

WAVE 315D_{III}

- On trolley Water Cooled Inverter AC/DC Pulse TIG / MMA Welder
- New Generation IGBT Inverter Technology controlled by MCU core processor
- Digital and full functional display
- 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
- Equipped with voltage protection and thermal protection
- Foot pedal control can be used
- Patented Compot Design
- IP21S Protection Class



126.5cm

114cm

50cm

HG HUGONG

SHANGHAI HUGONG ELECTRIC (GROUP) CO., LTD.



CE RoHS

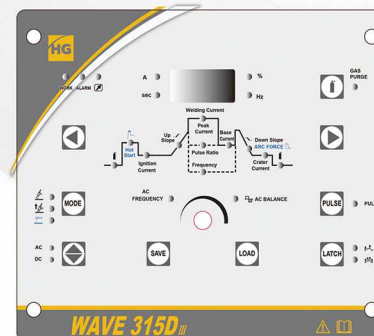
WAVE 315D_{III}

FEATURES AND ADVANTAGES

- On trolley Water Cooled Inverter AC/DC Pulse TIG / MMA Welder
- Compact, Heavy Duty, Industrial Type with easy moving and storage
- New Generation IGBT Inverter Technology controlled by MCU core processor
- Ideal for welding of carbon steels, low-alloy steels, stainless steels, aluminium / aluminium alloys and copper
- Digital and full functional display
- 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 and Built-in Anti-Sticking for MMA welding.
- Steeples Welding Current/Setting Knob
- Power, Overload and Under/Over-Voltage LED indicator
- Easy welding cable connections with European type quick connectors
- Foot pedal control can be used
- Fan cooling system
- IP21S Protection Class
- Patented Compot Design
- Weight is 87 Kg.
- Dimensions (cm.) (L×W×H) 114× 50× 126.5

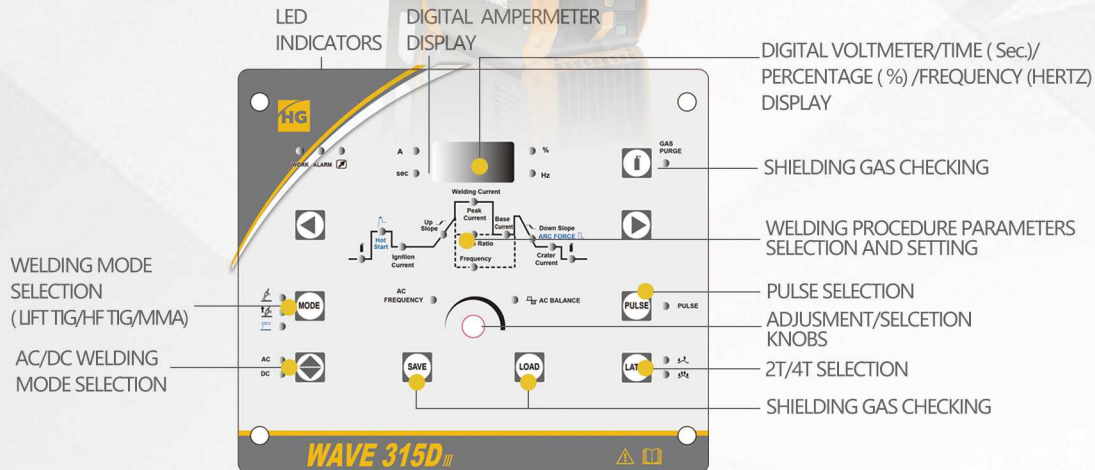


DIGITAL CONTROL PANEL



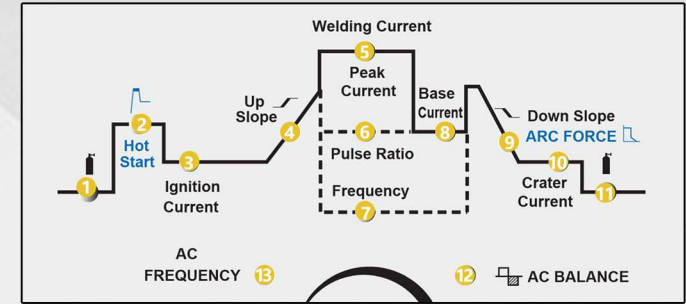
Model	Input Power (V)	Rated Input Current (A)	Rated Input Capacity (kVA)	Rated Open Circuit Voltage(V)	Welding Current Adjustment Range(A)	Rated Output(A) (20°C) / (40°C)	Weight (kg)	LxWxH (mm)
WAVE 315D _{III}	380	21	13.8	65	DC TIG10-315/AC TIG20-315/MMA20-230	60%35%@315	87	1140x500x1265

WAVE 315D_{III}

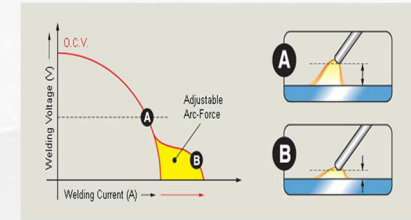


DIGITAL AND FULL FUNCTIONAL DISPLAY

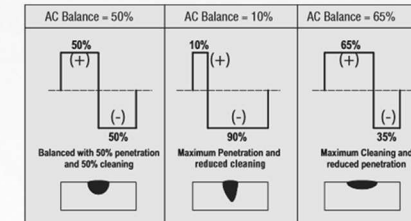
WELDING PROCEDURE PARAMETERS SELECTION AND SETTING



- 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.
Peak Current: In Pulse TIG (GTAW) welding mode; used for setting the peak current.
- 6- Pulse Ratio; In Pulse TIG (GTAW) welding mode; used for setting the percentage (%) time of the Pulse Frequency for welding current.
- 7- Frequency; In Pulse TIG (GTAW) welding mode; used for setting the pulse frequency in Hertz (Hz)
- 8- Base- Current; In Pulse TIG (GTAW) welding mode; used for setting the TIG (GTAW) back-ground current.
- 9-Down-Slope; In TIG (GTAW) welding mode; used for setting the time (in sec.) for the welding current to the crater current.
- 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.



- 10-Crater Current; In TIG (GTAW) welding mode; used for setting the crater current at the end of down-slope.
- 11-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.
- 12-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.



- 13-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.