



TIG225ACDCP SPECIFICATIONS

TABLE 1.1

Parameter	TIG225ACDCP			
Welding process	AC/DC GTAW-P DC-SMAW			
Inverter type	IGBT			
Input voltage	1 phase AC, 110V +/- 15%		1 Phase AC, 220V +/- 15%	
Input frequency	50/60Hz		50/60Hz	
Input connector type Pre-wired for NEMA 6-50P *adapter provided for NEMA 6-50 to NEMA 5-15 (for 220V or 110V operation)	 5-15P NEMA *See note		 6-50P NEMA	
Rated input current	TIG:	34.0A	TIG:	33.3A
	MMA:	46.3A	MMA:	38.1A
Rated output voltage	TIG:	15.6V	TIG:	19.0V
	MMA:	24.8V	MMA:	27.2V
Rated output current	TIG:	140.0A	TIG:	225.0A
	MMA:	120.0A	MMA:	180.0A
No-Load voltage	56.0V			
Arc initiation (TIG)	High Frequency Start (HF start)			
Duty Cycle	See table 1.2			
No-Load power consumption	40W			
Efficiency	>=80%			
Power factor	0.73			
Insulation grade	F			
Ingress protection Rating (IP)	IP21			
Weight	18.5Kg/40.7lbs			
Overall dimensions	705 x 300 x 565mm/27.76 x 11.80 x 22.24inches			
Remote control	2T operation			
Breaker size	50 amp 220v/30 amp 110v			
Welding process dependent				
Starting current	10A to 225A			
Ending current	10A to 225A			
Current up slope	0s to 10s			
Current down slope	0s to 25s			
Welding current	10A to 225A			
Base current	5% to 95%			
Pulse frequency	Low:	0.5Hz to 10Hz		
	High:	10Hz to 200Hz		
Gas: Pre-Flow	0.1s to 3s			
Gas: Post-Flow	0s to 15s			
AC Frequency	40Hz to 200Hz			
AC Balance	10% to 90%			

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TABLE 1.2

Welding type	Input voltage	Duty cycle
TIG	110V	140A/15.6V @ 40%
		124A/14.9V @ 60%
		108A/14.3V @ 100%
	220V	225A/19V @ 40%
		183A/17.3V @ 60%
		155A/16.2V @ 100%
Stick	110V	120A/24.8V @ 40%
		98A/23.9V @ 60%
		76A/23V @ 100%
	220V	180A/27.2V @ 40%
		162A/26.5V @ 60%
		139A/25.6V @ 100%

*note: all values are at 25°C