



- Water-cooled DC TIG cold wire inverter welding machine
- Features user database for Synergic operation at no extra charge
- Simple, menu-guided selection of welding tasks from user database
- 256 pre-programmed JOBS/characteristics in the user database
- 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
- TIG automated pulsing with automatic specification of required pulse parameters
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- **Please select the relevant hot and cold wire components from accessories!**
- Non-latched/latched operation
- 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/gouging**
- MMA/gouging, automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Antistick function
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Connection capability for remote control and function torch
- Crane-liftable casing
- Can be optionally networked with LAN or WiFi and EWM Xnet software

	TIG		MMA	
Setting range for welding current	5 A - 350 A			
Duty cycle at ambient t.e	40 °C	25 °C	40 °C	25 °C
100 %	350 A			
Open circuit voltage	79 V			
Mains frequency	50 Hz / 60 Hz			
Mains fuses (slow-blow)	3 x 25 A			
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Max. connected load	10.9 kVA		15.4 kVA	
Recommended generator power	14.7 kVA		20.8 kVA	
cos φ	0.99			
Efficiency	90 % , 88 %			
Drive rolls	4			
Wire speed	Wire speed m/min, 0.2 m/min - 10 m/min			
Dimensions machine, LxWxH in mm	1100 x 680 x 1000			
Wire feeder, LxWxH in mm	690 x 300 x 410			

Weight, machine	134 kg
Wire feeder weight	13.7 kg
Protection classification	IP 23
Torch connection	Decentral
Cooling output	1500 W (1l/min)
Tank capacity	12 l
Flow rate	5 l/min
Max. output pressure	3.5 bar

Welding site equipment for TIG welding

Tetrix drive 4L

090-000094-00502



- Wire feeder, aluminium casing
- Easy transport thanks to low weight and compact design
- A demodular Tetrix power source with connections for wire feeders is required for operation!
- Spool diameter up to 300 mm
- Casing: aluminium, dimensions: L x W x H in mm 690 x 300 x 410, weight: 15.1 kg

TIG W 70qmm KD 28POL 2m

094-010898-R0001



- Intermediate hose package, cold wire

TIG 450 GRIP WD CW U/D HFL 12P 4m flex.

094-500094-10200



- Water cooled TIG welding torch with a separate cold wire feed
- Wire feeding quantity setting during welding
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Replaceable steel/plastic liner
- Replaceable wire feed rotatable through 270°
- Wire feed integrated in the grip
- Excellent HF safety
- Equipment as delivered:
- Gas diffuser, multi-layer: Ø 3.2 mm
- Gas nozzle: Ø 10 mm, size 6
- Tungsten electrode E3 (purple): Ø 3.2 mm
- Back cap, short

KF 23E-10, -10

094-000530-00000



- Coolant (-10 °C), 9.3 l

OW CEE 32A

092-008215-00000



- Factory fitting (no retrofitting)
- Suitable for all machines with a welding current of 350 A and above

Welding site equipment for TIG welding

WK70mm² 450A/60% 4m/Z

092-000013-00000



- Completely assembled workpiece lead with clamp

DM 842 Ar/CO₂ 230bar 30l D

394-002910-00030



- Manufactured in accordance with ISO 2503
- Maximum primary pressure of 230 bar
- Single-stage
- Infinite and highly accurate adjustment
- Safety manometer with pressure meter or flow meter (bar/psi or litres per minute)
- With cut-off valve

Gas hose

094-000010-00001



- Equipped with plastic nuts on both sides for tool-free assembly

Accessories

ON LG-EX

090-008789-00502



- Networking via external LAN gateway for machines with 7-pole digital interface

ON WLG-EX

090-008790-00502

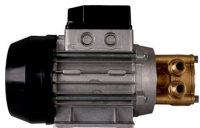


- Networking via external WiFi gateway for machines with 7-pole digital interface

- Retrofit kit for helium welding

OW Reinforced Pump T/P

092-002118-00001



- Reinforced coolant pump
- Recommended for long hose packages. Increases the flow rate up to 20 l/min and the pressure to max. 4.5 bar

OW Multivolt 451/551

092-002542-00001

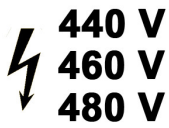


- Multi-voltage design for operation with mains voltages of 230 V, 400 V and 480 V

Accessories

OW 480Volt 351/451/551

092-002647-00001



- Multi-voltage design for operation with mains voltages of 440 V, 460 V and 480 V
- Not possible with the compact 355 series machines!

ON 7pol

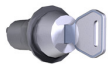
092-001826-00000



- Connection socket

ON Key Switch Tetrax

092-001828-00000



- Key switch

ON LB Wheels 160x40MM

092-002110-00000



- Front wheels with locking brake allow the machine to be safely parked even on uneven ground.
- Locking brake cannot be combined with ram protection!

ON Holder Gas Bottle <50L

092-002151-00000



- Holding plate for gas cylinders smaller than 50 litres
- Transport even small gas cylinders safely on the machine
- Not suitable for mounting on double cylinder carts!

Accessories

ON Shock Protect

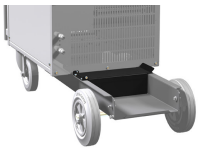
092-002154-00000



- Ram protection: protects the machine from scratches and dents. Highly recommended if the machine is transported frequently
- Not possible in combination with parking brake, wheel spacers or double cylinder cart!

ON Tool Box

092-002138-00000



- Toolbox between gas cylinder and rear casing panel
- Tools and torch replaceable parts always to hand.
- Dimensions L x W x H in mm: 240 x 100 x 80

ON 19pol 351/451/551

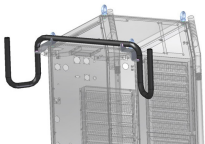
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- 19-pole connection socket for accessory components and/or as analog interface for automated welding

ON HS XX1

092-002910-00000



- Mount for hose packages and remote control
- Keeps the machine tidy: tubes and cables from items such as welding torches or remote controls can be coiled on the machine, so that they are neat and tidy. Also helps to fix remote controls in place
- For all mobile alpha Q/Phoenix/Taurus/Tetrix 351/401/451/551 machines

Tetrix 270 Hotwire

090-000164-00502



- Suitable for the Tetrix AW series only!
- TIG constant current source for wire preheating

Accessories

Tetrix drive 4L

090-000094-00502



- Wire feeder, aluminium casing
- Easy transport thanks to low weight and compact design
- A demodular Tetrix power source with connections for wire feeders is required for operation!
- Spool diameter up to 300 mm
- Casing: aluminium, dimensions: L x W x H in mm 690 x 300 x 410, weight: 15.1 kg

TIG W 70qmm HW 70qmm 2m

094-015223-00001



- Intermediate hose package, hot wire

TIG W 70qmm KD 28POL 2m

094-010898-R0001



- Intermediate hose package, cold wire

SPOTARC TIG 18 W 5P 4m

094-500048-00000



- Spot welding torch, with welding nozzles for fillet welds, edge welds and flat welds incl. setting gauge
- Better surface formation in comparison to resistance welding
- Flatter spot formation in comparison to MAG spot welding
- Excellent seam quality due to minimal heat input
- Very low thermal stresses and little distortion due to short welding times
- Perfect for visible joints due to clean seam appearance
- Robust design
- Excellent HF safety
- **Equipment as delivered:**
- Collet body: Ø 2.4 mm

- Crimpkontakt

Accessories

TIG 200 GRIP GD CW flex 3M

094-500132-10203



- Gas cooled TIG welding torch with integrated cold wire feed
- Setting of welding current and programs
- Ergonomic GRIP handle for a secure grip
- Highly flexible hose package with 1 m leather protector
- Replaceable steel/plastic liner
- Replaceable wire feed rotatable through 270°
- Ceramic-coated wire support
- Three fixed wire feed angles: 30°, 39° and 42°
- Flexible wire feed angles between 15°–42°
- **Equipment as delivered:**
- Gas diffuser, multi-layer: Ø 3.2 mm
- Gas nozzle: Ø 10 mm, size 6
- Tungsten electrode E3 (purple): Ø 3.2 mm

TIG 450 GRIP WD CW U/D HFL 12P 3m flex.

094-500094-10203



- Water cooled TIG welding torch with a separate cold wire feed
- Wire feeding quantity setting during welding
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Replaceable steel/plastic liner
- Replaceable wire feed rotatable through 270°
- Wire feed integrated in the grip
- Excellent HF safety
- Equipment as delivered:
- Gas diffuser, multi-layer: Ø 3.2 mm
- Gas nozzle: Ø 10 mm, size 6
- Tungsten electrode E3 (purple): Ø 3.2 mm
- Back cap, short

Accessories

TIG 450 GRIP WD HW U/D HFL 12P 3m flex.

094-500098-10203



- Water cooled TIG welding torch with a separate cold and hot wire feed
- Water-cooled TIG welding torch
- Wire feeding quantity setting during welding
- Equipment ex works:
- Gas diffuser: Ø 3.2 mm
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Replaceable steel/plastic liner
- Replaceable wire feed rotatable through 270°
- Wire feed and hot wire current lead integrated in grip
- Excellent HF safety
- Equipment as delivered:
- Gas diffuser, multi-layer: Ø 3.2 mm
- Gas nozzle: Ø 10 mm, size 6
- Tungsten electrode E3 (purple): Ø 3.2 mm
- Back cap, short

TIG 450 GRIP WD CW WO U/D HFL 12P 3m flex.

094-500157-10203



- Water cooled TIG welding torch with a separate cold wire feed
- Ideal for welding particularly soft wires due to external wire feed
- Setting of welding current and programs
- Ergonomic GRIP handle for a secure grip
- Highly flexible hose package with 1 m leather protector
- Delivered ready to weld ex works
- Replaceable steel/plastic liner
- Replaceable wire feed rotatable through 270°
- Ceramic-coated wire support
- **Equipment as delivered:**
- Gas diffuser, multi-layer: Ø 3.2 mm
- Gas nozzle: Ø 10 mm, size 6
- Tungsten electrode E3 (purple): Ø 3.2 mm

Accessories

TIG 450 GRIP WD CW/HW OW U/D HFL 12P 3m

094-500158-10203



- Water cooled TIG welding torch with a separate cold and hot wire feed
- Ideal for welding extremely soft or extremely hard wires thanks to external wire feed
- Wire feeding quantity setting during welding
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Replaceable steel/plastic liner
- Replaceable wire feed rotatable through 270°
- Excellent HF safety
- Equipment as delivered:
 - Gas diffuser, multi-layer: Ø 3.2 mm
 - Gas nozzle: Ø 10 mm, size 6
 - Tungsten electrode E3 (purple): Ø 3.2 mm
 - Back cap, short

GT 600 SKK95

094-016099-00000



- Compressed air gouging torch for separating metals
- Suitable for round carbon electrode Ø 3–10 mm, flat carbon electrode (width 10/16 mm; 5 mm thick)
- High-strength, heat-insulated grip
- Rotatable nozzle
- Suitable carbon electrodes can be found in the Accessories section of the price list!

KF 23E-10, -10

094-000530-00000



- Coolant (-10 °C), 9.3 l

RT50 7POL

090-008793-00000



- The RT50 7POL remote control allows machines with a 7-pole connection to be equipped with a second remote control
- Robust metal casing with rubber feet, retaining clip and holding magnet, 7-pole connection socket

Accessories

RT1 19POL

090-008097-00000



- Remote control, current
- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Operating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet

RTG1 19POL 5m

090-008106-00000



- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- With pre-fitted 5 or 10 m connection cable
- Operating point setting directly at the site of welding
- For Tetrix, Picotig 200 AC/DC and Stick machine series

RTP1 19POL

090-008098-00000



- Remote control, pulse, spot and pause times are infinitely adjustable.
- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Pulse/spot/normal
- Operating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- For Tetrix and Picotig 200 AC/DC machine series

RTP2 19POL

090-008099-00000



- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Pulse/spot/normal
- Frequency and spot times infinitely adjustable.
- Coarse adjustment of the cycle frequency.
- Pulse/pause ratio (balance) adjustable from 10% to 90%.
- Operating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- For Tetrix and Picotig 200 AC/DC machine series

Accessories

RTP3 spotArc 19POL

090-008211-00000



- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Remote control, pulse / spotArc spot welding / normal
- Frequency and spot times infinitely adjustable.
- Coarse adjustment of the cycle frequency.
- Pulse/pause ratio (balance) adjustable from 10% to 90%.
- Operating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- For Tetrix and Picotig 200 AC/DC machine series

RTF1 19POL 5 M

094-006680-00000



- Foot-operated remote control, start/stop
- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Start/stop welding operation
- Operating point setting directly at the site of welding

OW CEE 32A

092-008215-00000



- Factory fitting (no retrofitting)
- Suitable for all machines with a welding current of 350 A and above

5POLE/CEE/32A/M

094-000207-00000



- Mains plugs

WK25mm² 230A/60% 4m FIX

398-000593-00000



- Completely assembled workpiece lead with original FIX clamp

Accessories

WK70mm² 450A/60% 4m/Z
092-000013-00000



- Completely assembled workpiece lead with clamp

WK25mm² 230A/60% 4m/K
092-000016-00000



- Completely assembled workpiece lead with terminal

Tigex
094-001813-00001



- Single stage pressure regulator with float type meter for flow measurement

DM 842 Ar/CO₂ 230bar 15l D
394-002910-00015



- Manufactured in accordance with ISO 2503
- Maximum primary pressure of 230 bar
- Single-stage
- Infinite and highly accurate adjustment
- Safety manometer with pressure meter or flow meter (bar/psi or litres per minute)
- With cut-off valve

ON AL D13/27
092-003282-00000



- Cap for load sockets

Accessories

Gas hose

094-000010-00005



- Equipped with plastic nuts on both sides for tool-free assembly