

TIG 210E Pulse AC/DC

EASY TO USE AND VERSATILE. IDEAL FOR WELDING STEEL, STAINLESS STEEL AND ALUMINIUM.

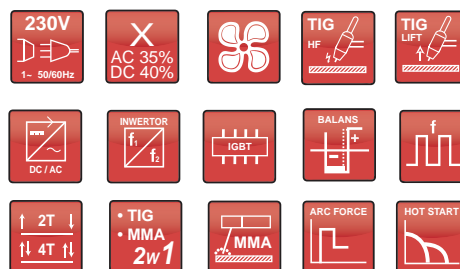
PRELIMINARY INFORMATION

SPARTUS Easy TIG 210E Pulse AC/DC. It is a modern digitally controlled inverter welding machine, constructed on the basis of IGBTs. Allows welding TIG AC/DC and MMA AC/DC modes. It is powered with single-phase 230V source power.

DESCRIPTION

Versatile unit for a wide range of applications. It has a simple-to-use digital control panel that provides instant access to the welding machine's functions. Allows to weld steel, stainless steel (TIG DC pulse welding - allows to weld thin elements). TIG AC welding function allows to weld aluminium and its alloys. Welder is ready to work with TIG torches equipped with remote control (in the handle).

SPARTUS Easy TIG 210E Pulse AC / DC impresses small dimensions and lightweight of just 8,7kg. It is ideal for maintenance, assembly, as well as production works.



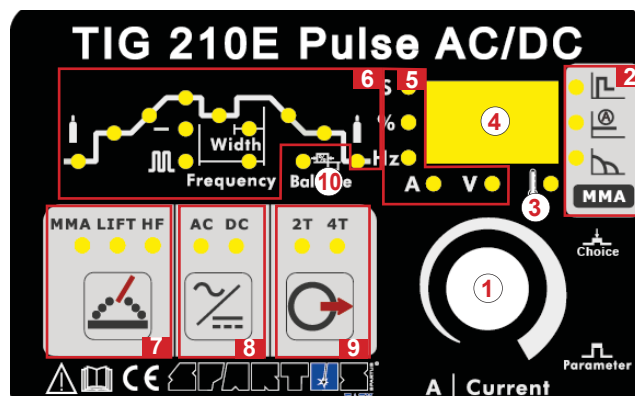
EXAMPLES OF USE

- portable repair,
- workshop,
- maintenance,
- constructions.

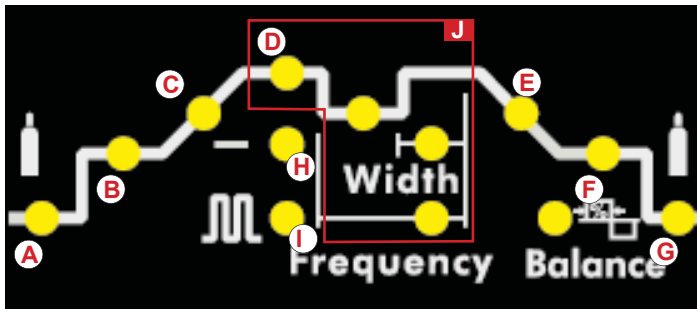
TECHNICAL PARAMETERS

Input	~1 x 230V ±10% 50/60 Hz
Welding Current TIG [A]	AC 10 – 200 DC 10 – 170
Duty cycle TIG [%]	AC 35 [200A] DC 40 [170A]
TIG PARAMETERS	
Start Amps, End Amps	✓
Gas pre flow [s]	0 – 2
Up slope [s]	0 – 10
Down slope [s]	0 – 10
Gas post flow [s]	0 – 10
TIG PULSE mode	tak
Pulse Amps [A]	[AC] 10 – 200 [DC] 10 – 170
Base Amps [A]	[AC] 10 – 200 [DC] 10 – 170
Pulse Width [%]	5 – 95
Pulse frequency [Hz]	0,5 – 200
AC Wave Forms	Square
AC balance [%]	-5 – +5
2T/4T Control	✓
Arc ignition	LIFT / HF
Output remote control	
MMA welding mode [AC/DC]	✓
Welding current MMA [A]	AC 10 – 170 DC 10 – 170
Duty cycle MMA [%]	AC 40 [170A] DC 40 [170A]
Hot Start range [%]	0 – 100
Arc Force range [%]	0 – 100
No-load voltage [V]	52
OTHER	
Current consumption [A]	22 TIG DC / 25 TIG AC / 40 MMA
Power factor (cosφ)	0,6
Efficiency η [%]	85
Insulation class	H
Protection class	IP23
Weight [kg]	8,7
Dimensions [mm]	450 x 135 x 230

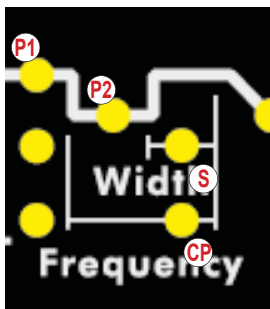
FUNCTION PANEL



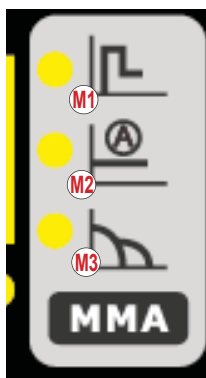
1. Selection button and knob of welding parameters
2. MMA welding parameters
3. Abnormal indicator
4. Digital meter
5. Indicators inform the units that are shown on the display
S – the time in seconds
% – percentage
Hz – frequency in Hertz
V – voltage Volt
6. A diagram of TIG parameters
7. Welding method:
MMA – manual metal Arc Welding
LIFT – TIG welding with arc ignition by friction
HF – TIG welding with high frequency arc ignition (contactless)
8. Selection of welding:
AC – AC welding
DC – DC welding
9. Operating mode:
2T – TIG 2T welding mode
4T – TIG 4T welding mode
10. AC balance (only in TIG AC mode)



- A. Pre-gas. Gas pre-flow time. (2T/4T)
- B. Starting current (4T)
- C. Up slope time. (2T/4T)
- D. Welding current. (2T/4T)
- E. Down slope time. (2T/4T)
- F. Ending current (4T)
- G. Post-gas. Gas post-flow time. (2T/4T)
- H. Mode selection: TIG welding (no pulse)
- I. Mode selection: TIG pulse welding
- J. Adjusting the parameters of pulsed current. Active for TIG pulse welding mode



- P1 Peak amps
- P2 Base amps
- CP Pulse frequency
- S Pulse width



- M1 HOT START
- M2 Welding current [A]
- M3 Arc Force

STANDARD EQUIPMENT

- 3 meter work clamp
- Gas hose
- User's manual



PACKAGE EQUIPMENT

- 3 meter work clamp
- Gas hose
- TIG torch SPARTUS Easy 26 4m
- User's manual

