

POLYSOUDE

MESSER GRIESHEIM

AUTOTIG® 140 P

- A new generation of programmable portable TIG orbital and automatic welding power sources.
- Robust, compact and light.
- Inverter based.
- Single phase mains input.
- 140 Amp. output (100% duty cycle).
- 24 programme internal storage capacity.
- Hand welding capability.
- Wire feed possible with POLYFIL B wire feeder.
- Working range : 1 - 140 Amps.
- Up to 99 separate sector changes for a given programme.
- All parameters are changeable during the weld cycle.
- Parameter changes may or may not be memorized.
- Integral card reader with "memo card" and external printer for programme saving and control.
- Interface with the Polytherm for closed loop water cooling of weldheads and hand torch.

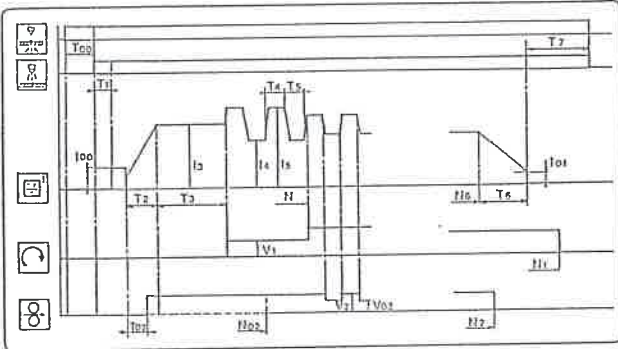
AUTOTIG 140 P - Enclosed welding head








AUTOTIG

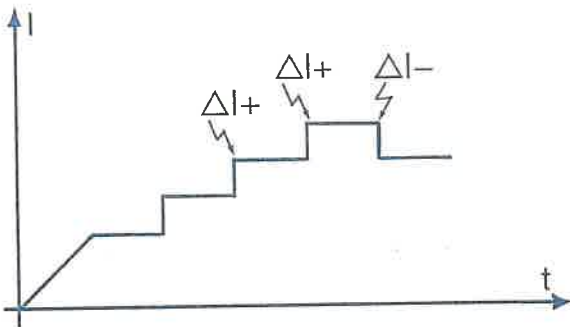
The new generation of microprocessor c

PROGRAM



-  - Prepurge, Postpurge, Flow.
-  - Upslope, Prefusion, Current, Downslope, Pulse characteristics.
-  - Start, Stop, Speed, Pulsing.
-  - Start, Stop, Speed, Pulsing.*
-  - Sectors (position based).

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- Programme sectors are creatable during the welding cycle. Incremental adjustments of parameters during welding (up or down) : current, speed etc via remote control.
- All parameter values are adjustable numerically during welding via the keypad.

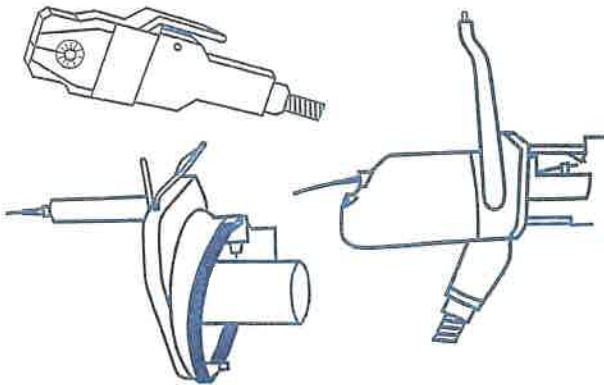
PROGRAMME AND LIS

POLYSOUDE
AUTOTIG 140P
SUBJECT: FLANGE
DATE: 10/01/92
Material:
Thickness:
Diameter:
Preparation:
WELDING PARAMETERS
TAPE NR:0010
PROGRAM NR: 49

T high T4=0100ms
I low I5=007.0 A
T low T5=0300ms
V welding V1=140V
DOWN SLOPE
Number of impul.:
-down slope N6=0780
-stop rotat. N1=0003
T down slope T6=010 s
T post gas T7=020 s
END OF PROGR. NR:49
POLYSOUDE

- Programmes stored without the power source being connected.
- External printer for weld procedure listing.*
- Integral card reader with "memo card" allows saving of programmes and machine to machine transfer.

APPLIC



- The electronics within the Autotig 140 P produce a responsive arc with a defined difference between high and low pulse. This means that the heat input is precisely controlled and thus the weldability, especially of the more

UPGRA



- Water cooling - Closed loop water cooling circuit to augment the duty cycle : POLYTHERM.
- Wire addition - For applications of slightly thicker wall thickness or tough quality standards : POLYFIL B.

* Optional

140 P

Controlled orbital TIG power source.



- All programming is via the keypad/display which has been designed to be easily operated and user friendly.



- Temporary parameter adjustments can be made during welding without altering the programme.



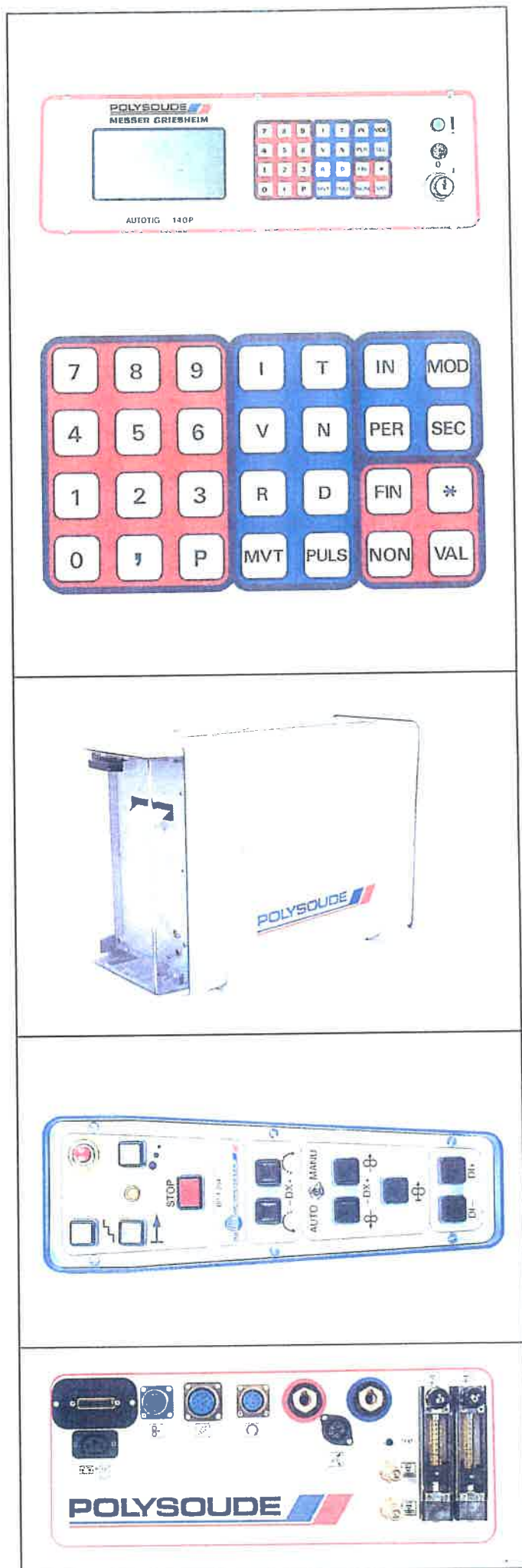
- Parameter hardcopies give a permanent record of preprogrammed parameters for the weld procedure library or quality control purposes.



difficult materials, is enhanced. The 24 memory storage capacity of the Autotig 140P and a change of weldhead means it is easy to move quickly from one application to another with the minimum of time loss.



- Backing gas control - Integrated into the power source for higher grade materials.
- Multilingual facility - English/French, English/German, etc...



Technical specification	Standard	Optional
Supply voltage	- Single phase 220 V, 50/60 Hz	
Primary rating	- 3,5 kVA	
Open circuit voltage	- 100 V	
Power source cooling	- Forced air	
Torch cooling	- Air	- water-cooled via Polytherm
Thermal protection	- Yes	
Insulation class	- F	
Protection rating	- IP 21	
Max. current	- 140 A/100 %	
Accuracy	- ± 1 %	
Pulsed current range	- 1 to 140 A	
Pulse times	- 0,01 - 0,99 s	
Wire feed facility		- Polyfil B
Rotation sequencing	- Positon based	
Wire sequencing		- Time and/or position based
Sector sequencing	- Position based	
Position accuracy	- Better than 1° of angle (= 0.2 mm for 25 mm tube)	
Number of possible sectors	- 99	
Gas control	- Integral gas flowmeter with safety cut off	- Backing gas flowmeter with safety cut off
Remote control	- Yes	
Parameters saving and controlling	- Integral card reader with "memo card"	- External printer
Parameters monitored during welding and displayed	- Voltage, current (high), travel speed, wire speed	
Weight	- 34 kg (75 lbs)	
Dimensions 140 P	- 520 x 400 x 370 mm (20" x 16" x 15")	
Polytherm weight		- 20 kg (44 lbs)
Polytherm dimensions		- 520 x 420 x 300 mm (20" x 17" x 12")
Microprocessor security entry code	- Yes (if programmed)	

Service Polysoude.

All our technicians are at your disposal for technical advice, training and commissioning.

POLYSOUDE 
MESSER GRIESHEIM

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