

GPS 4000 C

INDUSTRIAL MULTI-PROCESS EQUIPMENT. MIG/MAG PULSE SYNERGIC

Ref. 42384000

Ref. 42354000

FT42384000v1

05/07/2017

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GENERAL CHARACTERISTICS

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 \pm 15 % (Ref. 42384000)

3Ph. 440 V-50/60 Hz \pm 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 \varnothing 300 mm (15 Kg).
- Modular system with big possibilities and options.
- Change of polarity, (FCAW no gas)

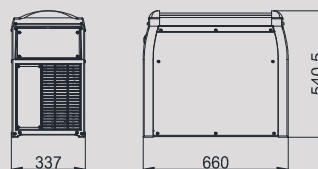
Functions and optional elements:

- 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 \div 1000Hz)
- Water cold module for welding torch.



GENERAL CHARACTERISTICS	GPS 4000 C	
Reference	42384000	42354000
Input voltage $U_1 U_1$ (3 Ph ; 50/60Hz)	400 V	440 V
Maximum input intensity I_{1max}	35 A	32 A
Effective primary intensity I_{1eff}	22 A	20 A
Maximum effective power	24 / 15 KVA	
Régulation margin MIG/MAG $I_{2min}-I_{2max}$	30 \div 400 A / 45%	
Welding intensity MIG/MAG ED=100%	270 A / 100%	
Welding tension regulation $U_{2min}-U_{2max}$	12 \div 34 V	
\varnothing Applicable wire diameters (mm.)	0.8 \div 1.2 mm	
Wire reels	\varnothing 300 mm - 15 Kg	
Maximum wire speed (m/min.)	1 \div 24 m/min	
Dragging system	4R – 100 W-Enc	
Margin of continue regulation MMA $I_{2min}-I_{2max}$	30 \div 400 A	
Margin of continue regulation TIG $I_{2min}-I_{2max}$	5 \div 400 A	
Mechanical protection factor IP	IP 23 S	
Ventilation	Forzada	
WIDTH x HEIGHT x DEPTH (mm)	345x541x660	
Weight	45 Kg	
ACCORDING TO THE STANDARDS UNE-EN 60974. (1)		

CIF A- 50 /045319 50.014 ZARAGOZA - SPAIN		GPS			
TYP: GPS 4000 C					
REF: 42384000					
UNE-EN 60974-1					
30A / 14 V - 400 A / 34 V					
= = X		45 %	60 %	100 %	
S	U_0	I_2	400A	350 A	270 A
	12-34 V	U_2	34 V	31.5 V	27.5V
3 ~ 50/60 Hz		U_1	400V	I_{1max} =32 A	I_{1eff} =22 A
30A(5A TIG)/21.2V - 400A/36 V					
= = X		40 %	60 %	100 %	
S	U_0	I_2	400A	350 A	270 A
	58 V	U_2	36 V	34 V	30.8 V
3 ~ 50/60 Hz		U_1	400 V	I_{1max} =35 A	I_{1eff} =22 A
FRONT:					
DSP:					
MOTOR:		IP 23 S			



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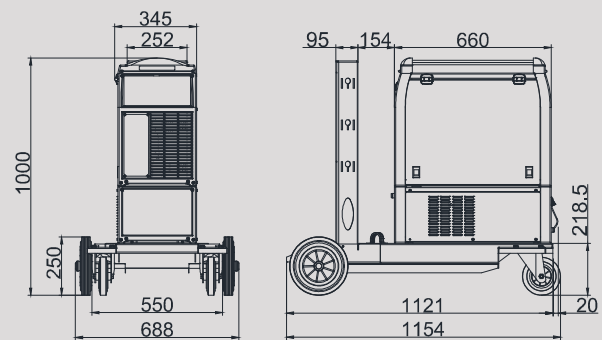
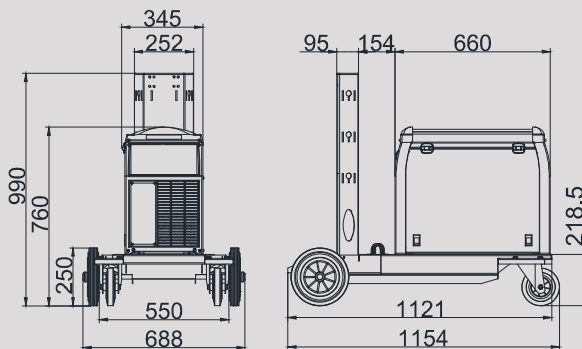
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MODULAR PACKAGE. OPTIONAL ELEMENTS

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	



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INCLUDED ACCESSORIES:

REFERENCE	DESCRIPTION	REFERENCE	DESCRIPTION
423.84.047	Instruction Manual	423.16.122	Wire reel Ø37, 1.0-1.2 mm "V"
439.12.063	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.									•
37600000	Argon pressure regulator – Mod. EN 2000	•	•	•	•	•	•		•	•
37900000	Gas welding pressure regulator Free Argon	•	•	•	•	•	•		•	•
600000	CO2 gas heater	•								
8044166-NT	Tungsten electrode sharpener								•	•
259064	Acrylic cable with electrode-holder, 50 mm ² - 4 m - 500A.							•		
43912063(*)	Earth clamp cable, 50 mm ² - 4 m - 400 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								•	•



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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	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	+
<i>Programs configuration</i>				<i>Protective gas</i>			<i>Programs number</i>	<i>Type of wire</i>		<i>Ø wire</i>		<i>Range</i>		



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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)				
												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		2%	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		
				Ar + O2 (2%)	SS	Ar			2%	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		
				Ar + O2 (2%)	SS	Ar			2%	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		
<i>Programs configuration</i>				Protective gas			<i>Programs number</i>	<i>Type of wire</i>		<i>Ø wire</i>		<i>Range</i>				



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