

# SOHAL ELECTRIC WORKS

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## THYRISTORIED TIG WELDER FT 400

### Features :

### EASY OPERATE

1. Quick & easy startup.

Trigger the gun, weld starts without any delay.

2. High-quality welding.

\* Beautifully uniform bead appearance is produced.

\* Gives high penetration, a higher quality weld, free from poor fusion and blowhole, is produced.

\* The welder displays its performance to the fullest capacity when welding plates of different thickness, welding workpiece with the gap, and all-position welding, etc.

\* The number of pulses and pulse curr. can be changed fashion ly.

3. H.F. filter.

The H.F. filter, and highly reliable design protect its electronic circuits from inner and outer H.F. produced by some other equipments. Carefully throughout counter measurements have been taken to avoid H. F. The TIG welder exhibits an outstanding capability for welding work.



4. Line surge supres-sor.

TIG welding incorporates a surge supressor printed circuit board which gives extra protection to its transformer and circuitry.

5. High-quality welding results are obtained even if external conditions vary.

A thyristor and IC are employed in this welding machine, keeping the welding current

constant, even if external conditions, such as supply voltage, ambient temperature, arc length or cable length vary.

6. Pulse current adjusted to any point.

As the welding current (base curr.) points to any value from min. to max. pulse current also are set to any desired value.

7. Post flow variation.

The post flow variation facility saves shielding gas as well as increase the life of electrode.

**Applications:** DC TIG is mostly used for mild steel and stainless steel and also plays significant roll in welding of copper, copper alloy, titanium, titanium-nickel etc. Welding of a thin sheet with a thicker one is more easy with TIG welder than another type of welder.

**Operat-ability:** The FT 400 is an operator friendly version. The machine demands least adjustments made by operator. No extra setting like slopes and crater need to be set by operator.

**Specifications:**

ITEM	MODEL	FT 400	FT 500
Rated input voltage	V	400	400
Supply voltage	V	360/420	360/420
Rated frequency	Hz	50	50
Phase	Phase	3	3
Rated KVA	KVA	17	26
Rated duty cycle	%	60	60
Type of transformer	Type	Double star	Double star
Starting voltage	V	102	105
Maximum no-load voltage	V	46	48
On load voltage	V	16~22	16~24
Welding (Base) current	A	20~400	25~500
Pulse current	A	20~400	25~500
Pulse frequency	Hz	0.5~12	0.5~12
Pulse width	%	10~90	10~90
Cooling	Type	Forced air cool	Forced air cool
Insulation class	Class	Class H	Class H
High frequency generator	Type	Spark type	Spark type
Gas pre-flow	sec.	0.2	0.2
Gas post-flow	Sec.	2~12	2~12
Max. Dimensions (W X H X D)	mm	485 X 780 X970	496 X 851 X 900
Weight	Kg	160	185

\* All specification subject to change without prior notice in order to improvements.

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