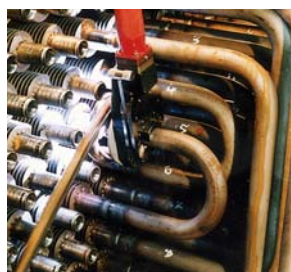


PS 254-2 MOBILE ALL POSITION ORBITAL TUBE WELDING POWER SOURCE TIG / GTAW – For Polysoude fusion weld heads and weld heads using cold wire



Ideal for use
in workshop

- The most simple to use and reliable system existing.
- Full function power source with useful welding features and convenient data acquisition for quality assurance.
- High precision inverter power source for perfectly controlled heat input and weld penetration.
- Made out of more than 40 years' experience in mastering welding technology.



PS 254-2 power source with
MU type open weld head



PS 254-2 power source with
TS type tube sheet weld head

UNIQUE FEATURES

- Non-volatile weld procedure library for all types of weld joints.
- Graphical intuitive user interface, no need for language translation capability.
- Programming by time or angular degrees, in RPM or 1 % of max. speed.
- Weld procedures are directly selected by the full function remote control.
- Key protected user interface.
- Paperless transfer and storage of weld procedures via built-in chip card manager.
- Real time data acquisition and print out via integrated printer.
- Closed loop regulation of rotation and wire speed.
- Integrated closed loop water cooling system for Polysoude weld heads and torches.
- Integrated safety valves for welding gas and torch cooling.
- Auto-diagnostic system.



Operator panel with integrated
printer and chip card manager for
weld procedure transfer and
storage

ACCESSORIES & OPTIONS for your particular needs

- PC off-line programming software with chip and compact flash card reader for weld procedure storage and transfer.
- Storage of real time welding programs / data acquisition by means of a built-in compact flash card manager.
- Adapter kits to use other than Polysoude weld heads.
- Manual tack welding kit including water-cooled TIG / GTAW torch.
- Dual weld head switch box.
- Extension cable (15 m).
- Gas hose.
- Pressure regulator and flowmeter.



Full function
remote control

PS 254-2 MOBILE ALL POSITION ORBITAL TUBE WELDING POWER SOURCE

POWER SOURCE SPECIFICATION

Input power	Three phase + earth 400 V ± 10 % – 50 or 60 Hz Option: multi voltage kit from 200 V to 480 V
Open circuit voltage	92 V
Insulation class	F
Protection class	IP 21 IK04
Welding current	4 to 250 A – constant or pulsed
Welding current precision	± 1 % when I > 100 A and ± 1 A when I ≤ 100 A
Duty cycle	250 A / 100 %
Motion controls	Torch rotation: constant or pulsed Wire feeding: constant or pulsed / automatic wire retract
Shielding gas control	Welding gas, backing gas (option) with flow safety valve
Power source cooling	Forced ventilation
Welding torch cooling	Built-in closed loop water cooling system with flow safety valve
Display / recording (non-volatile) of real values during welding	Arc voltage, welding current, electrode position in angular degrees, rotation and wire speed
Temporary "user" memory	16 programs
Weld procedure library (non-volatile)	60 programs
Weld program storage / transfer	Memo chip card
Real time data acquisition storage	Compact flash card (option)
Dimensions L x W x H	1060 x 580 x 1030 mm
Weight	145 kg (190 kg with multi voltage option)
Standards	EN 60974-1 / EN 50199



*Graphical intuitive user interface
(no language skills are required)*