

HERMAL ARC®



AC/DC INVERTER ARC WELDER

The Thermal Arc® 400GTSW delivers both AC and DC welding power using proven IGBT power transformation technology to provide reliable service and unmatched arc control. This unit can provide stable arc characteristics down to 10 amps on the AC side and 5 amps on the DC side.

The 400GTSW uses a unique design that provides a true square wave (AC) GTAW operation with no continuous high frequency and power input draw as much as 50% under standard square wave machines.

Standard on the 400GTSW are AC balance control, AC frequency control, a built-in TIG Pulser, slope control, gas preflow and postflow, gas solenoid, hot start, and arc starting with either H.F. or lift TIG.

FEATURES

- Heavy duty IGBT inverter design
- AC welding with no continuous H.F.
- 40% duty cycle at 400 amps (60% at 325 amps)
- Built to NEMA, CSA, IP-23S and IEC 974 standards
- Single output range
- AC balance control and frequency control
- Reduced current draw (29 amps at 400 amp output)
- 208/230/460 volt, single/three phase input with smart link
- 115 volt duplex outlet (1.5 KVA)

RECOMMENDED PROCESSES

GTAW (AC and DC) with H.F. Start and Lift TIG Starting

Excellent low end characteristics

SMAW (AC and DC)

Excellent with low hydrogen, stainless steel and maintenance electrodes.

ORDERING INFORMATION

Catalog No. 10-1042 208/230/460 volt-single/three phase

400GTSW



**400 AMP
AC/DC
SQUARE WAVE
INVERTER ARC
WELDING
POWER SUPPLY**

*Anything less is
yesterday's technology*



Applications

- Aircraft/Airframe
- Boat Marine
- Thin gauge aluminum
- Any AC GTAW application with:
 - limited input power
 - difficulties with H.F. interference
- Small fabrication shops
- Automated AC GTAW

Specifications

400GTSW	1 phase
Rated Output	
Amps	400 A
Volts	40 V
Duty Cycle	40%
Output Range	
Amps DC	5 - 470 A
Amps AC	10 - 470 A
Volts	10 - 40 V
Maximum OCV	69 V
Input Hz	50/60 Hz
Dimensions	
Width	16.25 in / 410mm
Length	20.75 in / 529mm
Height	32 in / 810mm
Weight	220 lbs/100kg

CATALOG NO. 10-1042			
Input 50/60 Hz	Load Characteristics		
	400 A	300 A	No Load
208 V 1 ph	119	84	3.7
208 V 3 ph	64	46	2.9
230 V 1 ph	107	76	3.3
230 V 3 ph	58	41	2.6
460 V 1 ph	54	38	1.7
460 V 3 ph	29	21	1.3
380 V 3 ph	35	25	1.6
415 V 3 ph	32	23	1.4
KW	17.5	11.5	.34
KVA	25	17.4	.72

Options/Accessories

- Foot Control - 25' (Cat. #10-2007)
- Foot Control - 15' (Cat. #10-2008)
- Amp Control
 - *5/8 - 7/8" (Cat. #10-2002)
 - *7/8 - 1-1/8" (Cat. #10-2003)
 - *1-1/8 - 1-3/8" (Cat. #10-2004)
 - *Designates torch handle size
- Water Cooled TIG Block (Cat. #10-2027)
(fits 7/8"-14 left hand thread)
- TIG Starter Kit (Cat. #10-2700)
 - Tweco® 150 Amp Air-Cooled TIG Torch w/Gas Valve
 - Tweco 300 Amp Ground Clamp
 - Tweco Electrode Holder
 - Tweco TIG/DIN Hook-up Kit
 - Victor Flowmeter/Regulator with Gas Hose
- Stick Kit (Cat. #10-2703)
 - Tweco 300 Amp Ground Clamp
 - Tweco Electrode Holder

Authorized Distributor



Thermal Dynamics Corp., located at West Lebanon, NH, is an ISO 9001 registered manufacturer.



WORLD HEADQUARTERS: Suite 300, 16052 Swingley Ridge Road • St. Louis, MO 63017 • 636-728-3000

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