

PS 254-2 POWER SOURCE



Ideal for use on site or in workshop



Operating panel with integrated printer



Remote control with 4 axes

CHARACTERISTICS

- Inverter based power source technology
- 16 program "user" memory directly accessible by operator pendant
- Integrated library with 60 pre-defined programs covering various common material types, tube diameters and wall thickness
- Data acquisition of actual parameters, printout via integrated printer or via an optional external data acquisition system from Polysoude
- Storage of programs by internal memory and/or by memory card
- Serial Interface for Data exchange with Laptop
- Integral closed circuit water recirculation system for torch cooling

USE

User friendly due to high performance, intuitive programming

TECHNICAL DATA

- Current ranges: 4 - 250 A
- Duty cycle: 250 A / 100 %
- Screen display during welding:
 - of welding current
 - of arc voltage at power source output
 - of torch position in degrees (impulses of movements)
- Remote control pendant with:
 - program selection
 - control of cycle start and cycle stop
 - emergency stop
 - manual movement control: torch and wire feeder
 - real time modification of parameters with cursors
 - gas and water flow control / security
 - manual slope down

APPLICATION SECTORS

- Chemical, food & beverage industries
- Heating and ventilation: production of heat exchangers

ACCESSORIES

- Memory card (16 programs)
- PC programming kit PS xx4 with Memory card reader
- Gas hose
- Pressure regulator and flow meter Argon and Argon/Hydrogen
- Manual torch 8 m with quick connectors and accessories

Technical Data :

Power input	Three phase + ground 400 V - (as an option : multi voltage ; 200 – 480 V) ± 10 % 50 or 60 Hz
Open circuit voltage	92 V
Insulation class	F
Protection class	IP 21 IK04
Welding current range	4 - 250 A D.C.
Duty cycle	250 A /100 %
Current resolution	1 % when I ≥ 100 A - 1 A when I ≤ 100 A
Pulse time	from 10 to 9999 ms
Movement controls	Direct or pulsed current Constant or pulsed command of torch rotation Constant or pulsed wire feed, wire-retract at the end of the weld
Precision on movements	± 1 % for Vp > 250 * Vp = programmed movement ± 1 % for Vp < 250 speed
Gas control	Gas torch with security second gas (option)
Power source cooling	Forced ventilation
Torch cooling	By water in closed circuit with flow safety valve
Display of real values during cycle	Continuous display: . of arc voltage at power source output . of welding current . of impulses of movements
Programs in user memory	16
Display	4 lines of 20 characters, with 8 characters reserved to the designation of programs
Program sectors	10 maximum
Program library	60
Program storage	On memory card
Auto-diagnostic system	Display of error code number
Immediate exploitation	All Polysoude compatible welding heads without AVC/OSC : with or without filler wire. Expl.: MU* - MW - HD - UHP - TS25 Wire feeder POLYFIL P0 motor for mechanised applications
Specific functions	Possibility of connecting a manual TIG torch As an option : possibility of controlling welding heads with tachometer feedback
Size L x W x H (mm)	1060 x 580 x 1030
Weight	145 kg (190 kg with multi voltage option)
Standard	EN 60974-1/EN 50199

(*) the use of welding heads with AVC and/or OSC is not possible with this power source.

