

## GPS 4000 Compacta

Portable multi-process inverter welding equipment

Ref.: 42354000

Code: FT42384000V1

Date: May-24



Ficha Web



### Description:

Compact inverter technology unit for multi-process electric welding (semi-automatic MIG/MAG, MMA electrode and TIG process).

### Use:

Professional use, ideal for MIG/MAG welding of mild steels, stainless steels and aluminium, excellent welding dynamics. Synergic control, wide range of programmes for MIG/MAG welding.

### Power supply:

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

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

### Main advantages:

- MIG/MAG process with synergic regulation by weld thickness.
- Complete list of standard MIG/MAG synergic programmes
- High speed DSP digital control. 4 \_roulette drive system. Encoder speed control.
- Thread reel  $\varnothing$  300 mm (15 Kg).
- Modular system with great possibilities optional.
- Polarity change (FCAW no gas).

### Functions and optional elements:

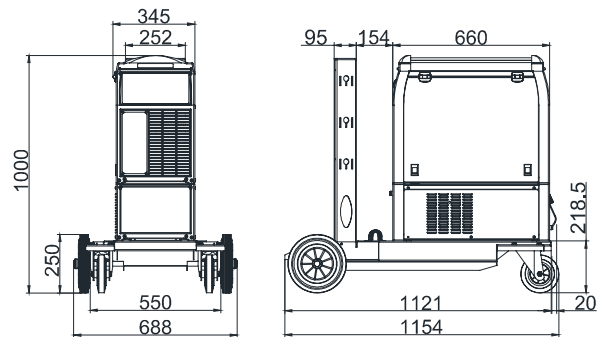
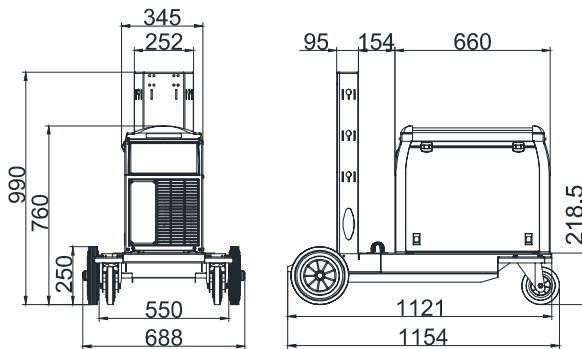
- Pulsed arc control. Extensive map of of synergic programmes.
- Syner BI-PULSE: Double pulsed control. aesthetic improvement of the bead
- TIG PULSE arc with full cycle control (F= 0.1÷1000Hz)
- Water cooling module for welding torch.

TECHNICAL CHARACTERISTICS	GPS 4000 C
Reference	42354000
Input voltage U1 (3 Ph ; 50/60hz)	440 V
Primary intensity Maximum I <sub>1máx</sub>	32 A
Effective primary intensity I <sub>1eff</sub>	20 A
Maximum/Effective Power	24 /15 KVA
MIG/MAG control range I <sub>2min</sub> -I <sub>2max</sub>	30 ÷ 400 A / 45%
MIG/MAG welding intensity ED=100%.	270 A / 100%
Welding voltage regulation U <sub>2min</sub> -U <sub>2max</sub>	12 ÷ 34 V
Ø of applicable thread (mm.)	0.8 ÷ 1.2 mm
Thread roll bobbins	Ø300 mm - 15 Kg
Thread speed (m/min.)	1 ÷ 24 m/min
Drag system	4R – 100 W-Enc
Continuous regulation range MMA I <sub>2min</sub> -I <sub>2max</sub>	30 ÷ 400 A
Continuous regulation range TIG I <sub>2min</sub> -I <sub>2max</sub>	5 ÷ 400 A
Mechanical protection index (IP)	IP 23 S
Ventilation	Forzada
WIDTH x HEIGHT x LENGTH (mm)	345x541x660
Weight	45 Kg
ACCORDING TO UNE-EN 60974 STANDARDS. (1)	

## Modular package - Optional elements

**1** COMPACT SELF-COOLED

**2** COMPACT REFRIGERATED



Reference	Description	1	2
42384000G	GPS 4000 C (400 V – 50/60Hz)	☒	☒
42354000G	GPS 4000 C (440 V – 50/60Hz)	☒	☒
64184000C	Transport car	☒	☒
65982000M	WCS 520 cooling module (400/440V)		☒
42370010P	Pulsed Arc Welding GPS Package	Optional	
42370011P	By-Pulse Package. Double arc pulsed	Optional	
42370020P	TIG Pulse Gala Package. TIG pulsed arc	Optional	

### MATERIALS INCLUDED AS STANDARD:

REFERENCE	DESCRIPTION	REFERENCE	DESCRIPTION
423.84.047	Manual	423.16.122	Roulette Ø37, 1.0-1.2 mm "V"
439.12.063	Ground cable	423.12.030	With machine-gas connection(2 m)/fitting

### RECOMMENDED ACCESSORIES

Reference	Description	MIG/MAG						MMA	TIG	
		Fe (Acero)	AL (Pulse)	SS (Inox. Pulse)	CuSi (Galvaniz.)	CuAL8 Galvaz.)	FCAW (Con gas)		FCAW (Sin gas)	Ø 2.0 - 2,4 mm
PK4012	TR 400 torch (4 m. self-cooled)	☑			☑		☑			
PK555040	PK 550 torch (4 m cooled)	☑	☑	☑	☑	☑	☑			
42316121	Roulette Ø37, 0.8-1.0 mm "V"	☑		☑	☑	☑				
42316122 (*)	Roulette Ø37, 1.0-1.2 mm "V"	☑		☑	☑	☑				
42316124	Roulette Ø37, 1.2-1.6 mm "V"	☑		☑	☑	☑				
42316125	Roulette Ø37, 0.9-1.2 mm "R" (TUBULAR)						☑	☑		
42316126	Roulette Ø37, 1.2-1.6 mm "R" (TUBULAR)						☑	☑		
42316127	Roulette Ø37, 1.0-1.2 mm "ALU"		☑			☑				
42316128	Roulette Ø37, 1.2-1.6 mm "ALU"		☑			☑				
42316227	ALU ROLLER KIT, 1.0-1.2 mm "ALU"		☑			☑				
5722	Graphite towbar (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 Refrig.									☑
37600000	Argon pressure reducer EN 2000	☑	☑	☑	☑	☑	☑		☑	☑
37900000	Gas Free Argon pressure reducer	☑	☑	☑	☑	☑	☑		☑	☑
600000	Gas heater CO2	☑								
8044166-NT	Tungsten sharpener								☑	☑
259064	Acrylic cable with clip 50 mm2 ; 4 mt ; 500 A							☑		
43912063 (*)	Ground cable 50 mm2 ; 4 mt ; 400 A							☑		
1704V10	TRC V10 stove. With thermometer and thermostat							☑		

(\*) Included as standard;      Recommended use;      Possible use

### SOFTWARE PACKAGES FOR WELDING APPLICATIONS

Reference	Description	MIG/MAG						MMA	TIG	
		Fe (Acero)	AL (Pulse)	SS (Inox. Pulse)	CuSi (Galvaniz.)	CuAL8 Galvaz.)	FCAW (Con gas)		FCAW (Sin gas)	Ø 2.0 - 2,4 mm
42370010	Pulsed arc package	☑	☑	☑	☑	☑				
42370011	Double arc pulsed By-Pulse package		☑	☑	☑	☑				
42370020	Gala Tig Pulse package. TIG pulsed arc								☑	☑

(\*) Included as standard;      Recommended use;      Possible use

## LIST OF STD ARC PROGRAMMES

Base Material	Input Material	Protective gas	Display Material	Display Gas				Display			Display thread		Observations		Polarity
								D1	D2	D3	mm	in	Thickness (mm)		
													Mín	Máx	
Fe	ER 70 S 6	Ar + CO2 (18%)	Fe	Ar	CO2	18%	12	SG2	SG3	0,8	0,030	0,8	10,0	+	
							13	SG2	SG3	---	0,035	0,8	15,0	+	
							14	SG2	SG3	1,0	---	0,8	15,0	+	
							15	SG2	SG3	1,2	0,045	0,8	15,0	+	
							16	SG2	SG3	1,6	---	1,5	15,0	+	
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	12,0	+	
							19	SG2	SG3	1,0	---	0,8	12,0	+	
							20	SG2	SG3	1,2	0,045	1,0	12,0	+	
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	20,0	+	
Al Mg 5	Al Mg 5	Ar (100%)	Al Mg	Ar			44	AL	MG5 %	1,0	---	1,0	20,0	+	
							45	AL	MG5 %	1,2	0,045	1,0	16,0	+	
Fe Galv.	Cu Si 3	Ar (100%)	Cu Si	Ar			59	Cu	Si3%	1,0	---	0,8	13,5	+	
Fe	FCAW E-71T11	Sin gas	Fe				68	NO	Gas	1,2	0,045	1,5	18,0	-	
							69	NO	Gas	1,6	---	1,5	16,0	-	
Fe	FCAW	Ar + CO2 (18%)	Fe	Ar	CO2	18%	70	_CO	rEd	1,2	0,045	1,0	16,0	+	
							71	_CO	rEd	1,6	---	1,5	15,0		
Ss (308L)	FCAW	Ar + CO2 (18%)	SS	Ar	CO2	18%	73	308	LTO	1,2	0,045	2,0	18,0	+	
Fe	Exento 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	15,0	+	
							87	NO	Cu	1,0	---	0,8	15,0	+	
							88	NO	Cu	1,2	0,045	0,8	15,0	+	

Programme configuration

Protective gas

Programme No

Thread type

Ø thread

Range

LIST OF STD ARC PROGRAMMES														
Base Material	Input Material	Protective gas	Display Material	Display Gas				Display			Display thread		Observations	
								D1	D2	D3	mm	in	Thickness (mm)	
													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	0,6	10,0
								13	SG2	SG3	---	0,035	0,8	14,0
								14	SG2	SG3	1,0	---	0,8	14,0
								15	SG2	SG3	1,2	0,045	0,8	18,0
SS (309)	Cr Ni AISI 309	Ar + CO2 (2%)	SS	Ar	CO2		21	309		1,0	---	0,6	15,0	
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	15,0
								24	308	LSi	1,0	---	0,6	15,0
								25	308	LSi	1,2	0,045	0,8	18,0
			27	308	0_2 %	0,8	0,030	0,6	15,0					
			28	308	0_2 %	---	0,035	0,6	15,0					
			29	308	0_2 %	1,0	---	0,6	15,0					
			30	308	0_2 %	1,2	0,045	0,8	18,0					
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	15,0
								34	316	LSi	1,0	---	0,6	15,0
								35	316	LSi	1,2	0,045	0,8	18,0
			37	316	0_2 %	0,8	0,030	0,6	12,0					
			38	316	0_2 %	---	0,035	0,6	15,0					
			39	316	0_2 %	1,0	---	0,6	15,0					
			40	316	0_2 %	1,2	0,045	0,8	18,0					
Ss (Duplex)	LDX 2101 SS 2209	Ar + CO2 (2%)	SS	Ar	CO2	2%		42	DUP	LEX	1,0	---	0,6	15,0
								43	DUP	LEX	1,2	0,045	1,0	15,0
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	15,0
								46	AL	MG5 %	1,6	---	1,2	20,0
Al Si 5	Al Si 5	Ar (100%)	Al Si	Ar				49	AL	Si5 %	1,0	---	0,6	12,0
								50	AL	Si5 %	1,2	0,045	0,8	18,0
								51	AL	Si5 %	1,6	---	1,0	18,0
Al Si 12	Al Si 12	Ar (100%)	Al Si	Ar				54	Si	12%	1,0	---	0,6	12,0
								55	Si	12%	1,2	0,045	0,9	18,0
Fe Galv.	Cu Si 3	Ar (100%)	Cu Si	Ar				57	Cu	Si3%	0,8	0,030	0,7	4,5
								58	Cu	Si3%	---	0,035	0,6	4,0
								59	Cu	Si3%	1,0	---	0,6	4,5
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	12,0
								63	Cu	Al8%	1,0	---	0,8	12,0
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	14,0
								87	NO	Cu	1,0	---	0,8	14,0
								88	NO	Cu	1,2	0,045	0,8	18,0
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	14,0
								92	Low	CO2	1,0	---	0,8	14,0
								93	Low	CO2	1,2	0,045	0,8	18,0
Programne configuration				Protective gas			Programme	Thread type		Ø thread		Range		