700730

Transtig 200Pi Power Source Part No. 700720

Refer to Easyfind page 22 for optimum setup

Recommended Process:

DC GTAW - HF Start TIG, Lift TIG, TIG pulse
 DC MMAW - Stick

Optional Accessories:

Slide Control	Part No. OTD10/4013
Hand Pendant	Part No. OTD10/4014
Foot Control	Part No. OTD10/4016
Hiderok Helmet	Part No. 453833
Dinse Plug Connector	Part No. 705152*
TIG torch	Part No. 518710402*
Torch Accessories Kit	Part No. BGSAK2*
Gas Hose	Part No. 700433*
Flowmeter / Regulator	Part No. 301526*
Lead Set (5M)	Part No. 646323*
8 Pin Plug	Part No. UOA706900

*Supplied with Plant Contents

Technical TIP

TIG ELECTRODE POLARITY: Connect the TIG torch to the -/ TORCH terminal and the work lead to the +/ TORCH terminal for direct current straight polarity. Direct current straight polarity is the most widely used polarity for DC TIG welding. It allows limited wear of the electrode since 70% of the heat is concentrated at the work piece.

WELDING PARAMETERS FOR ALUMINIUM

Base Metal Thickness	Recommended Tungsten Electrode Type	AC Current for Aluminium	Tungsten Electrode Diameter	Filler Rod Dia. (if required)	Argon Gas Flow Rate Litres/min	Joint Type
1.0mm	Zirconated or Ceriated	30-45 35-50	1.0mm	1.6mm	5-7	Butt/Corner Lap/Fillet
1.2mm	Zirconated or Ceriated	40-60 45-70	1.0mm	1.6mm	5-7	Butt/Corner Lap/Fillet
1.6mm	Zirconated or Ceriated	60-85 70-95	1.6mm	1.6mm	7	Butt/Corner Lap/Fillet
3.2mm	Zirconated or Ceriated	125-150 130-160	2.4mm 3.2mm	2.4mm	10	Butt/Corner Lap/Fillet
4.8mm	Zirconated or Ceriated	180-225 190-240	3.2mm 4.0mm	3.2mm	10	Butt/Corner Lap/Fillet
6.4mm	Zirconated or Ceriated	240-280 250-320	4.0mm 4.8mm	4.8mm	13	Butt/Corner Lap/Fillet

WELDING PARAMETERS FOR STEEL

Base Metal Thickness	Recommended Tungsten Electrode Type	AC Current for Mild Steel	DC Current for Stainless Steel	Tungsten Electrode Diameter	Filler Rod Dia. (if required)	Argon Gas Flow Rate Litres/min	Joint Type
1.0mm	Zirconated or Ceriated	35-45 40-50	20-30 25-35	1.0mm	1.6mm	5-7	Butt/Corner Lap/Fillet
1.2mm	Zirconated or Ceriated	45-55 50-60	30-45 35-50	1.0mm	1.6mm	5-7	Butt/Corner Lap/Fillet
1.6mm	Zirconated or Ceriated	60-70 70-90	40-60 50-70	1.6mm	1.6mm	7	Butt/Corner Lap/Fillet
3.2mm	Zirconated or Ceriated	80-100 90-115	65-85 90-110	1.6mm	2.4mm	7	Butt/Corner Lap/Fillet
4.8mm	Zirconated or Ceriated	115-135 140-165	100-125 125-150	2.4mm	3.2mm	10	Butt/Corner Lap/Fillet
6.4mm	Zirconated or Ceriated	160-175 170-200	135-160 160-180	3.2mm	4.0mm	10	Butt/Corner Lap/Fillet