

HELIARC 250 HF WELDING POWER SUPPLY

PART NO. 678480

L12-964

L12-964

L12-964

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.

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		37% lbs.	12% kg

- Post Flow Service Control . . . Allows timed interval 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.

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Heliarc 250 Hf Manual

Institute of Metals

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Heliarc 250 Hf Manual:

Welding Design & Fabrication ,1989 **Welding and Metal Fabrication** ,1987 **Underwater Repair Technology**
John H. Nixon,2000-09 The book provides an comprehensive overview of the techniques available for the joining and repair of offshore structures Nixon starts with joining systems that do not require welding and then explores the associated engineering systems needed for joining procedures Topics include pipe handling hyperbaric chamber design and principal underwater welding techniques including wet one atmosphere and hyperbaric Nixon also includes a description of the effects of environmental pressure on the various hyperbaric welding processes A complete guide to underwater welding this book also discusses technologies that show promise in the laboratory but are not currently in use Nixon provides appendices describing the relevant diving technologies basic oceanography and the research methods used in the development of hyperbaric welding *Summary Technical Report of NDRC, Master Subject Index* United States. Office of Scientific Research and Development. National Defense Research Committee,1946 Chilton's Food Engineering ,1983 *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 **Welding Engineer** ,1957
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