



For Welding Excellence

Consistency in quality & service 30 Years

INVA TIG SERIES (IGBT)

INVA TIG & INVA PULSETIG



MAIN FEATURES

- ▶ Soft switch technology with improved IGBT switching.
- ▶ Robust and sturdy design.
- ▶ TIG, PULSETIG and MMAW welding facility.
- ▶ Smooth and 100% Arc striking suitable for automation.
- ▶ PULSETIG facility to minimize the job distortion.
- ▶ Built-in Gas Pre-and Post flow control.
- ▶ Adjustable up-slope and down-slope time for welding current.
- ▶ 2 Step /4 step facility provides convenience for the welding operation.
- ▶ Built-in Over voltage, Under Voltage, Over Temperature, Phase failure protection.
- ▶ All the major parts like IGBT module, Power devices, Relay, and Rectifier are of reputed make with high reliability.

INPUT		OUTPUT		

BUILT IN FUNCTIONS FOR HIGH QUALITY TIG WELDING

Welding current control: The welding current can be continuously adjusted even during the welding from minimum current of 10 Amps to the rated current through the remote control unit or the potentiometer mounted on the power source.

Up-slope time control: To retain the weld quality at welding start by smooth changing from initial current with up-slope control.

Down-slope time control: Down-slope time control for smooth and perfect finish of welding. To prevent craters and defect in welding like crack etc.

Pulse current control: Able to choose any pulse current as desired.

Pulse frequency control: To change number of welding bead ripple and bead width.

Post flow timer for shielding gas: To prevent oxidation of weld bead at the end of welding and to increase the life of tungsten Electrode.

Arc spot timer control: To ensure tack welding of the plates before the actual welding.

Excellent Welding for Higher Performance...

INVA PULSETIG

TECHNICAL SPECIFICATIONS

PARAMETERS	MODEL	
	INVA TIG-300 P (IGBT)	INVA TIG-400P (IGBT)
Input supply voltage (V/Hz)	3 Ph ~415VAC, 10%, 50/60 Hz	
Rated input power (KVA)	10.9	15.3
Rated input current (A)	16.6	23.2
Open circuit voltage (V)	75	75
Rated welding voltage (V)	22.6	26
Current Adj. Range (A)	10 ~ 300	10 ~ 400
Current Upslope time (Sec)	0.1 ~ 2.5	
Current Down slope time (Sec)	0.1 ~ 12	
Gas Pre-flow time (Sec)	0.1 ~ 0.3	
Gas Post-flow time (Sec)	4 ~ 6	
Spot welding time (Sec)	4 ~ 12	
Pulse current range (A)	10 ~ 300	10 ~ 400
Pulse frequency range (Hz)	1 ~ 150	
Background current range (A)	10 ~ 300	10 ~ 400
Background current time range (Sec)	0.005 ~ 2.5	
Rated duty cycle (%)	60 %	
Insulation Class	H	
Protection Grade	IP - 23	
(L x W x H) Dimensions (mm)	670 x 370 x 650	
Weight (Kg)	43	45

Optional Accessories



Water Cooling Unit

Suitable for InputSupply : 230 V
 Tank capacity : 70 Ltrs.
 Output signal : No Contacts
 Over all size (LXWXH) : 700X400X550 mm

Along with built in Radiator, Cooling Fan, Pump Motor and Pressure Switch.



Gas cooled Model SR - 26

Water cooled Model WP - 18



Remote Controller

Foot Controlled Remote

Adjustment : 0 to maximum current continuous variable
 Cable Length : 5 meters

INVA TIG

PARAMETERS	MODEL		
	INVATIG - 300S (IGBT)	INVATIG - 400S (IGBT)	INVATIG - 500S (IGBT)
Input supply voltage (V/Hz)	3 ~ 415VAC, ± 10%, 50/60 Hz		
Rated input power (KVA)	10.9	15.3	19.9
Rated input current (A)	16.6	23.2	30.3
Open circuit voltage (V)	75	75	80
Rated welding voltage (V)	22.6	26	30
Current Adj. range (A)	10 ~ 300	10 ~ 400	10 ~ 500
Current up-slope time (Sec)	0.1 ~ 2.5		
Current Down slope time (Sec)	0.1 ~ 12		
Gas pre-flow time (Sec)	0.1 ~ 0.3		
Gas post-flow time (Sec)	4 ~ 6		
Rated duty cycle (%)	60 %		
Insulation Class	H		
Protection Grade	IP - 23		
(L x W x H) Dimension (mm)	670 x 370 x 650		750 x 430 x 740
Weight (kg)	43	45	50

Standard Scope of Supply

Power source : 01 No.
 Gas cooled torch 4 mtr length of appropriate capacity : 01 No.
 Argon regulator cum flow meter : 01 No.
 Gas hose of 3 mtr Length : 01 No.
 Welding Cable for earthing of 3 mtr : 01 No.

Optional Accessories (At Extra Cost)

Remote control unit
 Foot controlled remote
 Water cooling unit
 Water cooled torch
 Auto TIG feeding systems



MOGORA COSMIC PVT. LTD.

Office : EL 31/16 Electronic Zone, Pimpri Industrial Area, MIDC Bhosari, Pune 411 026, INDIA.
 Help desk : +91-020-66123806 / 66123807 (Weekdays: 9:00am to 5:30pm)
 Telefax : +91-020-66123803 / 27130374
 Email : info@mogora.com / sales@mogora.com
 Website : www.mogora.com

(In view of continuous development, we reserve the right to modify the design and / or dimensions without notice)



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