

## GPS 4000c Advanced

PORTABLE MULTI-PROCESS INVERTER WELDING EQUIPMENT

Ref.: 42384000

Code: FT43482000V3

Date: 18-04-2024



### 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:

- TFT screen.
- Access restriction (SECURITY LEVELS).
- Languages available: Spanish, English, French, German and Italian.
- 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.

### Technical characteristics

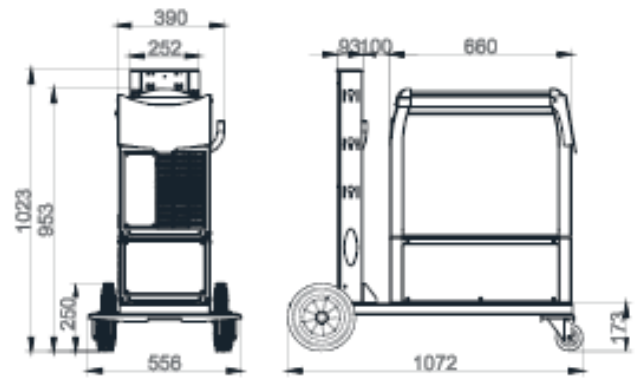
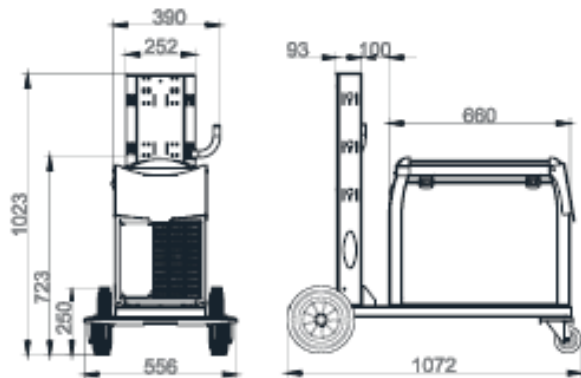
Reference	42384200	42354200
Input voltage U1U1 (3 Ph ; 50/60hz)	400V	440V
Maximum input intensity I1máx	35A	32A
Effective primary intensity 1eff	22A	20A
Maximum effective power	24 /15 KVA	
Régulation margin MIG/MAG I2min-I2max	30 + 400 A / 45%	
Welding intensity MIG/MAG ED=100%	270 A / 100%	
Welding tension regulation U2min-U2max	12 + 34 V	
$\varnothing$ Applicable wire diameters (mm.)	0.8 + 1.2 mm	
Wire reels	$\varnothing$ 300 mm - 15 Kg	
Maximum wire speed (m/min.)	1 + 24 m/min	
Dragging system	4R – 100 W-End	
Margin of continue regulation MMA I2min-I2max	30 + 400 A	
Margin of continue regulation TIG I2min-I2max	5 + 400 A	
Mechanical protection factor IP	IP 23 S	
Ventilation	Forzada	
WIDTH x HEIGHT x DEPTH (mm)	345x541x660	
Weight	45kg	
ACCORDING TO THE STANDARDS UNE-EN 60974. (1)		

## Modular package - Optional elements

**1** COMPACT AUTO COOLED

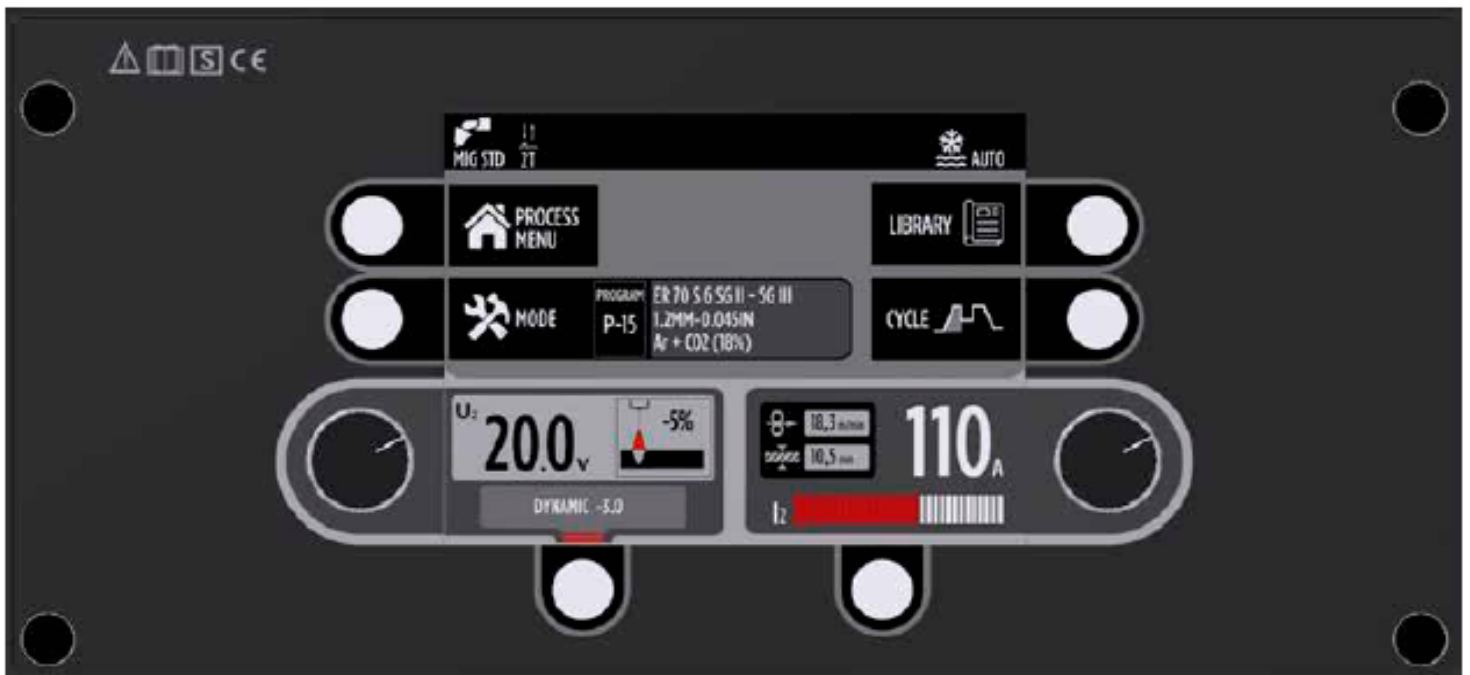


**2** COMPACT COOLED



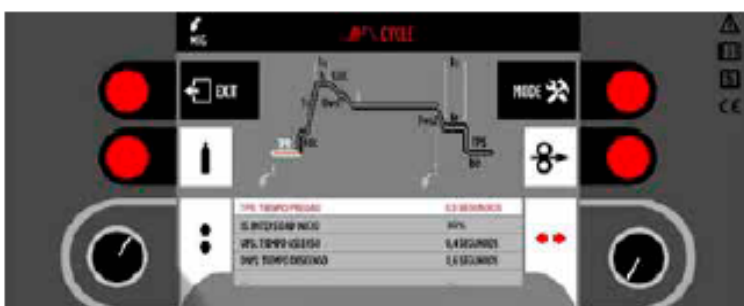
Reference	Description	1	2
42384200	GPS 4000 C ADVANCED( 400 V – 50/60Hz)	•	•
64191000	GPS Basic transport trolley	•	•
65982000	Cooling module WCS 520 (230/ 400 / 440V)		•
42370010	GPS Pulsed Arc Welding Package	Optional	
42370011	By-Pulse package of Double pulsed arc.	Optional	
42370020	Gala Tig Pulse package. TIG pulsed arc.	Optional	
42370012	Standard double arc By-Level package	Optional	
66790000	TCW, TIG welding package with cold wire feed Optional	Optional	
42370000	Special bows package	Optional	
42370015	Customised welding programme creation package	Optional	

## TFT CONTROL PANEL



### MODE OF OPERATION

STD -PULSE -SCA -MIXED SINGLE  
 ARC -DOUBLE ARC SYNERGIC  
 MODE - MANUAL MODE



### CYCLE PARAMETERS



### PROGRAMME LIBRARY

### INCLUDED ACCESSORIES:

REFERENCE	DESCRIPTION	REFERENCE	DESCRIPTION
423.84.247M	Instruction manual	23.16.122	Wire reells Ø37, 1.0-1.2 mm "V"
439.12.063C	Earth clamp cable	423.12.030C	Machine-gas connection (2 m) / coupling

### 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
880036P	Manual torch MIG 36 M8 (4 m. gas)	•			•		•	•		
880501P	Manual torch MIG 501 M8 (4 m refrigerada)	•	•	•	•	•	•			
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	KIT RULETAS ALU (wire reel), 1.0-1.2 mm "ALU"		•			•				
5722	Graphite towrope (PK 550)		•	□		•				
30144000V	PROFESIONAL screen	•	•	•	•	•	•	•	•	•
T264030	Torch SR26 EURO 4 m								•	•
T184030	Torch SR18 EURO 4 m Refrig.									•
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 <sup>2</sup> ; 4 mt ; 500							•		
43912063 (*)	Earth clamp cable, 50 mm <sup>2</sup> ; 4 mt ; 400 A							•		
1704V10	Stove TRC V10. Fitted with thermometer and thermostat.							•		

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

### SOFTWARE PACKAGES FOR WELDING APPLICATIONS

Reference	Description	MIG/MAG						MMA	TIG	
		Fe(Steel)	AL(Pulse)	SS (Inox. Pulse)	CuSi (Galvaniz.)	CuAL8 Galva z.)	FCAW (With gas)	FCAW (Without gas)		ø 2.0 - 2,4 mm
42370012	Standard double arc By-Level package	•		•	•	•				
42370010	Pulsed arc package	•	•	•	•	•				
42370011	Double arc pulsed By-Pulse package		•	•	•	•				
42370020	Gala Tig Pulse package. TIG pulsed arc								•	•
66790000	TCW, TIG welding package with cold wire input								•	•
42370100	SCA special bow package	•		•	•					
42370095	Special ROOT arc package	•		•	•					
42370055	Special SEED UP arc package	•	•	•						
42370057	Special SPEED UP+ arc package	•		•						
42370050	Special WELD SPEED arc package	•	•	•						
42370060	Special WELD POWER arc package	•		•						
42370065	Special CEILING arc package	•	•	•						

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



## Special Arcs

Each weld is different, and the execution requirements change depending on the application.

The specific quality requirements, production systems or the aesthetic improvement of the seam determine how we adjust the welding parameters of our equipment.

The SYNERWELD series incorporates different arc dynamics that allow us to obtain the desired results with greater ease and repeatability.



PACK SynerWeld Module  
Ref.42370000



### ARCO SCA-COLD - Ref.42370100

- Up to 35% reduction in heat input, less heat distortion.
- Drop transfer without spattering in the contact and opening process.
- Increased process speed.



### ARCO CEILING - Ref.42370065

- Welding in an under-roof position.
- Easier to execute, straight line welding without oscillation.
- Reduced bead time by avoiding oscillation.



### ARCO ROOT - Ref.42370095

- Root pass welding with pipe application.
- Increased arc stability and travel speed (+ 55%).



### ARCO SPEED-UP - Ref.42370055

- Vertical upward welding.
- Easier to execute, straight line welding without oscillation.
- Reduction of bead time by avoiding oscillation (-30%).



### ARCO SPEED - Ref.42370050

- Increase in travel speed. Between 30% and 50%.
- Travel speed up to 25 mm/s depending on material, thickness and welding position.



### ARCO SPEED-UP+ - Ref.42770057

- Vertical upward welding.
- Speed increase up to 18% with respect to SPEED UP arc.
- Exclusive application in carbon steels.



### ARCO POWER- Ref.42370060

- Increased penetration. Up to 47%.
- Improvement of bead geometry, reduction of bites and risk of porosity.
- Reduced welding time by reducing oscillation or torch movement.



### EDICIÓN de Programas- Ref.42370015

- Programme Customisation.
- Creation of New Programmes.
- Limitation of application of available Programmes.

PROGRAMA				REF								
Nº	MATERIAL	GAS	Ø	STD	PULSE	SCA	ROOT	SPEED UP	SPEED UP +	WELD SPEED	WELD POWER	CEILING
12	Fe ER70-S6	Ar+CO <sub>2</sub> 18%	0,8mm-0,030in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			
13	Fe ER70-S6	Ar+CO <sub>2</sub> 18%	0,035in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		
14	Fe ER70-S6	Ar+CO <sub>2</sub> 18%	1,0mm	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>
15	Fe ER70-S6	Ar+CO <sub>2</sub> 18%	1,2mm-0,045in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
16	Fe ER70-S6	Ar+CO <sub>2</sub> 18%	1,6mm-0,062in	<input checked="" type="checkbox"/>								
17	Fe ER70-S6	CO <sub>2</sub>	0,8mm-0,030in	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>					
18	Fe ER70-S6	CO <sub>2</sub>	0,035in	<input checked="" type="checkbox"/>								
19	Fe ER70-S6	CO <sub>2</sub>	1,0mm	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>					
20	Fe ER70-S6	CO <sub>2</sub>	1,2mm-0,045in	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>					
21	CrNi ER309L	Ar+CO <sub>2</sub> 2%	1,0mm		<input checked="" type="checkbox"/>							
22	CrNi ER308L	Ar+CO <sub>2</sub> 2%	0,8mm-0,030in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>		
23	CrNi ER308L	Ar+CO <sub>2</sub> 2%	0,035in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		
24	CrNi ER308L	Ar+CO <sub>2</sub> 2%	1,0mm	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>
25	CrNi ER308L	Ar+CO <sub>2</sub> 2%	1,2mm-0,045in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>
27	CrNi ER308L	Ar+O <sub>2</sub> 2%	0,8mm-0,030in		<input checked="" type="checkbox"/>							
28	CrNi ER308L	Ar+O <sub>2</sub> 2%	0,035in		<input checked="" type="checkbox"/>							
29	CrNi ER308L	Ar+O <sub>2</sub> 2%	1,0mm		<input checked="" type="checkbox"/>							
30	CrNi ER308L	Ar+O <sub>2</sub> 2%	1,2mm-0,045in		<input checked="" type="checkbox"/>							
32	CrNi ER316L	Ar+CO <sub>2</sub> 2%	0,8mm-0,030in		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>					
33	CrNi ER316L	Ar+CO <sub>2</sub> 2%	0,035in		<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		
34	CrNi ER316L	Ar+CO <sub>2</sub> 2%	1,0mm		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>
35	CrNi ER316L	Ar+CO <sub>2</sub> 2%	1,2mm-0,045in		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
37	CrNi ER316L	Ar+O <sub>2</sub> 2%	0,8mm-0,030in		<input checked="" type="checkbox"/>							
38	CrNi ER316L	Ar+O <sub>2</sub> 2%	0,035in		<input checked="" type="checkbox"/>							
39	CrNi ER316L	Ar+O <sub>2</sub> 2%	1,0mm		<input checked="" type="checkbox"/>							
40	CrNi ER316L	Ar+O <sub>2</sub> 2%	1,2mm-0,045in		<input checked="" type="checkbox"/>							
41	CrNi ER2209 - DUPLEX	Ar+CO <sub>2</sub> 2%	0,8mm-0,030in		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>					
42	CrNi ER2209 - DUPLEX	Ar+CO <sub>2</sub> 2%	1,0mm		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>					
43	CrNi ER2209 - DUPLEX	Ar+CO <sub>2</sub> 2%	1,2mm-0,045in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>					
44	ALMg5 ER5356	Ar	1,0mm	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>				
45	ALMg5 ER5356	Ar	1,2mm-0,045in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>
46	ALMg5 ER5356	Ar	1,6mm-0,062in		<input checked="" type="checkbox"/>							
49	ALSi5 ER4043	Ar	1,0mm		<input checked="" type="checkbox"/>							
50	ALSi5 ER4043	Ar	1,2mm-0,045in		<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		
51	ALSi5 ER4043	Ar	1,6mm-0,062in		<input checked="" type="checkbox"/>							
54	ALSi12 ER4047	Ar	1,0mm		<input checked="" type="checkbox"/>							
55	ALSi12 ER4047	Ar	1,2mm-0,045in		<input checked="" type="checkbox"/>							
57	Fe Galv. ERCuSi	Ar	0,8mm-0,030in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>					
58	Fe Galv. ERCuSi	Ar	0,035in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>							
59	Fe Galv. ERCuSi	Ar	1,0mm	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>					
61	Fe Galv. ERCuAL	Ar	0,8mm-0,030in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>							
62	Fe Galv. ERCuAL	Ar	0,035in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>							
63	Fe Galv. ERCuAL	Ar	1,0mm	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>							
67	Fe FCAW E71T-11	No Gas	0,9mm-0,035in									
68	Fe FCAW E71T-11	No Gas	1,1mm-0,045in	<input checked="" type="checkbox"/>								
69	Fe FCAW E71T-11	No Gas	1,7mm-0,068in	<input checked="" type="checkbox"/>								
70	Fe FCAW ER70C-C6	Ar+CO <sub>2</sub> 18%	1,2mm-0,045in	<input checked="" type="checkbox"/>								
71	Fe FCAW ER70C-C6	Ar+CO <sub>2</sub> 18%	1,6mm-0,062in	<input checked="" type="checkbox"/>								
73	CrNi FCAW ER308LT0	Ar+CO <sub>2</sub> 18%	1,2mm-0,045in	<input checked="" type="checkbox"/>								
74	Special (-)	Ar+CO <sub>2</sub> 18%	1,0mm	<input checked="" type="checkbox"/>								
75	Special (-)	Ar+CO <sub>2</sub> 18%	1,2mm-0,045in	<input checked="" type="checkbox"/>								
82	Fe ER110S-G 700MC	Ar+CO <sub>2</sub> 18%	1,0mm		<input checked="" type="checkbox"/>							
85	Fe ER70-S6 NO Cu	Ar+CO <sub>2</sub> 18%	0,8mm-0,030in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>							
86	Fe ER70-S6 NO Cu	Ar+CO <sub>2</sub> 18%	0,035in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>							
87	Fe ER70-S6 NO Cu	Ar+CO <sub>2</sub> 18%	1,0mm	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>							<input checked="" type="checkbox"/>
88	Fe ER70-S6 NO Cu	Ar+CO <sub>2</sub> 18%	1,2mm-0,045in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>						<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
90	Fe ER70-S6	Ar+CO <sub>2</sub> 8%	0,8mm-0,030in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>				
91	Fe ER70-S6	Ar+CO <sub>2</sub> 8%	0,035in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		
92	Fe ER70-S6	Ar+CO <sub>2</sub> 8%	1,0mm	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>
93	Fe ER70-S6	Ar+CO <sub>2</sub> 8%	1,2mm-0,045in	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>			<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
95	Fe Galv. ER70-S6	Ar+CO <sub>2</sub> 18%	0,8mm-0,030in			<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>					
96	Fe Galv. ER70-S6	Ar+CO <sub>2</sub> 18%	0,035in									
97	Fe Galv. ER70-S6	Ar+CO <sub>2</sub> 18%	1,0mm			<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>					
98	Fe Galv. ER70-S6	Ar+CO <sub>2</sub> 18%	1,2mm-0,045in									