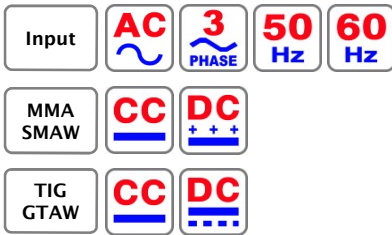




SMAW / MMA DC IGBT Inverter - 3 Phase



S 281 i

Main Applications

- Shipyards
- Metal tanks
- Steel fabricator
- Construction
- Sheet metal
- Medium to heavy industries
- Chemical and process industry
- Mechanical and electrical

Advantageous

- MMA / SMAW DC Inverter welding machine, feature exceptional ignition and welding properties
- Compact and robust design, user friendly panel design
- IGBT Inverter Technology for more durability
- Can weld cellulose electrode
- Voltage Reduction Device (VRD) system, especially for use in hazardous environments such as construction sites, shipyards and mines.
- Adjustable arc force for easily control the arc
- Adjustable hot start for easily starting welding current
- Anti stick function to cut down the welding current to minimum when the electrode is stuck to the work-piece for safety
- Digital display for accurate welding amperage adjustment
- Selector switch for Tig welding with Lift Arc ignition

MMA	S 280 i
Electrode range	1.6 - 6.0 mm
Material thickness	1 - 12 mm

TIG	
Tungsten range	1.6 - 4.0 mm
Material thickness	1 - 6 mm

Specifications	
Welding range	10 - 280 A
Load voltage	20.8 - 31.2 V
Open circuit voltage	81 V
Duty cycle at 100 % (40°C)	250 A at 30 V
Duty cycle at 80 % (40°C)	280 A at 31.2 V
Duty cycle at 60 % (40°C)	-
Duty cycle at 40 % (40°C)	-
Input power at 80 %	9.5 KVA
Input current at 80 %	17 A
Input phase	3 Phase
Main voltage, Tolerance	380 V, ±15 %
Power factor	0.93
Index protection	IP 23
Insulation class	F
Cooling	F
Dimensions (L x W x H)	500 x 210 x 420 mm
Weight	15.4 Kg

Item Code	Item Name	MoQ
101.02.007.1	S 281 i - MMA DC IGBT Inverter	1 Set



Item Code	Item Name	MoQ
Standard Accessories		
201.11.017	Plug to Ground Clamp 300 A, 50 mm ² at 3 m - S series IGBT Inverter	1 Set
201.11.018	Plug to Electrode Holder 400 A, 50 mm ² at 3 m - S series IGBT Inverter	1 Set
Optional Accessories for SMAW / MMA		
208.03.005	Pug to Electrode Holder 400 A, 50 mm ² at 5 m	1 Set
208.03.006	Pug to Electrode Holder 400 A, 50 mm ² at 10 m	1 Set
208.03.007	Pug to Electrode Holder 400 A, 50 mm ² at 20 m	1 Set
208.04.007	Lug to Ground Clamp 600 A, 50 mm ² at 5 m	1 Set
208.04.008	Lug to Ground Clamp 600 A, 50 mm ² at 10 m	1 Set
Optional Accessories for GTAW / TIG		
208.17.006.1	Tig Torch - WP 17 V - Complete Package + Tig Torch - WP 17 V-25-2 at 8 m + Plug - Trak-SK 35 mm + Argon Gas Regulator	1 Set
208.17.007.1	Tig Torch - WP 26 V - Complete Package + Tig Torch - WP 26 V-25-2 at 8 m + Plug - Trak-SK 35 mm + Argon Gas Regulator	1 Set
General Accessories		
208.18.001	Torch Holder - TIG	1 Pcs
201.22.009	Welding Helmet - Solarmatic Blue	1 Pcs



Thickness (mm)	Welding Current (A)			Tungsten (mm)	TIG Rod (mm)	Nozzle #	Gas Shielding (l / Min)	Travel Speed (cm / min)
	SS	Copper	Brass					
0.8 - 1.0	30-50	40-65	30-50	1.0 - 1.6	1.2 - 1.6	4 - 5	5-6	20 - 30
1.2 - 2.0	60-100	50-120	50-90	1.6 - 2.4	1.6 - 2.4	5 - 6	6-7	20 - 25
2.5 - 3.0	110-160	130-200	110-160	2.4 - 3.2	2.4 - 3.2	6 - 7	7-8	15 -25
4.0 - 5.0	170-220	220-300	200-250	3.2 - 4.0	3.2 - 4.0	7 - 8	10-12	15 -20
8.0 - 10.0	240-300	350-430	240-330	3.2 - 4.0	4.0	8 - 10	10-12	10 - 12