Mobile Power Source for orbital tube welding
Program control by time or angular degrees calibrated in mm/min or inch/min

Comprehensive real-time welding data acquisition

Error-diagnostic system

Automatic welding head recognition

Built-in printer for welding procedure archiving and documentation

Ethernet compatible

Closed loop regulation of torch rotation and wire speed

Built-in Arc Voltage Control (AVC) and Torch Oscillation Control (OSC)

Torch gas control with safety valve and flow detection

Built-in closed loop water cooling system with safety valve for welding head and torch

Automatic welding procedure generation with an intelligent and intuitive user interface combined with the latest most reliable industrial electronics

Help for optimising welding procedures

Real time welding data acquisition

High precision inverter power source, compact design with built-in water cooling system for welding head and torch

Resulting from 50 years’ experience in mastering welding technologies

Offline & online programming with standard PC as well as optional touch screen

Compatible with standard peripheral equipment: printer, bar code reader, oxygen indicator etc.

Full function remote control 4-axes or 6-axes with welding program selection
Graphical User Interface (GUI):
Just follow the instructions!

- **Intuitive graphical interface**
  With multilingual “Help” menu for optimised welding programs

- **Synergic mode auto-programming**

- **Traceability and complete documentation of mechanical and electrical parameters**
### Technical Specification

<table>
<thead>
<tr>
<th>Welding method</th>
<th>TIG - Cold Wire</th>
<th>TIG - Hot Wire</th>
</tr>
</thead>
<tbody>
<tr>
<td>Input power</td>
<td>Three phase 400 V / 415 V ± 10 % - 50 / 60 Hz incl. multi voltage kit option from 200 V to 480 V</td>
<td>Three phase 400 V / 415 V ± 10 % - 50 / 60 Hz</td>
</tr>
<tr>
<td>Open circuit voltage</td>
<td>98 V</td>
<td>78 V</td>
</tr>
<tr>
<td>Insulation class</td>
<td></td>
<td>F</td>
</tr>
<tr>
<td>Protection class</td>
<td>IP 23S (touch screen closed)</td>
<td></td>
</tr>
<tr>
<td>Welding current range</td>
<td>5 to 300 A - constant or pulsed</td>
<td>5 to 520 A - constant or pulsed</td>
</tr>
<tr>
<td>Hot Wire current range</td>
<td>3 to 140 A</td>
<td></td>
</tr>
<tr>
<td>Welding current precision</td>
<td>± 1 A when I ≤ 100 A and ± 1 % when I &gt; 100 A</td>
<td></td>
</tr>
<tr>
<td>Duty cycle welding current</td>
<td>300 A / 60 % - 240 A / 100 %</td>
<td>≥ 520 A / 60 % - 420 A / 100 %</td>
</tr>
<tr>
<td>Duty cycle Hot Wire</td>
<td></td>
<td>140 A / 100 %</td>
</tr>
<tr>
<td>Motion controls</td>
<td>Torch rotation: constant or pulsed</td>
<td>Wire feeder: constant or pulsed / automatic wire retract</td>
</tr>
<tr>
<td></td>
<td>AVC - Arc Voltage Control</td>
<td>OSC - Torch Oscillation Control</td>
</tr>
<tr>
<td>Shielding gas control</td>
<td>Welding gas, backing gas, with flow safety valve</td>
<td></td>
</tr>
<tr>
<td>Power source cooling</td>
<td></td>
<td>Forced ventilation</td>
</tr>
<tr>
<td>Welding torch cooling</td>
<td>Built-in closed loop water cooling system with flow safety valve</td>
<td>External cooling system with internal flow safety valve</td>
</tr>
<tr>
<td>Display / recording (non-volatile) of real values during welding</td>
<td>Arc Voltage, welding current, electrode position in angular degrees, welding speed and wire speed</td>
<td></td>
</tr>
<tr>
<td>Real time data acquisition</td>
<td></td>
<td>Hard disc / USB memory stick</td>
</tr>
<tr>
<td>Dimensions L x W x H</td>
<td>630 x 470 x 795 mm</td>
<td>800 x 470 x 950 mm</td>
</tr>
<tr>
<td></td>
<td>630 x 470 x 970 mm (incl. multi voltage option)</td>
<td>1060 x 530 x 1145 mm (incl. trolley option)</td>
</tr>
<tr>
<td></td>
<td>950 x 560 x 1130 mm (incl. multi voltage + trolley option)</td>
<td></td>
</tr>
<tr>
<td>Weight</td>
<td>75 kg</td>
<td>138 kg</td>
</tr>
<tr>
<td></td>
<td>115 kg (incl. multi voltage option)</td>
<td>154 kg (incl. trolley option)</td>
</tr>
<tr>
<td>Standards</td>
<td>EN 60974-1 / EN 60974-10</td>
<td></td>
</tr>
</tbody>
</table>

### Options and Accessories

- Large 10,4” colour touch screen with multilingual, graphically assisted welding software
- Laptop
- Full function remote control 6-axes
- Wire feeder
- AVC - Arc Voltage Control
- OSC - Torch Oscillation Control
- Interface for welding manipulators for mechanised welding (positioner, column and boom, seam welder...)
- Hot Wire capability
- Multi voltage kit 200 V to 480 V (not for Hot Wire version)
- Control kit for other than POLYSOUDÉ™ welding heads
- Extension cable (15 m) for welding heads
- Kit for backing gas
- 2nd integrated cooling unit
- Dual welding head switch box (only for Cold Wire version)
- Trolley
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