

TR6

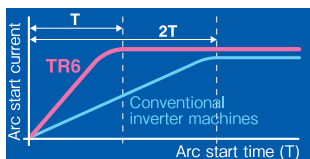
Inverter Control DC TIG welding Machines

High performance and stable arc
Innovative structure of the case that is very convenient for transportation and storage

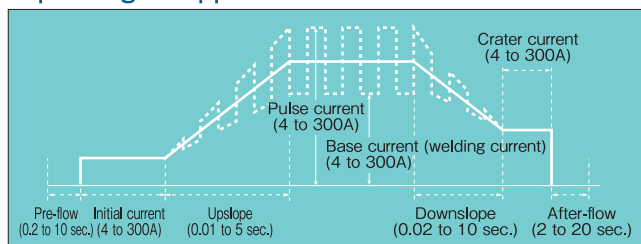
Stable and sharp arc with from 4A to the rated current

Concentration and stability of arc has been much improved by rapid control that is 1.6 times faster than conventional inverter controlled machines.

Thanks to adoption of a new circuit, rise time of arc start is twice as fast as conventional models.



Versatile wave form controls that can be chosen depending on applications.



Middle pulse control (10 to 500 Hz)
Effective for thin plate welding

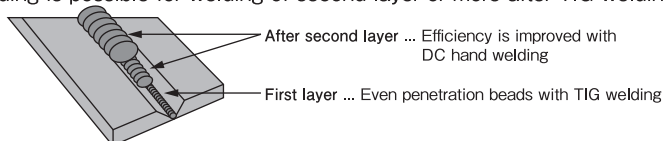
Upslope and downslope control
An even welding without burn through

Low pulse control (0.5 to 25 Hz)
Effective for medium and thick plate welding

Initial current control
To prevent defects such as insufficient melting at welding start or burn through

Also effective for DC manual welding

High quality welding can be made for variety of steels such as soft steel, stainless steel, high-tensile steel, Cr-Mo steel, etc and effective welding is possible for welding of second layer or more after TIG welding.



New structure of case, good for transportation and storage.

Two units can be stacked for transportation and three units can be stacked for storage.

Reliable check and protection functions are installed.

- Error display lamps
- Power switch with a no-fuse breaker
- Electric shock prevention function
- Connection terminals for various jigs



200TR6

300TR6

Rated specifications

Model No.	YC-200TR6		YC-300TR6		
Rated input voltage, rated frequency	— 200/220V common use, 50/60 Hz (common)				
Phase number	— single phase	3-phase	— single phase	3-phase	
Rated duty cycle (10 minute cycle)	% 40				
Rated input	kVA	6.5	7.6	7.9	10.5
	kW	4.7	6.9	5.9	9.3
Maximum no-load voltage (start voltage)	V 70				
Rated output current ※1	TIG welding	A 4~150	4~200	4~180	4~300
	Manual welding	A 4~150	4~200	4~180	4~250
Initial current	A 4~150	4~200	4~180	4~300	
Pulse current	A 4~150	4~200	4~180	4~300	
Crater current	A 4~150	4~200	4~180	4~300	
Rated output voltage	TIG welding	V 17	18	17.6	20
	Manual welding	V 26	28	28	30
Gas pre-flow time	s	0.2 to 10 continuous adjustment (0 possible with printed circuit board)			
Gas after-flow time	s	2 to 20 continuous adjustment			
Upslope time	s	0.1 to 5 continuous adjustment (0 possible with printed circuit board)			
Downslope time	s	0.2 to 10 continuous adjustment (0 possible with printed circuit board)			
Pulse frequency adjustment range	Middle pulse	Hz 10 to 500 continuous adjustment			
	Low pulse	0.5 to 25 continuous adjustment			
Pulse width	%	10~90			
Crater control method	—	Switching of "Yes", "No", and "Iterative" crater			
Arc spot time	s	0.2 to 5 continuous adjustment			
External dimensions (W x D x H)	mm	288x520x552			
Mass	kg	37			

※1 In low current range, select adequate application conditions to stabilize arc.

Power device capacity and required thickness of cables

Item	Welding PS	YC-200TR6		YC-300TR6	
		single phase	3-phase	single phase	3-phase
Power voltage	V	200/220 common use			
Phase number	—	single phase	3-phase	single phase	3-phase
Device capacity	kVA	6.5 or more	7.6 or more	7.9 or more	10.5 or more
Fuse capacity (no-fuse breaker)	A	30(40)	30(30)	30(40)	30(40)
Input side cable (Terminal hole)	mm ²	5.5 or more (for M5)	5.5 or more (for M5))	5.5 or more (for M5)	5.5 or more (for M5))
Output side cable (Terminal hole)	mm ²	22 or more (for M8)	22 or more (for M8)	38 or more (for M8)	38 or more (for M8)
Ground cable	mm ²	Equivalent to input side cable or above			

Options (Required devices for each application) ※Also see the page for options (pages 10 and 11).

■ Torch for TIG welding

Various types from 80 to 300A
(Standard cable length is 4 m and 8 m)



■ Argon gas regulator

● YX-251A



■ Extension cable (available on request)

Applicable torch	Cable length	Cable length		
		For 5 m	For 10 m	For 15 m
Air cooling	YT-15TS2	TWU15125	TWU15126	TWU15127
	YT-20TS2	TWU20131	TWU20132	TWU20133
Water cooling	YT-30TSW2	TWU30132	TWU30133	TWU30134
	YT-50TSW2	TWU50137	TWU50138	TWU50139

■ Remote controller

● YC-301URTRK1
(common use for 200 to 300A)



■ Cooling water unit

YX-09KGC1
(with flow rate switch)



■ Tungsten electrode (JIS: Z3233)

(Diameter 0.5 to 4.8 mm)

[Please prepare the following on your side]

- Holder for manual welding
- Welding rod
- Argon gas (for welding)
- Input and output side cables
- Ground cable