

The TITAN 231 DC FV is a professional 230A single-phase TIG power source with IP23 protection, designed to endure demanding operating conditions. Its advanced technology delivers a totally stable arc and superior weld quality, and its high duty cycle is ideal for industrial and robotic applications.

## 2 WELDING PROCESSES

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| TIG DC | <b>DC Standard:</b> smooth current welding on most ferrous materials.   |
| TIG DC | <b>DC Pulse, up to 2 kHz:</b> limits the temperature of the weld pool, reduces deformation and allows the assembly of thin sheet materials from 0.3 mm. |
| MMA    | <b>Standard MMA:</b> coated, rutile, basic and cellulosic electrodes (up to Ø 5 mm).  |
| MMA    | <b>MMA Pulse, up to 500 Hz:</b> facilitates welding in a vertical upright direction (tubes/pipelines, etc.)   |



Supplied without accessories

## ENHANCED TIG SETTINGS

- **TIG duty cycle 100% at 200 A**
- **4 spot modes:**
  - Spot / Multi Spot : traditional spot welding before joining thin sheets.
  - Tack / Multi Tack : ultra-precise and oxidation-free tacking reducing the risk of deformation.
- **3 types of ignition:** Lift, HF and Touch.HF (timed high frequency ignition).
- **3 trigger management options:** 2T, 4T and 4T LOG
- **Pulse TIG waveform settings for arc control and penetration.**
- **E-Weld mode** ensures that the unit delivers the required welding power regardless of the position of the torch in relation to the workpiece (control of welding energy).

## MAXIMUM CONNECTIVITY

- Accurately measuring power supply.
- Calibration mode for welding accessories (refines calculation of power usage).
- Ready for robotic integration via an optional kit (037960).
- Storage of up to 50 programs per process for recurring tasks.
- Compatible with slat, dual button, potentiometer and Up & Down torches.
- Full machine updates available via USB stick.
- Remote controls (foot switch or optional manual) connectable without the use of tools.
- Optional cooling unit (070820) with easy and tool-free installation.
- VRD can be activated to lower the no-load output voltage < 35 V.
- «FV» technology maintains a stable arc in case of mains voltage variations (85-265 V), power supplied via a generator, or when using very long power cables.



Dual display user interface with rotary knob and push button for fast adjustment of parameters

Main menu	Advanced menu
- pre-gas / post-gas	- I start / t start
- current upslope	- I stop / t stop
- welding current	- pulse waveforms
- downslope time	- spot time (0>60 sec)
- hot current	- time between two spots (0.1>25 sec)
- pulse frequency	
- cold current balance time	

## IDEAL ON SITE

- Suitable for extension cords up to 100m.
- Reinforced construction and anti-shock feet.
- IP23 rating
- Space-saving and easy to move on site.
- Protected against overvoltage up to 400 V (PROTEC 400).

## ACCESSORIES (optional)

 TIG torch - 8 m SR26L 046184    SR26DB 046177		 Cooling unit 1000 W 3 L - 14 kg KOOLWELD 1 070820		 Quick fixing kit 076006		 Trolley 10m <sup>3</sup> 076341		Analogue remote controls:  RC-HA1 - 8 m 045675  RC-FA1 - 4 m 045682		Digital remote controls:  RC-HD2 062122 +  Kit NUM-1 063938	
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50/60 Hz	A	I <sub>2</sub> TIG	I <sub>2</sub> MMA	INTEGRATED TECHNOLOGY		TIG			MMA			U <sub>0</sub>	U <sub>R</sub>	mm <sup>2</sup>	cm	kg	IP	2 m	Protected & compatible power generator (+/-15%)
				TIG DC PULSE	MMA PULSE	EN 60974-1 (40°C)			EN 60974-1 (40°C)										
110 V - 1~	32	3 → 140	5 → 120	0.1 → 2 kHz	0.4 → 500 Hz	120 A	40 %	100 A	85 A	23 %	70 A	69	31 (VRD)	35/50	49 x 26 x 40 cm	16.5	IP 23	2 m	12.5 kVA
230 V - 1~	16	3 → 230	5 → 230			215 A	45 %	200 A	175 A	25 %	145 A	77.5							