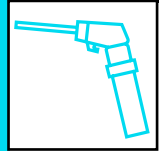

TRANSTIG 160 AC/DC/HF

Industrial

160 AMP | CC | H F | AC DC | 1 PHASE | 240 V

SPECIFICATIONS

SUPPLY VOLTAGE:
220/240 volt
1 phase 50Hz

SUPPLY PLUG AND LEAD:
15 amp

MINIMUM RECOMMENDED GENERATOR:
8.0 kVA for maximum welding current

WELDING CURRENT RANGE:
5 - 160 amps

DUTY CYCLES:
60% at 160 amps (STICK)
70% at 160 amps (TIG)

DUTY CYCLE TEST PERIOD:
5 & 10 minutes

POWER SOURCE WEIGHT:
17kg

POWER SOURCE DIMENSIONS (H X W X D):
H385mm x W230mm x D430mm

The Transarc 160 AC/DC/HF is an economical light weight, single phase, constant current power source incorporating the latest inverter technology to provide outstanding arc characteristics across a wide range of Manual Metal Arc Welding (MMAW) electrodes. It also features Electronic square wave AC HF Gas Tungsten Arc Welding (GTAW) and lift arc start (GTAW).

Features:

- **Designed to operate on a 15 amp 240 volt power point**
- **AC square wave and DC output**
- **Down slope**
- **Post flow**
- **Compact, lightweight & portable**
- **Excellent DC MMAW welding characteristics**
- **Anti-stick in MMAW mode**
- **Infinitely Variable Welding Current Control from 5 to 160 amps**
- **Overload protection**

Transtig 160 AC/DC/HF Power Source Contents:

Transarc 160 AC/DC/HF Power Source, 25mm² dinse connectors, Shoulder Strap, Operating Instructions, Primary lead for factory preset supply voltage, Gas Fitting and plug.

Ordering Information:

Transtig 160 AC/DC/HF **Part No. 700700**

Refer to Easyfind page 22 for optimum setup

Recommended Process:

DC Stick
AC Stick
DC GTAW - Lift Arc Start, HF Start
AC HF GTAW

Optional Accessories:

Manual Arc Lead Set	Part No. 646323
150 amp TIG Torch (4M)	Part No. 304710402
Remote Control	Part No. 700708
Remote Foot Control	Part No. 700709
TIG Pulse Module	Part No. 700710
Gas Connection 5/8-18RH	Part No. LP112
TIG Torch Accessories Kit	Part No. BGSAK2
Flowmeter / Regulator	Part No. 301526
Dinse Plug Connector	Part No. 705152
TIG Welding Kit (refer page 118)	Part No. 700707
Work Lead (3M)	Part No. 700638
4 Pin Plug	Part No. 700737
6 Pin & Earth Plug	Part No. 700738

For the full accessory range turn to the accessories section of this book.

TechnicalTIP

ARC WELDING TECHNIQUE

A Word to Beginners: For those who have not done any welding, the simplest way to commence is to run beads on a piece of scrap plate. Use mild steel plate about 6.0mm thick and a 3.2mm electrode. Clean any paint, loose scale or grease off the plate and set it firmly on the work bench so that welding can be carried out in the downhand position. Make sure that the work clamp is making good electrical contact with the work, either directly or through the work table. For light gauge material, always clamp the work lead directly to the job, otherwise a poor circuit will probably result.

The Welder: Place yourself in a comfortable position before beginning to weld. Get a seat of suitable height and do as much work as possible sitting down. Don't hold your body tense. A taut attitude of mind and a tensed body will soon make you feel tired. Relax and you will find that the job becomes much easier. You can add much to your peace of mind by wearing a leather apron and gauntlets. You won't be worrying then about being burnt or sparks setting alight to your clothes.

Place the work so that the direction of welding is across, rather than to or from, your body. the electrode holder lead should be clear of any obstruction so that you can move your arm freely along as the electrode burns down. If the lead is slung over your shoulder, it allows greater freedom of movement and takes a lot of weight off your hand. Be sure the insulation on your cable and electrode holder is not faulty, otherwise you are risking an electric shock.

Striking the Arc: Practice this on a piece of scrap plate before going on to more exacting work. You may at first experience difficulty due to the tip of the electrode "sticking" to the work piece. This is cause by making too heavy contact with the work and failing to withdraw the electrode quickly enough. A low amperage will accentuate it. This freezing-on of the tip may be overcome by scratching the electrode along the plate surface in the same way as a match is struck. As soon as the arc is established, maintain a 1.6mm to 3.2mm gap between the burning electrode end and the parent metal. Draw the electrode slowly along as it melts down.

Another difficulty you may meet is the tendency, after the arc is struck, to withdraw the electrode so far that the arc is broken again. A little practice will soon remedy both of these faults.

Striking an arc