DATA SHEET

tigSpeed oscillation drive 45 hotwire

090-000180-00502



- TIG cold/hot wire feeder
- Constant wire feed, oscillating wire feed and TIG superPuls
- To find out more about our high-tech TIG arcs, please click on TIG-Process
- High process reliability and much easier handling compared to manual TIG welding
- **Areas of application**: Low-, medium- and high-alloy materials; CrNi; nickel-based alloys, copper and copper alloys; aluminium and aluminium alloys (only cold wire); P91/P92 special alloys
- Suitable for mobile use thanks to optional trolley
- Strain relief and intermediate hose package bracket to protect the intermediate hose package available as an option
- Operating point adjustment via remote control directly at the workstation
- Can be used with any water cooled TIG welding machine
- Workpiece lead to connect the hot wire current is included in the supply package
- **TIG cold wire welding:**
  - Up to 60% faster welding speeds compared to manual TIG welding
- **TIG hot wire welding:**
  - The welding speed is significantly increased even more compared to cold wire welding.
  - Huge advantages for cladding thanks to reduced dilution in the weld pool as a result of targeted heat input
- **Constant wire feeding:**
  - Ideal for mechanised/automated applications and TIG cladding
  - Less distortion thanks to reduced heat input
  - Smooth, uniform seam finish
- **Oscillating wire feeding:**
  - The wire is fed continuously, at the same time the wire is moved forwards and backwards at a freely adjustable frequency (1-16 Hz)
  - Easy handling, even for positional welding
  - Highly stable process: the arc remains stable when the gap between the electrode and workpiece changes
  - Excellent sidewall fusion
  - Reduces risk of undercuts
  - Fine-flaked weld surface
  - Filler and cover passes
  - Optimum results with high-alloy materials
- **Superpuls with two wire feed speeds:**
  - Continual switch between two wire feed speeds
- **Superpuls “start/stop”:**
  - Continual switch between wire feeding and wire stop
  - Particularly suitable for PA, PB and PC position
- **Superpuls “reverse”:**
  - Continual switch between wire feeding and wire return
  - Optimally suitable for positional welding and thin sheet processing

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Setting range for welding current	40 A - 180 A
Duty cycle 40 °C	180 A / 35 %
	150 A / 60 %
	130 A / 100 %
Mains voltage (ex works)	1 x 230 V
Mains tolerances (ex works)	-40 % up to +15 %
Mains frequency	50 Hz / 60 Hz
Efficiency	86 %
Wire feed speed	0.3 m/min - 15 m/min
	11.811 ipm - 590.552 ipm
Factory-installed roll equipment	1,0 + 1,2 mm / Steel
Spool diameter	D200/D300
Protection classification	IP23
Test mark	CE UKCA EAC S
EMC class	A
Dimensions (L x B x H)	625 mm x 377 mm x 531 mm
	24.6 inch x 14.8 inch x 20.9 inch
Weight	32.4 kg / 71.4 lbs
Standards	IEC 60974-1, -5 and -10 CL.A

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