



AOTAI

CATALOGUE

Complete Solutions For
Welding & Cutting

WE

DELIVER

VISION

INVESTING IN RESEARCH
AND DEVELOPMENT FOR
INNOVATIONS

CUSTOMER

SMART

STABLE

QUALITY

BY FOCUSING ON THE DEVELOPMENT,
SKILLS, MORALE AND WELLBEING
OF OUR PEOPLE, AOTAI DRIVES THE
GROWTH, PROFITABILITY,
COMPETITIVENESS AND LONG-TERM
SUCCESS OF OUR CLIENTS

QUICK RESPONSE
ON-TIME DELIVERY
PROFESSIONAL SOLUTIONS...

SHOWING APPRECIATION
FOR EMPLOYEES

AOTAI SERVICE TEAM
IS ALWAYS HERE FOR YOU

ON-LINE SUPPORT OR
ON-SITE TROUBLE
SHOOTING

LONG-TERM
CUSTOMER
RELATIONSHIPS

MISSION

TO BE THE HIGHEST
QUALITY AND
MOST INNOVATIVE
PROVIDER OF
WELDING AND
CUTTING EQUIPMENTS

POWERFUL ARC

VALUES

OUR TEAM MAKES US STAND OUT
EXPERIENCE, KNOWLEDGE
CREATIVITY AND DEDICATION
RESEARCHING AND MANUFACTURING
INVERTER ARC WELDER
AND PLASMA CUTTER FOR OVER
28 YEARS

CUSTOMER-CENTRIC
SYSTEM SOLUTIONS

SERVICE

INTRODUCTION

Aotai Electric Co., LTD is a leading manufacturer of welding and cutting equipments in China. Aotai offers nearly 100 welding machine models in 13 series. Its line of welding machine products includes Inverter MMA, Inverter TIG, Inverter MIG, Inverter SAW, Water Cooling Machine, Inverter Air Plasma Cutter as well as a variety of accessories. Uncompromising in its high standards, Aotai is making every effort to provide its customers with highly functional and adaptable products that are easy to install and maintain. Despite the white hot competitions in Chinese market, Aotai's inverter welding machine series have remained the best selling welding machine since 2005.

Aotai was founded by several professors and their graduate students from Shandong University in 1993. Since it was founded, Aotai is dedicated to pursue innovative technologies that bring breakthrough in its field. In 2002 it was named one of the National Torch Plan Hi-Tech Enterprise, which is an award for hi-tech companies with excellence in R&D achievements. Aotai also received a National Science and Technology Advancement silver award in 2004. Aotai has a team of passionate and experienced R&D engineers. Most of them possess advanced degrees and rich experiences. The managements are also specialists and experts with an average of over 30 years experience. These individuals are the ones who developed the core intellectual property of the company. This is the technical foundation of the expertise that makes Aotai a national leader. To meet the growing demands of Chinese market, Aotai built 28,000 square feet manufacturing facilities in 1999 and a 1,700,000 square feet factory in 2005. In 2006, Aotai also built a 50,000 square feet office building to accommodate the growing R&D activities. In 2013, the third 1,000,000 square feet manufacturing facilities was set up. These extensions have greatly boosted the production capability to over 200,000 units a year.

With successes in domestic market, Aotai started to explore the global market opportunities in 2006. Since Global Sales Division was founded, over fifty thousands units have already been shipped to over 128 countries and areas. In order to provide fast on site technical service and quick delivery for our global distributors, Aotai plan to set up service centers and warehouses globally. In 2015, Aotai India and Aotai Russia were founded. We are continuing this effort to boost global sales, and we welcome all interested parties around the world to contact us for our product information and collaboration opportunities.



OUR FACILITIES

- A-Headquarter: 2006, Jinan (50, 000 square feet)
B- Factory I: 1999, Jining (28, 000 square feet)
C- Factory II: 2005, Zichuan (1, 700, 000 square feet)
D- Factory III: 2013, Jinan (1, 000, 000 square feet)



AOTAI Production Capacity



2,778,000

Square feet workshop



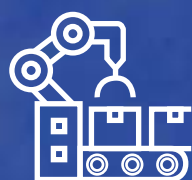
322 Patents



572 R&D
staffs



4 R&D centers



50% Fully automated
production flowline



200,000 Units
Welding machines
production capacity



3 Manufacture facilities



38 Modern
production lines



EXTENSIVE AFTER-SALE SERVICE

Besides the high quality machines, we also offer you professional after-sale service. These service programs include:

1. Life time technical support. Our experienced customer support team will help you solve technical problems. We guarantee to respond to your inquiry within 24 hours, whether it comes from phone, mail or fax.
2. We provide detail English operation manual and maintenance manual for each model of equipment. These manuals include lots of pictures to show the detail procedures for trouble shooting and spare parts replacement. Operating DVD will be provided upon request. All documents and spare parts are carefully designed and easy for user to follow.
3. We provide comprehensive training for our international distributors and clients. The training is held twice per year.
4. We provide life time spare parts mail service to our international clients.



SPECIALLY DESIGNED FOR HARSH



Mechanical Environment Test

EMC Test

Climate Environment Test

Life Test

INDUSTRIAL ENVIRONMENT



100+ tests





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03 GMAW

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MMA

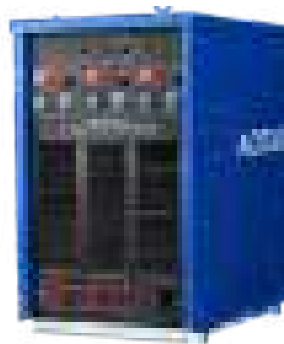
A close-up, low-angle shot of a welder working on a large metal structure. The welder is wearing a silver, dome-shaped protective helmet with a dark rectangular viewing window. They are wearing an orange safety vest over a dark shirt. Their hands, clad in worn, light-brown leather gloves, are holding a welding torch. A bright, intense flame and a shower of small, glowing sparks are visible at the point where the torch meets the metal. The background is a clear, bright blue sky. The overall scene conveys a sense of industrial activity and precision.

MMA SUMMARY

Special Industrial Application



ARC400II /DuraARC200II
For Cellulose Electrode
Page 16



ARC400-3T /6T
Multi-operators
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Professional Model



ARC-400 /500 /630
Page 18



ARC-1000 /1250
Carbon ARC Gouging
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Portable Model



DuraARC200
1Ph Portable Model
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CHOOSE YOUR MODEL

	Model	TIG	Cellulose Electrode	Current for Duty Cycle (A)		Input Voltage*		VRD
				60%	100%			
1-Phase	DuraARC200	✓		153	118	230V		
	DuraARC200II	✓	✓	153	118	230V		✓
3-Phase	ARC400			400	310	380V~525V	220V~440V	Optional
	ARC400II			400	310	380V~525V	220V~440V	Optional
	ARC400-3T		✓	400	310	380V~525V		Optional
	ARC400-6T	✓		400	310	380V~525V		Optional
	ARC500	✓		500	387	380V~525V		Optional
	ARC630	✓			630	380V~525V		Optional
	ARC1000	✓			1000	380V~525V		Optional
	ARC1250	✓			1250	380V~525V		Optional

* For Multi - Voltage Input, please check with sales for detail

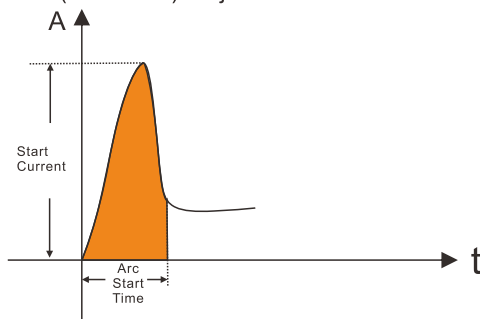
MMA (STICK) WELDERS



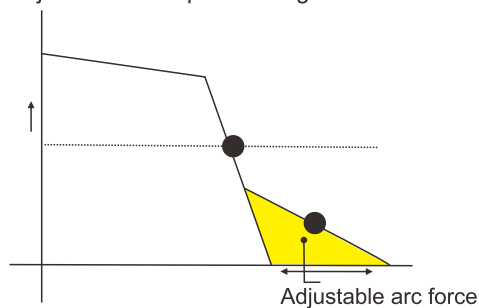
Aotai ARC series, a complete MMA solution, provide you versatile stick welders for shop and field applications. With the combination of modern inverter technology and precise wave control technology, ARC series reduce the spatter formation and ensure best quality weld results even when work with generator and 100 meters long distance welding.

Highlights for ARC

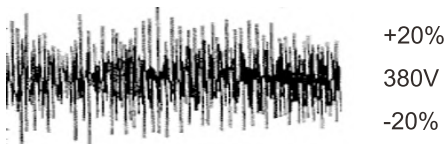
1. Multi-Voltage Adaptive technology: 1 phase /115V /230V, 3 phase /220V-440V, 380V-525V automatic voltage adaptation. (*Check each model for detail)
2. Anti-Voltage Fluctuation: Ensure the machines work perfectly under serious grid power fluctuation.
3. VRD: Low open circuit voltage. (*Check each model for detail)
4. Easy Arc Start (Hot start): Adjustable arc start current brings 100% arc ignition success.



5. ARC Force: Adjustable knee-point voltage and ARC force current.



6. Smart Fan: Fan starts when needed, for digital model.
7. Against voltage fluctuation



8. Workable With Generator



Welding machines are built-in the generator

Accessories for ARC Series

	Item NO.	Picture	Size (mm)	Model /Adjustable Parameters	Machine Model
Wire Remote Controller	340010-00001H		150*70*26	Mini-WRC • Welding Current	ARC Series
Wire Remote Controller with Digital Display	340010-00002H		207*97*92	WRC • Welding Current • Arc Force Current	
Wireless Remote Controller with Magnet	340010-00003H		160*95*29	WLRC • Welding Current • Arc Force Current	
	340010-00004H		150*70*26	Mini-WLRC • Welding Current • Arc Force Current	

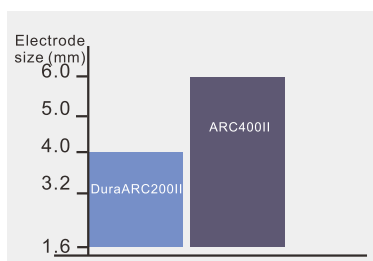
	Item NO.	Picture	Model /Specification	Machine Model
TIG Torch	310010-00087H		WP-17V 140A@35%, gas cooled 5m cable	ARC Series DuraARC Series
	310010-00088H		WP-26V 180A@35%, gas cooled 5m cable	
Electrode Holder	461005-00002H		EH-300 300A	
	461005-00004H		EH-500 500A	
Earth Clamp	461011-00002H		EC-300 300A	
	461011-00004H		EC-500 500A	
Gouging Torch	310060-00006H		TBQ-500 500A@60% 1.5m Cable	ARC630 /1000 /1250 ARC400-3T /6T
	310060-00010H		TBQ-1000 1000A@60% 1.5m Cable	
Trolley & Carry case	361005-00003H 361005-00004H 361005-00007H		Rack with wheels Depend on various models size	ARC Series
	361005-00009H		TM-II 770X300X1200mm	DuraARC Series



ARC II series is specially designed for MMA welding with Cellulose Electrodes (CEL). This series is suitable for working under extremely harsh industry field, special inner structure with optimum dust /water protection to ensure ARC II robust design with unconditional usage for optimum welding results.

Features and Benefits

- Hot Start ensure 100% arc ignition
- Wire remote control (ARC400II optional)
- Suitable for long distance welding (100m)
- Adjustable Arc Force bring great performance for all position welding
- Full power input ensure stable arc during long cable welding and voltage fluctuation
- Extra Arc Force Current ensure deep penetration and bring perfect vertical down-welding of cellulose electrodes (CEL)
- Work with generator

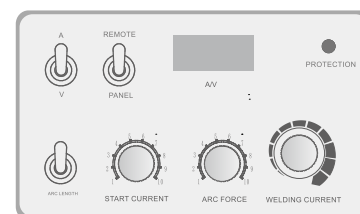


Standard Equipments (ARC400II)

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Welding cable L=3m
- 1 Ground cable L=3m

DuraARC200II

- 1 Power source
- 1 Connected primary cable L=3m
- 2 Quick plugs



ARC400II

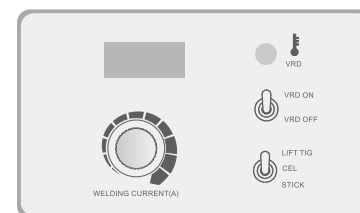
3 Phase **220V** **440V** **380V** **525V**

Multi-voltage Option

Check on Page **13**

Work with Remote Controller

Check on Page **15**



DuraARC200II

Technical Specification

	ARC400II	DuraARC200II
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz	1 phase, 230V±10%, 50 /60Hz
Rated input capacity (KVA)	26.3	9
Rated input current (A)	40	39
Duty cycle (40°C)	60%@400A	35%@200A
OCV (V)	84	82 (VRD OFF) /13 (VRD ON)
Output current range (A)	20-400	10-200
Efficiency	89%	>80%
Protection class	IP21S	IP23S
Insulation class	H	F
Dimension (mm)	594*307*578	381*155*298
Weight (kg/lb)	43 /95	7.3 /16.1



Multi-Operators SMAW

ARC400-3T /6T



ARC-T series is multi-operators model, it is new generation developed specially to meet industry requirement. The ARC-T integrates three or six single ARC units into one case. Three or six independent outputs allow corresponding number of welders to work at the same time. There are several individual control systems in one unit, one output failure will not affect other outputs. ARC-T also can combine three or six outputs together to reach max output for carbon arc gouging feature. Comparing with traditional rack solution in shipyard application, ARC-T will be more efficient in size, weight and cost. Adjustable welding cable length is up to 100m. Long distance welding provided.

Max output
current for
ARC400-3T
is 1200A



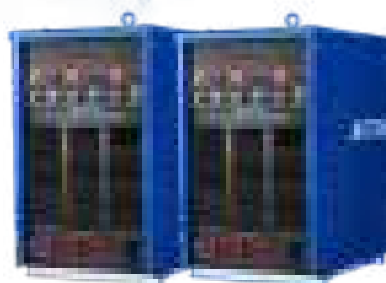
3 IN 1



Max output
current for
ARC400-6T
is 2400A



6 IN 1



Standard Equipments (3T)

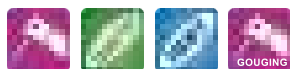
- 1 Connected primary cable L=3m
- 3 Electrode holders
- 3 Copper connectors
- 2 Copper connectors

Standard Equipments (6T)

- 2 Connected primary cable L=3m
- 6 Electrode holders
- 6 Copper connectors
- 4 Copper connectors

Technical Specification

	ARC400-3T	ARC400-6T
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz	
Rated input capacity (KVA)	18.7*3	18.7*6
Rated input current (A)	28.4*3	28.4*6
Duty cycle (40°C)	60%@400A*3	60%@400A*6
OCV (V)	68	
Output current range (A)	20-400*3	20-400*6
Efficiency	89%	
Protection class	IP21S	
Insulation class	H	
Dimension (mm)	675*505*850	675*1045*1000
Weight (kg/lb)	120 /265	234 /516.8



ARC series gives a highly stable DC arc and ensures perfect welding in all situations and positions. It is new generation developed specially to meet harsh industry requirement and performs full power against voltage fluctuation and long distance welding (up to 100m).

Features and Benefits

- Good performance with E6013, E7018 electrodes
- Adjustable arc force and hot start improve the performance
- Arc force feature against broken arc
- Extra arc force current to ensure deep penetration
- Hot start ensure 100% arc ignition
- Wire /wireless remote control (optional)
- Adjustable arc force bring great performance for all position welding
- VRD feature (optional)
- Suitable for long distance welding (100m)
- For high current model (>500A), 100% duty cycle and can perform carbon arc gouging feature.



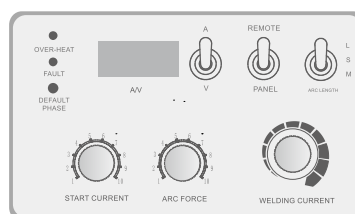
ARC-315 /400 /500 /630



ARC-1000 /1250

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Welding cable L=3m
- 1 Ground cable L=3m



ARC-1000 /1250



ARC-315 /400 /500 /630

Technical Specification

	ARC315	ARC400	ARC500	ARC630	ARC1000	ARC1250
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz					
Rated input capacity (KVA)	13.6	18.7	24.6	34.2	54.6	66.5
Rated input current (A)	20.7	28.4	37.4	52	83	101
Duty cycle (40℃)	60%@315A	60%@400A	60%@500A	100%@630A	100%@1000A	100%@1250A
OCV (V)	68	68	83	96	82	90
Output current range (A)	20-315	20-400	20-500	50-630	60-1000	60-1250
Efficiency	89%					
Protection class	IP23S				IP21S	
Insulation class	H					
Dimension (mm)	655*324*546	655*324*546	655*324*546	686*322*584	767*352*757	767*352*802
Weight (kg/lb)	43 /95	43 /95	50 /110.4	58 /128.1	95 /209.8	100 /220.9



Portable SMAW

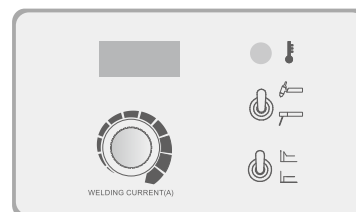
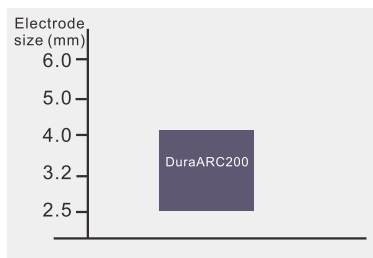
DuraARC200



DuraARC series is new generation single phase portable MMA model for industry and household application. Light weight, compact size and outstanding robust design make it more convenient to carry around. DuraARC performs powerful stable DC arc and can continuously welding 4mm electrode without stop. DuraARC is designed to work with generator and it performs full power against voltage fluctuation.

Features and Benefits

- Fashionable streamline design, beautiful and upscale
- Real current output 200A, strong power, high duty cycle, capable of 4mm electrode long time welding
- Multiple protections: over voltage protection, under voltage protection, over heat protection, fan fault protection, over current protection



DuraARC200

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 2 Quick plugs

Technical Specification

	DuraARC200
Rated input voltage/frequency (Hz)	1 phase, 230V±10%, 50 /60Hz
Rated input capacity (KVA)	8.6
Rated input current (A)	39
Duty cycle (40°C)	35%@200A
OCV (V)	59
Output current range (A)	10-200
Efficiency	>80%
Protection class	IP23S
Insulation class	F
Dimension (mm)	381*155*298
Weight (kg/lb)	7.3 /16.1

TIG

ROTARY WELDING



GTAW SUMMARY

Special Industrial Application



Hot Wire TIG ATIG-400/500P(HW)
Digital DC Pulse TIG
Page 27



ATIG-PAC-315III /500III
Digital AC /DC Pulse TIG
Page 31



ATIG-PAC-315 /500 /630
Digital AC /DC Pulse TIG
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TIG400II
TIG for CEL Welding
Page 37

Digital /Analog Professional Model



ATIG-P-270 /315 /400 /500
Digital DC Pulse TIG
Page 35



ATIG-400 /500 /1000
Digital DC TIG
Page 35



TIG-400 /500 /630 /1000 /1250
Analog DC TIG
Page 36

Single Phase Portable Model



TIG200 PRO
Analog DC Pulse TIG
Page 37



ATIG200P
Digital DC Pulse TIG
Page 37



ATIG210PAC
Digital AC /DC Pulse TIG
Page 38

CHOOSE YOUR MODEL

Model		MMA	DC TIG	Pulse TIG	AC TIG	Thin Plate Welding	Input Voltage*		Stored Program	TIG Wire Feeder Optional
1-Phase	TIG200PRO	✔	✔	✔		✔	230V			
	ATIG200P	✔	✔	✔		✔	230V			
	ATIG210PAC	✔	✔	✔	✔	✔	115V /230V		✔ (up to 10)	
3-Phase	TIG-400 /500 /630	✔	✔				380V~525V	220V~440V		✔
	TIG1000 / 1250	✔	✔				380V~525V	220V~440V		✔
	ATIG400	✔	✔				380V~525V	220V~440V		✔
	ATIG1000	✔	✔				380V~525V	220V~440V		✔
	ATIG270P	✔	✔	✔		✔	380V~525V	220V~440V		✔
	ATIG315P	✔	✔	✔		✔	380V~525V	220V~440V		✔
	ATIG400P	✔	✔	✔		✔	380V~525V	220V~440V		✔
	ATIG500P	✔	✔	✔			380V~525V	220V~440V		✔
	ATIG315PAC	✔	✔	✔	✔	✔	380V~525V	220V~440V		✔
	ATIG500PAC	✔	✔	✔	✔		380V~525V			✔
	ATIG630PAC	✔	✔	✔	✔		380V~525V			✔
	ATIG315PAC III	✔	✔	✔	✔	✔	380V~525V		✔ (up to 30)	✔
	ATIG500PAC III	✔	✔	✔	✔		380V~525V		✔ (up to 30)	✔
	Hot Wire TIG ATIG400P(HW)	✔	✔	✔						✔
	Hot Wire TIG ATIG500P(HW)	✔	✔	✔						✔

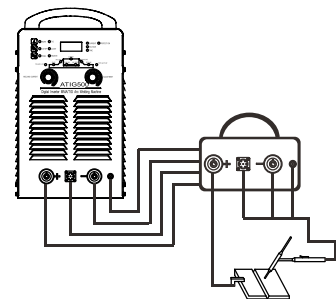
TIG WELDERS



AOTAI TIG series provides you full range of TIG welding products for the application needs in work shop or on-site. DC TIG series are powerful, robust and easy to operate, it brings extremely clean TIG Welding process. Full digital controlled ATIG-PACIII series have advanced wave control technology and they can be used in automatic and /or robotized welding system.

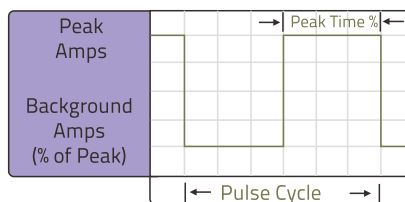
Highlights for DC TIG

1. Pre-Gas /post-gas protect the tungsten electrode and weld pool against oxidation.
2. Initial welding current allows to preheat work piece and point the start joint.
3. Up-slope current adjustment allows progressive increasing of the welding current.
4. Down-slope current adjustment prevents the crater at the end of welding process especially for thin welding material.
5. Final welding current reduction avoids the crater formation by reducing the current during extinguishing of the arc for a clean end of the weld seam.
6. Pulse TIG makes all position welding and thin sheet welding easier.
7. Full power output during the voltage fluctuation.
8. Repeat function allows secondary current to prevent over heat of workpiece.
9. Remote controller: hand or pedal controller.
10. Cold wire feeder: improves TIG productivity.
11. Tacking: allows quick tacking of joint before welding.
12. Extended torch technology (40m TIG welding torch): remote weld expert, with extended torch and improved components, to ensure 100% arc start success rate, and stable arc.
13. Junction components: remote weld solution, extend weld zone, reduce labor intensity. High duty cycle up to 100%.
14. TIG wire feeder: change from manual welding to semi-auto welding, highly reduce labor intensity, help for weld seam for mation.
15. Automation system interface: rich interface signals (start-stop, current on /off, voltage feedback signal), help to connect with automation system, realize auto welding.
16. Thin plate pulse weld: by adjusting pulse duty cycle to decrease heat input, suit for thin plate or material with larger crack tendency welding.
17. Shoe shape gas holding device with extra gas protection ensures high quality welding for nickel alloy and titanium alloy.

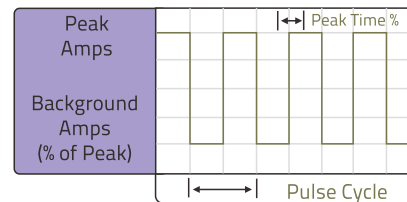


Highlights for AC /DC TIG

1. Square wave current provides more cleaning for Aluminum welding.
2. Balance adjustment improves the result during AC welding the penetration and clean phase.
3. Embedded expert database regulates the parameters for perfect arc.
4. Job saving: allows job memory for up to 30 welding tasks (optional).
5. Pulse TIG controls HF pulse, this can narrow weld seam, reduce heat affected zone, deepen weld seam penetration, improve weld speed.



Conventional Pulse TIG

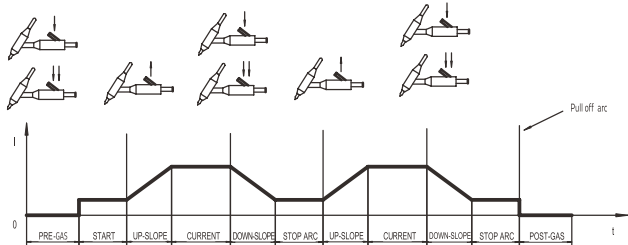


High-Speed Pulse TIG

6. Synchronous mutual arc welding technology: apply this technology for medium and thick plate, can improve weld efficiency (above 1.5 times), improve weld speed and weld deposition rate; by cooperative control, two welding machines' arc has no interference to each other.



7. Repeat function: realize discontinuous weld without arc breaking, reduce interference caused by frequency arc start.



8. Parameter adjustable torch (with /without displayer) allows welder control the welding current on torch for easy operation.

CUSTOMIZE YOUR DIGITAL TORCH



Open Canopy

Remove Switch






Switch Replacement



Canopy Replacement



Close Canopy








Accessories for TIG Series

	Item NO.	Picture	Model /Specification	Machine Model
Gas Cooled Torch	310010-00004H		WP17 135A (DC) 95A (AC) @35% Tungsten size: 1.0-3.2mm 5m cable	TIG Series ATIG Series
	310010-00026H		WP26 180A (DC) 125A (AC) @35% Tungsten size: 1.0-4.0mm 5m cable	TIG Series ATIG-P Series ATIG-PAC Series
Water Cooled Torch	310020-00012H		WP18 380A (DC) 270A (AC) @60% Tungsten size: 1.0-4.0mm 5m cable	ATIG-P Series ATIG-PAC Series
	310020-00189H		WP185C 410A (DC) 290A (AC) @60% Tungsten size: 1.0-4.8mm 5m cable	

	Item NO.	Picture	Size (mm)	Model /Adjustable Parameters	Machine Model
Wire Feeder	320020-00001H		640*250*400	TIG wirefeeder SB-10-D /TIG • Wire feeding speed and wire withdraw time • Cold wire	ATIG Series ATIG-P Series ATIG-PAC Series
	320020-00002H		650*380*290	Hot wire TIG wirefeeder TS-07G • Wire feeding speed • Delay • Pulse • Gas test / wire test • Hot wire	Hot wire TIG

	Item NO.	Picture	Size (mm)	Model /Adjustable Parameters	Machine Model
Wire Remote Control	340010-00005H		100*60*82	Wire remote controller WRPTA-I • Welding current control	ATIG-P Series ATIG-PAC Series
	340010-00002H		207*97*92	WRC • Welding current • Arc force current	TIG Series ATIG Series
	340010-00005H		170*122*79	Digital remote controller • Full parameters control	ATIG-P Series ATIG-PAC Series
Foot Pedal	340010-00008H		276*109*200	Foot pedal (JTKG-II) FP-II: • On/off switch with current control	ATIG-PAC Series

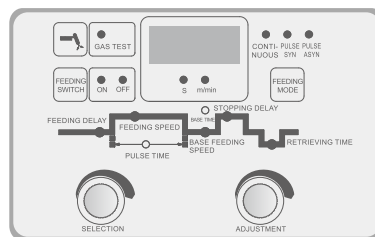
	Item NO.	Picture	Model /Specification	Machine Model
Cooling Unit	561130-00004H		WCS-T1 Supply: 380V Flow rate: Max.3L /min Tank volume: 5L Integrated cooling unit	TIG Series ATIG Series ATIG-P Series ATIG-PAC Series
	561130-00005H		WCS-10 Supply: 1ph 220V Flow rate: Max.3L /min Tank volume: 9L	
	561130-00006H		WCS-20 Supply: 1ph 220V Flow rate: Max.3L /min Tank volume: 26L	

	Item NO.	Picture	Model /Specification	Machine Model
Trolley	361005-00003H 361005-00004H 361005-00007H		Rack with wheels 4 standard wheels Can be designed according to power source size	TIG Series ATIG Series ATIG-P Series ATIG-PAC Series
	361011-00001H		TM-I 2 castor wheels and 2 standard wheels Can integrate cooling unit, power source and gas cylinder	TIG Series ATIG Series ATIG-P Series ATIG-PAC Series
	361005-00009H		TM-II 2 castor wheels and 2 standard wheels Can integrate cooling unit, power source and gas cylinder	ATIG-P Portable Series ATIG-PAC Portable Series

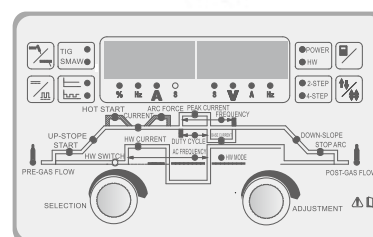


HOT WIRE TIG

Hot Wire TIG ATIG-400 /500P (HW)



Wire feeder control panel



Power source control panel

Features and Benefits

- Hot wire TIG automatic wire feeding efficiency is over twice of manual wire feeding, and greatly reduces labor intensity
- Suitable for long seam welding
- For short seam welding and spot welding, automatic wire feeding mode can be turned off, and manual wire feeding mode can be adopted
- Control with one key. Torch switch can control welding power source, wire feeder, and hot wire power source
- Can work with automation system
- Variety of analog and digital interfaces make it work with welding automation equipment as automatic system
- Pulse synergic function of wire feeder

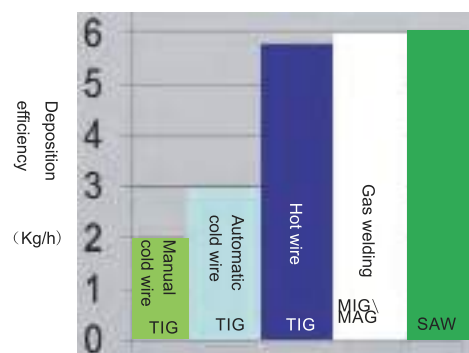
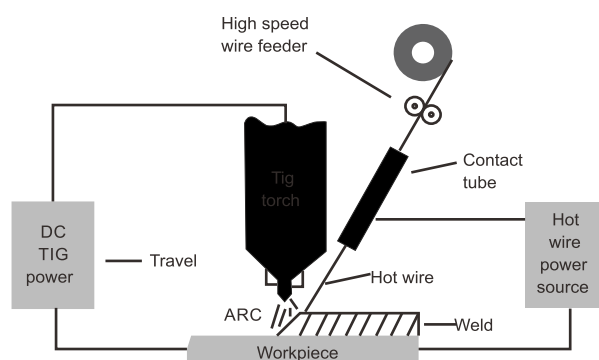
HW TIG comparison with other welding processes

- Less heat input than SAW
- Higher welding quality than MIG
- Higher efficiency than cold wire TIG



Process introduction

Hot wire TIG is designed based on cold wire TIG by adding one hot wire power source to pre-heat wire (300-400 °C). Without increasing base metal heat input, by increasing wire filling rate, the welding speed is almost close to MIG.



Technical Specification

Welding Power Source		
Model	ATIG400P(HW)	ATIG500P(HW)
Rated input voltage	3 phase 380V±10%/50Hz	
Rated input capacity (KVA)	18	23.4
Rated input current (A)	28	37.5
Rated duty cycle (%)	60	
Adjustable current range (A)	5~400A	5~500A
OCV (V)	73	78
Tungsten electrode diameter (mm)	1~6	
Weight (Kg/lb)	55/121.28	60/121.28
Dimension (mm)	660*330*580	
Insulation class	IP23	

Hot Wire Power Source	
Model	HW-200
Rated input voltage	3 phase 380V±10%/50Hz
Rated input capacity (KVA)	2.6
Rated input current (A)	4
Rated duty cycle (%)	35
Output current range (A)	5~200A
OCV (V)	16
Weight(Kg /lb)	21/46.31
Dimension (mm)	690*330*290
Insulation class	H

Water Cooler		Wire Feeder	
Model	SLJ-400WBi	Model	TS-07G
Power supply voltage	1phase 380V/50Hz	Power supply voltage	DC24V
Motor power (W)	260	Motor power(W)	260
Duty cycle (%)	100	Wire diameter(mm)	0.8~1.6
Max. pressure (MPa)	0.3	Wire feeding speed(m/min)	0.3~7.0
Temperature	-35~+40	Dimension (mm)	650*280*390
		Weight(Kg /lb)	15/33.08



HOT WIRE TIG

Hot Wire TIG ATIG-400 /500P (HW)

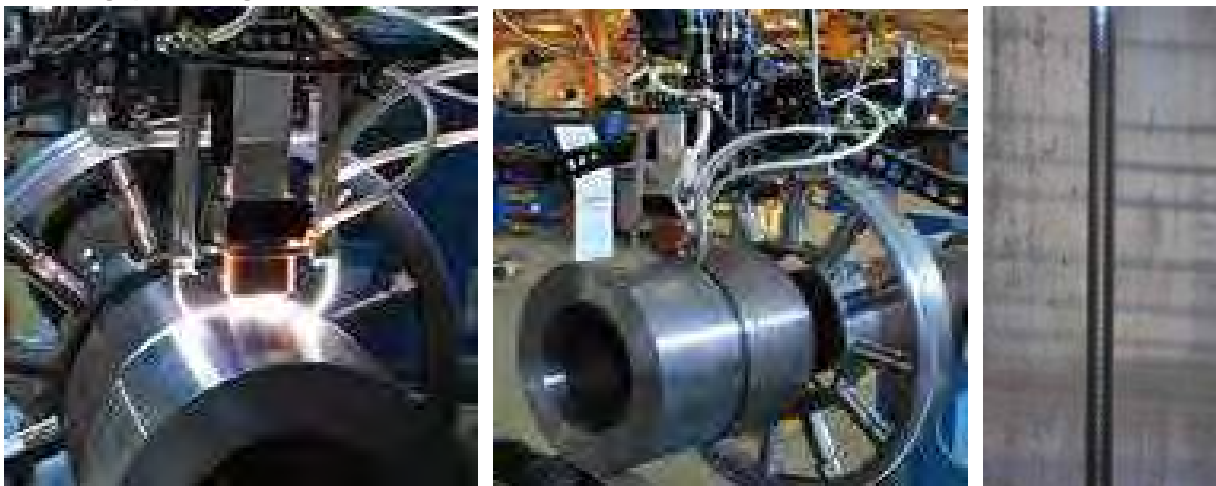
Application industry

Hot wire TIG welding has been used for welding of important work pieces of carbon steel, low alloy steel, high alloy steel, stainless steel and nickel base alloys in high-end industrial sectors such as boilers, pressure vessels, high pressure pipelines, marine oil production equipment, petrochemical plants, aerospace engineering and ordnance manufacturing, etc.

High quality cladding



Narrow gap welding





Case

Small-diameter pipe welding

Parameter

Welding current: 50A

HW current: 30A

Wire feeding speed: 0.3m/min

It can replace cold wire TIG, and welding efficiency is about twice of cold wire TIG.



HW TIG cladding

Parameter

Welding current: 180A

HW current: 90A

Wire feeding speed: 2.0m/min

Hot wire TIG welding deposition rate close to MIG.



Wine cans external cooling wall

Cladding materials: Wear-resistant alloy steel

Cladding thickness: 10mm

Welding current: 250A

HW current: 100A

Wire feeding speed: 4.0m/min

Cladding at internal layer of pipeline, low melting rate of base metal.



Big-diameter pipeline welding

Parameter

Welding current: 240A

HW current: 100A

Wire feeding speed: 3.2m/min

Low heat output, high welding quality, deposition rate close to SAW.





Advanced Digital GTAW

ATIG-PAC-315III /500III



ATIG-PACIII series is fully digital models with high end DSP technology, it is suitable for both automatic application and manual welding. Compared with ATIG-PAC series, it offers advanced wave control technology which brings more flexibility for thinner /thicker material during critical aluminum welding. Smart parameters adjustment brings cleanest, deepest penetration and perfect welding result for high welding quality demanding.



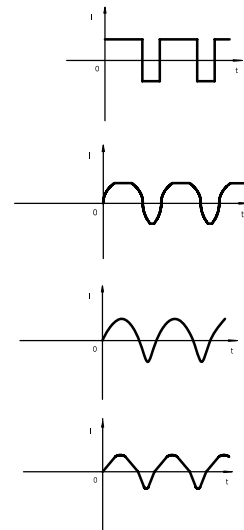
ATIG-PAC-315 /500III

Features and Benefits

- Full digital inverter power source. Current increasing speed during arc starting is greatly improved, which make beautiful aluminum welding
- Timing function which record the working time of welding machine.
- Tungsten electrode diameter select function, reduce the tungsten electrode consumption during arc ignition
- More output wave forms: standard square, Irregular square, Sine wave, Triangle wave, Mixture wave, suitable for various workpiece thickness
- Synchronous mutual arc feature
- All parameters can be precisely pre-setted
- Can store and load 30 sets of welding parameters
- Remote control function, can adjust welding current and peak current
- Can display current and voltage at the same time
- MMA: adjustable arc current, arc force current, knee point voltage, hot start current /time, easy arc starting

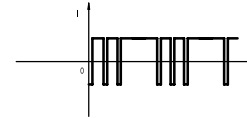
Advanced Shape Wave Control

1. Standard square wave: Responsive arc with fast zero crosses and reduced peak current. Stable arc with good puddle control and fast travel speed, minimizes tungsten overheating.
2. Irregular square wave: Stronger arc with slow zero crosses and less noise; the strongest arc and deep penetration, less noise.
3. Sine wave: Traditional smooth shaped waveform. Soft arc and less noise. Good for wide seam.
4. Triangle wave: Minimized area (heat) under the curve shape with high peaks. Lower amperages can minimize heat input to the weld high peaks more forceful for anodized applications.





5. Mixture wave: Alternate output AC current and DC current, high efficiency.



LOW NOISE

**0.38mm AL
Plate Welding**

Work with Remote Controller
Check on Page 26

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Welding cable L=3m
- 1 Ground cable L=3m
- 1 TIG torch (water cooled)
- Water cooling machine (Optional)
- Trolley (Optional)
- Remote control unit (Optional)
- Foot pedal (Optional)

Technical Specification

				ATIG315PAC III	ATIG500PAC III
Rated input voltage/frequency (Hz)				3 phase, 380V±10%, 50 /60Hz	
Rated input capacity (KVA)				13.6	25.4
Rated input current (A)				20.7	38.7
Duty cycle (40℃)				60%@315A	60%@500A
OCV (V)(MMA /TIG)				45/79	42/77
TIG	DC TIG	Output current range (A)		5-315	10-500
	Pulse TIG	Pulse frequency (Hz) (AC /DC)		0.2-250 /0.2-999	
		Peak current (A)		5-315	10-500
		Base current (A)		5-315	10-500
		Pulse duty cycle		15%-85%	
	AC TIG	Wave form		Square, Irregular square, Sine, Triangle, Mixture	
		AC frequency (Hz)		40-250	
		AC balance		-50%~+40%	
		Mixture	Frequency (Hz)	0.5-10	
	Duty cycle		15%-85%		
	Pre-gas /post gas (s)			OFF-10 /OFF-60	
	Initial /final current (A)			5-315 /5-315	10-500 /10-500
	Up-slope /down-slope (s)			OFF-10 /OFF-15	
	Trigger mode			2/4T, Repeat, Spot	
	Arc ignition method			HF /Contact	
MMA	Output current (A)			5-315	10-500
	Arc force (A)			10-200	
	Knee-point voltage (V)			15-30	
	Hot start duration (s)			0.1-2	
	Hot start (A)			10-200	
Job channels				30	
Dimension (mm)				655*324*546	665*353*778
Weight (kg /lb)				53 /117	80 /176.6

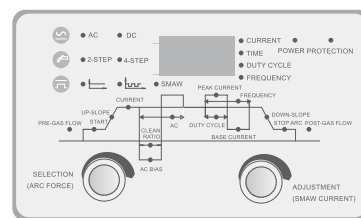


Digital AC /DC GTAW

ATIG-PAC-315 /500 /630



ATIG-PAC Series is digital models with high end MCU technology, suitable for both automatic application and manual welding. It offers multiple parameters adjustment to ensure perfect welding for stainless steel (DC) welding and Aluminum (AC) welding.



ATIG-PAC-315 /500 /630

Work with Remote Controller

Check on Page 26

Features and Benefits

- Can remotely control current
- All parameters can be precisely adjusted in real time
- MMA: adjustable arc current, arc force current, easy arc starting
- Synchronous mutual arc feature
- Widely used for nuclear power installation, pipe installation, shipbuilding, high pressure container, etc.
- Suitable for stainless steel, carbon steel, copper, titanium ,aluminum welding

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Welding cable L=3m
- 1 Ground cable L=3m
- 1 TIG torch (water cooled)
- Water cooling machine (Optional)
- Trolley (Optional)
- Remote control unit (Optional)
- Foot pedal (Optional)

Technical Specification

		ATIG315PAC	ATIG500PAC	ATIG630PAC
Rated input voltage/frequency (Hz)		3 phase, 380V±10%, 50 /60Hz		
Rated input capacity (KVA)		13.6	25.4	34.8
Rated input current (A)		20.7	38.7	52.9
Duty cycle (40°C)		60%@315A	60%@500A	60%@630A
OCV (V)(MMA /TIG)		45 /79	45 /77	42 /79
MMA	Output current range (A)	5-315	10-500	10-630
	Arc force (A)		10-200	
	Pre-gas/post gas (s)		0.1-9.99/0.1-60	
TIG	Initial/final current (A)	5-315 /5-315	10-500 /20-500	10-630 /20-630
	Up-slope/down-slope (s)	0.1-10 /0.1-15	0.1-10 /0.1-15	0.1-10 /0.1-15
	Peak current (A)	5-315	10-500	10-630
	Pulse frequency (Hz)		0.2-20	
	Pulse duty cycle		15%-85%	
	AC frequency (Hz)	20-200		20-100
	AC balance		-40%±40%	
Protection class		IP23S	IP21S	
Dimension (mm)		655*324*546	665*353*778	690*385*825
Weight (kg /lb)		50 /110.3	77 /170	90 /198.6



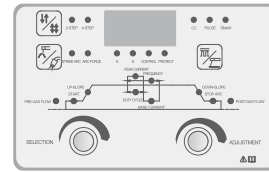
ATIG-P series is digital DC pulse TIG models with MCU technology, suitable for both automation application and manual welding. DC pulse function minimize the heat input for thin materials and provide a faster freezing for uphill welding.

Features and Benefits

- Can remotely control current
- TIG: can select HF and scratching arc starting methods, have short welding, long welding, spot welding and repeat welding
- All parameters can be precisely adjusted in real time
- MMA: adjustable arc current, arc force current, easy arc starting
- Smart fan feature greatly expands working life of the fan and reduces fault rate
- Widely used for nuclear power installation, pipe installation, shipbuilding, high pressure container, etc
- Suitable for stainless steel, carbon steel, copper, titanium welding
- Weld with cellulose electrode (ATIG270P)
- VRD function (ATIG270P)

Standard Equipments

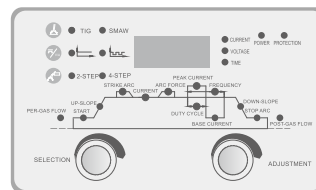
- 1 Power source
- 1 Connected primary cable L=3m
- 1 Welding cable L=3m
- 1 Ground cable L=3m
- 1 TIG torch



ATIG270P



ATIG270P



ATIG-P-315 /400 /500



Multi-voltage Option

Check on Page 22



ATIG-P-315 /400 /500

Technical Specification

	ATIG270P	ATIG315P	ATIG400P	ATIG500P
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz			
Rated input capacity (KVA)	10	14.4	17.8	24.6
Rated input current (A)	16.5	21.9	27.1	37.4
Duty cycle (40°C)	35%@275A 100%@200A	60%@315A	60%@400A	60%@500A
OCV (V)(MMA /TIG)	MMA(23V) /TIG(77V)	68	71	84
MMA	Output current (A)	5-275	5-400	5-500
	Arc force (A)	10-200		
	Hot start (A)	20-160		
	Output current (A)	5-275	5-400	5-500
TIG	Pre-gas /post gas (s)	0.1-9.99/0.1-60		
	Initial /final current (A)	5-275 /5-275	10-160 /5-400	10-160 /5-500
	Up-slope /down-slope (s)	0.1-10 /0.1-20	0.1-10 /0.1-15	
	Peak current (A)	5-275	5-400	5-500
	Base current (A)	5-275	5-400	5-500
	Pulse frequency (Hz)	0.2-30 /30-500		
	Pulse duty cycle	10%-90%		
	Trigger mode	2T, 4T, Spot welding, Repeat		
	Arc ignition method	HF		
	Protection class	IP23S		
	Insulation class	H		
Dimension (mm)	460*210*410	655*324*546	655*324*546	655*324*546
Weight (kg /lb)	19 /42	42 /93	42 /93	50 /108



Digital DC GTAW

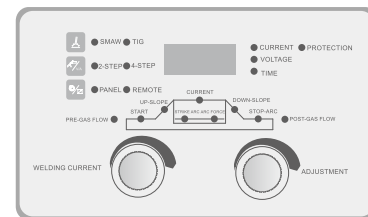
ATIG-400 /1000



ATIG DC series is digital DC TIG models with high end MCU technology, It is suitable for both automatic application and manual welding. provide high performance DC TIG and stick welding for alloy fabrication, pipe welding and workshop maintenance. For high current model (>500A), 100% duty cycle and can perform Carbon Arc Gouging feature.

Features and Benefits

- MMA adjustable parameters: arc force current, knee point voltage, arc starting time, arc starting current
- By setting knee-point voltage, the power source can be adapted to long and short cable welding. With setting of arc starting time, success rate of arc starting can be greatly improved
- TIG adjustable parameters: pre-gas time, post-gas time, up-slope time, down-slope time, arc starting current and crater filling current
- Wide current adjustment range, can be lower to 5A
- VRD function voltage (22V), safer and more reliable
- Enjoy long and short welding function, can set different welding modes according to welding cable length
- Smart fan feature greatly expands working life of the fan and reduces fault rate



ATIG-400 /1000

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Welding cable L=3m
- 1 Ground cable L=3m
- 1 TIG torch

Work with Remote Controller

Check on Page 26



Multi-voltage Option

Check on Page 22

Technical Specification

	ATIG400	ATIG1000
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz	
Rated input capacity (KVA)	18.7	54.6
Rated input current (A)	28.4	83
Duty cycle (40°C)	60%@400A	100%@1000A
OCV (V)	71/22 VRD	79
Output current (A)	5-400	60-1000
MMA	Arc force (A)	1-200
	Knee-point voltage (V)	10-30
	Hot start (A)	0-160
	Hot start duration (s)	0.1-1.5
TIG	Pre-gas /post gas (s)	0.1-15 /0.1-15
	Initial /final current (A)	10-160 /5-160
	Up-slope /down-slope (s)	0.1-10 /0.1-15
	Trigger mode	2 /4T
	Arc ignition method	HF
Protection class	IP23S	IP21S
Insulation class	H	
Dimension (mm)	655*324*546	767*352*757
Weight (kg /lb)	43 /95	95 /209.8



TIG-400 /400II /500 /630 /1000 /1250



TIG series is analog DC TIG models with soft switch inverter technology, specially designed for harsh industrial environment. Friendly user operation interface and stable ARC for manual welding.

TIG series provides high performance DC TIG and stick welding for alloy fabrication, pipe welding and workshop maintenance.

TIG400II is also suitable for great cellulose electrode welding application. For high current model (>500A), 100% duty cycle and can perform Carbon Arc Gouging feature.

Features and Benefits

- Adjustable ARC FORCE and hot start, down slope time
- Work with generator (optional)
- Wire /wireless remote control
- HF /scratch TIG with 100% ignition success rate
- Digital display
- 2 step /4 step
- TIG400II perform great cellulose electrode welding

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Welding cable L=3m
- 1 Ground cable L=3m
- 1 TIG torch

Work with Remote Controller

Check on Page 26

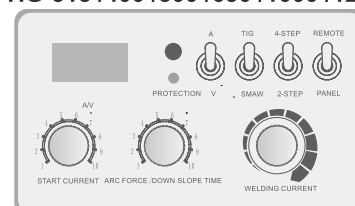


Multi-voltage Option

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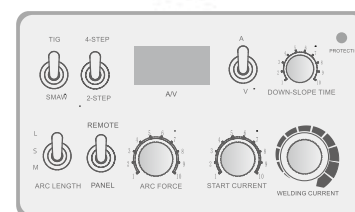
TIG-315 /400 /500 /630 /1000 /1250



TIG-315 /400 /500 /630 /1000 /1250



TIG400II



TIG400II

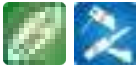
Technical Specification

	TIG400	TIG400II	TIG500	TIG630	TIG1000	TIG1250
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz					
Rated input capacity (KVA)	18.7	18.7	24.6	34.2	54.6	66.5
Rated input current (A)	28.4	28.4	37.4	52	83	101
Duty cycle (40℃)	60%@400A	60%@400A	60%@500A	100%@630A	100%@1000A	100%@1250A
OCV (V)	71	85	84	95	83	95
Output current (A)	20-400	20-400	20-500	50-630	60-1000	60-1250
Arc ignition method	HF /Contact					
Trigger mode	2/4T					
Efficiency	89%					
Protection class	IP23S			IP21S		
Insulation class	H					
Dimension (mm)	655*324*546	576*297*557	655*324*546	686*322*584	767*352*757	767*352*802
Weight (kg /lb)	43 /95	43 /95	50 /110.4	58 /128.1	95 /209.8	100 /220.9



DC Portable GTAW

TIG200 PRO ATIG200P



Features and Benefits

TIG200 PRO

MMA

- Adjustable arc force, anti-stick, easy arc ignition
- VRD, safe and reliable
- Suitable for all kinds of basic and acid welding electrodes

DC TIG

- HF arc starting
- High arc penetration, stable arc, fine welding seam, uniform and beautiful welding formation

DC pulse TIG

- Adjustable pulse frequency, pulse duty cycle, peak current
- Down-slope time current can be reduced to 5A, no crater after crater filling, no defect on welding seam

ATIG200P

- HF ignition
- VRD feature
- MCU control: adjustable parameter such like Peak current, base current, duty cycle and the frequency,
- Multi-parameters adjustment: up-slope time /down-slope time /pre-gas /post-gas
- Multi-protection against overheat, over current, over voltage, etc

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 TIG torch (with accessories)
- 1 Ground cable L=3m with clamp and quick plug
- 1 Quick plug



TIG200 PRO



ATIG200P

Technical Specification

	TIG200 PRO	ATIG200P
Rated input voltage/frequency (Hz)	1 phase, 230V±10%, 50 /60Hz	
Rated input capacity (KVA)	7.5	6.6
Rated input current (A)	34	30
Duty cycle (40C)	40%@200A	
OCV (V)	54 /9 (VRD)	60 /9 (VRD)
MMA	Output current range (A)	20-160
	Arc force (A)	50
	Hot start (A)	50~100
TIG	Output current range (A)	10-200
	Pre-gas /post-gas (s)	0.1-15 /0.1-15
	Initial /final current (A)	10-200 /10-200
	Up-slope /down-slope time (s)	0.1-10 /0.1-10
	Base current (A)	10-200
	Pulse frequency (Hz)	1-20
	Pulse duty cycle	35-75%
TIG	Trigger mode	2 /4T
	Arc ignition method	HF
Protection class	IP21S	
Insulation class	F	
Dimension (mm)	389*155*299	
Weight (kg /lb)	9.5 /21	



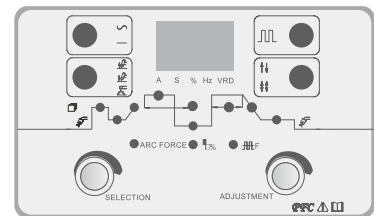
ATIG-PAC Series is digital models with high end MCU technology, suitable for both automatic application and manual welding. It offers multiple parameters adjustment to ensure perfect welding for stainless steel (DC) welding and Aluminum (AC) welding.

Features and Benefits

- Portable digital AC/DC TIG machine, high efficient inverter technology
- Perfect welding quality on heat-sensitive material and aluminum
- Controlled AC wave, including balance, AC frequency
- Fully controlled pulse wave, including pulse duty cycle, base current and high speed pulse frequency
- Multi controllable parameters, like pre-gas, post-gas, up-slope down-slope, initial current and final current
- HF and lift arc ignition, outstanding arc starting performance
- 2 /4T trigger mode, suitable for long /short welding seam
- Fast dynamic response, good arc characteristic
- PFC module, reduce harmonic wave input, improve power source efficiency, meet needs of 16A input (PFC model ONLY)
- Job channels are available

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 TIG torch (with accessories)
- 1 Ground cable L=3m with clamp and quick plug
- 1 Quick plug



ATIG210PAC



Multi-voltage Option

Check on Page 22

Technical Specification

ATIG210PAC		
Rated input voltage/frequency (Hz)		1 phase, 230V±10%, 50 /60Hz
Rated input capacity (KVA)		5.7
Rated input current (A)		25
Duty cycle (40°C)		35%@210A
OCV (V)		60
MMA	Output current (A)	10-170
	Arc force (A)	0-100
	Hot start (A)	0-100
	Output current (A)	3-210
	Pre-gas /post-gas (s)	0.1-9.99 /0.1-60
	Initial /final current (A)	3-210 /3-210
	Up-slope /down-slope time (s)	0-10 /0-15
	Peak current (A)	3-210
	Base current (A)	3-210
	Pulse frequency (Hz)	DC: 0.2-500/ AC: 0.2-20
TIG	Pulse duty cycle	5-95%
	AC frequency (Hz)	10-250
	AC balance	-40%±40%
	Trigger mode	2 /4T, Spot, Repeat
	Arc ignition method	HF /Lift
Protection class		IP23S
Insulation class		F
Dimension (mm)		430*160*300
Weight (kg /lb)		11.5 /25.2

MIG



GMAW SUMMARY

Digital Pulse MIG



AMIG-350 /500PM
High Speed Pulse
Page 45



AMIG-500 /630PD
Pulse MIG
Page 46



AMIG280PM
Compact Pulse MIG
Page 47



AMIG500PS
Digital Model
Page 48

Digital /Analog Professional MIG /MAG



AMIG350LST
Low Spatter Technology
Page 49



AMIG-350 /500
Digital Model
Page 50



MIG-250 /350 /400 /500 /630
Analog Model
Page 51

Multi-process Professional MIG /MAG



MIG350MC
Analog Compact
Page 52



MIG-350 /400/500M
Analog Model
Page 52

Portable Model



AMIG210M /210PM
1PH Portable Digital Model
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CHOOSE YOUR MODEL

	Model	SMAW	GTAW	GMAW	FCAW	GMAW-P	Double Pulsed	Input Voltage*	Wire	Duty Cycle	Synergic Adjustment	Digital Communication	Program Saving
1 Phase	AMIG210PM	✓	✓	✓	✓	✓	✓	230V		35%	✓		
	AMIG210M	✓	✓	✓	✓			230V	CS AS AL	35%	✓		
	MIG250C			✓	✓				CS AS	60%			
	MIG-250/350/500			✓	✓			380V~525V	CS AS	60%			
3 Phase	MIG630			✓	✓			380V~525V	CS AS	100%			
	MIG-350M /400M /500M	✓	✓	✓	✓			380V~525V	CS AS SS	60%			
	MIG350MC	✓	✓	✓	✓			380V~525V	CS AS SS	60%			
	MIG630M	✓	✓	✓	✓			380V~525V	CS AS SS	100%			
	AMIG350			✓	✓			380V~525V	CS AS	60%	✓	✓	✓ (10)
	AMIG500			✓	✓			380V~525V	CS AS	100%	✓	✓	✓ (10)
	AMIG630			✓	✓			380V~525V	CS AS	100%	✓	✓	✓ (10)
	AMIG350PM	✓	✓	✓	✓	✓	✓	380V~525V	CS AS SS Si AL	60%	✓	✓	✓ (100)
	AMIG500PM	✓	✓	✓	✓	✓	✓	380V~525V	CS AS SS Si AL	60%	✓	✓	✓ (100)
	AMIG350PC			✓	✓	✓	✓	380V~525V	CS AS SS Si AL	60%	✓	✓	✓ (100)
	AMIG350LST			✓	✓				CS AS SS	60%	✓	✓	✓ (100)
	AMIG280PM	✓	✓	✓	✓	✓	✓	380V~525V		60%	✓	✓	✓ (100)
	AMIG-500/630PD	✓	✓	✓	✓	✓	✓	380V~525V		60%	✓	✓	✓ (100)
	AMIG500PS			✓	✓	✓		380V~525V		60%	✓	✓	✓ (10)

* For Multi - Voltage Input, please check with sales for detail

CS Carbon Steel SS Stainless Steel AL Alloy Steel T Titanium C Copper

Mg Al-Mg alloy Si Al-Si alloy AL Aluminum

MIG /MAG WELDERS



AOTAI MIG Series provides you variety of MIG /MAG inverter welding products for different application needs in workshop or on site. Full digital Pulse MIG series provides precise control metal transfer to work piece, optimum weld pool control and impressive seam formation. For conventional MIG /MAG series, it offers incredible stable ARC and synergic operation features for digital models.

Highlights for MIG /MAG


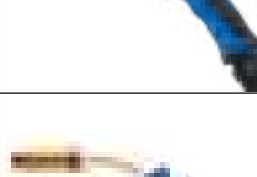
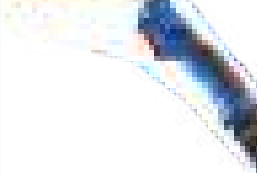
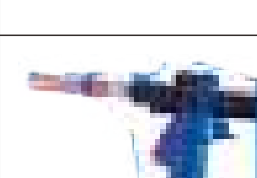
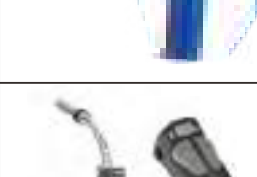



1. Outstanding MIG /MAG weld characteristics for mixed gas and CO₂.
2. Synergic control for digital model brings extremely easy operation.
3. Available for compact design with built-in wire feeder or separate wire feeder.
4. Professional design for harsh industrial application, with extra coating inner structure against dust, moisture, etc.
5. Digital models are suitable for both automation application and manual welding.
6. High duty cycle up to 100%.
7. Burn back feature to remove welding ball.
8. 2 step /4 step operation modes.
9. Crater filler feature ensures perfect seam formation.
10. Against the power grid fluctuation and capable to work with generator and 50M long distance welding cable.
11. Multi-voltage adaptive technology : 115V /230V, 220V-440V, 380V-525V automatic voltage adaptation.
12. Welding program storage.

More for Pulse MIG


1. Flexible adjustment of welding cycle brings more control on alimentary on waves form.
2. Stronger ARC improves penetration.
3. Digital control wire feeder with digital torch to make welding work more precisely .

Model		AMIG350PM /500PM	AMIG280PM
Structure		Separate design	Built-in wire feeder
WMMS		●	●
Wire type	Carbon Steel, Stainless Steel	Φ0.8 - Φ1.6	Φ0.8 - Φ1.2
	Al.and Al. alloy	Φ1.0 - Φ1.6	Φ1.0- Φ1.2
	Si. bronze and Al. bronze	Φ1.0 Φ1.2 Φ1.6	Φ1.0 Φ1.2
	Carbon steel FCAW Stainless steel FCAW	Φ1.2 - Φ1.6	
Wire feeding control		Digital (encoder)	Digital (encoder)
Work with robot		●	○
Double pulse		●	●
Digital torch		●	●
Push-pull torch		●	●
Twin wire		●	○

Accessories for MIG /MAG Series

	Item NO.	Picture	Model /Specification	Machine Model
Gas-Cooled Torch	310030-00065H		N24 3m Rated 60%@250A(CO ₂) /220A (mixed gas) Gas cooled, Euro connector Wire size: 0.6mm-1.2mm	MIG Series AMIG Series AMIG-PM Series
	310030-00070H		N36 3m Rated 60%@340A (CO ₂) /300A (mixed gas) Gas cooled, Euro connector Wire size: 0.8mm-1.6mm	
	310030-00096H		MB36KD 3m Rated 60%@340A(CO ₂) /300A(mixed gas) Gas cooled, Euro connector Wire size: 1.0mm-1.6mm	
Water-Cooled Torch	310040-00007H		MB501D 3m Rated 100%@500A (CO ₂) /450A (mixed gas) Water cooled, Euro connector Wire size: 1.0mm-1.6mm	
	310040-00052H		PP401D 8m Rated 100%@350A (CO ₂) /320A (mixed gas) Water cooled, Euro connector Wire size: 0.8mm-1.6mm Push-pull drive	
Digital Torch	310040-00048H		DM 501W 3m Rated 100%@500A (CO ₂) /450A (mixed gas) Water cooled, Euro connector Wire size: 1.0mm-1.6mm	AMIG-PM Series
	310040-00049H		DM 360A 3m Rated 60%@320A (CO ₂) /290A (mixed gas) Gas cooled, Euro connector Wire size: 0.8mm-1.2mm	
	 On /Off Switch LED On /Off Illumination Up /Down Mouse Control		 On /Off Switch LED On /Off Illumination Job Mode & Display Up /Down Mouse Control	

	Item NO.	Picture	Model /Adjustable Parameters	Machine Model
Wire Feeder	320020-00004H		Mini WF-M-A series <ul style="list-style-type: none"> • Closed type • Gas-cooled /water cooled option • 4 rollers • 500×200×350mm • 11kg 	MIG Series AMIG Series
	320030-00003H		WF-MP-D-I <ul style="list-style-type: none"> • Plastic case • Closed type /encoder motor • Gas-cooled /water cooled option • Digital display • Digital communication interface • 4 rollers 	AMIG-PM Series

	Item NO.	Picture	Model /Adjustable Parameters	Machine Model
GMAW Tractor	330010-00044H		AWC-5B <ul style="list-style-type: none"> • Up-down: 60mm • Forward-backward: 60mm 	MIG Series AMIG Series AMIG-PM Series
	330010-00084H		AWC500-6 <ul style="list-style-type: none"> • Horizontal and vertical adjustment • Torch swing control • Powered by battery • Guide wheel 	

Digital Multi-Process Pulse GMAW

AMIG-350 /500PM



AMIG-PM series is full digital pulse MIG series with multi-process feature. Due to high end DSP and waveform control technology, it provides outstanding control of arc and weld pool and brings spatter free welding quality and high efficient productivity. It can work with digital wire feeder and digital torch to achieve precise control and be ideal for both automation /robotic welding and manual welding.

Features and Benefits

Full-digital control accurately, excellent welding performance

- Minimizing spatter generation and excellent bead appearance



One pulse,one drop



Encoder motor

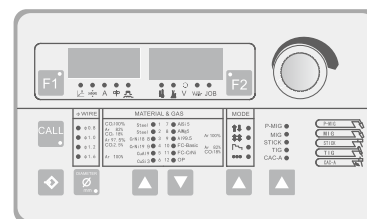
- Embedded welding expert database, which provides intelligent welding parameters widely used for selection of various welding materials and sheet thicknesses
- Full-digital control system for wire feeder, make wire feeding more precise and stable
- Digital touch control with adjustment of current and voltage (optional)

Digital communication interface

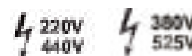
- Advanced digital communication interfaces, convenient to be equipped with automated welding



SYNERGIC INTELLIGENT ADJUSTMENT



AMIG-350 /500PM



Multi-voltage Option

Check on Page 41

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Water cooling machine
- 1 Ground cable L=3m
- 1 Water-cooled (or Gas-cooled) torch L=3m
- 1 Wire feeder with Europe connection
- 1 Trolley

Technical Specification

	AMIG350PM	AMIG500PM
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz	
Rated input capacity (KVA)	13	24
Rated input current (A)	20	38
Duty cycle (40°C)	60%@350A	60%@500A
OCV (V)	101	106
Adjustable current range (A)	25-350	25-500
Adjustable voltage range (V)	14-40	14-50
Trigger mode	2 /4T, Spot, Special 4T /Special 2T	
Wire size (mm)	0.8, 1.0, 1.2, 1.6	0.8, 1.0, 1.2, 1.6
Double pulse frequency (Hz)	0.5-5	
Job channels	100	
Protection class	IP23S	
Dimension (mm)	655*324*546	655*324*546
Weight (kg /lb)	45 /99	53 /116.3

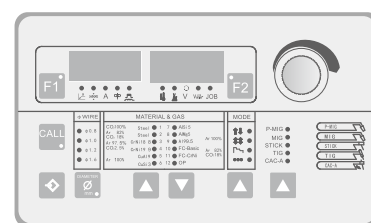


Features and Benefits

- High penetration welding technology is embedded to realize complete welding penetration of medium and thick plate, which can provide an brilliant welding quality.
- Expert database of 1.4mm carbon steel welding added to the program, which can reduce the number of welding layers and improve production efficiency.
- High speed DSP full digital precise control technology is adapted to realize precise control and keep arc length stable in welding process.
- Full digital double closed-loops grating feedback wire feeding system is adapted to perform more precise and stable wire feeding.
- 4G and WIFI, digital display wire feeder, remote control welding torch, all can be equipped to the machine.

High penetration pulse gas shielded welding technology

- It increases welding penetration by 30%, reduces spatter and can be used to replace gas shielded welding and traditional pulse welding.
- Traditional pulse MIG welding is limited in welding depth when the welding heat input should not be increased.
- It adapts precise waveform control technology to decrypt droplet transition principle of gas shielded welding, control welding form of arc, compress arc energy, and a concentrated high energy arc is generated between the welding torch and the workpiece, which can realize the breakthrough of high penetration pulse technology.



AMIG-500 /630PD



Traditional pulse MIG: 8.23mm



High penetration MIG: 10.36mm

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m
- 1 Gas-cooled torch L=3m
- 1 Wire feeder with Europe connection

Technical Specification

	AMIG500PD	AMIG630PD
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz	
Rated input capacity (KVA)	24	34
Rated input current (A)	38	51
Duty cycle (40°C)	60%@500A	100%@488A 60%@630A
OCV (V)	106	98
Output current range (A)	60-500	60-630
Output voltage range (V)	17-39	17-44
Trigger mode	2 /4T, Spot, Special 4T /Special 2T	
Wire size (mm)	1.0, 1.2, 1.4, 1.6	1.0, 1.2, 1.4, 1.6
Double pulse frequency (Hz)	0.5-5	
Job channels	100	
Protection class	IP23S	
Dimension (mm)	655*324*546	655*324*546
Weight (kg /lb)	55 /121	65 /143

Digital Multi-Process Pulse GMAW

AMIG280PM

AMIG280PM enjoys multi-process, including single pulse MIG, double pulse MIG, CV, MMA, TIG etc., as an expert on thin sheet welding, it can weld carbon steel, stainless steel, aluminum and aluminum alloy, copper and copper alloy, and non-ferrous metals, especially suitable for thin plate of aluminum alloy 0.7-4mm. In order to improve its welding performance, there are two major upgrading points.

Adopts dual core controller, built-in expert database, adopts core algorithm for pulse process so as to optimize pulse process parameters at low current. Motor adopts double closed loop control, two-way all-digital grating feedback & four-wheels double drive wire feeding system ensure more precise and stable wire feeding.

Features and Benefits

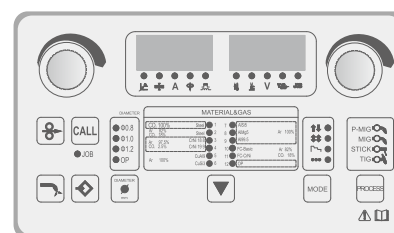
- The new digital control system and perfect combination of exact arc control algorithm, make more excellent thin sheet welding performance.
- Sheet welding expert, especially suitable for 0.7-4mm aluminum alloy sheet welding.
- Dual core double closed loop wire feeding control system + dual digital grating feedback control, which makes the wire feeding more precise and the arc more stable.
- Multiple welding modes: single pulse, double pulse, CV, MMA, TIG.
- Built-in wire feeder integrated design structure, which is small in size, light in weight and easy to move.
- Synergic function easy to operate and control. Standard digital interface which makes convenient for automatic machine.

Standard Equipments

- 1 Power source
- 1 Connected primary cables L=3m
- 1 Ground cable L=3m
- 1 Gas cooled torch L=3m

Technical Specification

	AMIG280PM
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50Hz
Rated input capacity (KVA)	14.3
Rated input current (A)	21.5
Duty cycle (40°C)	40%@280A
OCV (V)	107
VRD (V)	16
Output current range (A)	20-280
Output voltage range (V)	15-28
Wire size (mm)	0.8, 1.0, 1.2
Protection class	IP21S
Dimension (mm)	630*280*480
Weight (kg /lb)	34/74.8



AMIG280PM

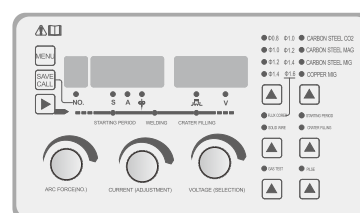


Features and Benefits

- Embedded welding expert database, to provide intelligent combination of different welding parameters
- Stable single pulse arc length, ensure minimize splashing and excellent bead appearance
- Synergic operation for optimum welding parameters
- 4-roller drive makes wire feeding more stable
- Capable of storing 10 sets of user-defined parameters
- 2-step /4-step /special 4-step operation mode. In standard long seam welding, 4-step /special 4-step will reduce workload and improve efficiency greatly
- Available for carbon steel and stainless steel welding

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m
- 1 Water-cooled torch L=3m
- 1 Wire feeder with Europe connection
- 1 Water cooling machine
- 1 Trolley



AMIG500PS

Technical Specification

	AMIG500PS
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz
Rated input capacity (KVA)	24
Rated input current (A)	38
Duty cycle (40C)	60%@500A
OCV(V)	101
Output voltage range (V)	60-500
Output current range (A)	10-50
Protection class	IP23S
Insulation class	H
Dimension (mm)	640*320*590
Weight (kg /lb)	50/110



Digital Low Spatter GMAW

AMIG350LST



AMIG-LST is fully digital MIG series with new low spatter technology. Due to high end DSP + FPGA and waveform control technology. It provides outstanding control of arc and weld pool and bring spatter free welding quality and high efficient productivity.

Features and Benefits

- High speed DSP+FPGA multi-core system, can shorten control period to control arc effectively
- Periodic molten drop control technology, molten pool is more stable, with beautiful welding seam formation
- Welding spatter for carbon steel decreases 80%, reduce spatter clean work; heat input reduces 10%~20%, small deformation
- Work with robot like KUKA, ABB, FANUC, YASKAWA, COMAU, IGM, etc.
- Integrated analog communication, international Devicenet digital communication and Ethernet communication interface, realize seamless integration with robot
- Open type communication mode, robot can control all parameters of welding machine
- Built-in start point test function, can achieve welding seam start point test without adding robot hardware
- Could realize weld the thickness range of 0.8-3mm carbon steel, stainless steel galvanized sheet with less spatter.
- Welding spatter off 80%, input heat off 10%-20%, easy control in thin sheet welding, less deformation.

Standard Equipments

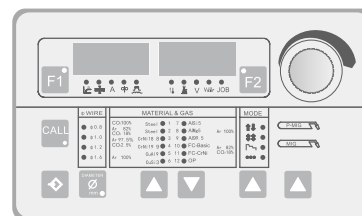
- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m
- 1 Gas-cooled torch L=3m
- 1 Wire feeder with Europe connection

Technical Specification

	AMIG350LST
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz
Rated input capacity (KVA)	12.7
Rated input current (A)	19.4
Duty cycle (40°C)	60%@350A
OCV (V)	72
Adjustable current range (A)	40-350
Adjustable voltage range (V)	14-40
Trigger mode	2 /4T, Spot, Repeat
Wire size (mm)	0.8, 1.0, 1.2
Protection class	IP23S
Insulation class	H
Dimension (mm)	655*324*546
Weight (kg /lb)	55 /121.3



SYNERGIC INTELLIGENT ADJUSTMENT



AMIG350-LST



AMIG series is specially designed digital MIG for steel welding. The control is based on MCU technology. All important MIG preference, like burnback, creep start and synergic is already included in this power source.

Features and Benefits

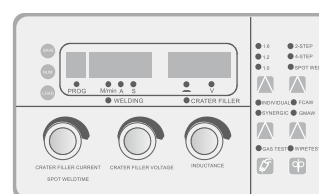
- MCU controlled technology, control precisely
- Perfect functions of starting arc and reducing melting ball while stopping arc
- Smart fan feature greatly expands working life of the fan and reduces fault rate
- Capable of operation with extended 50M long welding cable
- Capable for storing 10 sets of user-defined parameters
- Equipped with 485 commutation port unit, easily coupled with a cable of automatic welding
- Over heat, over current, over voltage and short circuit protections, error code display make it convenient for maintenance
- Can work with WMMS group control system

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m
- 1 Gas-cooled (or water-cooled) torch L=3m
- 1 Wire feeder with Europe connection



SYNERGIC INTELLIGENT ADJUSTMENT



AMIG-350 /500 /630



Multi-voltage Option

Check on Page 41

Technical Specification

	AMIG350	AMIG500	AMIG630
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz		
Rated input capacity (KVA)	12.7	23	33.6
Rated input current (A)	19.3	35	51
Duty cycle (40°C)	60%@350A	100%@500A	100%@630A
OCV (V)	70	82	95
Adjustable current range (A)	60-350	60-500	60-630
Adjustable voltage range (V)	14-40	14-50	14-50
Trigger mode	2 /4T, Spot		
Wire size (mm)	0.8, 1.0, 1.2	1.0, 1.2, 1.6	1.0, 1.2, 1.6
Job channels	10		
Protection class	IP23S		
Insulation class	H		
Dimension (mm)	655*324*546	655*324*546	708*322*584
Weight (kg /lb)	40 /88.3	50 /110.3	60 /132.4



MIG series is specially designed analog MIG for steel welding. All important MIG preference, like burnback and creep start is already included in this power source.

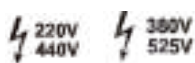
MIG-C series is compact design.

Features and Benefits

- Low welding distortion, pretty weld formation, high welding deposit rate
- Easy arc starting with slow wire feeding
- Stopping arc procedure has reducing melting ball feature
- Less spatter due to the advanced wave form control technology
- Continuous adjustment of current and voltage with wide range
- Can weld continuously for long time with high duty cycle
- Digital display for accurate parameter preset, easy to operate
- Used for solid /flux-cored welding wire

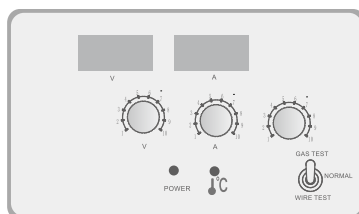
Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m
- 1 Gas-cooled (or water-cooled) torch L=3m
- 1 Wire feeder with Europe connection

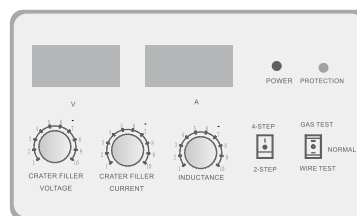


Multi-voltage Option

Check on Page 41



MIG-250C



MIG-250 /350 /500 /630



Technical Specification

	MIG250	MIG250C	MIG350	MIG500	MIG630
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz				
Rated input capacity (KVA)	8.5		12.7	23	33.6
Rated input current (A)	12.9		19.3	35	51
Duty cycle (40°C)	60%@250A		60%@350A	100%@500A	100%@630A
OCV (V)	55		70	82	95
Adjustable current range (A)	40-250		60-350	60-500	60-630
Adjustable voltage range (V)	14-30		14-40		
Trigger mode	2 /4T	2T		2 /4T	
Wire size (mm)	0.8, 1.0		0.8, 1.0, 1.2	1.0, 1.2, 1.6	
Protection class	IP21S		IP23S		IP21S
Insulation class			H		
Dimension (mm)	495*232*495	500*272*495	655*324*546	655*324*546	708*322*584
Weight (kg /lb)	20 /44.2	30 /66.3	40 /88.3	50 /110.3	60 /132.4



MIG-M series is specially designed analog MIG for steel welding. All important MIG preference, like burnback and creep start is already included in this power source. All MIG-M machines is multiprocess to perform all needs.

MIG-MC series is compact design.

Features and Benefits

- Multi-process for various applications
- Unique wave control technology ensures less spatter, stable current
- Advanced creep start and flashback, easily arc striking and arc stopping
- Built-in wire feeder, but also leave socket for separate wire feeder
- Stepless adjustment of current and voltage with wide range
- 2 step /4 step
- VRD feature (MMA mode)
- CC/CV wire feeder friendly

Standard Equipments

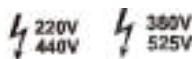
- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m
- 1 Gas-cooled (or water-cooled) torch L=3m
- 1 Wire feeder with Europe connection



MIG-M-350 /400 /500 /630

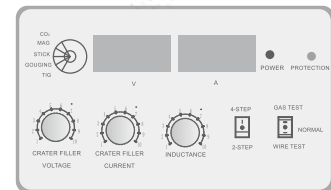


MIG350MC



Multi-voltage Option

Check on Page 41



MIG-M-350 /350C /400 /500 /630

Technical Specification

	MIG350M	MIG400M	MIG500M	MIG630M	MIG350MC
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz				
Rated input capacity (KVA)	12.7	18.7	23.4	33.6	12.7
Rated input current (A)	19.4	28.4	36.1	51.0	19.4
Duty cycle (40℃)	60%@350A	60%@400A	60%@500A	100%@630A	60%@350A
OCV (V)	70	70	82	95	70
Adjustable current range (A)	60-350	60-400	60-500	60-630	20-350
Adjustable voltage range (V)	14-40	14-40	14-50	14-50	14-40
Trigger mode	2 /4T				
Wire size (mm)	0.8, 1.0, 1.2	0.8, 1.0, 1.2	1.0, 1.2, 1.6	1.0, 1.2, 1.6	0.8, 1.0, 1.2
Electrode size (mm)	2.0-6.0				
Protection class	IP23S			IP21S	
Insulation class	H				
Dimension (mm)	655*324*546	655*324*546	655*324*546	708*322*584	580*350*640
Weight (kg /lb)	40 /88.3	40 /88.3	50 /110.3	60 /132.4	45 /99

Digital Multi Process GMAW

AMIG-210M /210PM



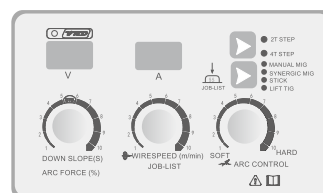
AMIG-M is specially designed digital MIG for steel welding. The control based on MCU technology. All important MIG preference, like burnback, creep start and synergic is already included in this power source. Portable model is very easy to maintain. Work with generator and compact design is very easy to work.

Features and Benefits

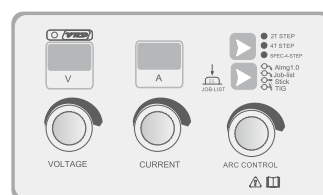
- Portable multi-process machine, MMA, Lift TIG, MIG/MAG, high efficient inverter
- Powerful expert database system, just select the built-in job lists for the application
- Digital model, MCU control, good arc characteristic
- Compatible with spool gun with current control
- Compact design, available for 5kg wire spool and 15kg wire spool
- 2 /4T trigger mode, suitable for long /short seam
- Over current /over voltage /over load protection
- User-friendly panel, self-explanatory operation
- Could weld the carbon steel, stainless steel and aluminum material
- 15kg wire

Standard Equipments

- 1 Power source, with built-in wire feeder
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m with clamp and quick plug
- 1 Welding torch (with accessories)
- With electrode holder and quick plug
- Spool gun (optional)



AMIG210M



AMIG210PM

Technical Specification

	AMIG210M	AMIG210PM
Rated input voltage/frequency (Hz)	1 phase, 230V±10%, 50 /60Hz	
Rated input capacity (KVA)	9.7	11.4
Rated input current (A)	42	42
Duty cycle (40°C)	35%@210A	
Modes	MMA /TIG /MIG	MMA /TIG /MIG /MIG-P
OCV (V)	63 /13.6 (VRD ON)	60
Output voltage range (V)	10-26	15-26.5
Spool weight (kg)	5/15	
Wire Diameter (mm)	0.8, 1.0, 1.2	
Trigger mode	2T /4T	2T /4T /Special 4T
Output current range (A)	30-210(MMA) /25-200	
Protection class	IP23S	
Insulation class	F	
Dimension (mm)	540*220*420	
Weight (kg /lb)	17 /37.4	

SAW

A close-up photograph of an industrial plasma cutting torch in operation. The torch, which is a complex assembly of metal pipes, hoses, and electrical connections, is positioned vertically and cutting through a thick, dark metal plate. A bright, intense blue and white flame is visible at the point of contact between the torch's nozzle and the metal. To the left of the main torch, a separate, angled torch head is also visible, with a bright orange-red flame emanating from its nozzle. The background is blurred, showing more industrial equipment and structures. The overall scene is one of heavy industrial manufacturing.

SAW SUMMARY

Special Industrial Application



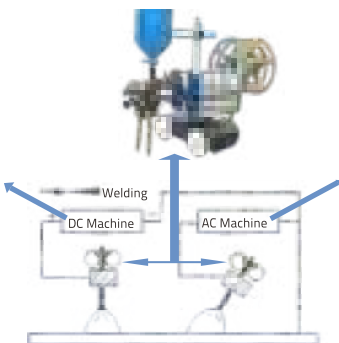
ASAW1000-AC/DC
Digital AC /DC SAW
Page 59



ASAW1000 IV
Digital DC SAW
Page 60





































ASAW-II-630 /1000 /1250 /1500
Digital DC SAW
Page 61



TANDEM-1000 /1250
Page 62



CHOOSE YOUR MODEL

Model	SMAW	SAW DC	Gouging	GMAW	SAW AC	Weldable Metals	Voltage Input	Program Saving
ASAW630 II 						CS  AS  HS 	380V	 (10)
ASAW1000 II /1250 II /1500 II 						CS  AS  HS 	380V/400V/415V/460V	 (10)
ASAW1000-AC/DC 						CS  AS  HS 	380V	 (10)
ASAW1000 IV 						CS  AS  HS 	380V/400V/415V/460V	 (10)

 Excellent
  Good
  Digital
  Analog
  Program Saving
  Digital Communication
  Al-Mg alloy

CS Carbon Steel
 AS Stainless Steel
 AS Alloy Steel

FOR HEAVY INDUSTRY

SHIPBUILDING

OFFSHORE

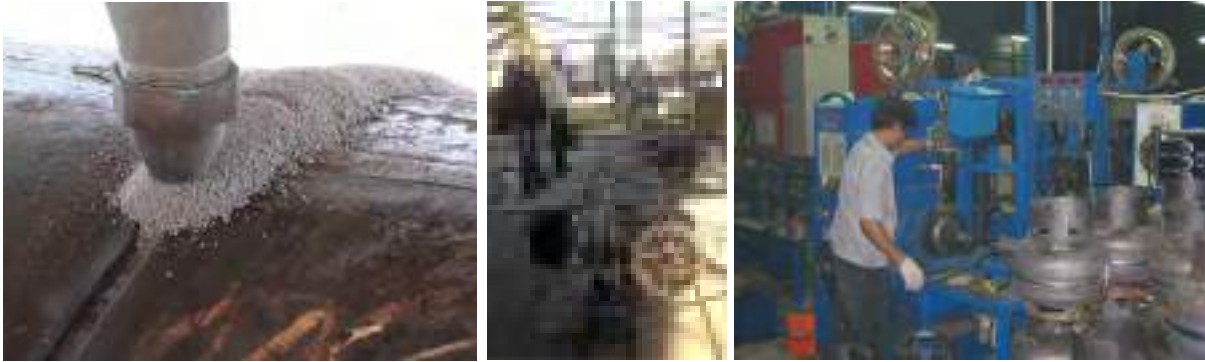
PIPELINE INDUSTRY

HEAVY MACHINERY

POWER STATION

STEEL FABRICATION

SAW WELDERS



Aotai SAW series provides customer best application with variety of submerge ARC welding, single wire, twin wire, tandem system, strip cladding with column and many other different solutions.

1. Using of inverter technology and CC /CV mode in digital power source give a high quality and stable of welding.
2. Friendly user interface for easy operation and setting of welding parameters
3. AC power source in cooperating with DC power source gives ability to use high end technology:
 - Twin Arc
 - Tandem Arc
 - Twin Tandem Arc
4. Professional design for harsh industrial application , with extra coating inner structure to protect against dust, moisture and etc.
5. All models can be integrated with automation system to increase the welding performance
6. High duty cycle up to 100% for non-stop work in heavy duty projects.
7. Memory up to 10 programs (digital)

More for special technology

Twin welding:

This technology can be used for special project to increase the welding performance by using two welding wires from 1.6 mm to 2.4 mm connected to one power source. For DC power source two wires create one arc, for AC power source two wires create two arc.

Tandem welding:

Combine two power sources with DC and AC welding current, we can create a high performance welding process with stable arc. Performance of this process can be increased by adding additional AC power source and additional arc for every welding pass.

Twin tandem welding:

Combine of two previous processes to create a extremely high welding performance.

Strip cladding:

For high performance cladding process, it is possible to use welding strip width from 30 to 60 mm. The performance is 10 times higher than standard cladding process using standard wire.

Accessories for SAW Series

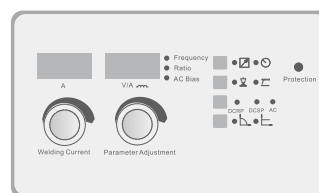
	Item NO.	Picture	Model /Adjustable Parameters	Machine Model
Welding Tractor	330010-00018H		MZC-Q1 • 3.0mm-6.0mm thick wire, pipe welding • WFS: 0.25-2.5m/min • Dimension: 800*500*700	ASAW Series
	330010-00086H		MZC-P4 • WFS: 0.55-6m /min • Wire size: 1.6-2.4mm • Dimension: 1020*480*740	
	330010-00069H		MZC-P3 • WFS: 0.25-2.5m /min • Wire size: 3.0-6mm • Dimension: 1100*900*770	Tandem-1000 /1250
	330010-00092H		STSKT-II • WFS: 0.25-2.5m /min • Wire size: 3.0-6mm • Dimension: 1020*480*1000	ASAW Series
Welding Head	330010-00005H		Cladding head • DJ-60 • Cladding width: 30-60mm	ASAW 1250II
	330010-00002H		Machine head • WFS: 0.25-2.5m /min • Wire size: 3.0-6.0mm	ASAW Series
Flux Recovery System	330010-00008H		• Load capacity: 50kg • Level recovery distance: 10-15m • Level transportation distance: 8-25 • Up and down speed of boom: 5-7m	ASAW Series



ASAW-AC /DC series applies IGBT soft switch technology, enjoy reasonable static characteristic and sound dynamic characteristic. It can perform carbon steel, stainless steel, heat resistant steel, and alloy steel welding. It has AC square wave submerged arc welding characteristic.

Features and Benefits

- Polarity switching can be achieved without adjusting the external welding cable
- Three phase AC input, has good ability against power grid fluctuation for AC transformer
- Communication interface, convenient for connecting with different automation system
- Waveform synergic control, easy for constituting the multi-wire and multi-arc welding system with multi power source
- Simple structure of main circuit
- 100% duty cycle
- Welding parameter can be set by control box
- Energy saving with 95% power factor
- The AC negative/positive half cycle wide could be adjusted, it could effectively control the input heat and penetration.



ASAW1000-AC /DC

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=5m
- 1 Welding cable L=15m
- 1 Control cable L=16m
- 1 Tractor

Work with Tractor
Check on page 58

Technical Specification

	ASAW1000-AC/DC
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz
Rated input capacity (KVA)	55
Rated input current (A)	83
Duty cycle (40°C)	100%@1000A
AC frequency	10-100Hz
AC duty cycle	25%-75%
AC bias	±25%
OCV (V)	90
Adjustable current range (A)	50-1010
Adjustable voltage range (V)	20-50
Wire size (mm)	3.0-6.0
Protection class	IP21S
Insulation class	H
Dimension (mm)	1040*500*720
Weight (kg /lb)	165 /364.7



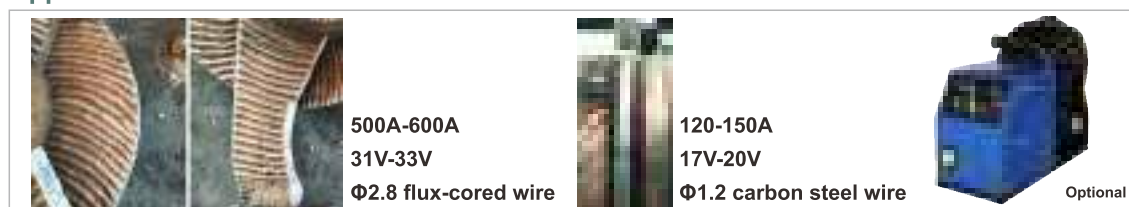
ASAW1000 IV is used in pipeline prefabrication, cladding, working with robot and automation equipment, high-power gas shielded welding, repairing wear resistant material and other industries, It enjoys great popularity for its comprehensive functions and multi-purpose performance.

Features and Benefits

- Submerged arc welding, gas shielded welding and carbon arc gouging.
- Thick wire 3.0-5.0mm (SAW)
- Thin wire 1.6-3.0mm (SAW)
- Flux-cored wire 1.2-3.2mm (SAW /MIG)
- Strip electrode 30-70mm (SAW)
- Twin-wire single arc submerged-arc welding 1.2-2.4mm (SAW)
- Optional wire feeder for gas shielded welding, synergic adjustment is available.
- Digital or analog interface, which can realize real-time communicating with arc welding robot and welding automation equipment.

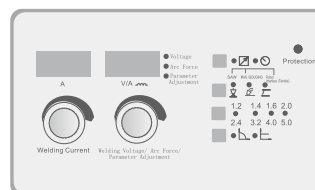


Application



Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=5m
- 1 Welding cable L=15m
- 1 Control cable L=16m
- 1 Tractor



Technical Specification

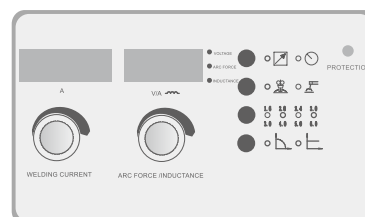
ASAW1000 IV	
	ASAW1000 IV
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz
Rated input capacity (KVA)	55
Rated input current (A)	83
Duty cycle (40°C)	100%@1000A
OCV (V)	84
Adjustable current range (A)	60-1000
Adjustable voltage range (V)	14-50
Wire size (mm)	1.2-6.0
Protection class	IP21S
Insulation class	H
Dimension (mm)	788*366*815
Weight (kg /lb)	95 /209.8



ASAW-II Series provides customer best application with variety of submerge ARC welding, single wire, twin wire, tandem system, strip cladding with column and many other different solutions.

Features and Benefits

- MCU+CPLD controlled technology, precise control, good welding performance
- Embedded expert program with 10 sets of complete welding parameters
- Flexible adjustment of welding parameters, reliable and convenient maintenance performance, low failure rate
- Weakly influenced by input voltage fluctuation
- Featured function of wire diameter selection
- Digital communication between tractor and welder
- 100% duty cycle
- Smart fan feature greatly expands working life of the fan and reduces fault rate
- Self-diagnostic function with error code display



ASAW-II-630 /1000 /1250 /1500

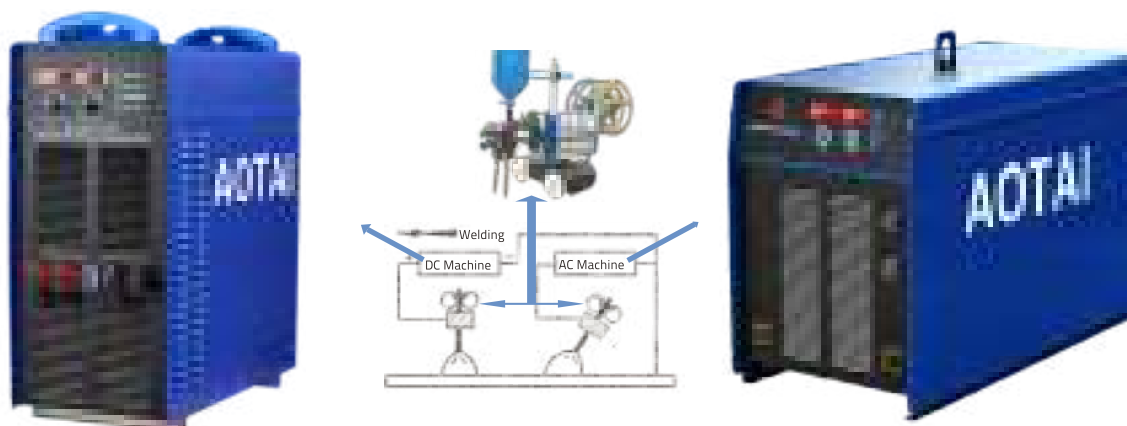
Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=5m
- 1 Welding cable L=15m
- 1 Control cable L=16m
- 1 Tractor

Work with Tractor
Check on page 58

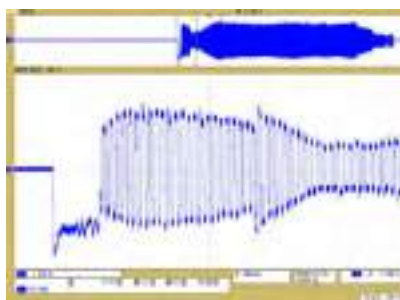
Technical Specification

	ASAW630 II	ASAW1000 II	ASAW1250 II	ASAW1500 II
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz			
Rated input capacity (KVA)	33.6	55	75.7	85.6
Rated input current (A)	51	83	115	130
Duty cycle (40℃)	100%@630A	100%@1000A	100%@1250A	60%@1500A
OCV (V)	89	84	92	92
Adjustable current range (A)	60-630	60-1000	60-1250	60-1500
Adjustable voltage range (V)	22-44			
Wire size (mm)	1.6-3.0	3.0-6.0		
Protection class	IP21S			
Insulation class	H			
Dimension (mm)	708*336*584	788*366*815	788*366*846	788*366*846
Weight (kg /lb)	55 /110.4	95 /209.8	100 /220.9	105 /232

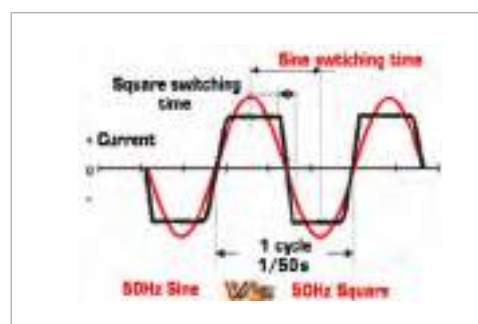


Features and Benefits

- High speed and efficient work could be done easily, and the welding speed and efficiency are over two times than single wire SAW
- Anterior DC works with posterior AC simultaneously, and separate work is also available
- The tractor head can be hung on the auxiliary machines, such as gantry, manipulator, etc.
- Applicable to the wire with the diameter more than 3mm, suitable for three welding modes: DC welding /AC welding /Tandem welding
- More adjustable parameters to guarantee the melting penetration and width, improve the welding quality



ASAW1000-AC/DC applies DC arc starting, then converts to AC mode, arc starting success rate is much higher than AC transformer power source.



ASAW1000-AC/DC can precisely control switching current, faster switching response, much better re-arc performance than AC transformer power source.



TANDEM

■ **TANDEM 1000 /1250**

Technical Specification

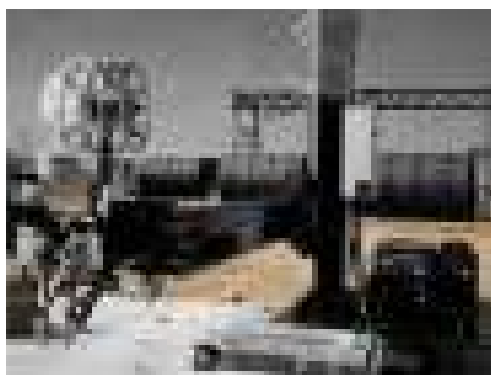
	TANDEM1000		TANDEM1250	
	ASAW1000 II	ASAW1000-AC/DC	ASAW1250 II	ASAW1000-AC/DC
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz			
Rated input capacity (KVA)	55		75.7	55
Rated input current (A)	83		115	83
Duty cycle (40°C)	100%@1000A	100%@1000A	100%@1250A	100%@1000A
OCV (V)	89	90	92	90
Adjustable current range (A)	60-1000	50-1010	60-1250	50-1010
Adjustable voltage range (V)	22-44			
Wire size (mm)	3.0-6.0			
Protection class	IP21S			
Insulation class	H			
Dimension (mm)	788*366*815	1040*500*720	788*366*846	1040*500*720
Weight (kg /lb)	95 /209.8	165 /364.7	100/220.9	165 /364.7



Section flange welding



Girth welding



Longitudinal seam welding by manipulator



Flat welding formation

PLASMA CUTTER



PLASMA CUTTER SUMMARY

Plasma Cutter for CNC



ACUT200
High performance
Page 68



ACUT120a
CNC CUT
Page 69

Digital Professional Model



ACUT60 /100 /120
Digital Model
Page 71

Portable Model



CUT60i
3ph Portable Analog Model
Page 72

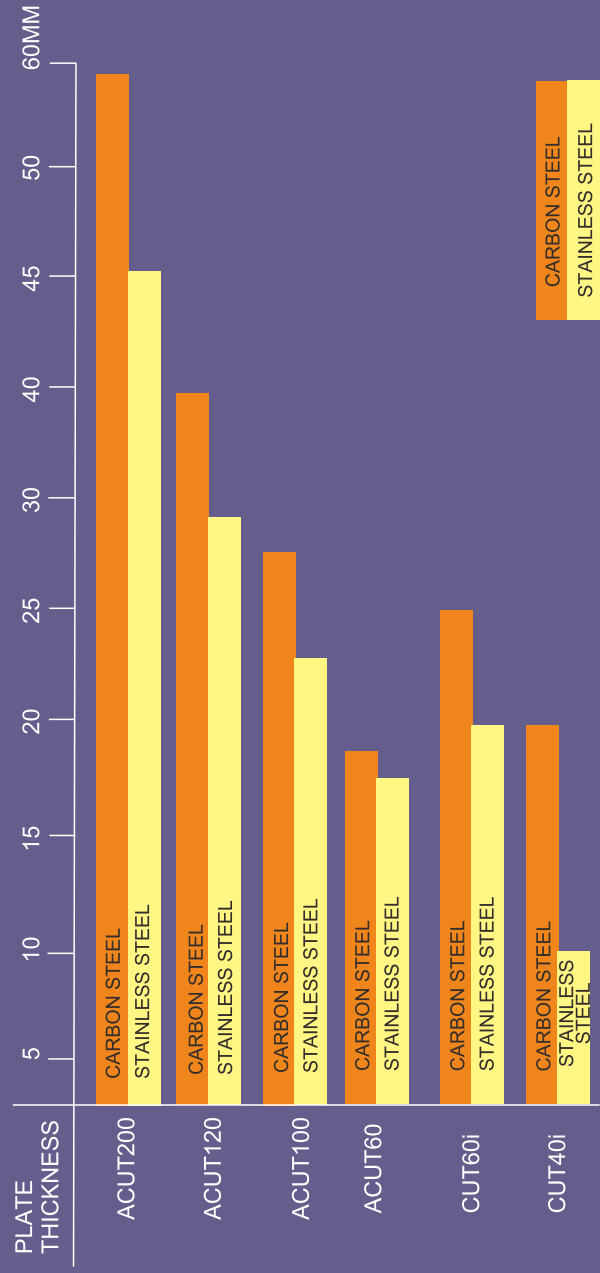


CUT40i
1ph Portable Analog Model
Page 73

CHOOSE YOUR MODEL


	Model	Input Voltage*	Portable	Contact HF	NON-HF Ignition	HF Pilot-arc Ignition	CNC
1-Phase	CUT40i	230V	✓	✓			
	ACUT60	380V		✓			
3-Phase	ACUT100	380V				✓	
	ACUT120	380V				✓	
	ACUT120a	380V			✓		✓
	ACUT200	380V				✓	✓
	CUT60i	380V	✓			✓	✓

* For PFC and Multi - Voltage Input, please check with sales for detail



Accessories for CUTTER Series

	Item NO.	Picture	Model /Specification	Machine Model
Hand Cutting	310050-00039H		PT31 40A@60%, gas cooled, 4m cable, HF contact	CUT40i
	310050-00008H		P80 60A@60%, gas cooled, 6m cable, HF contact	ACUT60
	310050-00033H		A101 100A@60%, gas cooled, 6m cable, HF pilot	ACUT100
	310050-00077H		S105 100A@60%, gas cooled, 6m cable, LF	ACUT120a
	310050-00037H		A141 140A@60%, gas cooled, 6m cable, special HF	ACUT120
	310050-00022H		HB200 200A@60%, water cooled, 6m cable, special HF	ACUT200
Machine Cutting	310050-00043H		PS105 100A@60%, gas cooled, 5m cable, LF	ACUT120a
	310050-00004H		HB2000 200A@100%, water cooled, 6m cable, special HF	ACUT200

	Item NO.	Picture	Model /Specification	Machine Model
Relieve Valve	220900-00001H		PV-II Setting pressure: 0.05-0.7MPa Connector: M5	ACUT Series



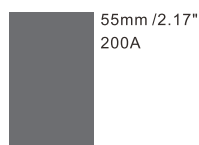
ACUT series is invented for professional use in heavy duty application. ACUT power source can be used for manual cutting with HF ignition to provide best arc start and avoid defect in arc start process. ACUT series can show best result for cutting steel with thickness up to 55 mm.

Features and Benefits

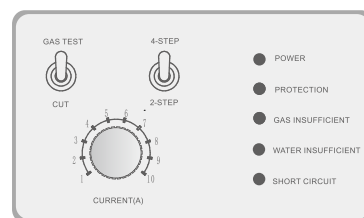
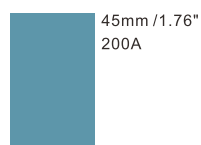
- Inverter technology provides a low weight power source that can be easily maintained or carried
- ACUT series is water-cooled power source to provide a non-stop work with 100% duty cycle with full power
- ACUT series provides cutting of steel, stainless steel, copper, aluminum, etc.
- Self-diagnostic and different protections help in work and maintain power source



Mild Steel Cutting Capability



Stainless Steel Cutting Capability



ACUT200

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m
- 1 Pressure-reducing valve
- 1 Plasma torch

Technical Specification

	ACUT200
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz
Rated input capacity (KVA)	42.8
Rated input current (A)	65
Duty cycle (40°C)	100%@200A
OCV (V)	350
Arc ignition method	30-200
Output current rang (A)	Special HF
Maximum cutting thickness (mm)	55
Clean cut thickness (mm)	1-20
Air pressure (Mpa)	0.4-0.6
Water flow rate (L/min)	1.4
Protection class	IP21S
Insulation class	H
Dimension (mm)	635*399*542
Weight (kg /lb)	58 /128.1



ACUT-a series is invented for professional use in heavy duty application with CNC system. ACUT-a series can be integrated with CNC system and have special non HF ignition for best arc start. ACUT-a series can show best result for cutting steel with thickness up to 15 mm.

Features and Benefits

- Inverter technology provide a low weight power source that can be easily maintained or carried by the welder
- ACUT-a is air cooled power source to provide a non-stop work with 60% duty cycle with full power
- ACUT-a provides cutting of steel, stainless steel, copper, aluminum and etc
- Self-diagnostic and different protections help in work and maintain power source
- Post flow function gives additional cooling for plasma torch
- ACUT-a series can be integrated with CNC system and has special non HF ignition for best arc start
- Smart fan feature greatly expands working life of the fan and reduces fault rate

Mild Steel Cutting Capability

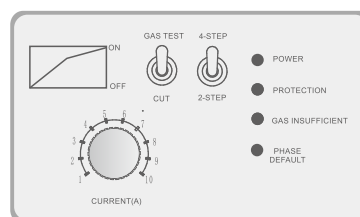


35mm /1.38"
120A

Stainless Steel Cutting Capability



28mm /1.10"
120A



ACUT120a

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m with clamp and quick plug
- 1 Pressure-reducing valve
- 1 Plasma torch

Technical Specification

	ACUT120a
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz
Rated input capacity (KVA)	16.5
Rated input current (A)	25
Duty cycle (40°C)	60%@120A
OCV (V)	340
Output current rang (A)	30-120
Arc ignition method	LF (low frequency)
Maximum cutting thickness (mm)	35
Clean cut thickness (mm)	1-15
Air pressure (Mpa)	0.8
Protection class	IP21S
Insulation class	H
Dimension (mm)	621*311*557
Weight (kg /lb)	43.5 /96.1

Features and Benefits

- **More user friendly**
USB Port
31-64M memory for user's programs
Built-in library of commonly used figures
Free FastCAM software
- **Fast cutting speed**
Can operate at a speed as high as 6 meters per minute (20 feet /minute)
- **Larger cutting area**
CNC cutting system can cut as wide as 2.0 meters (6.6ft), as long as 15 meters (48ft)
- **Easier maintenance**
Check up and maintenance of the controller can be done simply by removing the top cover
- **Motor enable/disable button**
This feature allows the user to enable or disable the motors



Series	Effective cutting area (X*Y)				
	Standard system (mm)	Customized system (mm) (feet)			
AOCUT CNC System	1200X2000	1200X2500	1300X2500 (4'X8')	...	1800X2500 (6'X8')
		1200X3000	1300X3000 (4'X10')	...	1800X3000 (6'X10')
		1200X3500	1300X3500 (4'X11')	...	1800X3500 (6'X11')
		⋮	⋮	...	⋮
		1200X15000	1300X15000 (4'X48')	...	1800X15000 (6'X48')

Model	AOCUT CNC-1200 x 2000
Rated input voltage (V)	110 /220
Frequency (Hz)	50 /60
Rated input power (W)	180
Display	LCD 5.7 "
Range of effective cutting (mm)	X-Axis: 1200 Y-Axis: 2000
Travelling speed (mm /min)	0-6000
Cross beam length (mm)	1700
Longitudinal rail length (mm)	2500
Cutting speed (mm /min)	0-6000
Cutting software	FastCAM standard version
Plasma power source	ACUT120a /ACUT200
Cross beam weight (kg /lb)	9.3 /20.5
Host machine weight (kg /lb)	26.7 /58.8
Total machine weight (kg /lb)	70.5 /155.4



ACUT series is designed for professional use in heavy duty application. ACUT power source can be used for manual cutting with HF ignition to provide best arc start and avoid defect in arc start process. ACUT series can show best result for cutting steel with thickness up to 35 mm.

Features and Benefits

- Inverter technology provides a low weight power source that can be easily maintained or carried by the welder
- ACUT is air cooled power source to provide a non-stop work
- ACUT provides cutting of steel, stainless steel, copper, aluminum etc
- Self diagnostic and different protections help in work and maintain power source
- Post flow function gives additional cooling for plasma torch
- Smart fan feature greatly expands working life of the fan and reduces fault rate

Mild Steel Cutting Capability



35mm / 1.38"
120A

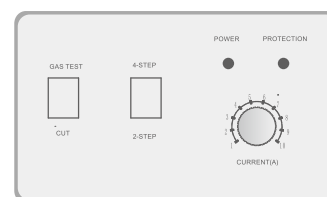
Stainless Steel Cutting Capability



28mm / 1.10"
120A

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m
- 1 Pressure-reducing valve
- 1 Plasma torch



ACUT-60 /100 /120

Technical Specification

	ACUT60	ACUT100	ACUT120
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz		
Rated input capacity (KVA)	7.5	14.4	16.5
Rated input current (A)	11.4	21.9	25
Duty cycle (40°C)	60%@60A	60%@100A	60%@120A
OCV (V)	319	319	340
Output current rang (A)	30-60	30-100	30-120
Arc ignition method	HF contact	HF pilot	HF pilot
Maximum cutting thickness (mm)	15	30	35
Clean cut thickness (mm)	1-8	1-12	1-18
Air pressure (Mpa)	0.45-0.6		
Protection class	IP21S		
Insulation class	H		
Dimension (mm)	501*232*495	576*297*557	576*297*557
Weight (kg /lb)	28.5 /63	43.2 /95.4	43.5 /96.1



CUT60i adopts IGBT single-tube high-frequency inverter technology. It has high arc dynamic response capability, small size and light weight, as well as ideal static and dynamic characteristics, and resistance against grid fluctuations.

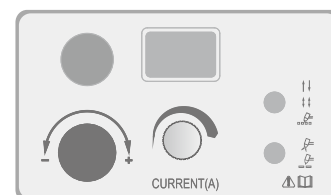
Features and Benefits

- Concentrated arc energy , smooth cutting mouth, and small heat affected zone.
- Full-digital control, digital display and continuous adjustment of cutting current and post-gas time .
- Continuous cutting function, suitable for fast cutting of metal mesh, grid and other porous metals.
- High cutting efficiency, cutting speed of 1mm carbon steel plate is up to 9000mm/min.
- High duty cycle, 60%@40℃, 100%@25℃.
- Complete interfaces make it convenient for working with automatic cutting equipment.



Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m
- 1 Pressure-reducing valve
- 1 Plasma torch



CUT60i

Technical Specification

	CUT60i
Rated input voltage/frequency (Hz)	3 phase, 380V±10%, 50 /60Hz
Rated input capacity (KVA)	10.4
Rated input current (A)	15.8
Duty cycle (40℃)	60%@60A
OCV (V)	335
Output current rang (A)	30-60
Air pressure (MPa)	0.4-0.5
Air flow (L/min)	≥250
Perforation quality cutting thickness (mm)	≤15
Edge quality cutting thickness (mm)	≤25
Protection class	IP21S
Insulation class	F
Dimension (mm)	430*160*300
Weight (kg /lb)	12 /25.2

CUT-I is invented as a portable power source for professional use in heavy duty application. CUT power source can be used for manual cutting with HF ignition to provide best arc start and avoid defect in arc start process. CUT-i series can show best result for cutting steel with thickness up to 12 mm.

Features and Benefits

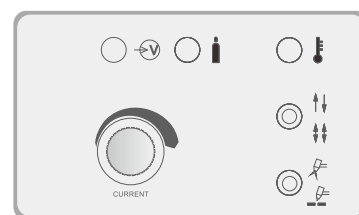
- Inverter technology provide a low weight power source that can be easily maintained or carried by the welder
- CUT-i is air cooled power source to provide a non-stop work with 60% duty cycle with full power
- CUT-i provides cutting of steel, stainless steel, copper, aluminum etc.
- Self-diagnostic and different protections help in work and maintain power source
- Post flow function gives additional cooling for plasma torch

Mild Steel Welding Capability

12mm / 0.47"
40A

Standard Equipments

- 1 Power source
- 1 Connected primary cable L=3m
- 1 Ground cable L=3m with clamp and quick plug
- 1 Pressure-reducing valve (Built-in)
- 1 Plasma torch

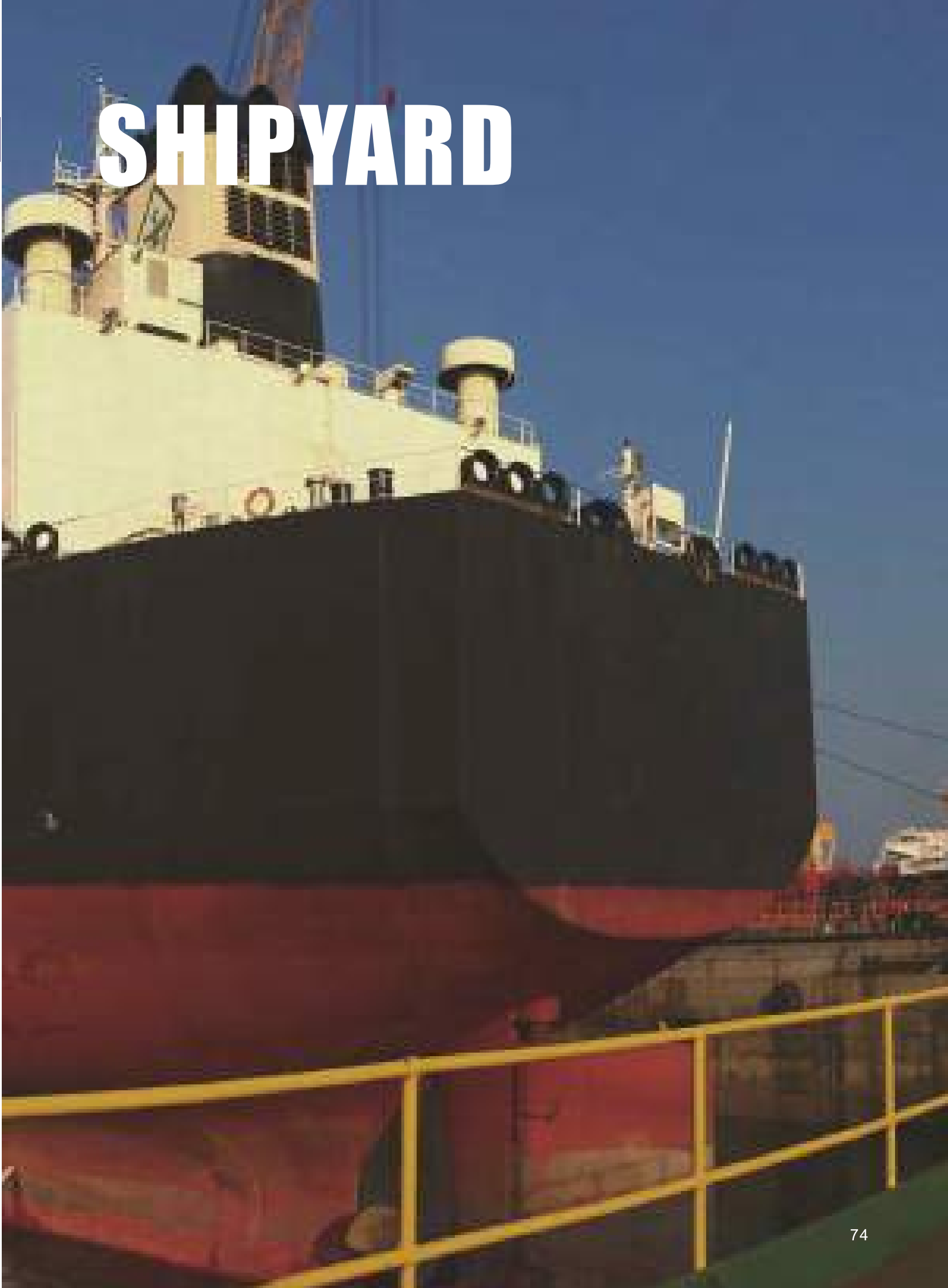


CUT40i

Technical Specification

	CUT40i
Rated input voltage/frequency (Hz)	1 phase, 230V±10%, 50 /60Hz
Rated input capacity (KVA)	7
Rated input current (A)	32
Duty cycle (40°C)	60%@40A
OCV (V)	285
Output current rang (A)	15-40
Arc ignition method	HF contact
Maximum cutting thickness (mm)	≤12
Clean cut thickness (mm)	1-7
Air pressure (Mpa)	0.4-0.6
Efficiency	>80%
Protection class	IP23S
Insulation class	F
Dimension (mm)	391*155*298
Weight (kg /lb)	9 /20

SHIPYARD

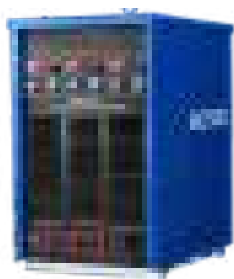


MIG



MIG500
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MMA /TIG



ARC400-3T /6T
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PLASMA CUTTER



ACUT-60 /100 /120
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ACUT200
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SAW



ASAW1000 IV
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ASAW-II-630 /1000 /1250
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Extra
protection
for PCB



■ Shipyard Application



STEEL FABRICATION



MIG



AMIG350PM / 500PM
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AMIG-350/500
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MMA

ASAW



ARC-400/500
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ASAW-II-630 / 1000 / 1250
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ASAW1000 IV
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GMAW Welding Carriage AWC-5B

Features and Benefits

- Suitable for discontinuous or continuous welding for straight angle
- Digital display of speed, distance of discontinuous /continuous welding and time of end.
- Magnet type of handle, which can control magnet force more or less
- Welding in both left and right, induction switch fixed in both end
- Carriage stop running while welding ends
- Permanent magnet and guide unit fixed in carriage, which can prevent it from deviating welding line



Technical Specification

		AWC-5B
Supply Voltage V /Hz		AC 220 /50
LxWxH(mm)		390x288x285
Rang for adjusting torch	Up down	60mm
	Forward backward	60mm
	Work angle	±45°
	Proceeing angle	±10°
Speed (mm /min)		50-1900
Method of driving		Rubber wheel drive
Weight (kg /lb)		8.5 /18.8



GMAW Welding Carriage AWC500-6

Technical Specification

	AWC500-6
Weight	12kg
Input Voltage	24V /4AH (Storage Battery)
Driver Method	4 Rubber Wheels Chain-Driver Motor
Traction Power	32kg
Travel Speed	35-930 (mm /min)
Track Method	
Torch Position Adjustment	Guide Wheel X Axis $\pm 45^\circ$ X Axis $\pm 30^\circ$ Horizontal Shift 20mm
Weaving Parameters	Vertical Shift 20mm Weaving Angle $0\pm 8^\circ$
Torch Clamp Device	Max Weaving Speed 0-40(r/m)
Unweldable Distance	Left /Right Dwell Time 0-2.5s Front 150mm Fit for Bend Torch or Straight Torch Rear 146mm
Dimension (L*W*H)	314*195*242mm



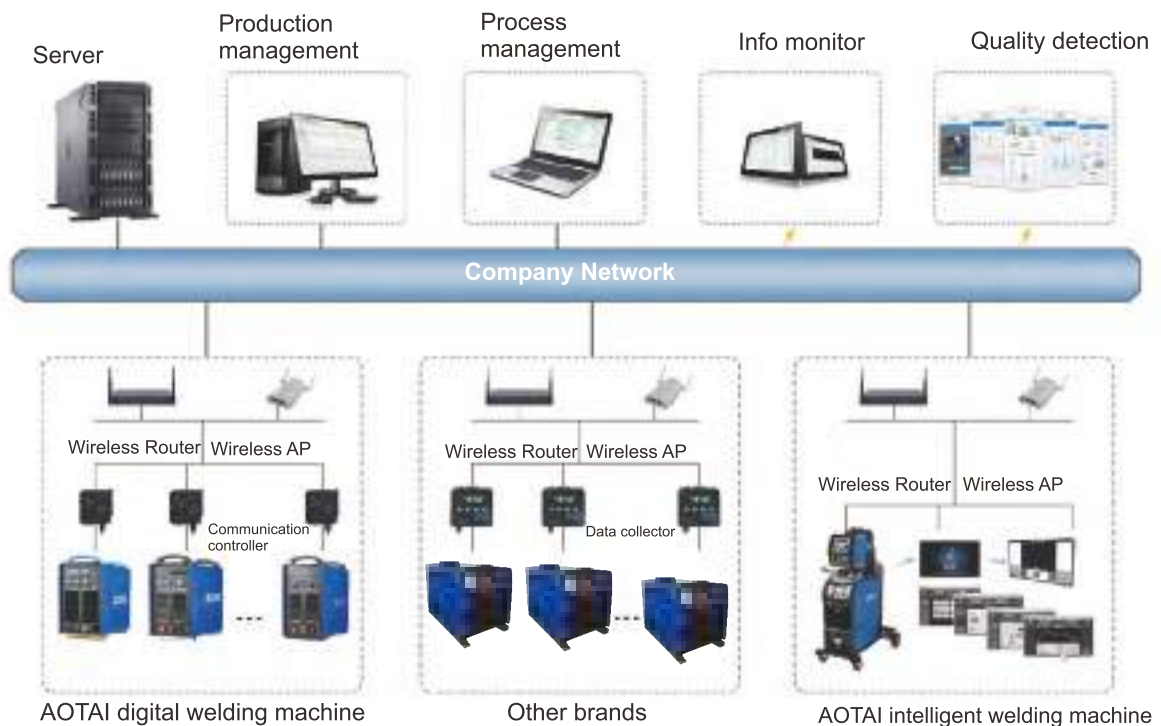
INTELLIGENT WELDING CLOUD SYSTEM



Intelligent welding cloud system

Intelligent welding cloud system is designed by AOTAI for welding machine management on site. It can realize welding machine status real-time monitoring, welding parameter online control, welding data mass storage, statistics, analysis, etc. It helps production companies improve product welding quality and reduce production cost.

The system adopts industrial Ethernet (wireless, wired) for connection. The upper computer system adopts B/S (browser/server) structure. It is convenient to realize remote access of data through enterprise network and data sharing by docking with enterprise information system.



Intelligent welding cloud system structure



Communication controller

ATQ communication controller can be used with AOTAI digital welding machine to complete communication between welding machine and server, and realize collection and control of all parameters of welding machine.

Communication controller can use wired or wireless communication modes. It has real-time clock and large-capacity data storage inside. Data can be temporarily stored when cannot connect with server so as to ensure data integrity.

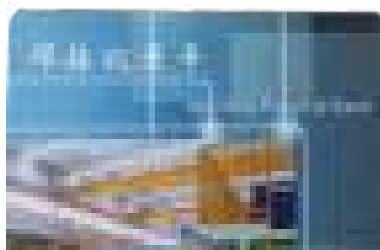


Welding data collector

ATQ-CJ welding data collector can work with AOTAI analog welding machine or other brand welding machines to realize collection of welding current, welding voltage, wire feeding speed and gas flow. Welding parameter limit can be set as needed. When welding parameters exceed the limit, sound and light alarm can be alarmed until welding machine is stopped.

Data collector can use wired or wireless communication modes. It has real-time clock and large-capacity data storage inside. Data can be temporarily stored when cannot connect with server so as to ensure data integrity.

Intelligent welding cloud system



IC card

IC card application and system can realize welder identification and automatically bind welding machine to welder. With IC card, welder's working data on any machine will be automatically connected with him to achieve statistical analysis of his attendance data.



Welding cloud front server

Realize pretreatment and temporary storage of welding data.

Configuration

Industrial CPU

Memory size: 8G

Hard disk: 1TB

Operating system: Windows 7

Dimension: 280mm×219.2mm×62mm

Operating temperature: -20~60

Installation method: Desktop or wall mounting



Welding cloud front terminal

Realize checking and operation of products, tasks, welding records and other information in workshop.

Configuration

CPU: Industrial CPU

Memory size: 4G

Hard disk: 120G SSD

Operating system : Windows 7

Display: 19 inches

Peripherals: metal keyboard, trackball mouse, IC card reader

Operating temperature: -20~60



Welding cloud handheld terminal

Function module :

Welding monitoring

Equipment maintenance

Statistical analysis

Welding procedure

Alarm management

System management

System Features

1. Workshop board

Real-time display of quality management factors during production in workshop, including people, machines, materials, methods, etc.



2. Equipment monitoring

Real-time display status of welding machines in the system, using status of all welding machines can be clearly displayed.



3. Device details

Real-time display of parameter changes during welding process, showing current working state of welding machine with dynamic curves.



4. Welding parameters

Preset welding parameters of welders in the system and lock the parameters within allowable range.



5. Statistical report

Statistics of working hours, welding material consumption, and process conformity in aspects of welders, equipment, products, etc., and multi-dimensional production data is presented in form of sheets.

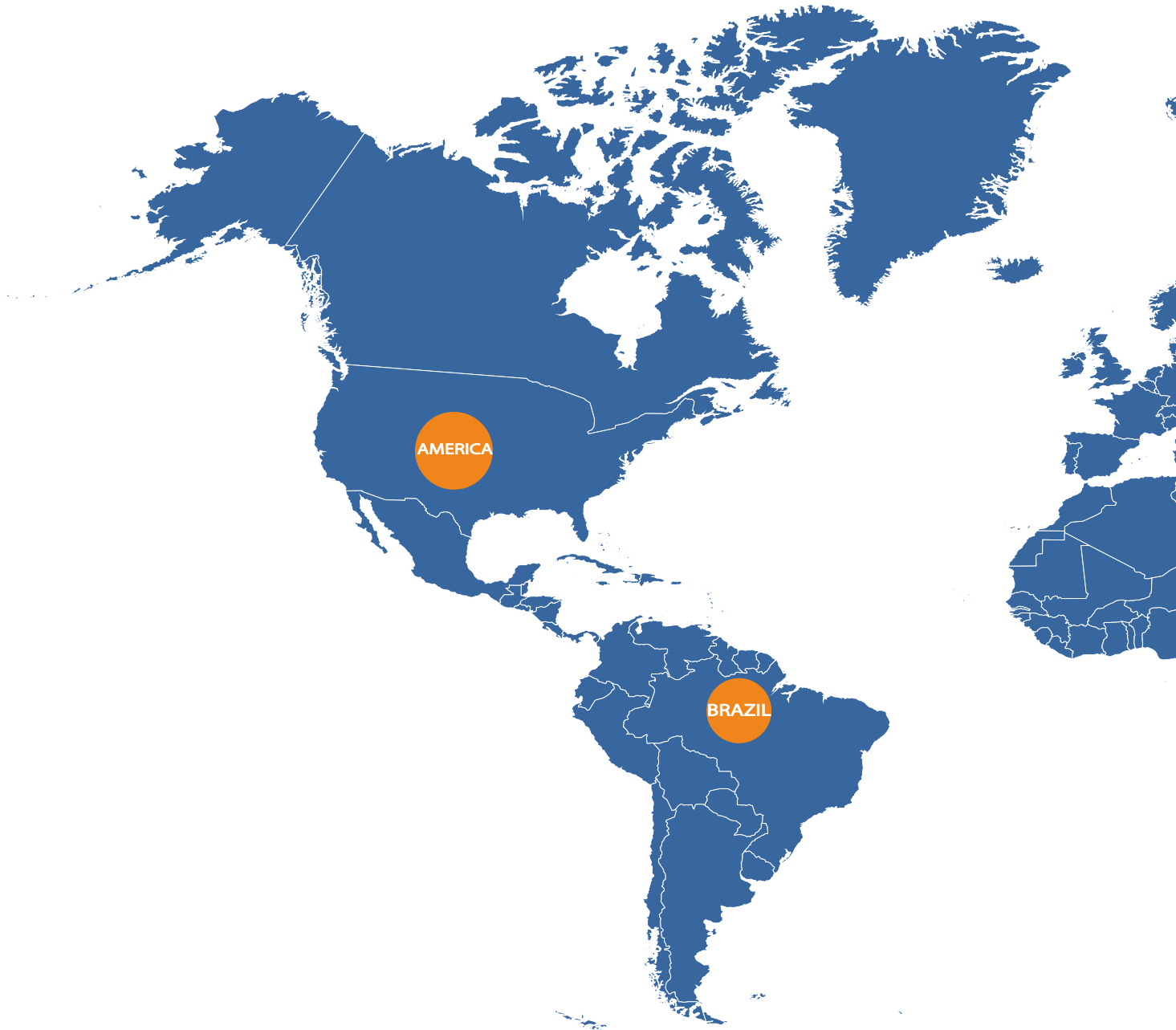


6. Alarm management

Current alarm info, alarm statistical analysis and historical traceback are reminded in real time through APP message, mobile phone short message, system message and other means.



AOTAI GLOBAL PARTNERS







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