

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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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.)	435.12.010	Machine-gas connection (2 mt) / coupling
531.12.219	Earth clamp cable	532.17.087	Abbreviated instructions

REFERENCES TO CONFIGURE THE INSTALLATION

Ref.	Description	MIG/MAG					MMA		TIG	
		Fe (Normal Steel)	Al (Pulse)	SS (Inox. Pulse)	CuSi	FCAW (No gas)	Standard	Cellulosics	R ø 2.0 - 2.4 mm	R ø 2.4 - 3.2 mm
532.00.000										
517.12.090	Mobile Workstation	R								
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

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
		P73	AL	MG5 %	1,0	---	0,6	6
		P74	AL	MG5 %	---	0,045	0,6	9
Al Mg	Ar	P75	AL	MG5 %	1,2	---	0,8	9
		P76	NO	Cu	0,8	0,030	0,6	5
		P77	NO	Cu	---	0,035	0,8	5
Fe	Ar CO ₂ 18%	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	300	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	0,0	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	0,0	0,030
				96	GAL	CAR	---	0,035
				97	GAL	CAR	1,0	---

