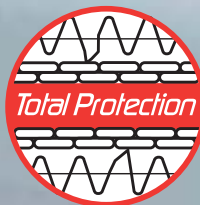




Multipower 204 T



**P. F. C. Power Factor Corrector
Dual Voltage**



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English

Multipower 204T

Full Optional TIG / MMA device



204 T: Applications

- Thanks to its dimensions and the ratio weigh-power/duty cycle 204T is the best option on the market, for small and medium workshops, ideal for maintenance, food industry, hydraulics, piping, medium weight steel constructions and chemical plants.
- Easy to transport, only 11,4 kg, it is the best option for maintenance and repair on field, shipyard and off-shore operations.
- Multipower 204T is designed for welders at all levels and is recommended also for demonstrations and welding schools.



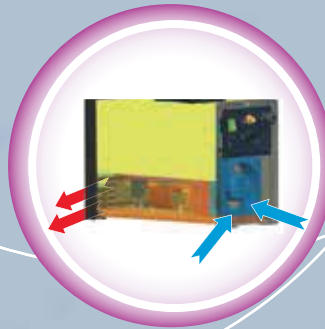
204 T: Remote Controls

- Connector with insulated pins for remote control of welding parameters.
- Torches with potentiometers and up/down switches can be used as well.



Cooling unit

- Thanks to the external connection the cooling unit is easily removable. (Optional)



204 T: Ventilation tunnel

- All electronic pcbs are insulated from ventilation flow.



P.F.C. Power Factor Corrector

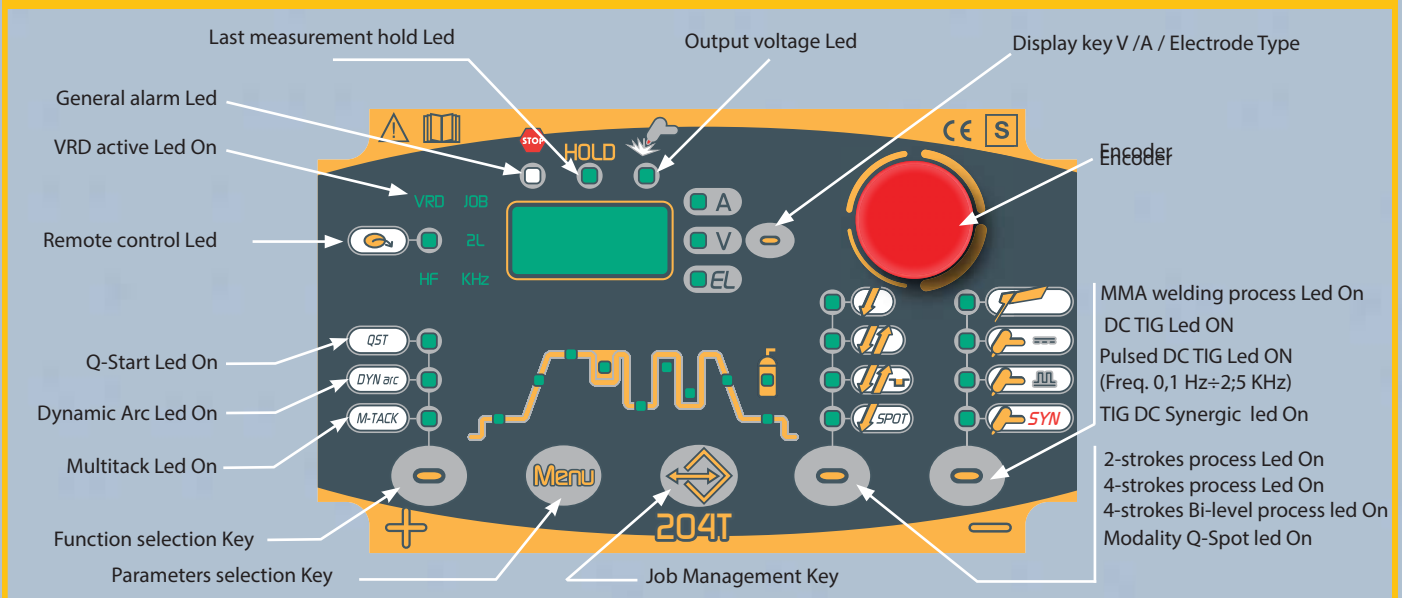
- This symbol highlights Weco's constant care for ecological issues and new technologies which have been introduced to reduce the environmental impact.
- Multipower 204 T Series introduce new technological solutions in order to reduce the harmonic current emissions according to the future International Standards, to increase even more the power inverter efficiency and to reduce the input current more than 20%.
- The same welding deposit is achieved with less electrical power, less total power and less CO₂ emission for the safety of Planet Earth.

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Control Panel

Easy setting of welding parameters



Generator Main features :

Multipower 204T is an advanced inverter power source characterized by a robust and reliable industrial construction. It is recommended for **MMA MMA/CELL** and **LIFT TIG DC** applications providing excellent arc characteristics.

Multipower 204T is ideal for routine maintenance operations, building construction and repairs.

The total protection device located inside the inverter is particularly useful in order to protect the inner components against overvoltage coming from the input power net.

Multipower 204T is equipped with a **PFC device (Power Factor Corrector)** which is dimensioned for supporting a voltage range from **90 Vac up to 270 Vac**, there is besides an intelligent system inside able to supply the generator with the needed energy on the basis of each specific working condition. These devices make it possible, that this generator can be used both with not stabilized lines or motor generators and with over **100 meters** long supplying cables.

Function **VRD (Volt Reduction Device)** reduces automatically the voltage of the welding machine during the Standby mode in order to allow the processing in those building site where low voltages are demanded for safety reasons (Dockyards, petrol platforms and so on).

MMA Main features:

Function **Dynamic Arc (DYNarc)** ensures a deeper penetration and more stable arc; it avoids the electrode's stiking on the base material, it allows the adaptation of the welding arc just through the holder's movements.

Multipower 204T allows setting of different coated electrode's type (**cellulose-basic-rutilic-CrNi - Aluminum**) so that welding machine can automatically optimize the processing parameters for each kind of base material.

Function **V.El (Switch off arc Voltage MMA)** allows to set up a switch off voltage, as protection factor in case the electrode is held too far away from the base material.

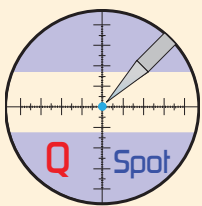
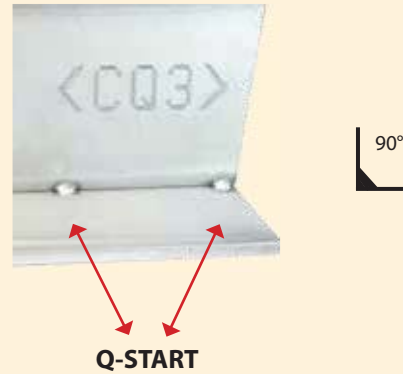
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Q-START

The **Q START** (Quick start) function facilitates joining of the parts in the initial stage of the welding process. On activating this function the machine automatically switches to Synergic pulsed mode for a preset time. The resulting pulses create movement of the molten metal on the two sheet metal edges thereby accelerating formation of the join. This function is invaluable in the case of seams with slight openings or with irregular preparation. The duration of the series of pulses can be adjusted, (from 0.1 to 10 second) depending on the thickness and shape of the sheet to be welded.



Q-Spot

The **Q-Spot** (Quick Spot) function makes it possible to minimise tacking times for light gauge sheet metal. The operator conveniently places the tungsten electrode on the fixing point, thereby obtaining perfect control of the position of the join. Once the electrode has been lifted the machine emits a very high intensity welding current pulse with a very short preset time (from 0.01 Sec to 1 Sec). The pulse time varies depending on the type of sheet metal to be joined. In this way the welded point closes instantly with minimum heat transfer, leaving the metal white, clean and almost cold.

Pipe butt weld
Ø 31.75 x 2 mm

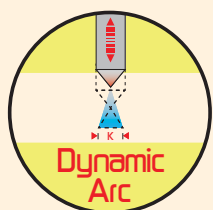


Corner spot welding
thickness 0,6 mm



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DYNAMIC ARC

The **DYNAMIC ARC** function makes it possible to keep the product of Voltage x Current constant. The power source increases the welding current as the arc voltage decreases and reduces the welding current if the arc voltage increases. The DynARC value can be adjusted from a minimum of 10 Ampere to a maximum of 50 Ampere at each 1 Volt variation, whether positive or negative.

Welding benefits of the DynARC function:

Faster welding - Less plastic deformation of the welded part. Increased vertex angle penetration - Heat output concentrated exclusively on the weld and not on the surrounding area - Less oxidation of the part and hence reduced post-welding reworking costs - Improved control of the first root pass (helpful for plumbers and plant engineers) - Reduced risk of the electrode sticking when it touches the weld puddle - Facility to work with the electrode very close to the weld puddle in order to concentrate the arc.



Dynamic Arc TIG welding

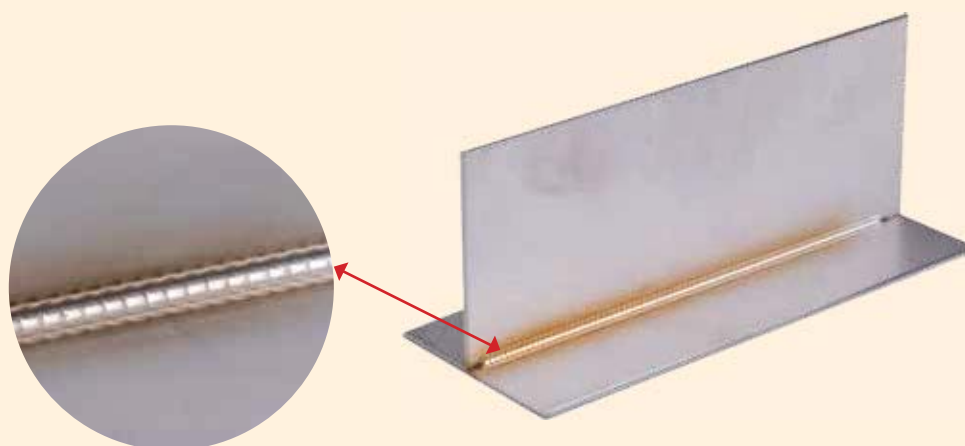


Standard TIG welding



MULTITACK

The **MULTITACK** system makes it possible to reduce heat output while joining two light gauge parts (0.6mm – 0.8mm). The series of arc strikes at short time intervals allows the material to cool during the pause between one strike and the next and thus minimize its deformation. The facility to adjust the frequency of the series of arc strikes in the time unit makes it possible to adapt the electric arc to the welding speed and the joint geometry.



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MMA

Up to 4 mm
electrodes
in MMA
Adjustable
Arc Force and
Hot Start



TIG DC

High quality HF
ignition suitable
for very long
torces



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APPLICATION FIELD



Industrial assembly

Maintenance and servicing

Naval shipbuilding industry

Electro-mechanical assembly

Agricultural machine servicing






Air conditioning plants

Hydraulics

Pipe welding

Metal windows and door frames

Fabrication

Multipower 204T												
	1x230Vac ± 15% @ 50-60Hz						1x115Vac ± 15% @ 50-60Hz					
	16A						32A					
	TIG - WIG			MMA			TIG - WIG			MMA		
$\%_{40^{\circ}\text{C}}$	30%	60%	100%	35%	60%	100%	----	----	100%	50%	60%	100%
$\triangleright I_2$	200A	140A	130A	180A	130A	120A	----	----	115A	115A	110A	105A
$\%_{RT}$	50%	60%	100%	50%	----	100%	----	----	100%	----	----	100%
$\triangleright I_2$	200A	180A	150A	180A	----	150A	----	----	115A	----	----	115A
I_2	5A - 200A			10A - 180A			10A - 115A			5A - 115A		
U_0	83V-11V											
P_{MAX}	5,8KVA - 5,6KW											
IP	23S											
	400 x 160 x 260mm											
	11,4Kg											



EN60974-1/10
EN60974-1/12
EN 60974-2



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