

HELIARC 250 HF WELDING POWER SUPPLY

PART NO. 678480

SPECIFICATIONS



FEATURES/BENEFITS

- High Quality AC Tig Performance . . . Easily handles difficult aluminum welding jobs.
- Electronic SCR Control . . . No output drift with line voltage or heat build up.
- Convenient Output Current Selection . . . A choice of AC, DCSP or DCRP welding current, with a simple turn of a knob, sets the best requirement for your application.
- Flexible Current Range Selection . . . Three widely overlapping ranges of AC and DC output current permits quick coarse adjustment by a simple turn of a knob.
- Solid State Current Control . . . Provides fine-tuned current adjustment within the selected range for consistent welding performance.
- Variable High Frequency Intensity Controls . . . Minimizes high frequency interference by allowing adjustment for optimum starts or for continuous arc stability depending on the welding application.

These INSTRUCTIONS are for experienced operators. If you are not fully familiar with the principles of operation and safe practices for electric welding equipment, we urge you to read Linde's free booklet, "Precautions and Safe Practices for Electric Welding and Cutting," Form S2-529. Do NOT permit untrained persons to install, operate, or maintain this equipment. Do NOT attempt to install or operate this equipment until you have read and fully understand these instructions. If you do not fully understand these instructions, contact your supplier for further information. Be sure to read the Safety Precautions on page 2 before installing or operating this equipment.

Be sure this information reaches the operator.
You can get extra copies through your supplier.

Rated Output @ 40% Duty Cycle		250 Amps @ 90 Volts AC/DC	
Open Circuit Voltage		70 Volts AC/72 Volts DC	
Output Current Range in Amperes	Welding Mode	AC	DC
	5 Amp. Min.	5 to 250	5 to 250
	25 Amp. Min.	25 to 250	25 to 250
Input Voltage		200-230/460 VAC, 1 Ph., 60 Hz.	
Input Current @ Rated Load in Amperes	Voltage	200	230
	Full Load	110	100
Power Factor @ Rated Load		Approx. 92 Percent	
Dimensions:	Width	19 inches	498 mm
	Depth	26 inches	660 mm
	Height	22 inches	559 mm
Weight		275 lbs.	125 kg

- Post Flow Service Control . . . Allows timed internal of gas and water at the end of the weld to protect the weld area, extend tungsten life and help increase torch life.
- Remote or Panel Control Features . . . Provides low voltage circuitry to remote (optional) foot, hand or torch switch control for operator safety and convenience.
- Highest Voltage Applied To Front Panel Components is 115 VAC . . . Conforms to various local codes and industry standards.
- 50 Amp. 115 VAC Auxiliary Outlet . . . Convenient additional power to run grinders, drills, etc.
- Input Power Light . . . Confirms primary power status even when fan cannot be heard.
- "E-2" Access Terminals . . . Output terminal studs are protectively mounted on the front panel for quick and easy connection of welding and ground cables.
- Compact Size . . . Easy to move, takes little floor space.

Heliarc 250 Hf Manual

Raffaella Di Napoli



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Welding Design & Fabrication ,1989 Welding and Metal Fabrication ,1987 **Underwater Repair Technology** J Nixon,2000-04-28 This book provides an overview of the techniques available to the offshore industry for the joining and repair of offshore structures The last few years have seen many developments in underwater engineering technology where a wide range of welding techniques and the necessary associated equipment are now available for underwater joining procedures in the offshore industry The extraction of hydrocarbons from offshore reserves is now a worldwide industry with activity on every continent There are huge steel and concrete structures standing in 200 metres of water with more innovative designs such as tethered platforms capable of operating in deeper waters and with 1000 metre reserves currently being considered New materials stainless steels duplex stainless steels aluminium Monel coated materials and non metallic materials such as reinforced plastics are beginning to be used in significant quantities Joining and inspection techniques have been greatly developed and new design concepts have been brought into use Concentrating on repair technology the author presents a survey of the techniques available for the fabrication repair and modification of structures underwater His book is an important reference for those working in the international offshore engineering industry and will also be of value to universities and training establishments offering courses on marine technology **Summary Technical Report of NDRC, Master Subject Index** United States. Office of Scientific Research and Development. National Defense Research Committee,1946 **Popular Mechanics** ,1959-10 Popular Mechanics inspires instructs and influences readers to help them master the modern world Whether it s practical DIY home improvement tips gadgets and digital technology information on the newest cars or the latest breakthroughs in science PM is the ultimate guide to our high tech lifestyle **Chilton's Food Engineering** ,1983 Welding Engineer ,1957 Metallurgical Abstracts Institute of Metals,1957 ASTM Bulletin ,1940 **Bibliographical Bulletin for Welding and Allied Processes** International Institute of Welding,1955 *Bulletin* American Society for Testing Materials,1957 **Popular Mechanics** ,1959 **Industrial Photography** ,1972 *Journal of the Institute of Metals* Institute of Metals,1957

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