

## ARC WELDING UNIT IW-250 CD

**APPLICATION:** IW-250 CD provides high arc stability and AMP set lock. This makes starting the arc easier and prevents the welding rod from contacting the part surface. It also prevents excessive splatter which normally happens with spray transfer type welding rods such as stainless steel and low hydrogen content. That is why this welding unit is ideal for the whole range of DC electrodes..

**OPERATION:** AMP settings are fixed by means of a moving core regulated through a handle on the front part of the unit. This control allows the operator to set the right amperage according to both, the kind and diameter of welding rod and the thickness of the parts to be joined. The voltage selector (high and low) provides tow open circuit voltage ranges. A high voltage setting for low hydrogen content and cellulosic welding rods and a low setting for general welding.

**CHARACTERISTICS:**

- a) The transformer was made with silicon steel plates, electrical grade, to minimize power loss when idle as well as power consumption.
- b) Coils made with copper wire shielded with Dacron and fibreglass strands to withstand high temperatures.
- c) Rectifier made with silicon diodes and aluminium heat sinks.
- d) Stabilizer with copper wire coils to ensure high arc stability.
- e) Integrated cart with handlebars, two wheels and a front stand which make moving the welding unit around an extremely easy task.



POWER SUPPLY		LOAD	
Tension	220/440 V	Open circuit maximum tension	73 V
Current	47/95 A	Nominal arc tension	30 V
Actual power	15.8 Kw	Nominal current	250 A
Seeming power	20.9 Kw	Nominal work cycle	40%
Power factor	76%	Current for 100% work cycle	150 A
No.of phases	1	Amperage range	50-280 A
Frequency	60 Hrz		
Type of insulation	155°C		

TECHNICAL OUTLINE									
Nomimal outlet 20% Work cycle	Current range Amperes	Maximum voltage Open circuit	Power Supply		Widht	Height	Length	Weight	Actual Power
			127 V	220 V					
250 Amps at 30 Volts DC	Low 50-190 High 75-250	72 Volts CD	88 A	44 A	45.7 cm (18")	60.5 cm (23.8")	71.1 cm (28")	102 Kg	15.8 Kw