



for Welding Excellence

IGBT BASED INVERTER TECHNOLOGY

MIG / MAG + MMA WELDING MACHINES

INVAMIG 300 / 400 / 500 / 600

Consistency
in quality
& service

30
Years



INVA series products are semi-automatic gas shielded metal arc- welding machines with IGBT inverter technology. The machine has the characteristics of stable welding process low spatter and good weld. The molten pool is easy to be controlled. Easy to operate. Suitable for all position welding of mild steel, stainless steel, carbon steel, aluminum & its alloys etc, for both solid wire and flux-cored welding wire with the diameter of $\Phi 0.8 / \Phi 1.2 / \Phi 1.6$.

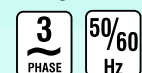
Features:

- Designed with high open circuit voltage and slow wire feeding speed for smooth and steady arc striking / initiation.
- Arc voltage and current feedback control circuit to make the welding process steady, strong adaptability for changes in the Arc length.
- Excellent FTT - Globule control circuit makes positive striking of arc.
- The function of crater filler, to improve the quality at the end of weld.
- Multi function power source combining MIG/MAG, MMA, Scratch TIG and Carbon Arc Gouging.

Functions:

- Soft-start ignition.
- Adjustable welding current / voltage, crater current / voltage, arc characteristics control.
- 2/4 step welding mode selection facility.
- Welding wire diameter selection facility.
- Welding voltage and welding current displayed digitally.
- Protective functions : over-temperature, over current, under / over voltage & single phasing etc.

INPUT

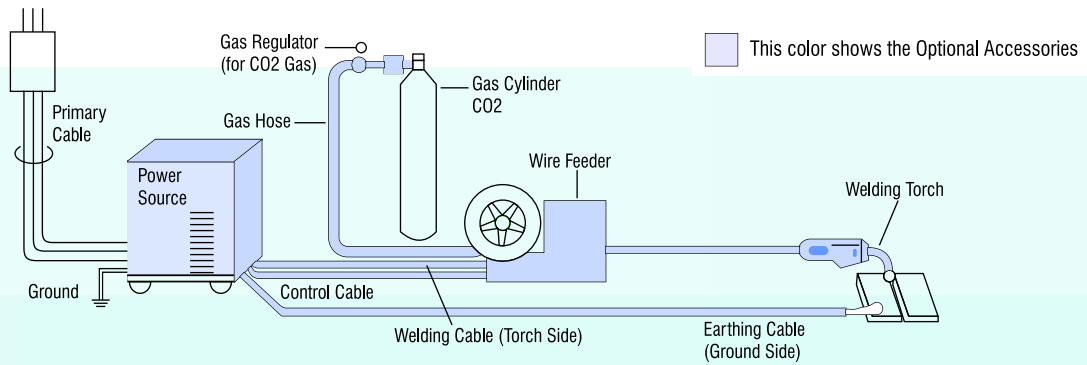


OUTPUT



Excellent Welding for Higher Performance. . .

CONNECTION DIAGRAM



TECHNICAL SPECIFICATIONS

PARAMETERS	INVA MIG-300	INVA MIG -400	INVA MIG-500	INVA MIG-600
Rated input supply	3Ph., 415VAC \pm 10%, 50/60Hz			
Power factor	0.99			
Protection	IP 23			
Insulation class	H			
Rated input current (A)	14.5	23.5	34	38
Rated MCB Capacity (A)	32	40	63	63
Rated input capacity (KVA)	10.5	16	23	30
No load voltage (VDC)	74	74	80	80
Output current range (A)	60-300	60-400	60-500	60-600
Output voltage range (V)	16-30	16-34	16-39	16-44
Crater current range (V)	60-300	80-400	80-500	80-600
Crater voltage range	16-30	16-34	16-39	16-44
Duty cycle (%)	60	60	100	60
Dimension (LxWxH) (mm)	645 x 290 x 600		750 x 430 x 740	
Weight (approx) (kg)	54	54	85	85
Wire Feeder	SK-INV-2		SK-INV-4	
Dimension (approx.) (mm)	480x190x330		480x190x330	
Applicable spool size	300mm dia 15 kg (max)		300mm dia 15 kg (max)	
Drive roll	2 roll		4 roll	
Input supply (VDC)	24		24	
Wire size (mm)	0.8, 1.2		0.8, 1.0, 1.2, 1.6	
Weight (approx) (kg)	9.4		10	
Welding Torch	24KD	WT 3510	WT 5000	
Max. current capacity (A)	250	350	500	
Duty cycle (%)	60%(Ar)/30% (MAG)	60%(Ar)/30% (MAG)	60%(Ar)/30% (MAG)	
Weight (kg)	2.2	2.7	3.04	
Cooling type	Gas Cooled	Gas Cooled	Gas Cooled	
Length (mtr)	3	3	3	
Wire size (mm)	(0.8, 1.0)	(0.8, 1.2)	(1.2, 1.6)	
Standard scope of supply				OPTIONAL ACCESORIES
Power Source	1 No.			PARAMETER LOCKING ATTACHMENT SPOT WELDING ATTACHMENT
Inter-Connection Cable (Welding Cable - 3 Mtr, Earthing Cable- 3 Mtr)	1 No.			
Wire Feeder	1 No.			
Welding Torch	1 No.			
Gas flow meter/regulator, Gas Pre heater	1 No.			

CAT: MO/CAT/INVA/MIG/02
ISSUED ON : JAN 14



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ISO 9001 : 2008