



# STRATA

## SUPERIOR WELDING PRODUCTS

### • ADVANCETIG 325AC/DC •

#### INVERTER TIG WELDER

Featuring the latest IGBT and active PFC technology the ADVANCETIG 325AC/DC is reliable, easy to use and energy efficient. Designed tough with IP23 and high quality, overspecified components - this machine is made for rugged NZ workshops and onsite tasks.



- IGBT module inverter technology for smooth & stable output, increased reliability and high duty cycle
- Phase loss protection shuts machine down automatically if power supply phase loss occurs, preventing damage
- Optional integrated heavy duty industrial trolley available with optional integrated water cooler
- Industrial IP23 casing with front panel protection resists damage, moisture and corrosion
- Microprocessor control system for superior and dynamic arc characteristics
- Extreme stress tested in production up to 550V, ensuring rugged reliability
- Lift TIG and HF start modes gives versatility when welding around sensitive electronic equipment
- Electronic HF TIG arc ignition system, contamination free and easy arc starting with low EMF interference
- 2T/4T multi-level trigger control modes
- Dual digital display meters for accurate pre-setting and feedback of welding parameters and output
- Durable and reliable with high quality & over specified electronic components
- Intelligent protection system with temperature, voltage and current sensors for increased reliability and safety
- Designed to work with generator power supply with protection from power surges
- Potentiometer torch/ foot pedal remote control
- All remote functions connect through single plug 12 pin connection
- Power source wind tunnel cooling construction helps protect against environmental contamination
- Quick connect inlet gas fitting
- Accessories include integrated trolley and water cooler, 3m earth lead with heavy duty earth clamp, 4m MMA lead with heavy duty twist lock electrode holder, Strata Professional PRO18 water cooled 25ft TIG torch with thumbwheel remote control, 2 stage flowmeter, argon gas regulator, 4m gas hose, gas inlet quick connector and hose clamps.



ALTERNATING/  
DIRECT  
CURRENT



CORROSION  
RESISTANT



SPIKE/  
GENERATOR  
SAFE



IGBT  
INVERTER  
TECHNOLOGY



INTELLIGENT  
PROTECTION  
SYSTEM



WATER  
COOLER



400V 50HZ  
3 PHASE

#### ADVANCETIG 325AC/DC

DIMENSIONS (LxWxH)	WEIGHT	INPUT POWER SUPPLY	INPUT POWER SUPPLY TOLERANCE	MAXIMUM INPUT CURRENT	GENERATOR CAPACITY	MMA, AC/DC TIG CURRENT OUTPUT	MMA O/C VOLTAGE	MMA /AC TIG/ DC TIG DUTY CYCLE	TIG UP SLOPE DOWN SLOPE ADJUSTMENT	TIG GAS POST FLOW/PRE-FLOW ADJUSTMENT	TIG PULSE FREQUENCY
550 x 240 x 445mm	26kg	400V AC 32A 3 PH 50/60Hz	±10%V	32A	22.5kVA	10 - 320A	74V	320A@60% 250A@100%	0-10s	0-2/0-10s	0.5 - 250Hz

TIG PULSE WIDTH RANGE	AC TIG WAVEFORM	AC FREQUENCY ADJUSTMENT	INSULATION CLASS	POWER EFFICIENCY	POWER FACTOR	STANDARDS	WARRANTY
5 - 95%	Square wave Sine wave Triangular wave	50-250Hz	IP23	85%	0.75	EN60974-1: 2012	36 months* with registration

\* 36 Month Warranty only with online registration of product - [www.strata.co.nz](http://www.strata.co.nz)

[www.strata.co.nz](http://www.strata.co.nz)

# TIG WELDING ACCESSORIES & CONSUMABLES

## Standard Collets

CODE:	DESCRIPTION:
TCB10N23	1.6mm Standard Collet
TCB10N24	2.4mm Standard Collet
TCB10N25	3.2mm Standard Collet

## Standard Collet Bodies

TCB10N31	1.6mm Standard Collet Body
TCB10N32	2.4mm Standard Collet Body
TCB10N28	3.2mm Standard Collet Body

## Standard Ceramic Cups

TCC1046	1/2" Standard Ceramic Cup
TCC1047	7/16" Standard Ceramic Cup
TCC1048	3/8" Standard Ceramic Cup

## Mild Steel TIG Rods

- ER70S-6 Grade.

TR16MS-70S-6	1.6mm x 1m Mild Steel TIG Rods
TR24MS-70S-6	2.4mm x 1m Mild Steel TIG Rods
TR32MS-70S-6	3.2mm x 1m Mild Steel TIG Rods

## Aluminium TIG Rods

- 5356 Grade

TR16AL-5356	1.6mm x 1m Aluminium TIG Rods
TR24AL-5356	2.4mm x 1m Aluminium TIG Rods
TR32AL-5356	3.2mm x 1m Aluminium TIG Rods

## Stainless Steel TIG Rods

- 316 Grade.

TR16SS-316	1.6mm x 1m Stainless Steel TIG Rods
TR24SS-316	2.4mm x 1m Stainless Steel TIG Rods
TR32SS-316	3.2mm x 1m Stainless Steel TIG Rods

## Industrial Welding Trolley

- Suitable for ADVANCETIG 205ACDC/325 and water cooling unit or industrial storage unit
- Super duty wheels and castors
- Includes gas bottle chains and takes 'G' size gas bottles.

22108	Industrial Welding Trolley - V2
-------	---------------------------------

## Compact Welding Trolley

- Capable of holding 'G' size gas bottles.

17384	Industrial Welding Trolley
-------	----------------------------

○ Standard ● Optional

ACCESSORY:	EZITIG 205DC	EZITIG 205AC/DC	ADVANCETIG 205AC/DC	ADVANCETIG 325AC/DC
Arc Leads	○ AAL3550	○ AAL3550	○ AAL3550	○ 17849
Earth Leads	○ AEL3550	○ AEL3550	○ AEL3550	○ 17848
TIG Torch	○ PRO26	○ PRO26	○ PRO26	○ PRO18
TIG Starter Kit	● DCKIT	● DCKIT	● ACDCKIT	● ACDCKIT
Foot Pedal (Electric)	-	● 17401	● 17401	● 17401
Foot Pedal (Wireless)	-	● 17399	● 17399	● 17399

## Tungsten Electrodes

- Zirconiated for use on aluminium
- Thoriated for use on stainless and mild steel

TT16-150	1.6mm x 150mm Thoriated Tungsten Electrodes
TT24-150	2.4mm x 150mm Thoriated Tungsten Electrodes
TT32-150	3.2mm x 150mm Thoriated Tungsten Electrodes
TZ16-150	1.6mm x 150mm Zirconiated Tungsten Electrodes
TZ24-150	2.4mm x 150mm Zirconiated Tungsten Electrodes
TZ32-150	3.2mm x 150mm Zirconiated Tungsten Electrodes

## MMA Welding Electrodes

HYU21675	2.6mm 6013 General Purpose Electrodes - 5kg
HYU21676	3.2mm 6013 General Purpose Electrodes - 5kg
HYU21677	2.6mm 7018 Low Hydrogen Electrodes - 5kg
HYU21678	3.2mm 7018 Low Hydrogen Electrodes - 5kg

## Water Coolers

- Suitable for ADVANCETIG machines with a water cooled torch set up (not incl.)
- Induction motor with safety pressure switch.

24331	Water Cooler Unit 400V w/ Connection Cable
-------	--

## Industrial Storage Unit

- Fits in industrial welding trolley (#22108)
- 620 x 420 x 290mm
- Convenient storage for welding wire, electrodes, gloves and welding accessories.

22115	Industrial Storage Unit - V2
-------	------------------------------