

MULTIFUNCTION / 0241



Quick specs



Light industrial Application:

Metal fabrication workshops
Shipyards and offshore industry
Maintenance and Repair
Pipe welding outside
Auto Body
Light Industry

Process:

DC TIG (GTAW)
Stick (SMAW)
Plasma Cutting

Input Power: 230V, 1-Phase

Amperage Range: 10-200A

Rated Output at 40 C (104 F):

MMA: 170A at 28V @ 60% Duty Cycle

TIG: 200A at 18V @ 60% Duty Cycle

CUT: 50A at 100V @ 60% Duty Cycle

Weight: 15KG

For TIG, Plasma and Stick Welding

A total solution of precise DC TIG welding and plasma cutting machine

0241 is the ideal DC TIG welding and Air Plasma Cutting solution for installation, repair and maintenance applications.

0241 is built on the base of the DIGITAL system, offers precise and efficient TIG welding process with full DC pulse TIG functions whatever you need. Accurate and refined HF ignition and the necessary control, power and work capacity to reliably complete a variety of professional welding tasks.

0241 also comes with a 50A @ 60% heavy duty cycle plasma cutting power source. What you need for any metal welding or cutting works, you just get this combi machine and it's all you needs.

Easy operation and full functions: From the control panel allowing fast adjustment of all necessary controls for DC TIG welding with either HF or contact ignition. It's also very convenient to store or take out the welding parameters from the memory .

Specialist Features

Precision Arc Performance:

◆ Pulse control:

Built in pulsing functions help to minimize heat input on thin materials, and provide for a faster freezing weld puddle for uphill welding on curved surfaces such as process piping. The TIG pulse also helps moderate filler metal deposition for consistent bead appearance.

◆ High-frequency TIG starting:

Makes it easy to establish an arc under a variety of conditions. Enhances quality by minimizing the potential for weld contamination created by tungsten inclusions in the weld.

◆ Refined arc ignition from 5A (optional 3A).

◆ Pilot Arc for superior arc performance and easy start.

◆ HF or Non-HF Arc ignition: reliable plasma arc initiation without high frequency.

◆ Continuous Output Control: focus the arc for different material



thickness.

- ◆ Rapid Arc Restrike: fast cutting through gaps, even expanded metal.
- ◆ Powerful with heavy duty: 50A @60%.
- ◆ Hot Start Function reliably ignites the electrode and melts perfectly to ensure the best quality even at the start of the seam.
- ◆ Arc Force makes it easier to weld large-drop melting electrode types at low current strengths with a short arc in particular.
- ◆ Fast Spot Arc system simply controls the spot arc parameter and offers a stable arc.
- ◆ 4T Trigger Hold allows to hold the present current by user until press the trigger again.
- ◆ Fast, precise, clean arc ignition and arc ending.
- ◆ 10 channels memory capacity



Outstanding Quality:

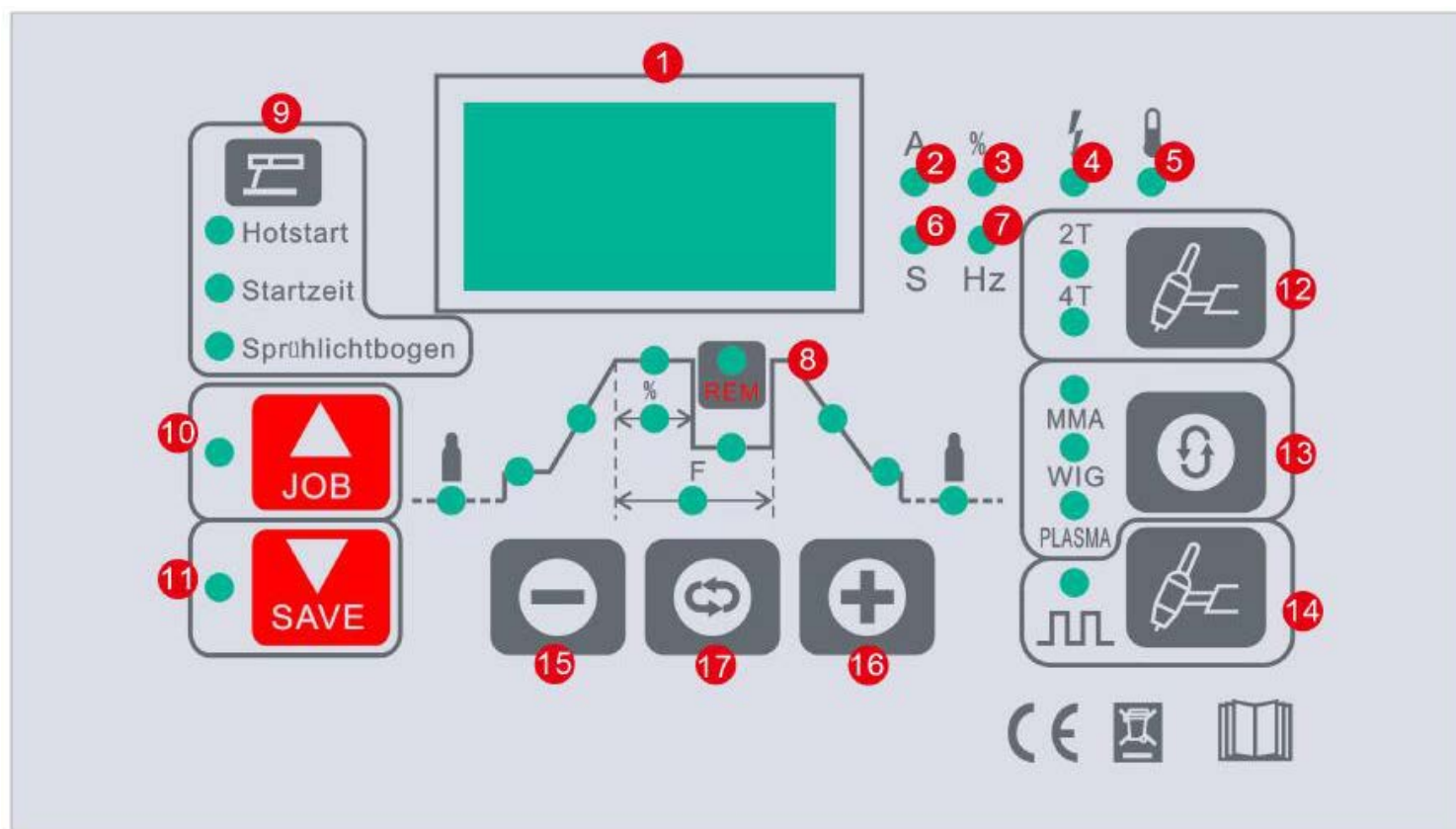
- ◆ Newly designed using the latest power electronic technology for improved reliability.
- ◆ CE Certified.
- 3 Years Warranty on parts , 5 Years Warranty on Transformer

Technical specifications

Description	VECTOR DIGITAL O241 MULTIFUNCTION
Weight	15 kg
Power Source Dimensions	L390mmxW150mmxH300mm
Cooling	Fan Cooled
Welder Type	Inverter Power Source
European Standards	EN 60974-1 / IEC 60974-1

Number of Phases	1
Nominal Supply Voltage	230V +/- 15%
Nominal Supply Frequency	50/60Hz
Welding Current Range (STICK Mode)	10 - 200A
Welding Current Range (TIG Mode)	10 - 200A
Welding Current Range (CUT Mode)	10 - 50A
Effective Input Current /STICK /TIG	32.3A
Maximum Input Current/STICK/ TIG	41.7A
Single Phase Generator Requirement	9.5KVA
STICK (MMA) Welding Output, 40oC, 10 min.	170A @ 60%, 28V / 145A @ 100%, 26.2V
TIG (GTAW) Welding Output, 40oC, 10 min.	200A @ 40%, 18V / 155A @ 100%, 26.2V
Welding Output, 40oC, 10 min.	50A @ 60%, 100V / 31A @ 100%, 92.4V
Open circuit voltage	70.0-80.0V DC
Protection Class	IP23S

General View of Control Panel



Control Panel Parameter Values

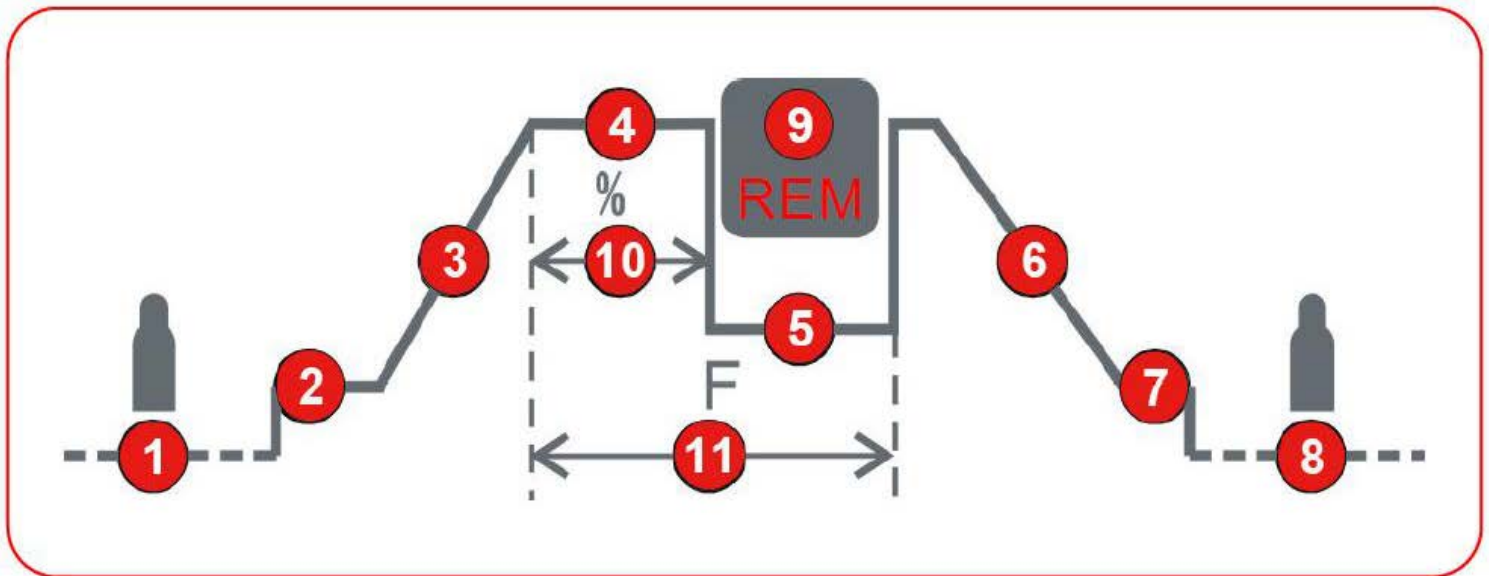
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|-----------------------------------|-------------------------------------|------------------------------|
| 1. Digital Ammeter | 7. Frequency Indicator (Hz) | 13. Process Selection Button |
| 2. Current Indicator | 8. Programming Parameter Indicators | 14. Pulse Button |
| 9. Hot Start/ Arcforce Correction | 15. Negative Control | |

- 3. percentage indicator (%)
- 4. Power Indicator
- 5. Thermal Overload Indicator
- 6. Time Indicator (s)

- 10. JOB
- 11. SAVE
- 12. Trigger Mode Control Button (HF TIG and LIFT TIG Mode only)

16. Positive Control

General View of Contrl Panel(Continued)

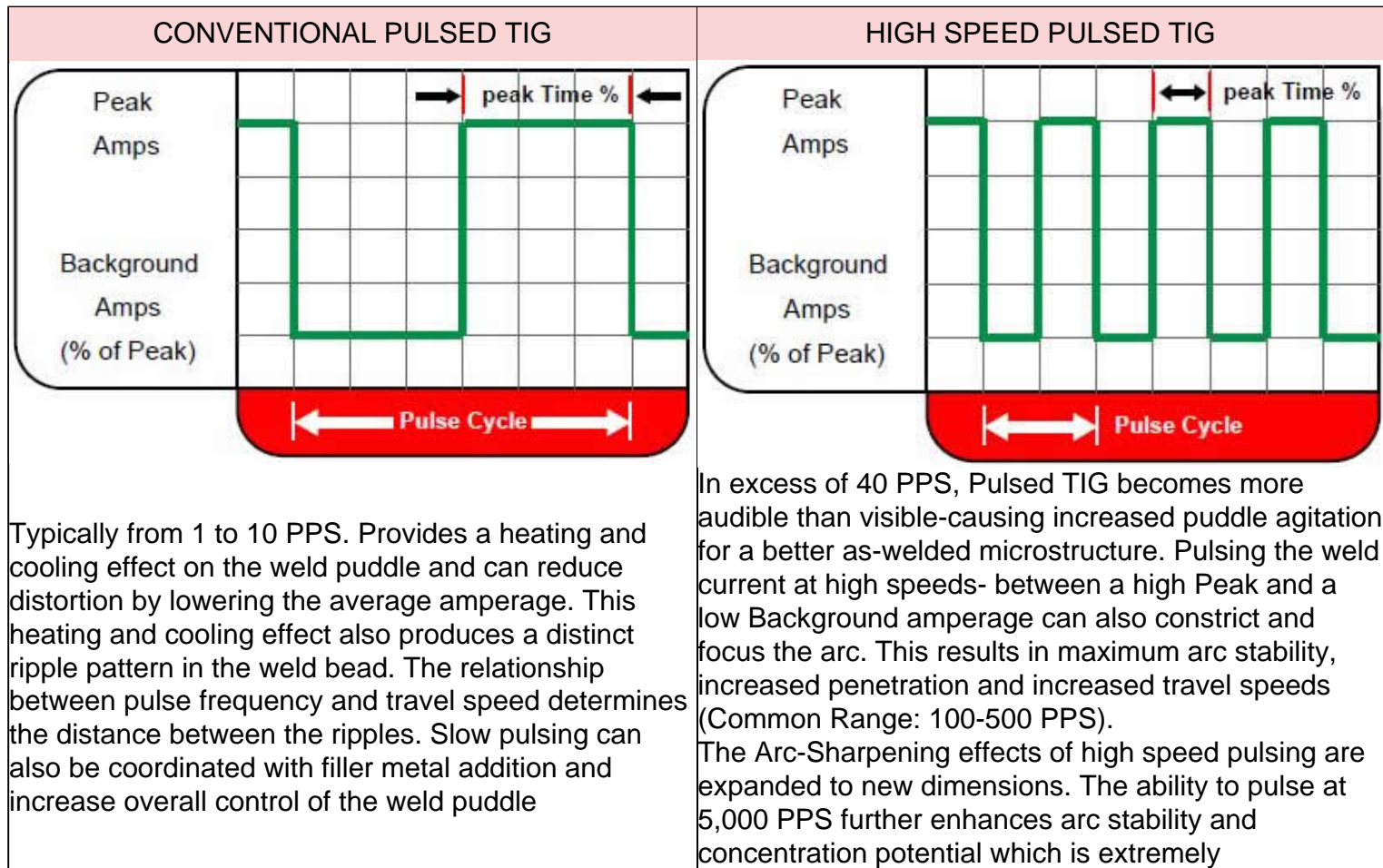


Item	Symbol	Description
1	Gas Pre-Flow	Absolute setting range 0.1s to 20s (0.1S increments)
2	Initial Current	The main current Setting range 10AMP to 100AMP
3	Up Slope	Setting ranges :0.1S-10S (0.1S increments)
4	Peak Current	Setting ranges 10AMP to 200AMP (DC TIG mode)
5	Base Current	Setting ranges 10AMP to 200AMP (DC TIG mode)
6	Down Slope	Setting ranges 0.1-10s
7	End current	Setting ranges 10A-100A
8	Post Flow	Setting ranges 1-20S
9	Remote Control	The system independently identifies the remote control, and when the indicator light is on, the 9 welding current can be adjusted by remote (foot or welding gun).
10	Pulse Width	Setting ranges 10%-90%
11	Pulse Frequency	Setting ranges 1HZ -200HZ

DC TIG-Pulse

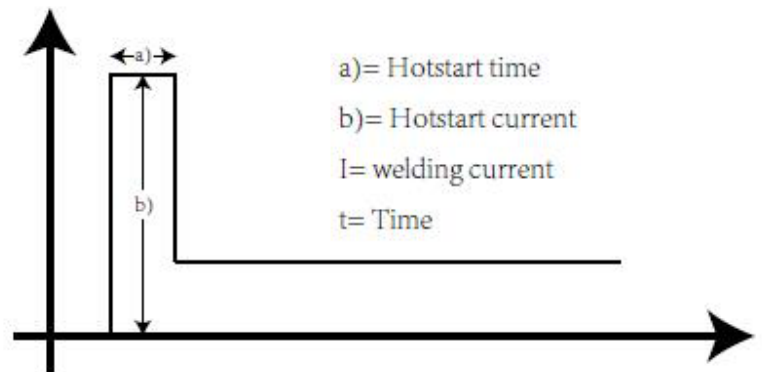
- ◆ High Speed DC TIG-Pulse Controls
- ◆ PPS Pulses per second (Hz): DC=0.1- 5,000 PPS

- ◆ % ON-% Peak Time: 5-95% (Controls the amount of time during each pulse cycle at the PEAK amperage.)
- ◆ Background Amps: 5-99% (Sets the low-pulse amperage value as a % of the Peak Amps.)



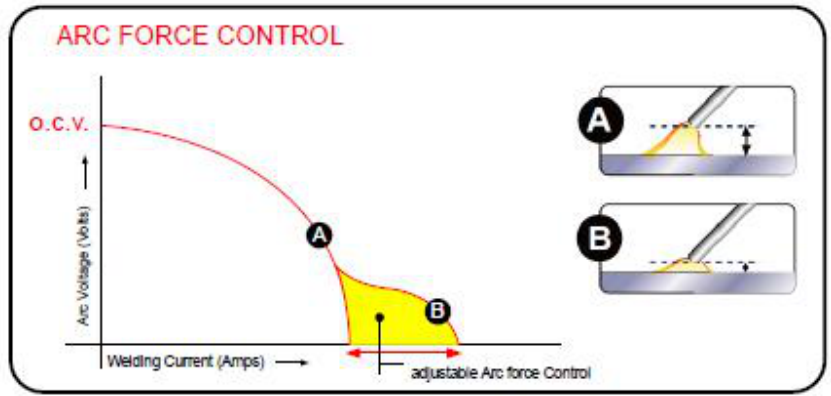
Hot Start

Hot Start Function reliably ignites the electrode and melts perfectly to ensure the best quality even at the start of the seam. this solution makes lack of fusion and cold welds a thing of the past and significantly reduces weld reinforcement. Adjust the hot start current here and the time here.



Arcforce correction (welding characteristics)

During the welding process, arcforce prevents the electrode sticking in the weld pool with increases in current. this makes it easier to weld large-drop melting electrode types at low current strengths with a short arc in particular.



Accessories

For Standard accessories



TIG torch: WP-26
 Gas connector: M16
 Cable length 3M
 5-pin control coupler



Electrode holder
 with cable 3M/200A



AG 60-
 Torch/4.5M



Earth clamp with
 cable 3m



Reducing valve
 AW2000

For Optional accessories



Argon gas regular



Water-cooling unit: wc-100
 Operating Voltage: 230V
 50/60Hz
 Rated Power: 260W
 Cooling
 Power: 1.5KW (1L/MIN)
 Tank Volume: 6.5L



TIG torch: DGT
 26
 Cooling Method:
 Air-Cooled
 Rating: DC
 200A AC 125A
 Duty Cycle:
 35%
 Electrode Size:
 1.0-4.0



Trolley



Foot Pedal
 Trolley:
 5-pin aviation plug