

## INVA TIG DIGITAL SERIES

INVA TIG STANDARD DIGITAL & INVA PULSETIG DIGITAL

INVA TIG 300 S DIGITAL/INVA TIG 400 S DIGITAL / INVA TIG 300 P DIGITAL /INVA TIG 400P DIGITAL



### Beneficial Features

- Single Knob control for hassle free operation.
- Easy program saving and retrieval.
- Excellent crater control function.
- Available in 2T/4T/SPOT modes.
- Supports TIG, MMA, PULSE TIG.
- Both Pulse Time and Pulse Frequency adjustment is available for Superior quality welding result.
- Digital indication of Error for easy fault detection.
- Software up gradation can be done for critical applications.

### INPUT



### OUTPUT

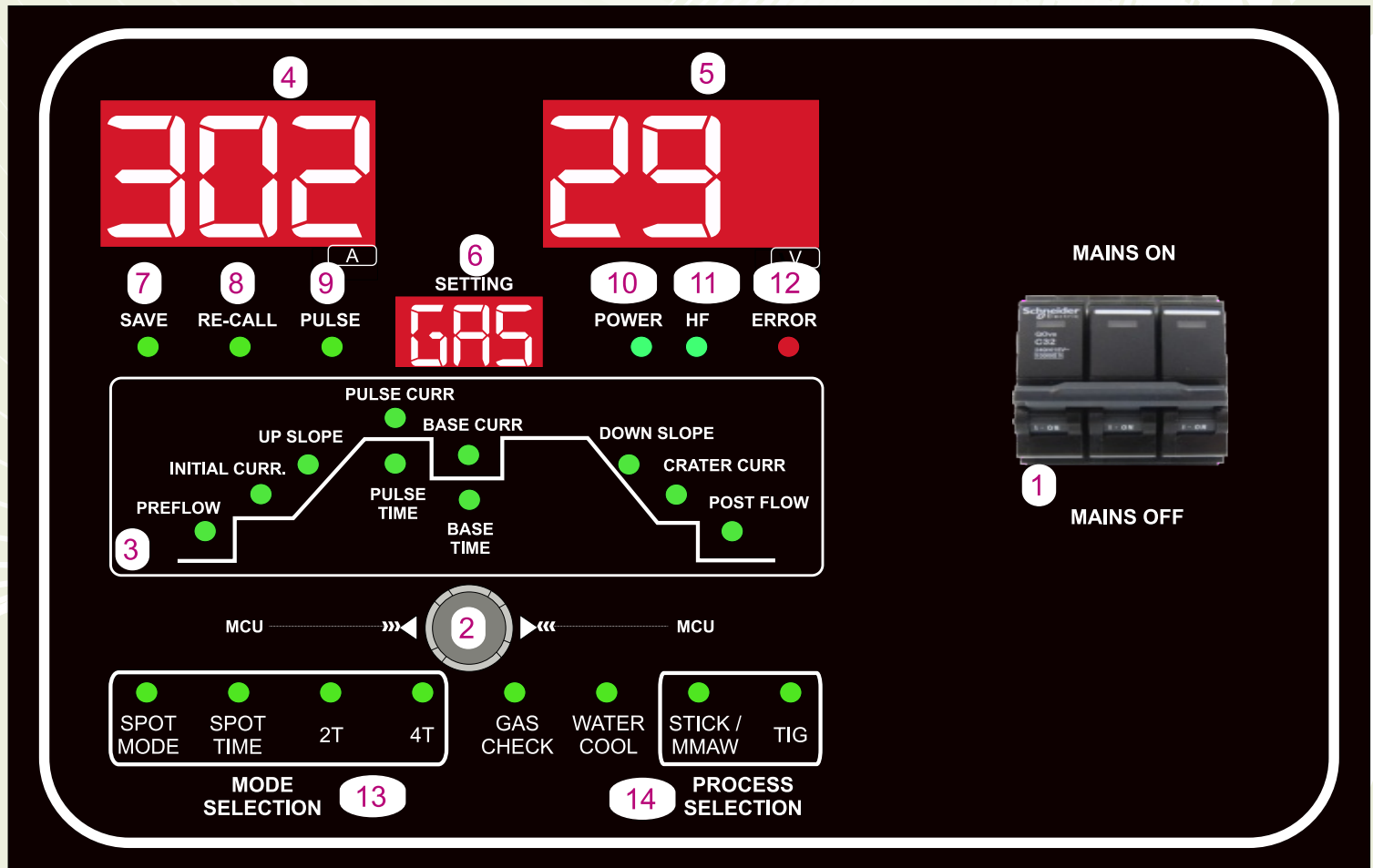


### BUILT IN FUNCTIONS FOR HIGH QUALITY TIG WELDING

- Soft switch technology with improved IGBT switching.
- Robust and sturdy design.
- TIG, PULSETIG and MMAW welding facility.
- Smooth and 100% Arc striking suitable for automation.
- PULSETIG facility to minimize the job distortion.
- Gas Controlling system.
- Adjustable up-slope & down-slope for welding current.
- Built-in Over voltage, Under Voltage, Over Temperature, Phase failure protection.
- Highly reliable power devices.

*Excellent Welding for Higher Performance...*

# ACTIVE DIGITAL INTERFACE



## DETAILS:

- 1 - MCB TO SWITCH ON/OFF THE MACHINE
- 2 - MCU (MASTER CONTROL UNIT) WHICH ENABLES THE USER TO CHOOSE & EDIT EACH PARAMETERS.
- 3 - CURRENT AND GAS CONTROL PANEL (TO SELECT (BY ROTATING MCU) & EDIT (BY PRESSING MCU) OF VARIOUS PARAMETERS.
- 4 - DIGITAL DISPLAY OF CURRENT
- 5 - DIGITAL DISPLAY OF VOLTAGE
- 6 - SETTING DISPLAY (THIS SHOWS THE SETTING VALUES OF PARAMETERS LIKE PRE FLOW TIME, POST FLOW TIME, PULSE CURRENT, BASE CURRENT ETC)
- 7 - SAVE THE PROGRAMS (IT CAN SAVE MIN. 20 JOBS)
- 8 - RECALL THE SAVED PROGRAMS
- 9 - INDICATION FOR PULSE ON OR, OFF.
- 10 - POWER ON INDICATION
- 11 - HF ON/OFF SIGNAL
- 12 - ERROR INDICATION (FOR FAULTS)
- 13 - MODE SELECTION (2T/4T/SPOT)
- 14 - PROCESS SELECTION (MMA / TIG)

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## TECHNICAL SPECIFICATIONS

	INVA TIG-300 P DIGITAL	INVA TIG-400 P DIGITAL
Input supply voltage (V/Hz)	3 Ph ~415VAC, 10%, 50/60 Hz	
Rated input power (KVA)	10.9	15.3
Rated input current (A)	16.6	23.2
Open circuit voltage (V)	75	75
Rated welding voltage (V)	22.6	26
Current Adj. Range (A)	10 ~ 300	10 ~ 400
Current Upslope time (Sec)	0.1 ~ 25.0	
Current Down slope time (Sec)	0.1 ~ 25.0	
Gas Pre-flow time (Sec)	0.1 ~ 25.0	
Gas Post-flow time (Sec)	0.1 ~ 25.0	
Spot welding time (Sec)	0.1 ~ 50.0	
Pulse current range (A)	10 ~ 300	10 ~ 400
Pulse frequency range (Hz)	10 ~ 200	
Pulse time range(sec)	0.1 ~ 10.0	
Base time range(sec)	0.1 ~ 10.0	
Background current range (A)	10 ~ 300	10 ~ 400
Background current time range (Sec)	0.005 ~ 2.5	
Rated duty cycle (%)	60 %	
Insulation Class	H	
Protection Grade	IP - 23	
(L x W x H) Dimensions (mm)	670 x 370 x 650	
Weight (Kg)	43	45

**NOTE: IN INVA TIG 300 S DIGITAL / INVATIG 400 S DIGITAL, FOLLOWING FEATURES WILL NOT BE AVAILABLE.**  
**1 . BASE CURRENT CONTROL 2. BASE TIME CONTROL 3. PULSE FREQUENCY CONTROL 4. PULSE TIME CONTROL**

### Optional Accessories



#### Remote Controller

**Adjustment** : 0 to maximum current continuous step less.  
**Cable Length** : 5 meters



#### Foot Controlled Remote



#### Water Cooling Unit

Suitable for Input Supply : 230 V  
 Tank capacity : 70 Ltrs.  
 Output signal : No Contacts  
 Over all size (LXWXH) : 700X400X550 mm

Along with built in Radiator, Cooling Fan, Pump Motor and Pressure Switch.



Gas cooled  
Model SR - 26



Water cooled  
Model WP - 18

STANDARD TIG



PULSE TIG

Additional software to enable PULSE TIG function in INVA TIG STANDARD DIGITAL machines.

### Standard Scope of Supply

Power source	01 No.
Gas cooled torch 4 mtr length of appropriate capacity	01 No.
Argon regulator cum flow meter	01 No.
Gas hose of 3 mtr Length	01 No.
Welding Cable for earthing of 3 mtr	01 No.

### Optional Accessories (At Extra Cost)

Remote control unit
Foot controlled remote
Water cooling unit( 70 Ltrs / 25 Ltrs )
Water cooled torch
Auto TIG feeding systems
Pulse TIG Software