

# TIG Equipments

## Portable solutions for professional welding

### Robust and powerful

Aristo™ Tig /Caddy™ TIG/Origo™ TIG are ideal partner when it comes to efficient production indoors or outdoors, installation on site or all type of repair & maintenance welding. The power source is a compact and sturdy piece of equipment with a chassis made of robust material that withstands rough treatment. The power source is based on inverter IGBT technology that provides reliable equipment with outstanding welding characteristics. The communications and control CAN-bus system means fewer cables, which in turn increases operational reliability. Details of Heliarc AC/DC TIG included.



|   | Caddy™ Tig 1500i                | Caddy™ Tig 2200i                       | Origo™ TIG 3001i             | Aristo™ Tig 4000iw   |
|---|---------------------------------|--|------------------------------|--|
| Control Panel options                         | TA33 (no pulse)<br>TA34 (pulse) | TA33 (no pulse)<br>TA34 (pulse)        | TA24 (pulse)                 | TA4 (no pulse)<br>TA6 (pulse)  |
| Mains supply ph x V, Hz                       | 1x230, 50                       | 1x230, 50                              | 3x400, 50                    | 3x400, 50  |
| Fuse (slow), A                                | 16                              | 16                                     | 16                           | 25   |
| Energy save mode, W                           | 30                              | 30                                     | 30                           | 60   |
| Power input KVA TIG                           | 2.0                             | 2.5                                    | 7.2                          | 12   |
| 2/4 stroke                                    | Yes                             | Yes                                    | Yes                          | Yes  |
| Setting range TIG                             | 3 – 150                         | 3 - 220                                | 4-300                        | 4-400  |
| Setting range MMA                             | 4 - 150                         | 4 - 170                                | 16-300                       | 16-400   |
| Open circuit voltage, V                       | 72                              | 72                                     | 67                           | 78-90  |
| Power factor at 100% TIG                      | 0,98                            | 0,99                                   | 0,89                         | 0.65   |
| Efficiency at 100%, at TIG                    | 77                              | 75                                     | 82                           | 85   |
| at 60% duty cycle, TIG, A/V                   | 120/14,8                        | 150/16,0                               | 240/19,6                     | 320/23   |
| at 100% duty cycle-TIG,A/V                    | 110/14,4                        | 110/14,4                               | 200/18,0                     | 250/20   |
| Slope up, sec                                 | 0-10                            | 0-10                                   | 0-10                         | 0-5  |
| Slope down, sec                               | 0-10                            | 0-10                                   | 0-10                         | 0-10   |
| Gas pre flow, sec                             | 0-5                             | 0-5                                    | 0-5 Gas                      | 0-5  |
| post flow, sec                                | 0-25                            | 0-25                                   | 0-25                         | 0-25   |
| Pulse time, sec                               | 0.001-2.5                       | 0.001-2.5                              | 0,001-2,5                    | 0.001-5  |
| Background time sec                           | 0.001-2.5                       | 0.001-2.5                              | 0.001-2.5                    | 0.001-1.0  |
| Pulse current A                               | 4-200                           | 4-200                                  | 4-300                        | 4-400  |
| Background current A                          | 4-200                           | 4-200                                  | 4-300                        | 4-400  |
| Insulation class                              | H                               | H                                      | H                            | H  |
| Enclosure class                               | IP 23                           | IP 23                                  | IP 23                        | IP 23  |
| Application class                             | S                               | S                                      | S                            | S  |
| Dimensions l x w x h, mm (incl. cooling unit) | 418 x 188 x 208                 | 418 x 188 x 208                        | 652x249x423/<br>714x249x693* | 625 x 394 x 496  |
| Weight, kg (incl. cooling unit)               | 9,2                             | 9,4                                    | 33,5/ 54                     | 59/79  |
| Standards IEC/EN                              | 60974-1,-3,-10                  | 60974-1,-3,-10                         | 60974-1,-3,-10               | 60974-1,-3,-10   |
| Water cooled version Add-on unit              | CoolMini                        | CoolMini                               | CoolMidi 1000                | Built-in   |
| Coolant volume, l                             | 2,2                             | 2,2                                    | 5                            | 5.5  |
| Order Code                                    | 1620607391 (TA34)               | 1620607385 (TA33)<br>1620607386 (TA34) | 1620607572 (TA24)            | 1620607187 (TA4)<br>1620607189 (TA6)<br>1620607188 (iwTA4)<br>1620607190 (iwTA6) |

• TA34 AC/DC



|                                       | Caddy TIG<br>2200i AC/DC               | Origo TIG<br>3000i AC/DC    | OrigoTIG<br>4300i AC/DC | Heliarc<br>355BR AC/DC |
|---------------------------------------|--|-----------------------------|-------------------------|------------------------|
| Control Panel options                 | TA33 (no pulse)<br>TA34 (pulse)        | TA24 (pulse)                | TA24 (pulse)            | -                      |
| Input                                 |  |                             |                         |                        |
| Mains supply, V/Ph, Hz                | 1x230, 50                              | 3x400, 50                   | 3x400, 50               | 2x440, 50              |
| Fuse (slow), A (with PFC)             | 16                                     | 20                          | 25                      | 80                     |
| Energy save mode, W                   | 40                                     | 30                          | 75                      | -                      |
| Output                                |  |                             |                         |                        |
| Setting range TIG AC/DC A             | 4-220                                  | 4-300                       | 4 - 430                 | 5 - 380                |
| Setting range MMA                     | 16-160                                 | 16-300                      | 16 - 430                | 10 - 380               |
| at 60% duty cycle, TIG, A/V           | 150/16,0                               | 240/19.6                    | 400/26                  | -                      |
| at 100% duty cycle, TIG, A/V          | 140/15,6                               | 200/18                      | 315/22.6                | 250/30                 |
| Open circuit voltage, V DC            | 54-64 V                                | 54-64                       | 83                      | 72-80                  |
| Frequency AC, Hz                      | 10-152                                 | 10-150                      | 10-152                  | 50                     |
| AC balance, %                         | 50-98                                  | 50-98                       | 50-98                   | 50                     |
| Power factor at 100%,<br>at TIG mode  | 0,98                                   | 0.72                        | 0.89                    | 0.76 with PFC          |
| 2/4 Stroke                            | Yes                                    | Yes                         | Yes                     | Yes                    |
| Enclosure class                       | IP 23                                  | IP 23C                      | IP 23                   | IP22                   |
| Insulation class                      | H                                      | H                           | H                       | H                      |
| Standards: IEC/EN                     | 60974-1, -3, -10                       | 60974-1, -3, -10            | 60974-1, -3, -10        | -                      |
| Weight, kg (with cooler for built-in) | 15                                     | 42                          | 95                      | 200                    |
| Slope up, sec                         | 0-10 -                                 | 0-10                        | 0-10                    | 0.1-5*                 |
| Slope down, sec                       | 0-10                                   | 0-10                        | 0-10                    | 0.1-5*                 |
| Gas post-flow, sec                    | 0-25                                   | 0-25                        | 0-25                    | 3-30                   |
| Pulse frequency DC, sec               | 0,01-2,5                               | 0.01-2.5                    | 0.01-2.5                | 0.05-5**               |
| External dimensions mm, lwxwxh        | 407x187x345                            | 652x412x423                 | 625x394x776             | 700 x 1400 x 950       |
| Water cooling unit                    | CoolMini 1000<br>1620607582            | CoolMidi 1800<br>1620607283 | Built-in option         | WC-8c<br>1620607462    |
| Coolant volume, l                     | 2,2                                    | 4.2                         | 5.5                     | 7                      |
| Order Code                            | 1620607362 (TA33)<br>1620607363 (TA34) | 1620607282                  | 1620607365              | 1620607421             |
| TIG Torch option 4/8M                 | TXH 200<br>TXH 250W                    | TXH 200<br>TXH 250W         | TXH 200<br>TXH 250W     | HW26<br>HW18           |
| Options                               | -                                      | Trolley<br>1620607285       | Trolley<br>1620607183   | -                      |



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