

THE WELDING EXPERTS®

LINCOLN

TIG WELDERS Precision TIG[®] 225

ADVANTAGE

Precision Arc Performance

 Processes in stick and TIG •5-230 amps is the widest welding range in its class

► Patent Micro-Start™II

Technology delivers extremely stable low amperage starting, welding and cratering for AC and DC welding

Excellent Stick Welder

Even with Fleetweld® 5P (E6010)

Professional Features

 115 volt auxiliary power receptacles with 20 amp service reliably powers water coolers.

•Optional understorage cart for extra storage and portability including a low lift cylinder platform.

Superb Quality

•Fan-As-Needed[™] (F.A.N.) prevents overheating. F.A.N. reduces power consumption noise, motor wear and dust in the machine.

•Three-Year Lincoln Warranty on parts and labor.





The Power To Perform!

With the widest welding range in its class (5-230 amps), the Precision TIG[®] 225 gives you the "Power to Perform[™]", for general fabrication, automotive/ motorsports, vocational schools or serious hobby work.

Micro-Start[™] II Technology delivers precision arc performance to improve arc starting, welding and weld cratering. Lincoln Electric's patented Auto-Balance[™] and a built-in simple pulse control make the Precision TIG[®] 225 easy to use.

Professional features like the most auxiliary power, with the flexibility of both AC and DC TIG welding (GTAW) and excellent stick welding (MMAW), make the Precision TIG[®] 225 outstanding value.

SIMPLE CONTROLS -

Easy to Use:

 AC Auto-Balance[™] automatically sets the optimal cleaning vs. penetration levels for great looking aluminum welds. • FREE! Built-in TIG pulser helps

control heat input in the weld.

- · Digital Meter, and simple, wellspaced controls.
- FREE! GTAW (TIG) Handbook and TIG Procedure Guide.

TECHNICAL SPECIFICATIONS							
Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽¹⁾	Output Range	Dimensions H x W x D mm	Net Weight kg
Precision TIG [®] 225	K2534-1	380/400-415/1/50/60	90A/23.4V/100%	21/20A	5-230 Amps AC 5-230 Amps DC Max. OCV: 75V	800 x 356 x 985	112

A CLOSER LOOK

ARC PERFORMANCE Micro-Start[™] II Technology — More than just a starting aid. Better control for starting, arc stability and crater fill.





Micro-Start[™] II Technology minimizes high frequency and 'hot starts' to deliver soft arc starts without arc wandering for AC and DC welding.

Stable

Micro-Start[™] II Technology aids arc stability THROUGHOUT THE WELD CYCLE even at the lowest amperage!



"Set It/See It" Pulse Control -Make attractive and consistent welds! What Is It?

Pulse welding systems vary weld current between peak (high heat) and background current (low heat) levels. Adjusting the pulse frequency controls the level of heat input applied to the weld relative to the weld travel speed.



PULSE FREQUENCY:





Micro-Start[™] II Technology

controlled ramp down helps precisely fill

NOW INCLUDES

· C

ALUMINUM

Results

Better control of heat input in the weld, resulting in:

Precise

- Reduced warping and burnthrough on thin materials.
- · Smaller heat-affected zone.
- Smaller bead profile without compromising proper penetration.



(at 60 amps)

Great For

• Thin materials – Faster pulse settings help to narrow the bead profile and minimize the heat-affected zone and resulting warping or burnthrough.

• Consistent appearance - Slower pulse settings aid in timing the application of filler metal to produce the consistent stacked bead appearance associated with high quality TIG welding.

· Maintaining a steady welding rhythm.

Easy Operation:

· Flashing indicator light lets you see the pulse rate before you strike an arc.

A CLOSER LOOK

FEATURES, CON'T.

• Large, well-spaced controls make it easy to view and set up with gloved hands.

Key Controls

- 1) Power Switch
- 2) AC Balance Control with Auto Setting
- 3) Mode Switch
- 4) Digital Amp Meter (Preset/Actual)
- 5) Thermal Shutdown Light (Back Lit)
- 6) Output Control
- 7) Post Flow Time
- 8) Pulse Frequency Control and Pulse Rate Indicator Light
- 9) Polarity Switch
- 10) Twist-Mate Output Connector for TIG Torch
- or Electrode Cable for Stick Welding
- 11) Attached Work Cable
- 12) Remote Receptacle

QUALITY AND RELIABILITY

- Fan-As-Needed[™] (F.A.N.) minimises repeated heating and cooling of internal components, keeps dust and dirt build-up to a minimum and saves on electricity costs.
- Engineered cooling air routing brings clean air in from the top and exhausts at the bottom to draw and collect less dirt in the machine (see photo at right) unlike competitive systems with a vacuum-cleaner-like floor intake.
- · Compare these reliability enhancing design features:
- Crimped and soldered power connections.
- Electrical coils are wound and varnished without coil spacers to remain secure. Competitive models use wooden coil spacers which can loosen over time.
- Locking tabs on PC board connectors eliminate loosening that can cause electrical failure.
- Tough testing cycles ensure long service dropping, jerking, rolling, shipping, vibration, resistance to real world extreme conditions, and extended in-service life testing.
- Line Voltage Compensation holds output setting constant to maintain weld quality even when the input voltage fluctuates ±10%.
- · CSA C/US certified.
- Three-Year Lincoln Warranty on parts and labor.







Snap-action durable switches make positive mechanical contact to reduce chances of intermittent contact failure.

A CLOSER LOOK

AC Auto-Balance[™] Controls — Automatically sets the optimal cleaning vs. penetration level for aluminum welding!

What Is It?

When aluminum welding, the positive (+) portion of the AC welding amperage cleans the oxides from the aluminum surface. The negative (-) portion delivers more heat input, increasing penetration level.

Patented AC Auto-Balance[™] automatically sets the ratio of cleaning action (+) versus penetration (-) based on amperage.

Manual balance control provides the flexibility to customize the arc to your preference.



Easy Operation:

· Set it and forget it or override when you choose to customize the settings.



Setting

Auto-Balance Setting

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