

**210 AMP GTAW WELDING POWER SUPPLY  
ORDERING SPECIFICATIONS  
DOCUMENT # 2285-3342**

1. MUST BE MULTI PROCESS CAPABLE ABLE TO BE USED IN THE GAS TUNGSTEN ARC WELDING (GTAW), PULSED GAS TUNGSTEN ARC WELDING (GTAW-P) AND SHIELD METAL ARC WELDING (SMAW)
2. NEEDS TO WEIGH 38 POUNDS OR LESS
4. NEEDS TO BE APPROXIMATELY 13.6" HIGH X 8.6" WIDE X 19.5" LONG
5. NEEDS TO HAVE AUTO SELECT INPUT VOLTAGE HOOKUP FEATURE TO ENABLE POWER SUPPLY TO BE HOOKED UP TO ANY INPUT POWER SOURCE (120-480 V) TO BE USED WITH UNRELIABLE OR "DIRTY" POWER
6. NEEDS TO HAVE FAN ON DEMAND POWER SOURCE COOLING SYSTEM THAT OPERATES ONLY WHEN NEEDED FOR COOLING TO REDUCE NOISE, REDUCE POWER USAGE, AND AMOUNT OF CONTAMINATING PARTICULATES DRAWN INTO THE MACHINE BY COOLING FAN
7. NEEDS TO HAVE LIFT-ARC FEATURE THAT ALLOWS FOR DC ARC INITIATION WITH OUT THE USE OF HIGH FREQUENCY AT THE SAME TIME REDUCING RISK OF TUNGSTEN CONTAMINATION BY GRADUAL AMPERAGE RAMP UP
8. NEEDS TO ALSO HAVE HIGH FREQUENCY ARC STARTER FOR NON CONTACT ARC INITIATION
9. NEEDS TO HAVE A CONTROL FEATURE FOR SMAW WELDING PROCESS WITH 0 TO 100% ADJUSTMENT THAT ALLOWS THE ARC CHARACTERISTICS TO BE CHANGED FOR SPECIFIC APPLICATIONS AND ELECTRODES
10. NEEDS TO HAVE HOT START ADAPTIVE CONTROL TO PROVIDE SMOOTH NON-STICKING ARC STARTS
11. NEEDS TO HAVE AN OPTION FOR WIRELESS FOOT CONTROL USE
12. NEEDS TO BE ABLE TO BE USED WITH EITHER SINGLE OR THREE PHASE POWER
13. THREE PHASE MUST HAVE AMPERAGE RANGE OF 1-210 AMP (DC) WITH RATED OUTPUT OF AT LEAST 210A AT 18 V WITH 60% DUTY CYCLE FOR GTAW WELDING
14. THREE PHASE MUST ALSO HAVE AMPERAGE RANGE OF 5-210 A WITH RATED OUTPUT OF 160 A AT 26.4 V WITH 60% DUTY CYCLE FOR SMAW WELDING
15. NEEDS TO HAVE VOLT/AMP DISPLAYS ON CONTROL PANNEL
16. NEEDS TO HAVE OUTPUT CONTROL FOR STANDARD REMOTE, 2T TRIGGER HOLD, AND OUTPUT ON
17. NEEDS TO HAVE CONTROL TO ADJUST SHIELDING GAS POSTFLOW ADJUST RANGE .0 TO 50 SECONDS

18. NEEDS TO HAVE SEQUENCER CONTROL FOR ADJUSTING INITIAL AMPERAGE 1-210A, INITIAL SLOPE .0-25 SECONDS, FINAL SLOPE .0-25 SECONDS, FINAL AMPERAGE 1-210A

19. NEEDS TO HAVE PULSER CONTROL FOR ADJUSTING PULSES PER SECOND .1-500 PPS, PEAK TIME 5-95%, AND BACKGROUND AMPERAGE OF 5-95%

20. NEEDS TO BE CAPABLE OF ADDITIONAL SETUP PARAMETER VALUES OF:

- PREPROGRAMED STARTS .020-1/8" TUNGSTEN
- PROGRAMABLE STARTS AMPERAGE 5-210 A, TIME 1-200 MILLIESECONDS, RAMP TIME 0-150 MILLISECONDS, AND MINIMUM AMPERAGE 1-20 A
- ADDITIONAL TRIGGER OPTIONS, 3T, 4T, MINI LOGIC, 4T MOMENTARY
- SPOT/TIMER .1-25 SECONDS
- OVC LOW OVC AND NORMAL OVC
- STICK-STUCK CHECK ON/OFF
- LOCK OUTS- FOUR LEVELS
- ARC TIMER. 0-9999 HOURS AND 0-59 MINUTES
- CYCLE COUNTER 0-999,999 CYCLES

21. HIGH SPEED DC PULSED TIG CONTROLS MUST BE CAPABLE OF .1-500 PPS DC, % ON-% PEAK TIME 5-95%, AND BACKGROUND AMPS 5-99% OF PEAK AMPS

22. POWER SUPPLY MUST BE ACCOMPANIED BY AN ADJUSTABLE SHOULDER STRAP, AN 8FT PRIMARY CORD AND TWO 50-MM DINSE-STYLE CONNECTORS

23. NEEDS TO HAVE CERTIFICATION FROM OSHA APPROVED NATIONALLY RECOGNIZED TESTING LABORATORY SUCH AS CSA, TUVSUD, UL ETC.

24. NEEDS TO HAVE LOW OPEN CIRCUIT VOLTAGE FEATURE

25. NEEDS TO HAVE 3T TRIGGER METHOD FOR REMOTE AMPERAGE CONTROL

26. NEEDS TO BE ABLE TO INTERFACE WITH CURRENT INVENTORY OF S/26 3T TRIGGER AND HAND HELD REMOTE CONTROL SWITCHES (APPROXIMATE VALUE \$214K) AND FOOT PEDDLE REMOTE CONTROL SWITCHS (APPROXIAMTE VALUE \$ 5K)