

## GPS 3000c Compacta

Industrial multi-process equipment. Mig/mag pulse synergic

Ref.: 42385000/42355000

Code: FT42385000v1

Date: May-24



### Description:

Industrial multi-process equipment for MIG/MAG – PULSED MIG/MAG, MMA and TIG – PULSED TIG welding with Inverter technology.

### Use:

Professional use, optimal for MIG/MAG welding of soft stainless steels and ALUM, Excellent dynamics of welding. Synergic Regulation, ample range of programs for MIG/MAG welding.

### Electrical power supply:

3Ph. 400 V-50/60 Hz ± 15 % (Ref. 42384000)

3Ph. 440 V-50/60 Hz ± 10 % (Ref. 42354000)

### Main advantages:

- MIG/MAG process of synergic regulation by thickness weld.
- Full list of synergic programs MIG/MAG standard
- Digital control DSP in high speed.
- Unwind system of 4 rolls. Speed control by encoder
- Wire bobbin Ø 300 mm (15 Kg).
- Modular system with big possibilities and options.
- Change of polarity, (FCAW no gas)

### Functions and optional elements:

- Pulsed arc control. An ample range of synergic programs.
- Syner BI-PULSE: Pulsed Control Double, cordon's improvement
- Arc TIG PULSE with total control of cycle (F= 0.1÷1000Hz)
- Water cold module for welding torch.

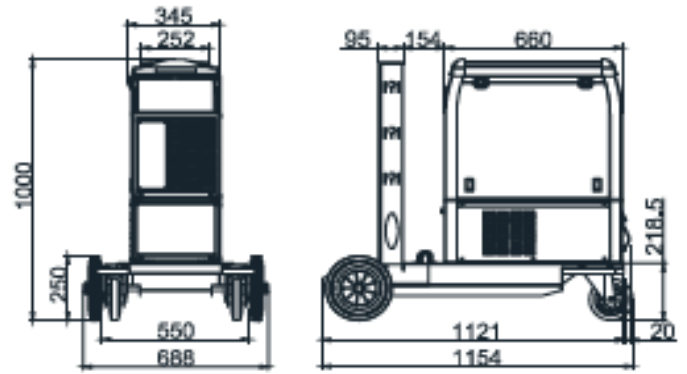
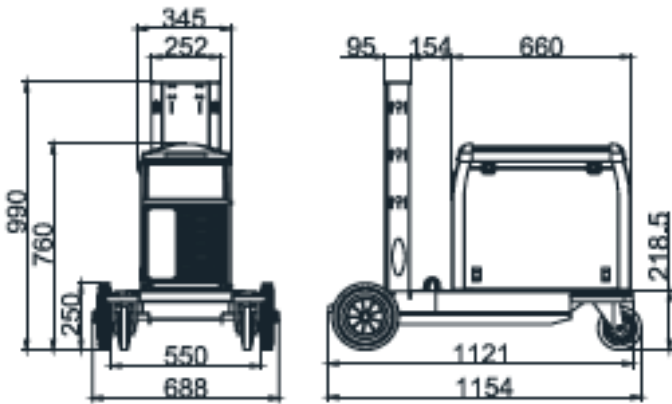
### Technical characteristics

Reference	42385000	42355000
Input voltage U1 (3 Ph ; 50/60hz)	400V	440V
Maximum input intensity I1máx	24A	22A
Effective primary intensity I1eff	15A	13A
Maximum effective power	17 / 10 KVA	
Regulation margin MIG/MAG I2min-I2max	30 + 300 A / 45%	
Welding intensity MIG/MAG ED=100%	250 A / 100%	
Welding tension regulation U2min-U2max	12 + 32 V	
Ø Applicable wire diameters (mm.)	0.8 + 1.2 mm	
Wire reels	Ø300 mm - 15 Kg	
Maximum wire speed (m/min.)	1 + 24 m/min	
Dragging system	4R – 100 W-Enc	
Margin of continue regulation MMA I2min-I2max	30 + 300 A	
Margin of continue regulation TIG I2min-I2max	5 + 300 A	
Mechanical protection factor IP	IP 23 S	
Ventilation	Forzada	
WIDTH x HEIGHT x DEPTH (mm)	345x541x660	
Weight	44kg	
ACCORDING TO THE STANDARDS UNE-EN 60974. (1)		

## Modular package - Optional elements

**1** Compact auto cooled

**2** Compact cooled



Reference	Description	1	2
42384000	GPS 4000 C (400 V – 50/60Hz)	•	•
42354000	GPS 4000 C (440 V – 50/60Hz)	•	•
64184000	Trolley	•	•
65982000	Refrigeration module WCS 520 (400/440V)		•
42370010	Pack GPS Arc welding pulsed	Optional	
42370011	Pack Bi-Pulse Double arc Pulsed	Optional	
42370020	Pack Gala TIG Pulse. TIG arc Pulsed	Optional	

### INCLUDED ACCESSORIES:

REFERENCE	DESCRIPTION	REFERENCE	DESCRIPTION
423.84.047	Instruction Manual	423.16.122	Wire reel Ø37, 1.0-1.2 mm "V"
438.12.219	Earth clamp cable	423.12.030	Machine-gas connection (2 m) / coupling

### RECOMMENDED ACCESSORIES

Reference	Description	MIG/MAG						MMA	TIG	
		Fe (Steel)	AL (Pulse)	SS (Inox. Pulse)	CuSi (Galvaniz.)	CuAL8 Galvaz.)	FCAW (Con gas)	FCAW (Sin gas)	ø 2.0 - 2,4 mm	ø 2.4 - 3,2 mm
PK4012	Torch TR 400 (4 m. auto-cooled)	•			•		•	•		
PK555040	Torch PK 550 (4 m cooled)	•	•	•	•	•	•			
42316121	Wire reel Ø37, 0.8-1.0 mm "V"	•		•	•	□				
42316122(*)	Wire reel Ø37, 1.0-1.2 mm "V" (*)	•		•	•	□				
42316124	Wire reel Ø37, 1.2-1.6 mm "V"	•		•	•	□				
42316125	Wire reel Ø37, 0.9-1.2 mm "R" (TUBULAR)						•	•		
42316126	Wire reel Ø37, 1.2-1.6 mm "R" (TUBULAR)						•	•		
42316127	Wire reel Ø37, 1.0-1.2 mm "ALU"		•			•				
42316128	Wire reel Ø37, 1.2-1.6 mm "ALU"		•			•				
42316227	ROULETTE ALU KIT (wire reel) 1.0-1.2 mm "ALU"		•			•				
5722	Graphite towrope (PK 550)		•	□	□	•				
30144000V	PROFESSIONAL screen	•	•	•	•	•	•	•	•	•
19052604	Torch TIG XT-26V 4 m								□	
19052634	Torch TIG XT-26E EURO 4 m								•	
19051834	Torch TIG XT-18E EURO - 4 m - Cooled.									•
37800000	Argon pressure regulator – Mod. EN 2000	•	•	•	•	•	•		•	•
37900000	Gas welding pressure regulator Free Argon	•	•	•	•	•	•		•	•
800000	CO2 gas heater	•								
8044166-NT	Tungsten electrode sharpener									•
259064	Acrylic cable with electrode-holder, 50 mm <sup>2</sup> - 4 m - 500A.							•		
43912063(*)	Earth clamp cable, 35 mm <sup>2</sup> - 4 m - 300 A (*)							•		
1704V10	Stove TRC V10. Fitted with thermometer and thermostat.							•		

(\* ) Standard as equipment; • Recommended use; □ Possible use

### SOFTWARE PACKS

Reference	Description	MIG/MAG						MMA	TIG	
		Fe (Steel)	AL (Pulse)	SS (Inox. Pulse)	CuSi (Galvaniz.)	CuAL8 Galvaz.)	FCAW (Con gas)	FCAW (Sin gas)	ø 2.0 - 2,4 mm	ø 2.4 - 3,2 mm
42370010	Pack GPS Arc welding pulsed	•	•	•	•	•				
42370011	Pack Bi-Pulse Double arc Pulsed		•	•	•	•				
42370020	Pack Gala TIG Pulse. TIG arc Pulsed								•	•

## PROGRAMS LIST STANDART ARC

Base material	Filler Material	Protective gas	Material display	Gas display			Display			Wire display		Observations		
							D1	D2	D3	mm	in	Thickness (mm)		Polarity
												Mín	Máx	
Fe	ER 70 S 6 SG II - SG III	Ar + CO2 (18%)	Fe	Ar	CO2	18%	12	SG2	SG3	0,8	0,030	0,8	6,0	+
							13	SG2	SG3	---	0,035	0,8	10,0	+
							14	SG2	SG3	1,0	---	0,8	10,0	+
							15	SG2	SG3	1,2	0,045	0,8	11,0	+
Fe	ER 70 S 6 SG II - SG III	CO2 (100%)	Fe		CO2		17	SG2	SG3	0,8	0,030	0,8	10,0	+
							18	SG2	SG3	---	0,035	0,8	9,0	+
							19	SG2	SG3	1,0	---	0,8	9,0	+
							20	SG2	SG3	1,2	0,045	1,0	9,5	+
Ss (308L)	Cr Ni 19-9 AISI 308L	Ar + CO2 (2%)	SS	Ar	CO2	2%	22	308	LSi	0,8	0,030	0,6	10,0	+
							23	308	LSi	---	0,035	0,5	20,0	+
							24	308	LSi	1,0	---	0,5	20,0	+
							25	308	LSi	1,2	0,045	1,0	13,5	+
Al Mg 5	Al Mg 5	Ar (100%)	Al Mg	Ar			44	AL	MG5 %	1,0	---	1,0	16,0	+
							45	AL	MG5 %	1,2	0,045	1,0	15,0	+
Fe Galv.	Cu Si 3	Ar (100%)	Cu Si	Ar			59	Cu	Si3%	1,0	---	0,8	10,0	+
Fe	FCAW E-71T11	Sin gas	Fe				68	NO	Gas	1,2	0,045	1,5	10,0	-
							69	NO	Gas	1,6	---	1,5	9,5	-
Fe	FCAW	Ar + CO2 (18%)	Fe	Ar	CO2	18%	70	_CO	rEd	1,2	0,045	1,0	6,0	+
Ss (308L)	FCAW	Ar + CO2 (18%)	SS	Ar	CO2	18%	73	308	LTO	1,2	0,045	2,0	12,5	+
Fe	Evento de cobre	Ar + CO2 (18%)	Fe	Ar	CO2	18%	85	NO	Cu	0,8	0,030	0,8	10,0	+
							86	NO	Cu	---	0,035	0,8	10,0	+
							87	NO	Cu	1,0	---	0,8	10,0	+
							88	NO	Cu	1,2	0,045	0,8	11,0	+
<i>Programs configuration</i>				<i>Protective gas</i>			<i>Programs number</i>	<i>Type of wire</i>		<i>Ø wire</i>		<i>Range</i>		

## PULSED ARC PROGRAMS LIST

Base material	Filler Material	Protective gas	Material display	Gas display			Display			Wire display		Observations			
							D1	D2	D3	mm	in	Thickness (mm)			
												Min.	Max.		
Fe	ER 70 S 6 SG II - SG III	Ar + CO2 (18%)	Fe	Ar	CO2	18%	12	SG2	SG3	0,8	0,030	0,6	10,0		
							13	SG2	SG3	---	0,035	0,8	13,0		
							14	SG2	SG3	1,0	---	0,8	13,0		
							15	SG2	SG3	1,2	0,045	0,8	12,8		
SS (309)	Cr Ni AISI 309	Ar + CO2 (2%)	SS	Ar	CO2		2%	21	309		1,0	---	0,6	12,5	
Ss (308L)	Cr Ni 19-9 AISI 308L	Ar + CO2 (2%)	SS	Ar	CO2		2%	22	308	LSi	0,8	0,030	0,6	15,0	
								23	308	LSi	---	0,035	0,6	12,5	
								24	308	LSi	1,0	---	0,6	12,5	
								25	308	LSi	1,2	0,045	0,8	10,5	
		2%	SS	Ar				2%	27	308	0 2 %	0,8	0,030	0,6	12,5
									28	308	0 2 %	---	0,035	0,6	13,0
									29	308	0 2 %	1,0	---	0,6	13,0
									30	308	0 2 %	1,2	0,045	0,8	12,0
Ss (316L)	Cr Ni 18-86 AISI 316L	Ar + CO2 (2%)	SS	Ar	CO2		2%	32	316	LSi	0,8	0,030	0,6	15,0	
								33	316	LSi	---	0,035	0,6	12,5	
								34	316	LSi	1,0	---	0,6	12,5	
								35	316	LSi	1,2	0,045	0,8	12,0	
		2%	SS	Ar				2%	37	316	0 2 %	0,8	0,030	0,6	12,0
									38	316	0 2 %	---	0,035	0,6	12,5
									39	316	0 2 %	1,0	---	0,6	12,5
									40	316	0 2 %	1,2	0,045	0,8	12,0
Ss (Duplex)	LDX 2101 SS 2209	Ar + CO2 (2%)	SS	Ar	CO2		2%	42	DUP	LEX	1,0	---	0,6	12,5	
								43	DUP	LEX	1,2	0,045	1,0	12,0	
Al Mg 5	Al Mg 5	Ar (100%)	Al Mg	Ar				44	AL	MG5 %	1,0	---	0,6	12,0	
								45	AL	MG5 %	1,2	0,045	0,6	13,2	
								46	AL	MG5 %	1,6	---	1,2	14,0	
Al Si 5	Al Si 5	Ar (100%)	Al Si	Ar				49	AL	Si5 %	1,0	---	0,6	10,0	
								50	AL	Si5 %	1,2	0,045	0,8	13,0	
Al Si 12	Al Si 12	Ar (100%)	Al Si	Ar				54	Si	12%	1,0	---	0,6	11,5	
								55	Si	12%	1,2	0,045	0,9	14,0	
Fe Galv.	Cu Si 3	Ar (100%)	Cu Si	Ar				57	Cu	Si3%	0,8	0,030	0,7	4,2	
								58	Cu	Si3%	---	0,035	0,6	4,2	
								59	Cu	Si3%	1,0	---	0,6	4,2	
Fe Galv.	Cu Al 8	Ar (100%)		Ar				61	Cu	Al8%	0,8	0,030	0,8	20,0	
								62	Cu	Al8%	---	0,035	0,8	10,5	
								63	Cu	Al8%	1,0	---	0,8	10,5	
Fe	Especial 2 Exento de cobre Recargue dureza	Ar + CO2 (18%)	Fe	Ar	CO2	18%		82	700	MC	1,0	---	0,8	15,0	
Fe	Especial 1 Exento Cobre Exento de cobre	Ar + CO2 (18%)	Fe	Ar	CO2	18%		85	NO	Cu	0,8	0,030	0,6	10,0	
								86	NO	Cu	---	0,035	0,8	13,0	
								87	NO	Cu	1,0	---	0,8	13,0	
								88	NO	Cu	1,2	0,045	0,8	12,8	
Fe	ER 70 S 6 SG II - SG III	Ar + CO2 <10%	Fe	Ar	CO2			90	Low	CO2	0,8	0,030	0,6	10,0	
								91	Low	CO2	---	0,035	0,8	13,5	
								92	Low	CO2	1,0	---	0,8	13,5	
								93	Low	CO2	1,2	0,045	0,8	12,5	
<i>Programs configuration</i>				<i>Protective gas</i>			<i>Programs number</i>	<i>Type of wire</i>		<i>Ø wire</i>		<i>Range</i>			