

# 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

**SJ Ball**



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