

WAVE 200D_{III}

- Portable Inverter AC/DC Pulse TIG / MMA Welder
- New Generation IGBT Inverter Technology
- Easy-to-use and user-friendly control panel
- Digital and full functional display
- Adjustable & displayable gas pre-flow/post flow, AC frequency/balance, ignition/ base/peak current; simply welding procedure parameters
- Adjustable; Hot start, Arc Force for MMA welding
- Foot pedal control can be used
- IP21S Protection Class
- Lightweight, Small and Patented Compact Design



HG HUGONG

SHANGHAI HUGONG ELECTRIC (GROUP) CO., LTD.



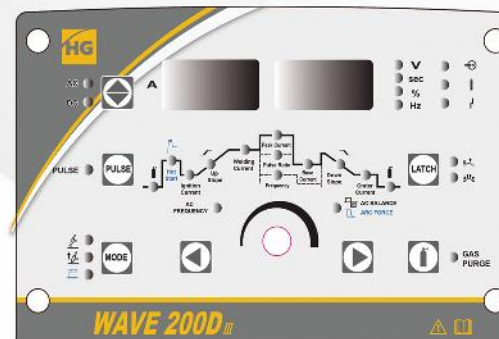
WAVE 200D_{III}

FEATURES AND ADVANTAGES

- Portable Inverter AC/DC Pulse TIG / MMA Welder
- New Generation IGBT Inverter Technology
- Ideal for welding of carbon steels, low-alloy steels, stainless steels, aluminium / aluminium alloys and copper
- Digital and full functional display
- Digital ampermeter / voltmeter
- Built-in Anti-Sticking
- Equipped with voltage protection and thermal protection
- Easy-to-use and user-friendly control panel
- Welding Mode, AC/DC, Pulse, 2T/4T, parameter +/- and gas checking selections/settings buttons.
- Adjustable & displayable gas pre-flow/post flow, AC frequency/balance, ignition/ base/peak current; simply welding procedure parameters.
- Adjustable; Hot start, Arc Force for MMA welding.
- Steeples Welding Current/Setting Knob
- Power, Overload and Under/Over-Voltage LED indicators
- Easy welding cable connections with European type quick connectors
- Foot pedal control can be used
- Fan cooling system
- IP21S Protection Class
- Lightweight, Small and Patented Compact Design
- Weight is only 19.5 Kg.
- Dimensions (cm.) (L×W×H) 50×24×41

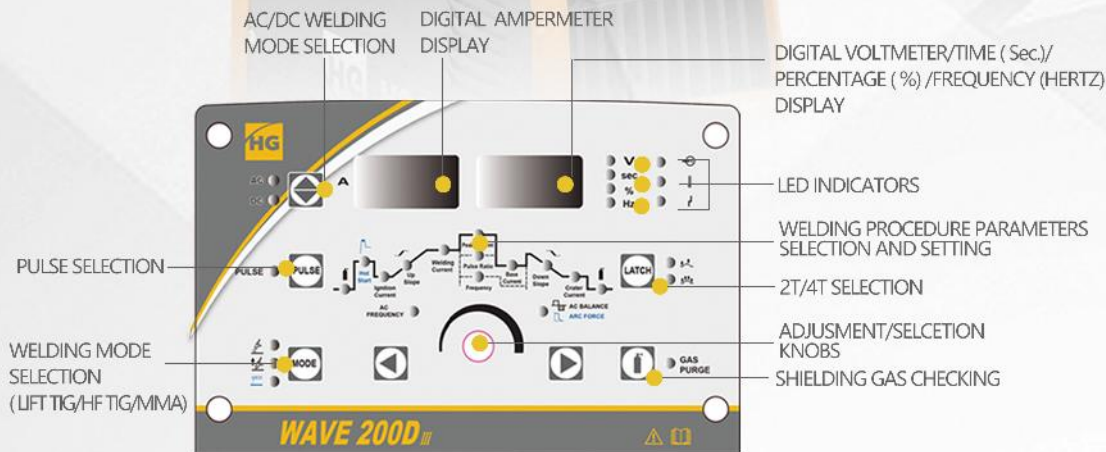


DIGITAL AND FULL FUNCTIONAL DISPLAY

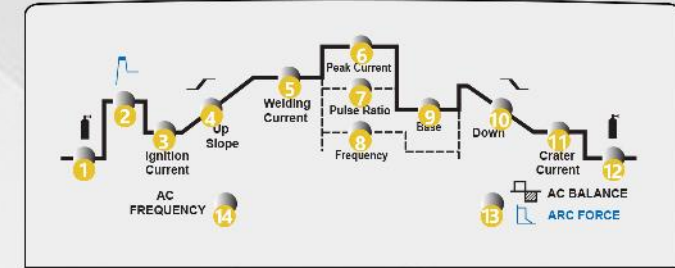


Model	Input Power (V)	Rated Input Current (A)	Rated Input Capacity (kVA)	Rated Open Circuit Voltage(V)	Welding Current Adjustment Range(A)	Rated Output(A) (20°C) / (40°C)	Weight (kg)	LxWxH (mm)
WAVE 200D _{III}	230	35	8.05	68	TIGS-200/ACTIG10-200/MMA5-170	35%15%@200	19.5	500x240x410

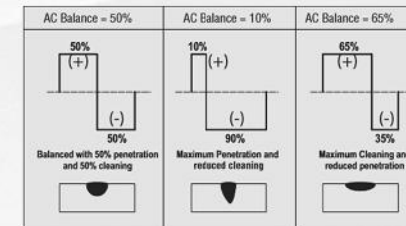
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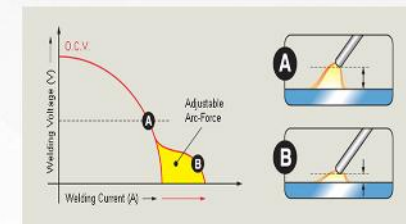
DIGITAL AND FULL FUNCTIONAL DISPLAY



- 1- Pre-Flow ; Shielding gas pre-flow time (sec); in TIG (GTAW) welding mode; used for providing the shielding gas to the weld zone before the arc striking.
- 2- Hot-Start; In MMA (SMAW) welding mode; used for temporary increase of the output current during the start of weld.
- 3- Ignition Current; In TIG (GTAW) welding mode; used for setting the start current.
- 4- Up-Slope; In TIG (GTAW) welding mode; used for setting the time (in sec.) for the ignition current to the welding current.
- 5- Welding Current; In TIG (GTAW) and MMA (SMAW) welding modes; used for setting the welding current.
- 6- Peak Current ; In Pulse TIG (GTAW) welding mode; used for setting the peak current.
- 7- Pulse Ratio ; In Pulse TIG (GTAW) welding mode; used for setting the percentage (%) time of the Pulse Frequency for welding current.
- 8- Frequency; In Pulse TIG (GTAW) welding mode; used for setting the pulse frequency in Hertz (Hz)
- 9- Base- Current; In Pulse TIG (GTAW) welding mode; used for setting the TIG (GTAW) back-ground current.
- 10- Down-Slope; In TIG (GTAW) welding mode; used for setting the time (in sec.) for the welding current to the crater current.
- 11- Crater Current; In TIG (GTAW) welding mode; used for setting the crater current at the end of Down-Slope .
- 12- Post-Flow ; Shielding gas post-flow time (sec); in TIG (GTAW) welding mode; used for providing the shielding gas to the weld zone after arc extinguished.
- 13- AC Balance; In AC TIG (GTAW) welding mode; used for setting penetration to cleaning ratio for AC weld current for Aluminium welding. For increasing the penetration; AC Balance percentage (%) has to be decreased. For maximum cleaning ; AC Balance percentage (%) has to be increased. Maximum cleaning is necessary for heavily oxidized aluminium and/or magnesium alloys.
- 14- AC Frequency; In AC TIG (GTAW) welding mode; used for setting AC square wave frequency in Hertz (Hz)



Arc – Force; In MMA (SMAW) welding mode; it used for preventing the electrode from sticking during welding. Arc force is a temporary increase of the output current during welding when the arc is too short.



- 14- AC Frequency; In AC TIG (GTAW) welding mode; used for setting AC square wave frequency in Hertz (Hz)
- AC frequency controls width of the arc cone;
Low AC frequency=Wider bead, softer arc and good penetration
High AC frequency=Narrower bead; ideal choice for fillet welding.