

# LIGHT DUTY DC TIG EQUIPMENT

## Tradestig DC150 & DC220



**The Tradestig DC150 and DC220 are TIG welding power sources, which can also be used for MMA welding. They can be used with direct current (DC).**

These compact units with their impact resistant polymer cases, are light and easy to carry. However the compact design does not compromise cooling. Large heat sinks provide a cool running machine and the carefully thought out internal design helps to protect the sensitive internal components from dust and dirt to give a longer working life, even when used in harsh industrial environments. Compliance with IP23 gives you the assurance that these new Tradestigs can be used out of doors – even in the rain.

- Compact and robust design, fully IP23 compliant
- Capable of producing quality TIG welds in alloyed, non alloyed and stainless steel
- Weld parameters presented on a clear easy to use control panel
- Pulsed TIG and Micro pulse facilities available on the on Tradestig 220
- Both machines offer true MMA welding characteristics with hot start and arc force setting
- ArcPlus™ II provides an intense yet smooth and stable arc for MMA welding

For TIG welding with the Tradestig DC150 all you need to do is set the plate thickness on the control panel and the machine will do the rest, however you can still control the welding current, slope down and post-gas manually.

With the more advanced Tradestig DC220 you can also weld pulsed TIG, giving you better control of the heat input and with the micro pulse function you can set pulse times down to 0.001 of a second. With two memories, you can store all your settings and switch between the memories from the control panel or from the torch trigger, even when welding. You can also set slope up/down, post-gas and connect a remote control. The control panels of both machines are easy to set even when wearing welding gloves.

## Technical Specification

	Tradestig DC150	Tradestig DC220
<b>Mains Voltage</b>	230V ± 10%, 1~50/60Hz	230V ± 10%, 1~50/60Hz
<b>Mains Supply</b>	Z <sub>max</sub> 0.35 ohm	Z <sub>max</sub> 0.31 ohm
<b>Primary current</b>		
I <sub>max</sub> TIG	14A	24A
I <sub>max</sub> MMA	22A	25A
<b>No-load power demand when in the energy saving mode, 6.5min after welding</b>	30W	30W
<b>Setting range</b>		
TIG	3 - 150A	3 - 220A
MMA	4 - 150A	4 - 170 A
<b>Ignition Voltage (U<sub>pk</sub>)</b>	11.5kV	11.5kV
<b>Permissible load at TIG</b>		
100% duty cycle	110A/14.4V	110A/14.4V
60% duty cycle	120A/14.8V	150A/16V
25% duty cycle	150A/16V	-
20% duty cycle	-	220A/18.8V
<b>Permissible load at MMA</b>		
100% duty cycle	90A/23.6V	110A/24.4V
60% duty cycle	100A/24V	130A/25.2V
25% duty cycle	150A/26V	170A/26.8V
<b>Power factor at maximum current</b>		
TIG	0.98	0.99
MMA	0.99	0.99
<b>Efficiency at maximum current</b>		
TIG	77%	75%
MMA	80%	81%
<b>Open circuit voltage TIG with VRD</b>	55-60V <35V	55-60V <35V
<b>Open circuit voltage MMA with VRD</b>	55-60V < 35V	55-60V < 35V
<b>Operating temperature</b>	-10 to +40°C	-10 to +40°C
<b>Transportation temperature</b>	-20 to +55°C	-20 to +55°C
<b>Constant sound pressure in open circuit</b>	< 70 dB(A)	< 70 dB(A)
<b>Dimensions L x W x H</b>	418 x 188 x 208mm	418 x 188 x 208mm
<b>Weight</b>	9.2kg	9.4kg
<b>Shielding gas</b>	All types intended for TIG welding	All types intended for TIG welding
max pressure	5 bar	5 bar
<b>Insulation class transformer</b>	H	H
<b>Enclosure class</b>	IP23	IP23
<b>Application class</b>	S	S



## Ordering Information

Description	Part No
<b>Tradestig DC 150 Package</b>	<b>0479100228</b>
<b>Comprises:-</b>	
Tradestig DC150 Power Source	0460441882
TG 153 TIG torch 3.8m leads	0701415291
TG 153 torch accessory kit	0701410208
Adaptor 1/4 - 1/8 BSP TIG torch	0701415248
Vantage flowmeter 14L/min	0701300021
Saffire 300 series 1ec Ar2	
TIG regulator	0701282689
Instruction manual	
<b>Tradestig DC 220 Package</b>	<b>0479100229</b>
<b>Comprises:-</b>	
Tradestig DC 220 Power Source	0460441883
TG 203 TIG torch 3.8m leads	0701415022
TG 203 torch accessory kit	0701410207
Adaptor 1/4 - 1/8 BSP TIG torch	0701415248
Vantage flowmeter 14L/min	0701300021
Saffire 300 series 1ec Ar2	
TIG regulator	0701282689
Instruction manual	

## Typical areas of application

Repair & maintenance, garages, body shops, aerospace, sheet metalwork and process engineering.