

Tetrix 351 DC Comfort 2.0 puls

090-000246-00502



WE ARE WELDING



- Water-cooled DC TIG inverter welding machine
- Comfort 2.0 control, simple operation with click wheel
- **TIG welding**
 - 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 average value pulsing: the preset welding current is maintained at all times, so particularly suitable for welding as per welding procedure specification
 - TIG automated pulsing with automatic specification of required pulse parameters
 - Pulsed TIG welding in Hz and kHz range up to 15 kHz
 - 8 programmed JOBs (welding tasks)
 - Non-latched/latched operation
 - Reduced secondary current accessible using torch trigger
 - Spot welding/tack function (spotArc/spotmatic)
 - spotmatic and spotArc with direct access
 - 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
 - 8 programmed JOBs (welding tasks)
 - Safe, reliable vertical-up and vertical-down welding
 - Adjustable hot start current and hot start time
 - Adjustable Arcforce
 - Antistick function
- **Highlights**
 - 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 connected to LAN or WiFi. Xnet-compatible
 - PC interface for PC300.Net 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 %			
Dimensions machine, LxWxH in mm	1085 x 680 x 1003			

14.06.2018

Welding site equipment for TIG welding

TIG 450 GRIP WD 5P 4m

394-510993-00600



- Water-cooled TIG welding torch
- Double push-button
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Excellent HF safety
- **Equipment as delivered:**
- Electrode holder: Ø 2.4 mm
- Gas nozzle: Ø 11 mm, size 7
- Tungsten electrode E3 (purple): Ø 2.4 mm

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

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

Welding site equipment for TIG welding

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

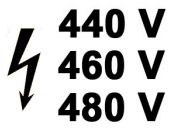


- Multi-voltage design for operation with mains voltages of 230 V, 400 V and 480 V

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 Filter T/P

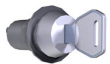
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- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.
- For all mobile alpha Q/Phoenix/Taurus/Tetrix 351/401/451/551 machines

ON Key Switch Tetrix

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

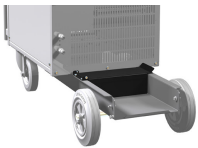
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- Ram protection: protects the machine from scratches and dents. Highly recommended if the machine is transported frequently
- Not possible in combination with parking brake, wheel spacers or double cylinder cart!

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

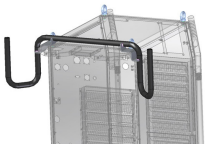
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- 19-pole connection socket for accessory components and/or as analog interface for automated welding

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

Accessories

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

TIG 450 GRIP WD 5P 8m

394-510993-00608



- Water-cooled TIG welding torch
- Double push-button
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Excellent HF safety
- **Equipment as delivered:**
- Electrode holder: Ø 2.4 mm
- Gas nozzle: Ø 11 mm, size 7
- Tungsten electrode E3 (purple): Ø 2.4 mm

TIG 450 GRIP WD 5P HFL 4m

394-510993-10600



- Water cooled TIG welding torch with a highly flexible hose package
- Double push-button
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Excellent HF safety
- **Equipment as delivered:**
- Electrode holder: Ø 2.4 mm
- Gas nozzle: Ø 11 mm, size 7
- Tungsten electrode E3 (purple): Ø 2.4 mm

Accessories

TIG 450 GRIP WD 8P U/D 4m

394-510993-00200



- Water-cooled TIG welding torch
- Setting of welding current and programs
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Suitable for devices from the Tetrix DC and AC/DC series
- An 8-pole connection socket is required for portable machines
- Excellent HF safety
- **Equipment as delivered:**
- Electrode holder: Ø 2.4 mm
- Gas nozzle: Ø 11 mm, size 7
- Tungsten electrode E3 (purple): Ø 2.4 mm

TIG 450 GRIP WD 8P U/D HFL 4m

394-510993-10200



- Water cooled TIG welding torch with a highly flexible hose package
- Setting of welding current and programs
- Ergonomic GRIP handle for a secure hold and ergonomic use
- Suitable for devices from the Tetrix DC and AC/DC series
- An 8-pole connection socket is required for portable machines
- Excellent HF safety
- **Equipment as delivered:**
- Electrode holder: Ø 2.4 mm
- Gas nozzle: Ø 11 mm, size 7
- Tungsten electrode E3 (purple): Ø 2.4 mm

TIG 450 WD GRIP 12P RETOX HFL 4m

394-510993-10700



- Water cooled TIG welding torch with a highly flexible hose package
- Setting and display of welding current and programs
- Ergonomic GRIP handle for a secure hold and ergonomic use
- For Tetrix DC, AC/DC Comfort and Synergic
- "ON 12-pole connection socket" option required
- Excellent HF safety
- **Equipment as delivered:**
- Electrode holder: Ø 2.4 mm
- Gas nozzle: Ø 11 mm, size 7
- Tungsten electrode E3 (purple): Ø 2.4 mm

Accessories

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

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

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

Accessories

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

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

Accessories

OW CEE 32A

092-008215-00000



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

ON 12pol Retox TIG 1807 (300/351-551)

092-001807-00000



- Connection socket

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

WK16mm² 170A/60% 4m/K

094-005314-00000



- Completely assembled workpiece lead with terminal

WK70mm² 450A/60% 4m/Z

092-000013-00000



- Completely assembled workpiece lead with clamp

Accessories

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

ON AL D13/27

092-003282-00000



- Cap for load sockets

Gas hose

094-000010-00003



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