



PRO-TEC® 200B ACDC

TIG & Stick Welding System

A complete, multi-process (TIG ACDC/Stick) welding system. Basic user interface with pre-set controls for a wide variety of applications. Both AC and DC output delivering the flexibility for welding a broad range of ferrous and nonferrous materials. HF Arc Start providing non-contact arc starting to eliminate tungsten or material contamination.

- **Complete, Optimized TIG/Stick System**, supplied with all accessories ready for welding
- **AC/DC Output**, for aluminum and non-ferrous alloys, stainless, mild and chrome moly steels
- **High TIG Output & Duty Cycle**, with 200 amps and 30% (AC) / 25% (DC) duty cycle, this system is designed and built for light industrial use with both TIG and Stick processes
- **Flexible with Multi Voltage**, 120/208-240VAC input
- **Optimized Arc** that delivers an exceptionally smooth stable welding arc characteristic on both AC and DC output
- **Digital Meter**, preview and hold capability for easy setup
- **Remote Receptacle** that enables connection of remote control devices such as foot pedal or TIG torch with integrated controls
- **Thermal Overload Protection** that will protect the internal electrical components from overheating if the duty cycle is exceeded



200B ACDC
PART NO. G1320000

TIG Features

- **Basic Control**, with adjustable Wave Balance, AC frequency, AC or DC Pulse, fixed Pre/Post gas flow and fixed Upslope/Downslope with 4T

Stick Features

- **Fixed Hot Start & Arc Force** for optimum performance



QUICK SPECS	
PROCESSES	AMPERAGE RANGE
HF TIG (GTAW) AC or DC	AC: 10 - 200 Amp (GTAW) 208-240V
Stick (SMAW) DC	DC: 5 - 200 Amp (GTAW) 208-240V
RATED OUTPUT	AC: 10 - 140 Amp (GTAW) 120V
AC: 200A / 18V @ 30% Duty Cycle (GTAW) 208-240V	DC: 5 - 140 Amp (GTAW) 120V
DC: 200A / 18V @ 25% Duty Cycle (GTAW) 208-240V	DC: 5 - 170 Amp (SMAW) 208-240V
DC: 170A / 26.8V @ 35% Duty Cycle (SMAW) 208-240V	DC: 5 - 100 Amp (SMAW) 120V
AC or DC: 140A / 15.6V @ 40% Duty Cycle (GTAW) 120V	WEIGHT
DC: 100A / 24V @ 35% Duty Cycle (SMAW) 120V	25 lb (11.3 kg)
MAX. OPEN CIRCUIT VOLTAGE	ORDER INFORMATION
45V	Part No: G1320000 PRO-TEC 200B AC/DC TIG/Stick Welding Package

SYSTEM INCLUDES	
PRO-TEC 200B AC/DC Power Supply	
17 Style TIG Torch & Accessories with Integrated Controls, 50 mm Dinse with 12.5 ft (3.8 m) Lead	
Ground Clamp with 10 ft (3 m) Lead	
Electrode Holder with 10 ft (3 m) Lead	
Argon Flow-gauge Regulator with 12.5 ft (3.8 m) gas Hose	
Power Cord 9.5 ft (2.9 m) and NEMA 6-50P 250V Plug	
Power Cord Adapter 250V/50A to 120V/15A	
Operator's Manual	
Shoulder Strap	
APPLICATIONS	
Aluminum Fabricators	Maintenance & Repair
Automotive, Boats & Trailers	Training Institutions
On-Site & Portable Welding Applications	

CONTROL PANEL

Parameter Selection Button
AC TIG Mode:
Amp, AC Bal, AC Freq, PULSE
DC TIG Mode: Amp, PULSE
DC Stick Mode: Amp

Digital Display
Displays preview/actual amperage
and parameter values

Power Indicator Light

Overheat / Fault Indicator Light

Weld Amperage and
Parameter Control Knob

AC TIG, DC TIG or DC Stick
Process Button

2T Normal Mode or 4T Latch
Mode Torch Trigger Button



SYSTEM FEATURES

Heavy Duty 50 mm Dinse
Terminals

Shielding Gas Outlet

8 Pin Remote Receptacle

WELDING DC	
Type: Constant Current	AC/DC HF TIG; DC Stick
Maximum Output	208 - 240V 200 Amp (GTAW); 170 Amp (SMAW)
	120V 140 Amp (GTAW); 100 Amp (SMAW)
TIG (GTAW) Welding Output @104°F (40°C)	
208 - 240V	AC: 200A / 18V @ 30% Duty Cycle DC: 200A / 18V @ 25% Duty Cycle
120V	AC or DC: 140A / 15.6V @ 40% Duty Cycle
STICK (SMAW) Welding Output @104°F (40°C)	
208 - 240V	DC: 170A / 26.8V @ 30% Duty Cycle
120V	DC: 100A / 24V @ 35% Duty Cycle
Current Range	
TIG 208 - 240V	AC: 10 - 200 Amp
	DC: 5 - 200 Amp
TIG 120V	AC: 10 - 140 Amp
	DC: 5 - 140 Amp
Stick 208-240V	DC: 5 - 170 Amp
Stick 120V	DC: 5 - 100 Amp
Nominal OCV Volt	45V
Warranty Period	3 Year*
Approvals	CAN/CSA - E60974 - 1:12, ANSI/IEC 60974 - 1:2008
Protection	Class IP23S
Power Source Dimensions (H x W x D)	12.2" x 6.9" x 18.9" (310 mm x 175 mm x 480 mm)
Power Source Weight	25 lb (11.3 kg)

* Limited Warranty, refer to warranty schedule.

PRIMARY POWER	
Primary Voltage	120/208 - 240 VAC
Supply Voltage Range	120V: 104 - 127VAC; 230V: 187 - 264V
Number of Phases	Single Phase
Supply Frequency	50/60Hz
Supply Plug	NEMA 6-50P
Rated kVA @ Max Amp	120V: 3.5 kVA
	208 - 240V: 6.0 kVA
Lead Cord Length	9.5 ft (2.9 m)
	230V: 26.1 Amp
Maximum Input Current	230V: 26.1 Amp
	120V: 29.2 Amp

REPLACEMENT ACCESSORIES	
TIG Torch & Accessories, 17 Style, 50 mm Dinse with 12.5 ft (3.8 m) Lead Up-Down weld current control	G5217122
Electrode Holder with 10 ft (3 m) Lead, 50 mm Dinse	G5315010
Ground Clamp with 10 ft (3 m) Lead, 50 mm Dinse	G5315000
Argon Flow-gauge Regulator	G4300000
Gas Hose, 12.5 ft (3.8 m), male 5/8-18UNF	G4300010
Foot Control, 8 pin, 15 ft (4.6 m)	G4200815
Power Cord Adapter (250V/50A - 120V/15A)	G4123000

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System accessories shown below.

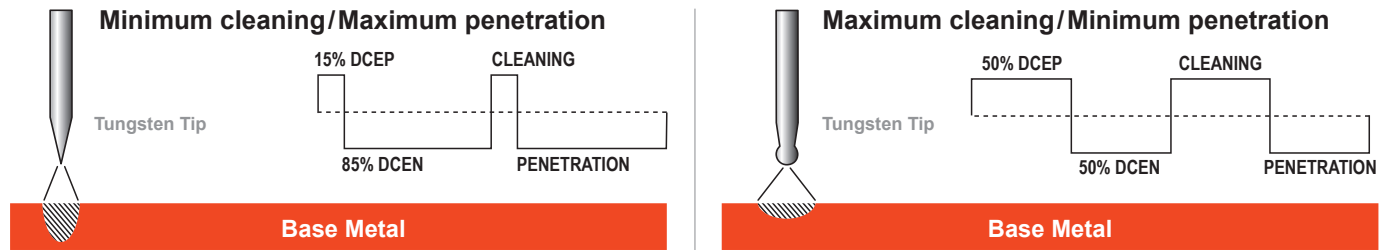


1. Electrode Holder w/ 10 ft (3 m) Lead
2. Ground Clamp w/ 10 ft (3 m) Lead
3. TIG Torch & Accessories, 17 Style, 50 mm Dinse, 12.5 ft (3.8 m) Lead
4. Gas Hose, 12.5 ft (3.8 m)

5. Argon Flow-gauge Regulator
6. 250V/50A to 120V/15A Power Cord Adapter
7. Operating Manual
8. Shoulder Strap

EFFECT OF WAVE BALANCE ADJUSTMENT ON AC GTAW

The PRO-TEC 200B AC/DC controls the wave form changes on the amount of time spent on DCEP (cleaning) and DCEN (penetration) parts of each cycle, increasing arc stability. The DCEP cycle insures that the aluminum oxide is thoroughly removed, allowing the DCEN cycle to achieve a greater penetration of the base metal. Both cycles enhance weld quality and significantly improve performance.



ORDERING FORM

Equipment	Part No.	Description	Quantity	Price
PRO-TEC 200B ACDC Stick/TIG Welding System 	G1320000	PRO-TEC 200B AC/DC power supply, electrode holder with 10 ft (3 m) Lead, Ground Clamp with 10 ft (3 m) Lead, Operator's Manual, 17 Style TIG Torch & Accessories, Power Cord Adapter, Argon Flow-gauge Regulator and Gas Hose.		
Accessories TIG Torch & Accessory Kit 	G5217122	17 Style TIG Torch, 5/8"-18 UNF Hose Connection, Gas Valve, 50 mm Dinse Connection, Contactor On/Off, Up - Down Current Control and TIG Accessory Kit with 1/16", 3/32", 2% Ceriated (EWCe-2) Tungstens; 1/16", 3/32", Collets; 1/16", 3/32", Collet Bodies; No. 5, 6, 7, Alumina Nozzle; Short Back Cap; Long Back Cap.		
Ground Clamp 	G5315000	Ground Clamp with 10 ft (3 m) Lead Assembly, 50 mm Dinse Connector		
Electrode Holder 	G5315010	Electrode Holder with 10 ft (3 m), Lead Assembly, 50 mm Dinse Connector		
Argon Flow-gauge Regulator 	G4300000	Argon Flow-gauge Regulator		
Foot Control 	G4200815	Foot Control, Contactor On/Off and Current Control with 15 ft (4.6 m) Cable and 8 Pin Male Plug		
Gas Hose 	G4300010	Gas Hose, 12.5 ft (3.8 m), Male 5/8-18UNF		