

CHAMP TIG 221 AD EVO

TIG AC/DC - MMA





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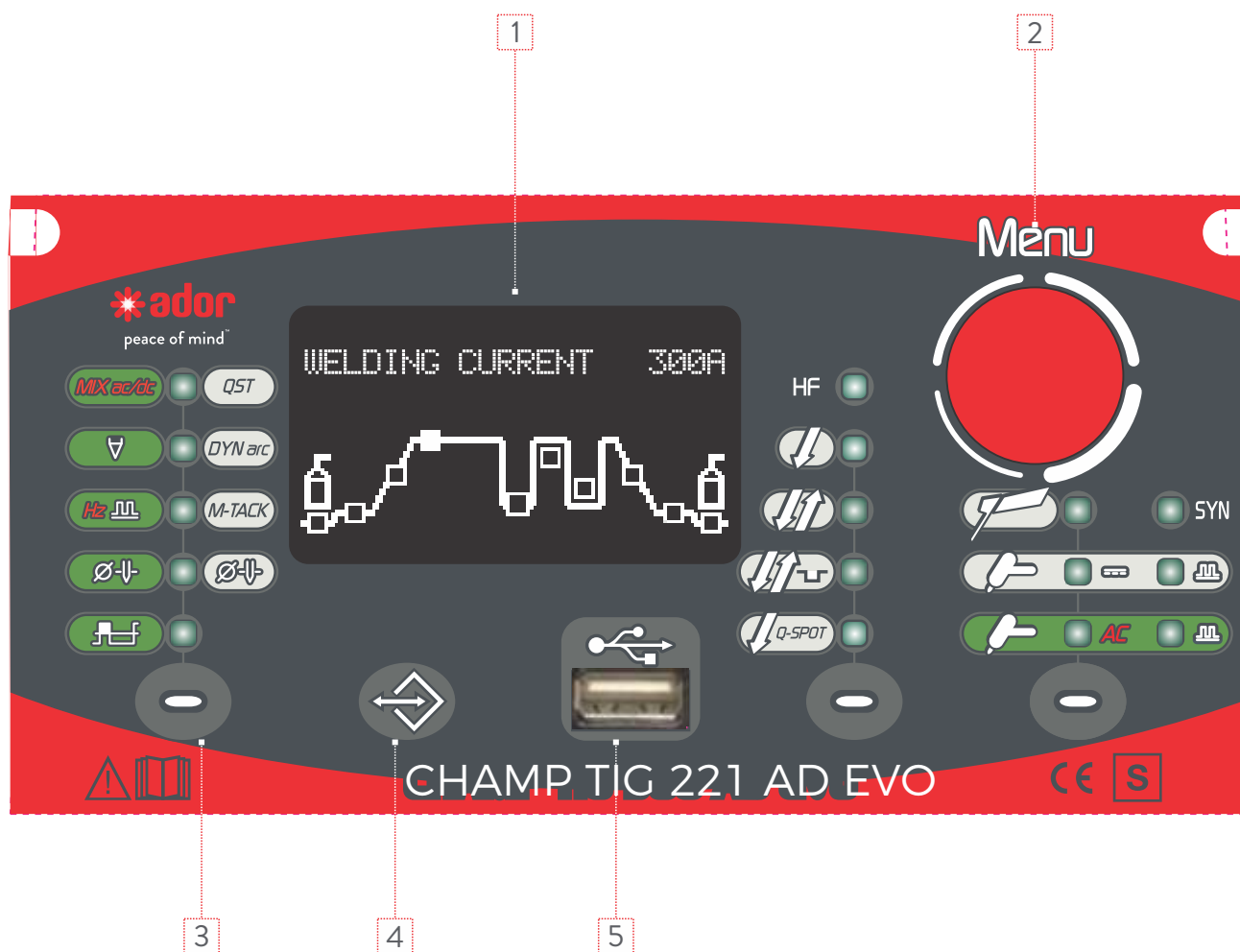


CHAMP TIG 221 AD EVO

TIG AC/DC - MMA



USER INTERFACE SIMPLE AND INFORMATIVE



- 1 - Graphic Display complete with multi-language Menu.
- 2 - Encoder with push button navigation permits the setting with one hand.
- 3 - Direct access to all special functions.
- 4 - Quick Jobs` Management.
- 5 - USB Connection for Jobs back up and rapid transmission.



TECHNICAL DATA

Key Benefits



TECHNICAL DATA

CHAMP TIG 221 AD EVO is a revolutionary state-of-the-art 1Phase portable TIG AC/DC welding Inverter. TIG AC functions are ideal for welding aluminum, magnesium, and related alloys. Ordinary steels, stainless steel and copper can be easily welded in TIG DC.

CHAMP TIG 221 AD EVO is specifically designed for extremely precise welding in the construction, petrochemical, food industries and other applications that require very a high welding performance.

The new user interface (EVO) provides fast and effective access to all available functions. 50 programs can be loaded and saved in memory (JOB), All programs can be easily recalled when using an Up/Down torch. It is also possible to create different jobs' sequences to be used on specific applications. Simple selection of the MMA mode provides a choice of the electrode-type (basic, rutile, CrNi, Alu) setting, resulting in optimizing the weldability and parameters. It is also possible to control the polarity switch (swap) directly from the user interface, avoiding any cable disconnection. Finally the function AC (for welding in alternate current) is additionally available, this is particularly suitable for the welding of special electrodes.

CHAMP TIG 221 AD EVO						
	1x230Vac ± 15% (@ 50-60Hz)					
	16A			25A		
	TIG			MMA		
% _{40°C}	35%	60%	100%	40%	60%	100%
I_2	220A	180A	160A	180A	150A	120A
I_2	5A – 220A			10A – 180A		
U_0	79,5V					
$P_{1\text{ MAX}}$	6,2kVA – 6,1kW					
IP	23S					
	460 x 230 x 325mm					
	19,5Kg					

TECHNOLOGY				PROCESSES			
							
				TIG AC/DC		MMA	
SPECIAL FUNCTIONS							
							
SYN2,5KHzSTARTMULTI-TACKDynamic ArcQ SpotMIX AC/DCExtra Fusion							
MATERIALS							
							
ALUMINIUM	MILD STEEL	STAINLESS STEEL	COPPER	MAINTENANCE	INDUSTRY	SHIPYARD	PIPE WELDING



TECHNOLOGY AND SPECIAL FUNCTIONS



PFC reduces harmonic current emissions and 20% input current, increasing the power inverter efficiency.



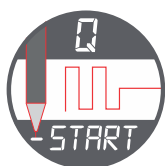
Function VRD (Volt Reduction Device) reduces automatically the voltage of the welding machine during the Standby mode in order to allow the processing in those building site where low voltages are demanded for safety reasons (Dockyards, petrol platforms and so on).



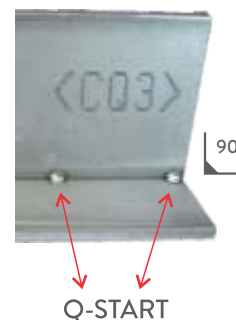
The pulse TIG with frequency until 2500Hz allows to weld very thin materials with easy arc control and very low heat input on workpiece.



Pre-set balanced parameters, stored in the Synergic Pulse TIG DC SYN curve, simplify Pulsed welding by adjusting only welding current.



The Q START (Quick start) function facilitates the joining of the parts in the initial stage of the welding process. On activating this function the machine automatically switches to Synergic pulsed mode for a preset time. The resulting pulses create movement of the molten metal on the two sheet metal edges thereby accelerating formation of the join. This function is invaluable in the case of seams with slight openings or with irregular preparation. The duration of the series of pulses can be adjusted, (from 0.1 to 60 second) depending on the thickness and shape of the sheet to be welded.



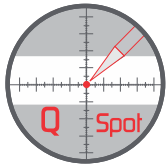
The DYNAMIC ARC function makes it possible to keep the product of Voltage x Current constant. The power source increases the welding current as the arc voltage decreases and reduces the welding current if the arc voltage increases. The DynARC value can be adjusted from a minimum of 1 Ampere to a maximum of 50 Ampere at each 1 Volt variation, whether positive or negative.



Dynamic Arc TIG welding



Standard TIG welding



The Q-SPOT (Quick Spot) function makes it possible to minimise tacking times for light gauge sheet metal. The operator conveniently places the tungsten electrode on the fixing point, thereby obtaining perfect control of the position of the join. Once the electrode has been lifted the machine emits a very high intensity welding current pulse with a very short preset time (from 0.01 Sec to 1 Sec). The pulse time varies depending on the type of sheet metal to be joined. In this way the welded point closes instantly with minimum heat transfer, leaving the metal white, clean and almost cold.

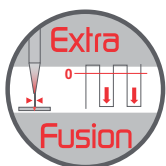
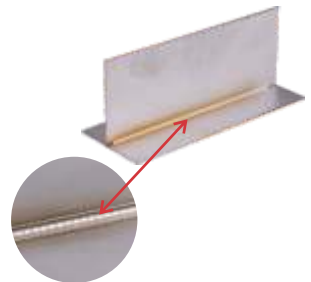
Pipe butt weld
Ø 31.75 x 2 mm



Corner spot welding thickness 0,6 mm

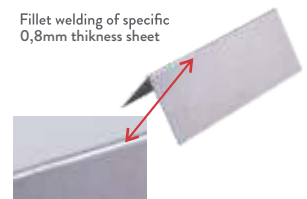


The MULTITACK system makes it possible to reduce heat output while joining two light gauge parts (0.6mm – 0.8mm). The series of arc strikes at short time intervals allows the material to cool during the pause between one strike and the other and thus minimizes its deformation. The facility to adjust the frequency of the series of arc strikes in the time unit makes it possible to adapt the electric arc to the welding speed and the joint geometry.



This function makes it possible to shift the waveform towards the negative part with respect to zero. This makes it possible to create a highly penetrative and precise fusion bath so that very light gauge sheets can be welded with an electrode tip comparable to that of an electrode for DC - TIG welding. The adjustable value in our AC/DC TIG power sources ranges from 0% to 80% (with respect to the DC - halfwave percentage). The Extra Fusion function is not recommended when welding heavy gauges because the DC+ component is insufficient to ensure optimal cleaning (pickling) of the part during the welding process.

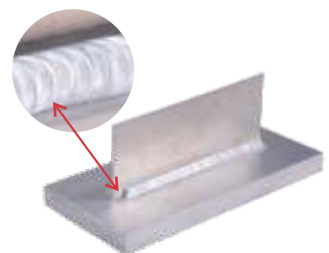
Fillet welding of specific
0,8mm thickness sheet



Particular on the fillet welding.
It is possible to notice the remarkable degree
of finishing and the high welding precision



This function MIX AC/DC makes it possible to modulate the welding current, alternating a half-period of TIG AC with a half-period of TIG DC-. This means that the efficacy of AC TIG welding can be combined with the high penetration of DC TIG welding, thus obtaining high welding speed and creating the weld puddle rapidly on a cold workpiece. It is also possible to weld heavier gauges with lower amperage, since the DC- portion is far higher than when using an entirely AC waveform. The operator adjustable parameter is the percentage of AC waveform compared to DC waveform over the entire period, which can be varied from 10% to 80%.

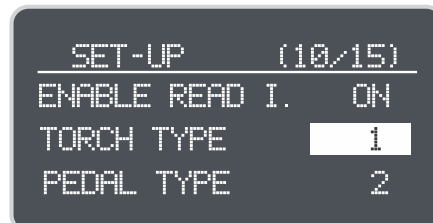




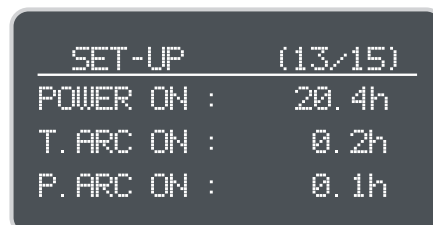
Menu for use with a USB-Stick



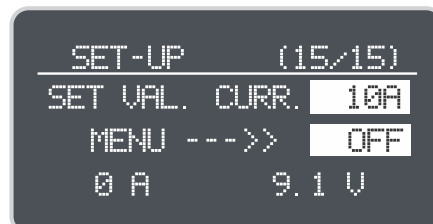
Different remote-control types can be applied including selection of different torch settings



Welding hour counter

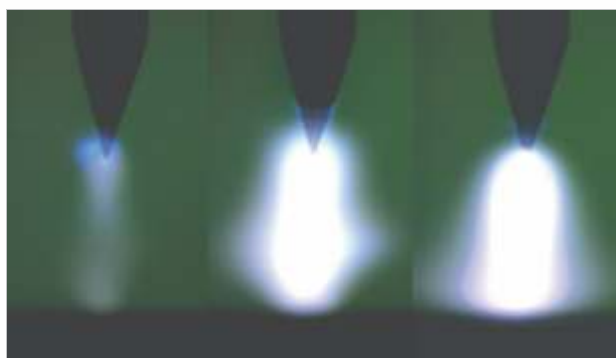


Validation and Calibration system for welding parameters reading in accordance with EN 60974-14 (EN50504)



TIG AC and DC Ignitions have been optimized

It is possible to regulate the current impulse dynamics in relation to the electrode diameter in order to achieve perfect arc-ignitions and optimum weld conditions every time. This setting avoids inconsistent arc-ignitions and welding defects.





COMPATIBILITY AND ACCESSORIES



**CHAMP TIG 221
AD EVO**

COMPATIBILITY



LIGHTNESS

The lightness of Champ TIG 221 AD EVO makes it particularly suitable for maintenance and mobile welding.



COMPACTNESS

The compactness of Champ TIG 221 AD EVO makes it easy to place it even on a working environment of small size.



TRANSPORTABILITY

A sturdy strap makes Champ TIG 221 AD EVO easily transported from one workplace to another.

ACCESSORIES



FOOT PEDAL



SOFTWARE UPGRADE
OF THE WHOLE MACHINE



UP & DOWN TORCH



REMOTE CONTROL



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