

GPS 2300 Bi-Pulse

Mig/mag multi-process inverter

Ref.: 53200000

Code: FT53200000V1

Date: May-24



Description:

Inverter technology equipment for multi-process welding (MIG/MAG - PULSED MIG/MAG, MMA & TIG – Pulsed TIG with striking by LIFT ARC).

Application:

Professional use; ideal for pulsed-arc MIG/MAG welding of stainless steels and aluminium.

Electrical power supply:

1 Ph 230V – 50/60 Hz. ±15 %

Main advantages:

- Synergic programming MIG/MAG equipment by welding thickness.
- Pulsed-arc MIG/MAG synergy for Al and CrNi welding.
- Syner BI-PULSE Mode (Dual pulsed-arc feature improve the welding bead aesthetic).
- Modular system with possibility for torch cooling.
- Inductance synergic control. Spatter free.
- A great dynamic with pure CO2 gas.
- Direct driven system of 4 rolls - 50 W.
- Polarity change system (tubular wire).
- Wire reel Ø 300 mm (15 Kg.)
- MMA welding process with specific MMA CEL mode for special electrode welding.
- TIG DC / TIG PULSE welding process with general control of cycle parameters. Lift-arc striking.
- Suitable for generating set.
- It supports connection at 400 V without breakage.

Technical characteristics


Input voltage U_1 (1Ph. 50-60hz) (1)		230 V
Maximum input intensity I_{1max}		43 A
Maximum effective intensity (I_{1eff})		25 A
Maximum absorbed power P_{1max}		10 KVA
MIG/MAG adjustment margin I_{2min} - I_{2max}		10 ÷ 200 A
Welding voltage adjustment U_{2min} - U_{2max}		12 ÷ 30 V
MIG-MAG welding intensity I_2	ED%	
	40 %	200 A
	60 %	165 A
	100 %	125 A
Applicable wire diameters (mm.)		0.6 ÷ 1.0 (1.2mm Al)
Wire reels		Ø300 mm - 15 Kg
Wire speed (m/min.)		1 ÷ 15 m/min
Drive system		4R – 50 W
Bi-Pulse Mode (Dual pulsed-arc)		YES
Continuous MMA adjustment margin I_{2min} - I_{2max}		30 ÷ 200 A (35%)
Continuous TIG adjustment margin I_{2min} - I_{2max}		5 ÷ 200 A (35%)
TIG pulse frequency adjustment margin		0.1 ÷ 500 Hz
Mechanical protection index (IP class)		IP 23 S
Ventilation		Forced
Weight		25 Kg.
ACCORDING TO UNE-EN 60974. (1) Others power supply voltage values on demand.		

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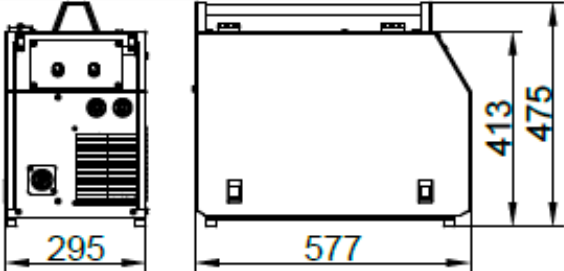



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WELDING

USE MODE		
1- Standard.	2- On workstation.	3- On workstation with WCS-510
		

ELEMETS SUPPLIED AS STANDARD WITH EQUIPMENT:

Ref.	DESCRIPTION	Ref.	DESCRIPTION
532.17.047	Instruction manual.	517.16.520	Wire reel Ø37, 0.8-1.0 mm "V"
503.12.029	Input cable 3x4 mm ² , 3 m. (Plug not incl.)	435.12.018	Machine-gas connection (2 mt) / coupling
531.12.219	Earth clamp cable	532.17.087	Abbreviated instructions

REFERENCES TO CONFIGURE THE INSTALLATION

532.00.000										
Ref.	Description	MIG/MAG				MMA		TIG		
		R Fe (Normal Steel)	Al (Pulse)	SS (Inox. Pulse)	CuSi	FCAW (No gas)	Standard	Cellulosics	R ø 2.0 - 2,4 mm	ø 2.4 -3,2 mm
517.12.090	Mobile Workstation	•	•	•	•				•	•
634.00.000	Water cooling system WCS-510		•	•	•				•	•
517.02.089	WCS support with torch connection extension		•	•	•				•	•
880.531M	Torch XM-501 (3 m, cooled)		•	•	•					
880.338M	Torch XM-38 (3 m, self-cooled)	•				•				
517.16.524	Wire reel Ø37, 0.9-1.2 mm "TUBULAR"					•				
517.16.523	Wire reel Ø37, 1.0-1.2 mm "ALU"		•							
5722	Graphite wire conduit		•							
301.44.000V	Servoglas electronic shield	•	•	•	•	•	•	•	•	•
190.52.634	Torch TIG XT-26E EURO (4 m. self-cooled)								•	
190.51.834	Torch TIG XT-18E EURO (4 m. Cooled)									•
376.00.000	Argon pressure regulator – Mod. EN 2	•	•	•	•				•	•
379.00.000	Argón-CO ₂ pressure regulator – Mod. GASFREE	R	R	R	R				R	R
259.040	Electrode 300A-35/50 accessories						•	•		
1704V10	Electrode heater TRC V10.						R	•		
Use mode recommended		2	3	3	3	1	1	1	2	3

• Component installation.



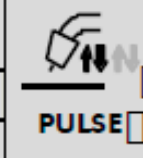


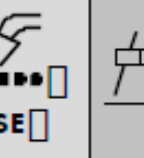
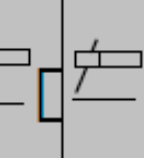
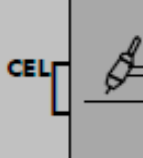

R Component recommended.

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WELDING

MULTI-PROCESS								
								
MIG	MIG SPOT	MIG PULSE	MIG Bi-PULSE	MIG SPOT PULSE	MMA	MMA CEL	TIG	TIG PULSE

Pulsed arc - programs table							Soft. V 0.5			
Material display	Gas display			Display			Wire display		e(mm)	
				D1	D2	D3	mm	In	min.	máx.
Fe	Ar	CO ₂	18%	P50	SG2	SG3	0,8	0,030	0,6	5
				P51	SG2	SG3	---	0,035	0,8	5
				P52	SG2	SG3	1,0	---	0,8	5
SS	Ar	CO ₂	2%	P53	308	LSi	0,8	0,030	0,6	5
				P54	308	LSi	---	0,035	0,6	6
				P55	308	LSi	1,0	---	0,6	6
SS	Ar		2%	P56	308	0 2 %	0,8	0,030	0,6	5
				P57	308	0 2 %	---	0,035	0,6	6
				P58	308	0 2 %	1,0	---	0,6	6
SS	Ar	CO ₂	2%	P59	316	LSi	0,8	0,030	0,6	5
				P60	316	LSi	---	0,035	0,6	6
				P61	316	LSi	1,0	---	0,6	6
SS	Ar		2%	P62	316	0 2 %	0,8	0,030	0,6	5
				P63	316	0 2 %	---	0,035	0,6	6
				P64	316	0 2 %	1,0	---	0,6	6
CuSi	Ar			P65	Cu	Si3	0,8	0,030	0,6	3
				P66	Cu	Si3	---	0,035	0,8	3,5
				P67	Cu	Si3	1,0	---	0,8	3,5
Al Si	Ar			P68	AL	Si5 %	1,0	---	0,6	7
				P69	AL	Si5 %	---	0,045	0,8	6
				P70	AL	Si5 %	1,2	---	0,8	6
Al Si	Ar			P72	Si	12%	1,2	0,045	0,8	7
Al Mg	Ar			P73	AL	MG5 %	1,0	---	0,6	6
				P74	AL	MG5 %	---	0,045	0,6	9
				P75	AL	MG5 %	1,2	---	0,8	9
Fe	Ar	CO ₂	18%	P76	NO	Cu	0,8	0,030	0,6	5
				P77	NO	Cu	---	0,035	0,8	5
				P78	NO	Cu	1,0	---	0,8	5

Standard arc - programs table

Soft. V 0.5

Display Material	Display Gas			Displays 8 SEGMENTOS			Display hilo	
				D1	D2	D3	mm	in
Fe	Ar	CO2	18%	P00	SG2	SG3	0,6	0,023
				P01	SG2	SG3	0,8	0,030
				P02	SG2	SG3	---	0,035
				P03	SG2	SG3	1,0	---
SS	Ar	CO2	2%	P04	308	LSi	0,8	0,030
				P05	308	LSi	---	0,035
				P06	308	LSi	1,0	---
CuSi	Ar			P07	Cu	Si3 %	---	0,035
				P08	Cu	Si3 %	1,0	---
Fe			FCAW	P09	E71	T11	0,8	0,030
				P10	E71	T11	---	0,035
				P11	E71	T11	1,0	---
Al Si	Ar			P12	AL	Si5 %	1,2	0,045
Al Mg	Ar			P13	AL	MG5 %	1,0	---
				P14	AL	MG5 %	---	0,045
				P15	AL	MG5 %	1,2	---
Fe		CO2		P16	SG2	SG3	0,8	0,030
				P17	SG2	SG3	---	0,035
				P18	SG2	SG3	1,0	---
Fe	Ar	CO2	18%	P19	NO	Cu	1,0	---
Cu Si	Ar			95	GAL	CAR	0,8	0,030
				96	GAL	CAR	---	0,035
				97	GAL	CAR	1,0	---

