



TIG Welding Unit Model MobiTIG 180 AC/DC

Primary:

Supply:	1 x 230 V
Frequency:	50/60 Hz
Cont. power (TIG/MMA):	2.8 / 3.7 kVA
Cont. current (TIG/MMA):	12 / 16 A
Max. current (TIG/MMA):	23 A / 26 A
cos phi:	0.95

Secondary (TIG operation):

Open circuit voltage:	64 V
Welding voltage:	10 - 17.6 V
Welding current (DC):	5 - 180 A
Welding current (AC):	10 - 180 A
Duty cycle 25 % (10 min.):	180 A (40°C)
Duty cycle 35 % (10 min.):	180 A (20°C)
Duty cycle 60 % (10 min.):	150 A (20°C) 110 A (40°C)
Duty cycle 100 % (10 min.):	130 A (20°C) 90 A (40°C)

MMA/stick electrode operation:

Stick electrode:	1.5 - 3.25 mm
Open circuit voltage:	64 V
Welding voltage:	20 - 26 V
Welding current:	20 - 160 A
HSB 30 % ED (10 min.):	150 A (40°C)
HSB 60 % ED (10 min.):	150 A (20°C) 110 A (40°C)
DB 100 % ED:	130 A (20°C) 90 A (40°C)

Protection class:	IP 23
Insulation class:	H
Cooling:	AF
Modes:	TIG (AC and DC) / MMA welding
Parameter:	current 1, current 2, reduction, final current, gas afterflow
Adjustments:	continuously at potentiometer
Current control:	at the unit, at the torch, at the remote controls
Functions:	2 stroke, 4 stroke 4 stroke with current 2
Ignition:	HF / Liftarc
Indication:	display
Current 2:	switchable via 2nd torch button
Spot welding time:	0.01 - 2.5 s
Pulse times slow:	0.1 - 2.5 s
Pulse times fast:	50 Hz - 12 kHz
Down slope time:	0 - 25 s
Up slope time:	0 - 2 s
Gas pre flow time:	0 - 2 s
Gas post flow time:	0 - 25 s

Hotstart time:	0.1 - 2 s
Hotstart current:	5 - 160 A
Current readjustment:	up to 160 A
AC frequency:	50 - 120 Hz
AC balance:	10 - 90 %
LED:	mains ON
LED:	welding ON
LED:	temperature protection
LED:	failure
Power socket:	via remote control connection
Current source:	inverter
Ignition:	HF device
Torch connection:	Merkle TCG and 5-pole plug
Cooling torch:	gas
Socket 50 mm²:	earth lead
Socket 50 mm²:	electrode welding cable
Mains supply cable:	3 x 2.5 mm², 2.5 m long with plug Schuko
Gas hose:	2 m long
Handle:	at topside of device
Norm:	EN 60974-1 "S" / CE
Weight:	9.1 kg
Dimension L x W x H:	355 x 160 x 275 mm

