

## TIG/STICK WELDING EQUIPMENT »

# alphaTIG 225Xi



## PRO LEVEL FEATURES AND PERFORMANCE

- NO NONSENSE ANALOG INPUT DESIGN FOR EASY SETUP
- AC AND DC OUTPUT FOR TIG AND STICK
- SUPPORTS OPTIONAL WATER COOLER
- FEATURES ARE GROUPED BY COLOR AND FUNCTION
- FAST RATE OF PULSE IN AC AND DC MODES UP TO 200 Hz
- 225 A TIG OUTPUT @ 35% DUTY CYCLE (AC OR DC)
- 185 A STICK OUTPUT @ 35% DUTY CYCLE (AC OR DC)
- OPERATES ON 240V OR 120V OUTPUT ( $\pm 10\%$ )



## APPLICATIONS:

- MOTOR SPORTS/AEROSPACE
- FABRICATION/PROTOTYPING
- HOME/HOBBY
- HVAC
- PRODUCTION WELDING
- PORTABLE REPAIR

## DESIGNED FOR SIMPLICITY.

Even though the AlphaTIG 225Xi is full of features, and packed with plenty of performance, the unit is simple enough for any hobbyist to get started with TIG welding, thanks to its analog “at-a-glance” design and color coded grouping of functions. However, the list of features is long enough and advanced enough for any professional to use. This unit is uniquely suited a unit that will “grow” with the beginning user or professional business, without needing to upgrade later on. By offering plenty of power and features such as adjustable AC balance, AC Frequency, and Pulse, the unit has the credentials you would expect in a much more expensive welder. The square wave, AC/DC output inverter design keeps the unit light

and portable, and allows it to be to weld any metal you find, including Aluminum, Steel, Stainless (Inox), Titanium, and even Copper.

This unit has power to spare as well. For Aluminum, you can expect to be able to weld 1/4” thick material in a single pass, and up to 1/2” in multiple passes. For Steel and Stainless, you should be able to weld upwards of 3/8” in a single pass if required. Multiple passes could go as high as 5/8” or 3/4”.\* This units duty cycle is also is high enough to keep you welding with little interruptions even at 200 or more Amps.

[\*Keep in mind best industry practices usually require, thinner, multiple passes for strongest welds on materials 1/4” and over. Heavy, thick passes are often discouraged or prohibited by codes or protocols. The ratings are given for comparative information only to give an idea of the capability of the unit.]



# alphaTIG 225Xi



## ALPHATIG 225Xi SPECIFICATIONS

Voltage Input	120V/240V
Input Amperage 120V Inrush (I <sub>1MAX</sub> ), Rated Effective (I <sub>1EFF</sub> )	42A/25A
Input Amperage 240V Inrush (I <sub>1MAX</sub> ), Rated Effective (I <sub>1EFF</sub> )	35A/24A
TIG Output 120V AC/DC	20-150A, 10.8-16V / 10-150A, 10.4-16V
TIG Output 240V AC/DC	20-225A, 10.8-19V / 10-225A, 10.4-19V
Stick Output 120V AC/DC	20-125A, 20.8V-25V / 10-125A, 20.4V-25V
Stick Output 240V AC/DC	20-185A, 20.8-27.8V / 10-185A, 20.4V-27.4V
OCV	75V
TIG Duty Cycle @ Max Output 120V/240V	60% @ 150A, 16V / 35% @ 225A, 19V (60% @ 200A, 18V)
Stick Duty Cycle @ Max Output 120V/240V	35% @ 125A, 25V / 35% @ 180A, 27.4V (60% @ 160A, 26.4V)
E6010 Capable	No, use E6011
TIG Pre Flow Gas/Post Flow Gas Time (Seconds)	0-10 S / 0-25 S
TIG Up Slope/ Down Slope Time (Seconds)	Up Slope Not Adjustable/ Down Slope: 0-25 S
TIG Start/End Amps AC/DC	20A AC, 10A DC to 225A / 20A AC, 10A DC to 225 A
AC Frequency	20-200 Hz
AC Balance	10-90% of Electrode Positive
TIG Pulse Frequency (Hertz) AC/DC	.5-200 Hz / .5-200 Hz
TIG Pulse Time On (Percent)	5-95 %
TIG Base Pulse Amps (Percent)	5-95 %
2T/4T/Pedal Control Capability	Yes
TIG Start Type	HF Start Only, No Lift Start
Unit Weight and Dimensions	50 lbs., 18"H X 9.5"W X 25"L
Plug Type and Length	NEMA 6-50P, 6.5 ft.



### STANDARD PACKAGED ACCESSORIES:

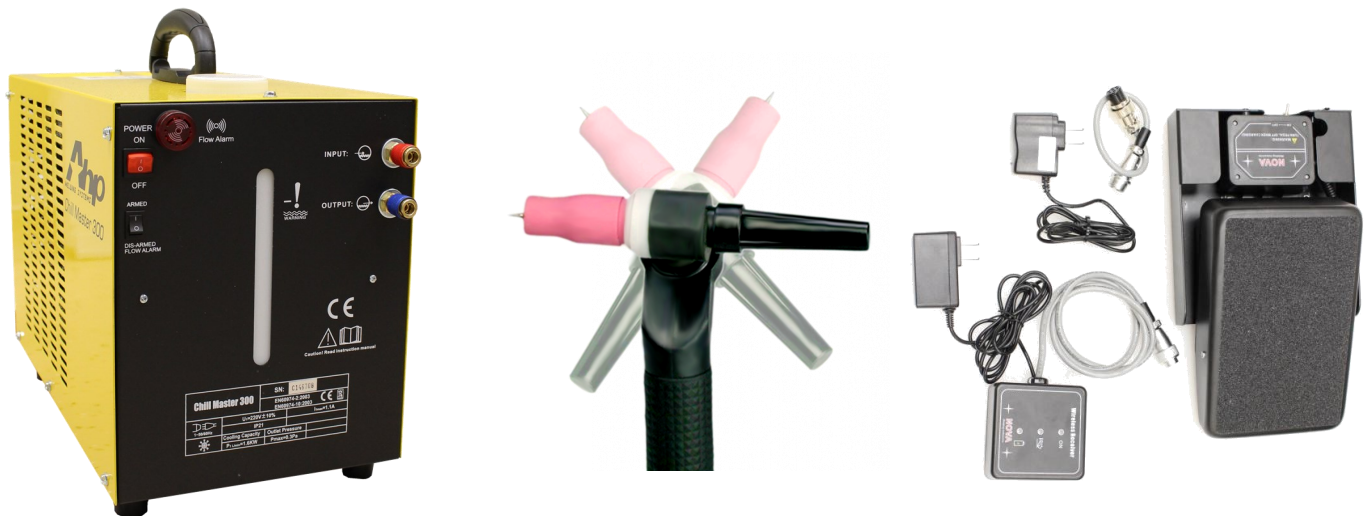
- NOVA 26 SERIES RIGID NECK TIG TORCH (AIR COOLED) WITH 12.5 FT. CABLE AND DINSE 35/70 DINSE TYPE POWER CONNECTION
- 250A STICK ELECTRODE HOLDER, WITH 9 FT. CABLE AND CONNECTOR
- WORK CLAMP WITH 6 FT CABLE AND CONNECTOR
- FLOATING BALL TYPE (BRASS BILLET CONSTRUCTION) REGULATOR AND HOSE
- NOVA FOOT PEDAL WITH 25 FT CABLE AND 7 PIN CONNECTOR
- 240V TO 120V INPUT PIGTAIL POWER ADAPTER (NEMA 6-50P TO 15-5R)
- BASIC CONSUMABLE STARTER KIT (TUNGSTEN NOT INCLUDED)

# alphaTIG 225Xi



## SUGGESTED OPTIONAL ACCESSORIES:

- CHILL MASTER 300 WATER COOLER
- NOVA ROTAFLEX 20 SERIES TIG TORCH (WATER COOLED) 12.5 FT. OR 25 FT.
- NOVA WIRELESS PEDAL FOR AHP PRODUCTS



## FRONT PANEL USER INTERFACE:



## SALES CONTACT NORTH AMERICA:

AHP WELDING SYSTEMS

[sales@ahpwelds.com](mailto:sales@ahpwelds.com)

925-391-3599

380 Swift Ave # 11

South San Francisco California 94080