



for Welding Excellence

INVA TIG DIGITAL SERIES

INVA TIG 400P AC-DC / INVA TIG 500P AC-DC
AC-DC PULSE TIG WELDING MACHINES

Consistency in quality & service **30** Years

Beneficial Features

- ⊙ Available in 2T/4T/SPOT modes.
- ⊙ Supports DC TIG, AC TIG, MMA, PULSE TIG DC/AC.
- ⊙ Both Pulse Time and Pulse Frequency adjustment is available for Superior quality welding result.
- ⊙ Digital microprocessor based system for accurate output in every time.
- ⊙ Confirms to IEC 60974 international Standards.
- ⊙ MMA Welding suitable for rutile,basic,unalloyed, low & high alloyed, nickel base & copper alloys.
- ⊙ More than 85% efficiency.
- ⊙ In-built Water cooling system.
- ⊙ Rust Proof coating to provide the worry free working even in saline or, marine weather.
- ⊙ Microcontroller or, microprocessor based digital control with 256 job saving facility.
- ⊙ Customized sinusoidal wave for better quality AC welding.
- ⊙ TIG welding suitable to weld different thickness(thin to thick) micro alloy steel, aluminum, stainless steel sections.

- ➔ DC TIG
- ➔ AC TIG
- ➔ Rectangular AC
- ➔ Sinusoid AC
- ➔ Triangular AC
- ➔ PULSE TIG
- ➔ MMA



INPUT		OUTPUT				
3 PHASE	50/60 Hz	CC	DC	AC	HF	DSP

BUILT IN FUNCTIONS FOR HIGH QUALITY TIG WELDING

Advance AC TIG Wave forms

Advance AC TIG Wave forms

Note: The Picture shows in the catalog is the advance ac-dc TIG welding machine, The standard machine may not give you the same look.

Excellent Welding for Higher Performance...

TECHNICAL SPECIFICATIONS

MODEL	INVA TIG 400P AC-DC DIGITAL		INVA TIG 500P AC-DC DIGITAL	
	TIG	ARC	TIG	ARC
Rated input volt	3 phase 410 V (-15%, +15%) , 50 / 60 Hz			
Max. input capacity	12.3 KVA	16.8 KVA	17.6KVA	23.5KVA
Rated input current (Slow blow Fuse)	3 x 17.4 A	3 x 24 A	3 x 24.7A	3 x 34 A
Rated current	5-400 A	5-400A	5-500 A	20-500A
Output Load Voltage	10- 26 V	10-34 V	10-30 V	20-40 V
Output Current @ 40% Duty	400 A	400 A	500 A	500A
Output Current @ 45% Duty	400 A	400 A	500 A	500 A
Output Current @ 60% Duty	400 A	400 A	500 A	500 A
Output Current @ 65% Duty	380 A	380 A	480 A	480 A
Output Current @ 100% Duty	310 A	310 A	400 A	400 A
Pulse ratio	1-100%			
AC bias	-50% TO +30%*			
Pulse frequency	0.2 - 200 Hz			
Pre / Post-gas flow	0.1-15s			
Up-slope	0.2-10s			
Down -slope	0.1-15s			
Rated duty cycle	60% (400A)		60% (500A)	
OCV	80V		80V	
Power factor	0.99			
Insulation degree of main transformer	H			
IP CLASS	IP23			
Weight	40Kg		70Kg	
Dimension	640 x 330 x 520		660 x 360 x 782	
Safety Standards	IEC 60 974-1; 3; 10 / CE / S-Safety sign / EMC class A			

Standard Scope of Supply

Power source	01 No.
Water cooled torch 4 mtr length	01 No.
Argon regulator cum flow meter	01 No.
Gas hose of 3 mtr Length	01 No.
Welding Cable for earthing of 3 mtr	01 No.



Gas cooled
Model SR - 26



Water cooled
Model WP - 18

Optional Accessories (At Extra Cost)

Remote control unit
Foot controlled remote
Water cooling unit(70 Ltrs / 20 Ltrs)
Water cooled torch
Auto TIG feeding systems



Remote Controller



Foot Controlled
Remote

Adjustment :0 to maximum current
continuous step less.
Cable Length :5 meters