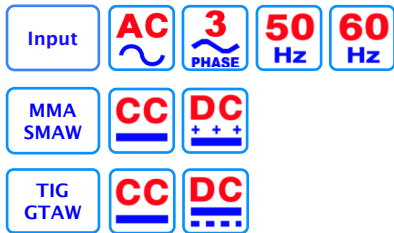




## SMAW / MMA DC Inverter Power 401 i



### Main Applications

- Installations and Outfitting
- Steel Fabricator
- Chemical and Process Industry
- Mechanical and Electrical
- Construction
- Metal Tank
- Sheet Metal
- Shipyard

### Advantageous

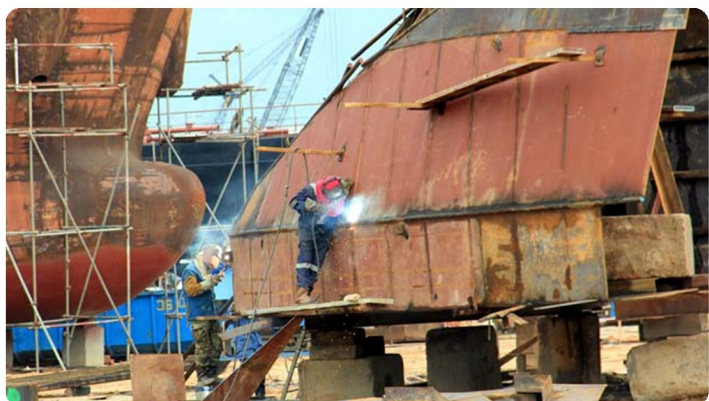
- MMA / SMAW DC Inverter welding machine, feature exceptional ignition and welding properties
- Compact design, minimal weight & user friendly
- IGBT Module Inverter Technology for durability
- Digital display for Welding Current
- Adaptability for Input Voltage fluctuation
- Automatic Hot Start for easily starting welding current
- Adjustable Arc Force function to reduce spatter
- Lift Arc - TIG ignition - DC Welding
- Voltage Reduction Device (VRD) system, especially for use in hazardous environments such as construction sites, shipyards and mining

MMA	Power 401 i
Weldable electrodes	1.6 - 6.0 mm
Material thickness	1 - 18 mm

TIG	
Tungsten range	1.6 - 4.0 mm
Material thickness	1 - 10 mm

Specifications	
Welding range	30 - 400 A
Load voltage	21.2 - 36 V
No load voltage	66 V
Current at 60 % at 40° C	400 A
Current at 100 % at 40° C	310 A
Input power at 100 %	14.4 KVA
Input current at 100 %	22 A
Input phase	3 P
Main voltage, Tolerance	380 V, ± 10 %
Power factor	0.95
Protection class	IP 23
Insulation	F
Cooling	F
Dimensions ( L x W x H )	520 x 260 x 440 mm
Weight	24 Kg

Item Code	Item Name
108.05.002.1	MMA Inverter - Power 401 i - Standard Package + Cable Plug 50 - 70 mm 2 pcs



Item Code	Item Name	MoQ
<b>Standard Accessories</b>		
108.05.001	MMA Inverter - Power 401 i	1 Unit
517.01.092	Welding Cable Plug 50-70 mm	2 Set
<b>Optional Accessories for SMAW / MMA</b>		
208.03.002	Plug to Electrode Holder 600 A, 70 mm <sup>2</sup> at 10 m	1 Set
208.03.003	Plug to Electrode Holder 600 A, 70 mm <sup>2</sup> at 20 m	1 Set
208.03.011	Plug to Electrode Holder 600 A, 50 mm <sup>2</sup> at 10 m	1 Set
208.03.012	Plug to Electrode Holder 600 A, 50 mm <sup>2</sup> at 20 m	1 Set
208.04.005	Plug to Ground Clamp 600 A, 70 mm <sup>2</sup> at 10 m	1 Set
208.04.008	Plug to Ground Clamp 600 A, 50 mm <sup>2</sup> at 10 m	1 Set
208.04.011	Plug to Ground Clamp 400 A, 50 mm <sup>2</sup> at 10 m	1 Set
<b>Optional Accessories for GTAW / TIG</b>		
250.38.002	Tig Torch - Air Cooled - WP 17 V-25-2 at 8 m	1 Set
250.38.003	Tig Torch - Air Cooled - WP 26 V-25-2 at 8 m	1 Set
201.23.001	Argon Gas Regulator	1 Pcs
250.01.006.1	Plug - Male - 35-50 mm - 2 Pcs	1 Pack
<b>General Accessories</b>		
208.18.001	Torch Holder - TIG	1 Pcs
201.22.009	Welding Helmet - Solarmatic Blue	1 Pcs

### Parameter for SMAW / MMA Welding Process

Electrode Ø	mm	1.6	2.6	3.2	4.0	5.0
Rutile	A	30 - 55	50 - 100	80 - 130	120 - 170	150 - 250
Basic	A	50 - 75	70 - 120	110 - 150	140 - 200	190 - 260
Cellulose	A	20 - 45	40 - 80	70 - 120	100 - 150	140 - 230

### Parameter for GTAW / TIG Welding Process



Thickness ( mm )	Welding Current ( A )			Tungsten ( mm )	TIG Rod ( mm )	Nozzle #	Gas Shielding ( l / Min )	Travel Speed ( cm / min )
	SS	Copper	Brass					
0.8 - 1.0	30-50	40-65	30-50	1.0 - 1.6	1.2 - 1,6	4 - 5	5-6	20 - 30
1.2 - 2.0	60-100	50-120	50-90	1.6 - 2.4	1.6 - 2.4	5 - 6	6-7	20 - 25
2.5 - 3.0	110-160	130-200	110-160	2.4 - 3.2	2.4 - 3.2	6 - 7	7-8	15 -25
4.0 - 5.0	170-220	220-300	200-250	3.2 - 4.0	3.2 - 4.0	7 - 8	10-12	15 -20
8.0 - 10.0	240-300	350-430	240-330	3.2 - 4.0	4.0	8 - 10	10-12	10 - 12