

# Tetrix 230 AC/DC Comfort 2.0 puls 5P TM

090-000239-00502



- Modular AC/DC TIG inverter welding machine, gas- or water-cooled
- Comfort 2.0 control, simple operation with click wheel
- **TIG welding**
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- Special AC welding procedure to join markedly different aluminium plates together, e.g. welding 1-mm-sheet to a 10-mm-plate
- Adjustable AC waveform, sine, trapezoidal, square current
- Adjustable AC frequency between 50 Hz and 200 Hz
- Adjustable AC balance
- TIG automated pulsing with automatic specification of required pulse parameters
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- 8 programmed JOBS (welding tasks)
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- MMA average value pulsing
- Ideal for root welding
- Safe vertical-up welding with MMA pulse
- Adjustable hot start current and hot start time
- Antistick function
- **Highlights**
- Safe ignition also for long hose packages
- Gas-cooled or optionally water-cooled with cool 40 U31 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 4-litre water tank (cool 41U31 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Connection capability for remote control and function torch
- Trolley 35.2-2 trolley available for delivery
- Mains connection 230 V/16 A
- High mains voltage tolerance +15%/-40% and therefore fully generator-compatible
- 3.5 m mains lead with 16 A earthed plug
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**
- **Scope of supply includes welding machine only; other components such as trolley and cooling unit can be selected from accessories!**

	TIG	MMA
Setting range for welding current	3 A - 230 A	5 A - 180 A
Duty cycle at ambient t.e	40 °C	
40 %	230 A	180 A
60 %	200 A	150 A
100 %	170 A	120 A
Open circuit voltage	45 V	

Mains frequency	50 Hz / 60 Hz	
Mains fuses (slow-blow)	1 x 16 A	
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)	
Max. connected load	5.5 kVA	6 kVA
Recommended generator power	7.4 kVA	8.1 kVA
cos $\phi$	1	
Efficiency	85 %	
Dimensions machine, LxWxH in mm	539 x 210 x 415	
Weight, machine	18.3 kg	
Insulation class	F	
Torch connection	Decentral	