



Tetricx 230 AC/DC Smart • Comfort TM

/activArc®



Smart



Comfort



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- Modular AC/DC TIG inverter welding machine, gas- or water-cooled
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- Adjustable AC waveform, sine, trapezoidal, square current
- Adjustable AC frequency between 50 Hz and 200 Hz
- Adjustable AC balance
- TIG welding with reproducible, electronic HF start
- Safe ignition also for long hose packages
- TIG lift arc welding without HF
- TIG automated pulsing with automatic specification of required pulse parameters
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Adjustable up-slope/down-slope
- Spot welding/tacking function
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- MMA automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Antistick function
- Gas-cooled or optionally water-cooled with cool 40 U31 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 4-litre water tank (cool 41U31 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Connection capability for remote control and function torch
- Trolley 35.2-2 trolley available for delivery
- Mains connection 230 V/16 A
- High mains voltage tolerance +15%/-40% and therefore fully generator-compatible
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Open circuit voltage	45 V
Setting range for welding current	3 A - 230 A
Duty cycle 40 °C	230 A / 40 % 200 A / 60 % 170 A / 100 %
cos φ	1
Efficiency	85 %
Dimensions LxWxH in mm	600 x 205 x 415
Weight	19.3 kg
Dimensions cooling unit in mm	600 x 210 x 340
Weight, cooling unit	14 kg
Trolley dimensions L x W x H in mm	600 x 580 x 1200
Transport cart weight	33 kg



Type	Designation	Item no.
Tetrix 230 AC/DC Smart 5P TM	TIG AC/DC welding machine, portable, modular, decentral, 5-pole connection socket	090-000158-00502
Tetrix 230 AC/DC Comfort 5P TM		090-000159-00502
Tetrix 230 AC/DC Smart 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	090-000158-00504
Tetrix 230 AC/DC Comfort 8P TM		090-000159-00504
TIG 200 GRIP GD 5P 4m	TIG welding torch, gas-cooled	394-510981-00600
TIG 200 GRIP GD 5P 8m		394-510981-00608
WK35 mm² 4m/K	Welding lead	092-000008-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Tetrix 230 AC/DC Smart 5P TM	TIG AC/DC welding machine, portable, modular, decentral, 5-pole connection socket	090-000158-00502
Tetrix 230 AC/DC Comfort 5P TM		090-000159-00502
Tetrix 230 AC/DC Smart 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	090-000158-00504
Tetrix 230 AC/DC Comfort 8P TM		090-000159-00504
cool40 U31	Cooling unit with centrifugal pump	090-008593-00502
TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	394-510990-00600
TIG 260 GRIP WD 5P 8m		394-510990-00608
WK35 mm² 4m/K	Welding lead	092-000008-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
Trolley 35.2-2	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	090-008296-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

- ▶ * Alternative, not included in the final total
- ▶ Welding machines optionally available with different controls

Packing units

Type	Designation	PU Unit	Item no.
6x Tetrix 230 AC/DC Smart 5P	6-item pack, Tetrix 230 AC/DC Smart, 5-pole connection socket	6	092-002629-00502
6x Tetrix 230 AC/DC Smart 8P	6-item pack, Tetrix 230 AC/DC Smart, 8-pole connection socket	6	092-002629-00504
6x Tetrix 230 AC/DC Comfort 5P	6-item pack, Tetrix 230 AC/DC Comfort, 5-pole connection socket	6	092-002630-00502
6x Tetrix 230 AC/DC Comfort 8P	6-item pack, Tetrix 230 AC/DC Comfort, 8-pole connection socket	6	092-002630-00504

▶ Packing units containing 6 pieces of Tetrix 230 AC/DC welding machines without accessories can be found in the packing units chapter on page 247.