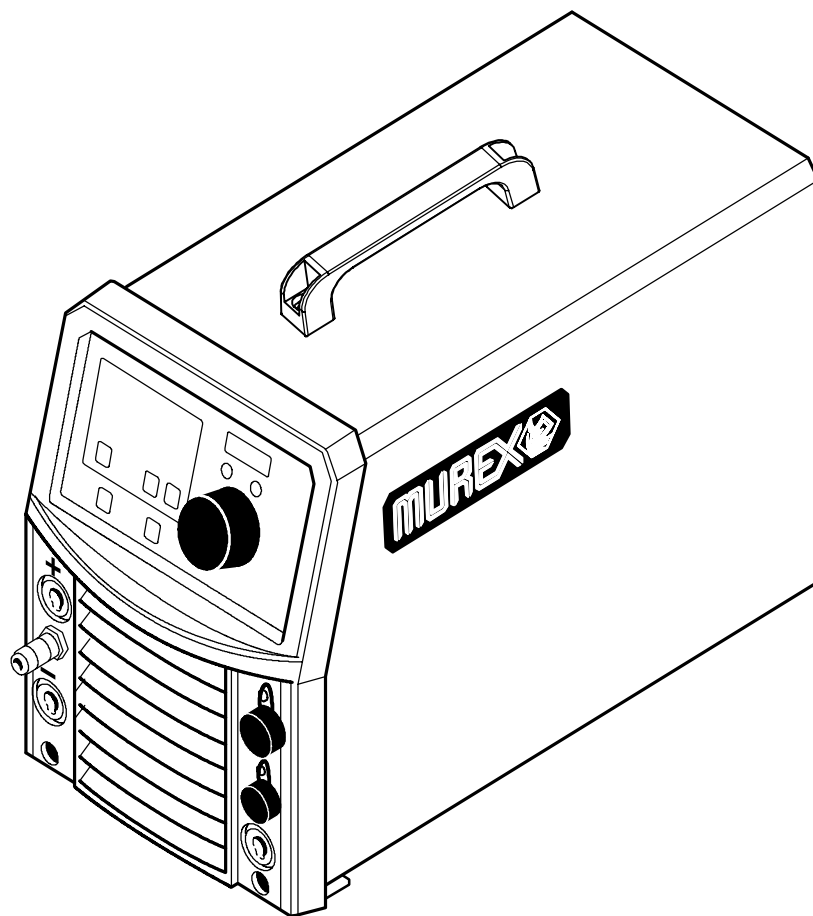


GB



# *Transtig 150-1*

# *Transtig 200-1*



**Instruction manual and  
spare parts list**

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## 1 DIRECTIVE

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### DECLARATION OF CONFORMITY

Murex Welding Products Ltd, EN8 7TF England, gives its unreserved guarantee that welding power source **Transtig 150-1** and **Transtig 200-1** from serial number 517 complies with standards EN 60974-1/-3, in accordance with the requirements of directive (72/23/EEC) and addendum (93/68/EEC) and with standard EN 50199 in accordance with the requirements of directive (89/336/EEC) and addendum (93/68/EEC).

-----

On behalf of Murex Welding Products Ltd.

Laxå 2005-05-25



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## 2 SAFETY

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Users of welding equipment have the ultimate responsibility for ensuring that anyone who works on or near the equipment observes all the relevant safety precautions. Safety precautions must meet the requirements that apply to this type of welding equipment. The following recommendations should be observed in addition to the standard regulations that apply to the workplace.

All work must be carried out by trained personnel well-acquainted with the operation of the welding equipment. Incorrect operation of the equipment may lead to hazardous situations which can result in injury to the operator and damage to the equipment.

1. Anyone who uses the welding equipment must be familiar with:
  - its operation
  - location of emergency stops
  - its function
  - relevant safety precautions
  - welding
2. The operator must ensure that:
  - no unauthorized person is stationed within the working area of the equipment when it is started up.
  - no-one is unprotected when the arc is struck
3. The workplace must:
  - be suitable for the purpose
  - be free from drafts
4. Personal safety equipment
  - Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves.
  - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns.
5. General precautions
  - Make sure the return cable is connected securely.
  - Work on high voltage equipment **may only be carried out by a qualified electrician.**
  - Appropriate fire extinguishing equipment must be clearly marked and close at hand.
  - Lubrication and maintenance must **not** be carried out on the equipment during operation.



# WARNING



**ARC WELDING AND CUTTING CAN BE INJURIOUS TO YOURSELF AND OTHERS. TAKE PRECAUTIONS WHEN WELDING. ASK FOR YOUR EMPLOYER'S SAFETY PRACTICES WHICH SHOULD BE BASED ON MANUFACTURERS' HAZARD DATA.**

**ELECTRIC SHOCK - Can kill**

- Install and earth the welding unit in accordance with applicable standards.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves or wet clothing.
- Insulate yourself from earth and the workpiece.
- Ensure your working stance is safe.

**FUMES AND GASES - Can be dangerous to health**

- Keep your head out of the fumes.
- Use ventilation, extraction at the arc, or both, to take fumes and gases away from your breathing zone and the general area.

**ARC RAYS - Can injure eyes and burn skin.**

- Protect your eyes and body. Use the correct welding screen and filter lens and wear protective clothing.
- Protect bystanders with suitable screens or curtains.

**FIRE HAZARD**

- Sparks (spatter) can cause fire. Make sure therefore that there are no inflammable materials nearby.

**NOISE - Excessive noise can damage hearing**

- Protect your ears. Use earmuffs or other hearing protection.
- Warn bystanders of the risk.

**MALFUNCTION - Call for expert assistance in the event of malfunction.**

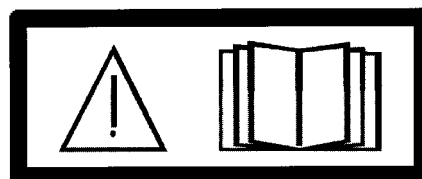
**READ AND UNDERSTAND THE INSTRUCTION MANUAL BEFORE INSTALLING OR OPERATING.**

**PROTECT YOURSELF AND OTHERS!**



**WARNING!**

Read and understand the instruction manual before installing or operating.



**We can provide you with all necessary welding protection and accessories.**



**WARNING!**

Do not use the power source for thawing frozen pipes.



**This product is solely intended for arc welding.**

## 3 INTRODUCTION

The **Transtig 150-1** and **Transtig 200-1** are welding current power sources based on the static converter technology intended TIG welding and welding with coated electrodes (MMA). Advanced electronics with microcomputer control produces e.g. rapid regulation and top-class welding properties.

### 3.1 Equipment

The **Transtig** is supplied with 3 m of mains cable and an instruction manual.

**ESAB's accessories for the product can be found on page 29.**

## 4 TECHNICAL DATA

	<b>Transtig 150-1</b>	<b>Transtig 200-1</b>
<b>Mains voltage</b>	230V, 1~ 50/60 Hz	230V, 1~ 50/60 Hz
<b>Fuse (delayed-action)</b>	16 A	16 A
<b>Primary current <math>I_{max}</math></b>	36 A	36 A
<b>Primary current <math>I_{eff}</math></b>	21 A	21 A
<b>Voltage/current range</b> (TIG) (MMA)	3 A / 10 V - 150 A / 16 V 4 A / 20 V - 150 A / 26 V	3 A / 10 V - 200 A / 18 V 4 A / 20 V - 150 A / 26 V
<b>Maximum permissible load at TIG</b>		
25% duty cycle		200 A / 18 V
35% duty cycle	150 A / 16 V	180 A / 17 V
60% duty cycle	120 A / 15 V	140 A / 15,5 V
100% duty cycle	95 A / 14 V	110 A / 14,5 V
<b>Maximum permissible load at MMA</b>		
25% duty cycle	150 A / 26 V	150 A / 26 V
35% duty cycle	140 A / 25,5 V	140 A / 25,5V
60% duty cycle	110 A / 24,5 V	110 A / 24,5V
100% duty cycle	90 A / 23,5 V	90 A / 23,5V
<b>Power factor</b> at maximum current	0,62	0,62
<b>Efficiency</b> at maximum current	77 %	79 %
<b>Open-circuit voltage</b>	71 - 78 V	71 - 78 V
<b>Operating temperature</b>	-10°C - + 40°C	-10°C - + 40°C
<b>Constant A-weighted sound pressure</b>	<70 db	<70 db
<b>Dimensions, l x b x h</b>	394 x 267 x 274 mm	394 x 267 x 274 mm
<b>Weight</b>	10 kg	10 kg
<b>Enclosure class</b>	IP 23C	IP 23C
<b>Application class</b>	<b>S</b>	<b>S</b>

#### Duty cycle

The duty cycle refers to the time as a percentage of a ten-minute period that you can weld at a certain load without overloading.

#### Enclosure class

The **IP** code indicates the enclosure class, i. e. the degree of protection against penetration by solid objects or water. Equipment marked **IP23** is designed for indoor and outdoor use.

#### Application class

The symbol **S** indicates that the power source is designed for use in areas with increased electrical hazard.

## 4.1 Settings

### 4.1.1 TIG welding without pulsing

Settings	Setting range	In steps of:	Default value
Welding method	TIG, TIG pulse or MMA	-	TIG
2/4 stroke *	2 stroke or 4 stroke	-	2 stroke
HF / LiftArc™ *	HF or Liftarc™	-	LiftArc™
Gas pre-flow	0 - 5 s	0.1 s	0.5 s
Slope up time	0 - 10 s	0.1 s	0.0 s
Slope down time	0 - 10 s	0.1 s	1.0 s
Gas post-flow	0 - 25 s	0.1 s	2.0 s
Current        Transtig 150-1	3 - 150 A	1 A	60 A
Current        Transtig 200-1	3 - 200 A	1 A	60 A

### 4.1.2 TIG welding with pulsing

Settings	Setting range	In steps of:	Default value
Welding method *	TIG, TIG pulse or MMA	-	TIG
2/4 stroke *	2 stroke or 4 stroke	-	2 stroke
HF / LiftArc™ *	HF or Liftarc™	-	LiftArc™
Gas pre-flow	0 - 5 s	0.1 s	0.5 s
Slope up time	0 - 10 s	0.1 s	0.0 s
Slope down time	0 - 10 s	0.1 s	1.0 s
Gas post-flow	0 - 25 s	0.1 s	2.0 s
Pulse time	0.1 - 2.5 s	0.01 s	1.0 s
Micro pulse**	0.001 - 0.250 s	0.001 s	
Background time	0.1 - 2.5 s	0.01 s	1.0 s
Micro pulse**	0.001 - 0.250 s	0.001 s	
Pulse current     Transtig 150-1	3 - 150 A	1 A	60 A
Background current   Transtig 150-1	3 - 150 A	1 A	20 A
Pulse current     Transtig 200-1	3 - 200 A	1 A	60 A
Background current   Transtig 200-1	3 - 200 A	1 A	20 A

### 4.1.3 MMA settings

Settings	Setting range	In steps of:	Default value
Welding method	TIG / MMA	-	TIG
Arc Force	0 - 99%	1%	5%
Drop welding	1 / 0	-	0
Regulator type ArcPlus™	1 / 0	-	1
Hot start	0 - 99%	1%	0%
Current        Transtig 150-1	4 - 150 A	2 A	100 A
Current        Transtig 200-1	4 - 150 A	2 A	100 A

\*) These functions cannot be changed while welding is in progress.

\*\*\*) Gas pre-flow time and micro pulse are hidden functions, see page 9 .

## 5 INSTALLATION



### WARNING!

This product is intended for industrial use. In a domestic environment this product may cause radio interference. It is the user's responsibility to take adequate precautions.

### 5.1 Placing

Place the power source so that its cooling air inlets and outlets are not obstructed.

### 5.2 Rating plate

The rating plate is located on the rear side of the power source.

### 5.3 Mains power supply

Make sure that the welding power source is connected to the correct supply voltage and that it is protected by the correct fuse rating. The standards for the country in question must be complied with as regards the mains cable area. A protective earth connection must be made in accordance with regulations.

#### 5.3.1 Recommended fuse sizes and minimum cable areas

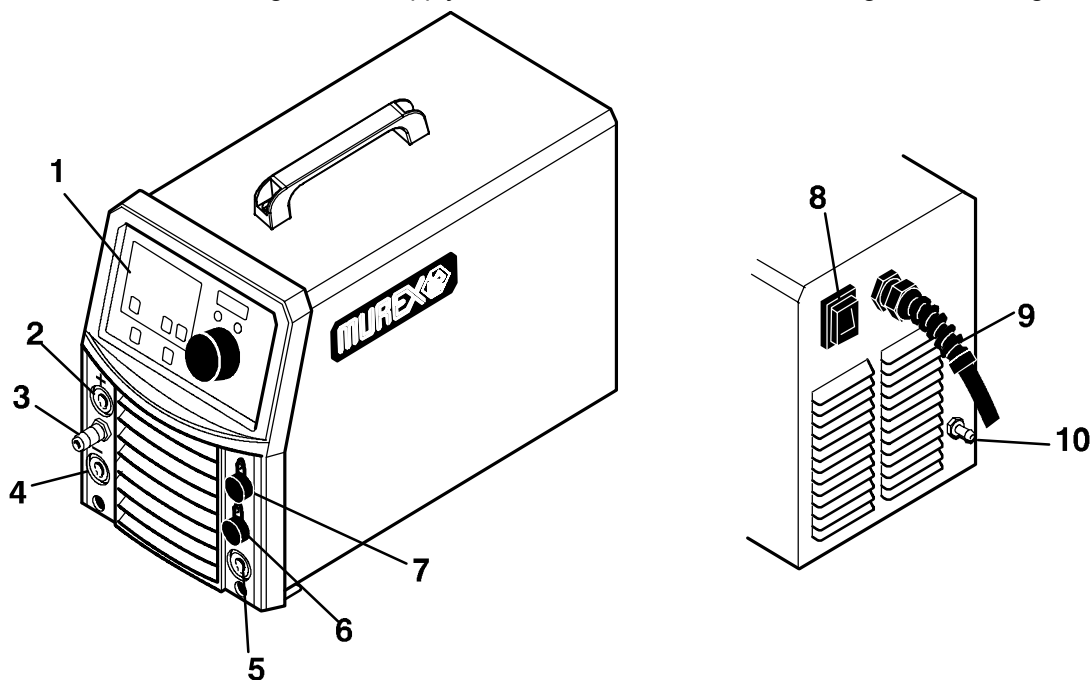
	Transtig 150-1	Transtig 200-1
<b>Mains voltage</b>	230 V $\pm$ 10 %, 1-phase	230 V $\pm$ 10 %, 1-phase
<b>Mains frequency</b>	50-60 Hz	50-60 Hz
<b>Fuse (delayed-action)</b>		
85A 35% duty cycle MMA	10 A	10 A
120A 20% duty cycle MMA	16 A	16 A
150A 25% duty cycle MMA	20 A*)	20 A*)
<b>Mains cable, area</b>	3 x 2.5 mm <sup>2</sup>	3 x 2.5 mm <sup>2</sup>
<b>Welding cable, area MMA</b>	16 mm <sup>2</sup>	16 mm <sup>2</sup>
<b>Welding cable, area TIG</b>	16 mm <sup>2</sup>	25 mm <sup>2</sup>

\*) **NOTE!** The mains plug is approved for maximum 16A.

## 5.4 Connections and control devices

- |   |   |    |                                     |
|---|---|----|-------------------------------------|
| 1 | Control panel   | 6  | Connection for the TIG torch switch |
| 2 | TIG: Return cable connection (+)<br>MMA: Welding cable connection (-) | 7  | Remote control unit connection      |
| 3 | Gas hose connection to the TIG torch                                  | 8  | Mains power supply switch           |
| 4 | MMA: Return cable connection (-)                                      | 9  | Mains cable                         |
| 5 | TIG torch connection (-)  | 10 | Connection for shielding gas        |

2 and 4 are used for welding current supply and return cable connection during MMA welding



## 6 OPERATION

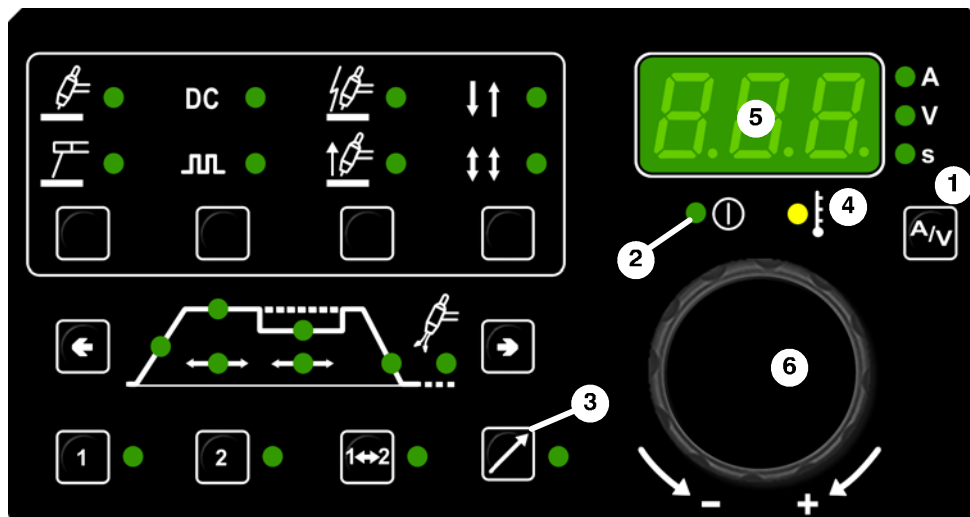
**General safety regulations for the handling of the equipment can be found on page 3. Read through before you start using the equipment!**

### 6.1 Control panel

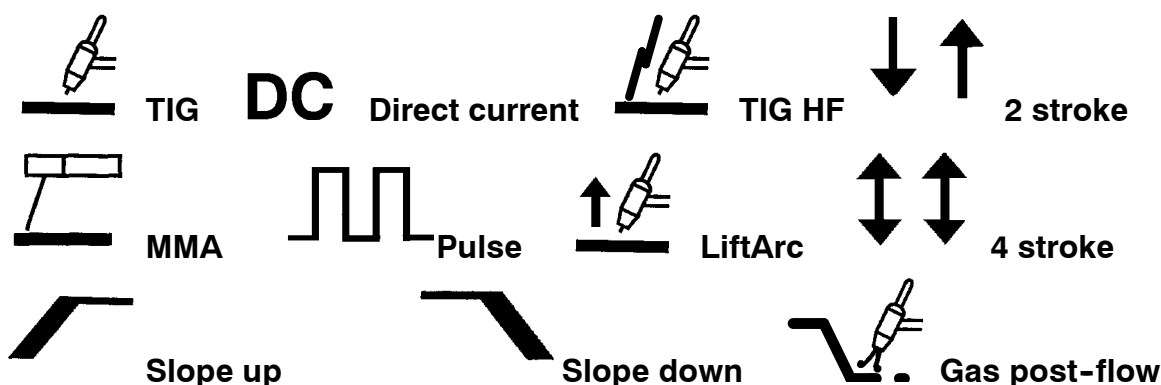
On the upper side of the power source there is a control panel for choosing functions and setting parameters. This comprises a display, setting knob, LEDs and pushbuttons. Using the pushbuttons, it is possible to move between the various functions. The selected function is indicated by the relevant LED lighting up.

**The power source checks the LEDs and all segments in the display when main switch is turned on. The machine type and program version are also displayed.**

- |   |                     |   |  |
|---|---------------------|---|--|
| 1 | Ampere/volt/Seconds | 2 | LED (green) mains voltage  |
| 3 | Remote control      | 4 | LED (yellow) overheating   |
| 5 | Data display        | 6 | Knob for setting data.<br><i>Increase (+) or Decrease (-) selected by the function pushbuttons</i> |



### 6.1.1 Function symbols in the control panel





## 6.2 Overheating protection



The welding power source has a thermal overload trip which operates if the temperature becomes too high, interrupting the welding current and lighting a yellow indicating lamp on the front of the power source. The thermal overload trip resets automatically when the temperature has fallen.

## 6.3 Hidden functions

The Transtig is supplied with ArcPlus™, a new type of control that, during MMA welding, produces a more intensive, more concentrated and calmer arc. It recovers more quickly after a drop short-circuit, which reduces the risk of the electrode becoming caught.

The machine is also equipped with Arc Force, which means that the power source's dynamics can be adjusted, softer or harder depending on the type of electrode and according to preference. However, the Arc Plus™ regulator's good properties mean that there is only reason to alter the Arc Force setting in exceptional cases.

The Transtig includes additional setting options that are obtained by pressing  and  simultaneously for 1 second.

Access to the setting options (A -H) are displayed by pressing  or . Set the values or function by turning the knob.

**Hidden functions TIG welding**



For TIG, the following options under the double press function can be found under the letters:

- A** = setting gas pre-flow time in seconds
- b** = setting micropulse (TIG pulse) Off= 0 or On=1

The following welding data setting options for MMA can be found under the letters:

**Hidden functions MMA welding**

- C** = setting ArcForce value in percent
- d** = setting Drop welding Off=0 or On =1
- F** = setting regulator ArcPlus™ Off=1 or On =0
- H** = setting Hot Start value in percent

Reset additional settings by pressing  and  simultaneously for 1 second.

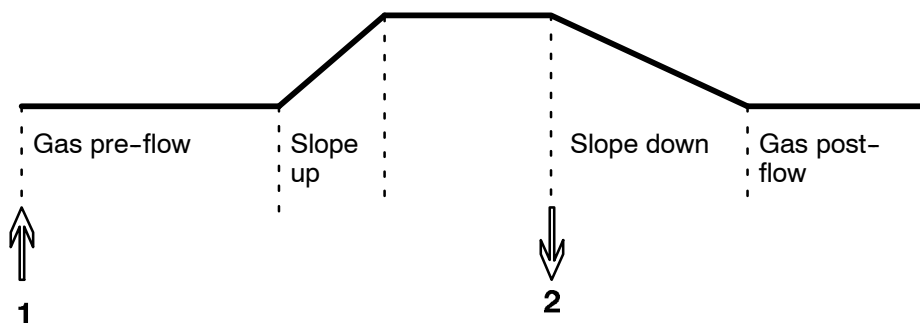
**7 WELDING**

**7.1 TIG welding**

During TIG welding, the return cable must be connected to (+) and the TIG torch to (-). If they are connected in reverse, the tungsten electrode will melt.


Pulsing is used for improved control of the weld pool and the solidification process. The pulse frequency is set so slow that the weld pool has time to solidify at least partially between each pulse. In order to set pulsing, four parameters are required: pulse time, background time, pulse current and background current.

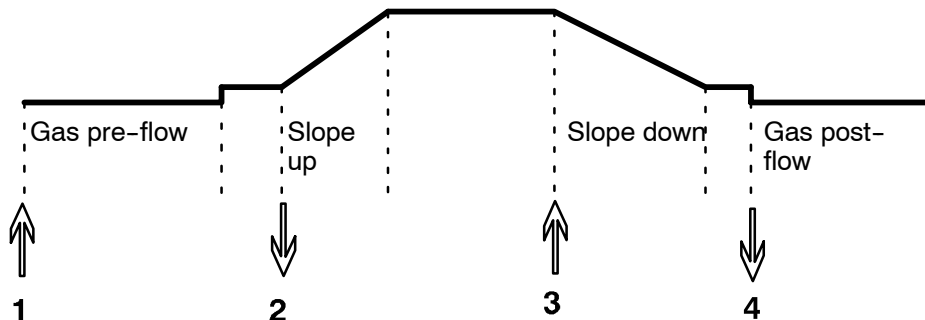
**7.1.1**   **2 stroke**



*Functions when using 2 stroke control of the welding torch.*

In the **2 stroke** control mode, pressing the trigger switch starts gas pre-flow (if used) and strikes the arc (1). The current rises to the set value (as controlled by the slope up function, if in operation). Releasing the trigger switch (2) reduces the current (or starts slope down if in operation) and extinguishes the arc. Gas post-flow follows if it is in operation.

7.1.2  **4 stroke**



Functions when using 4 stroke control of the welding torch.

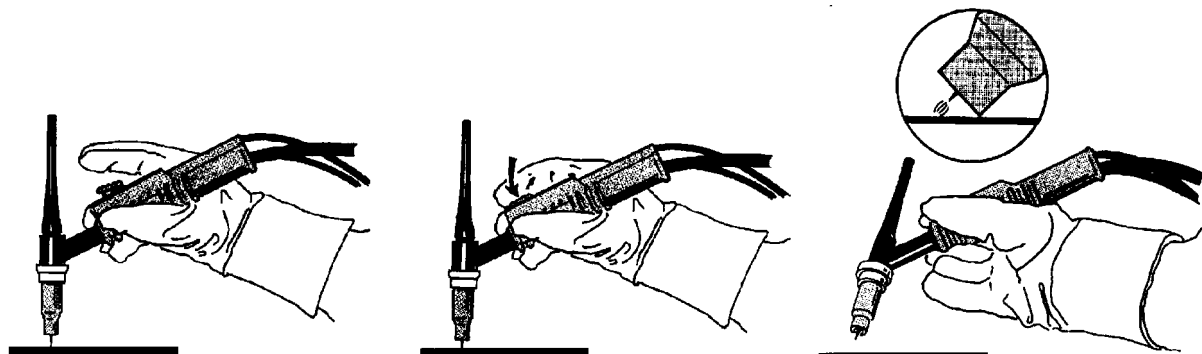
In the **4 stroke** control mode, pressing the trigger switch starts gas pre-flow (if used) (1). At the end of the gas pre-flow time, the current rises to the pilot level (a few amperes), and the arc is struck. Releasing the trigger switch (2) increases the current to the set value (with slope up, if in use). At the end of welding, the welder presses the trigger switch again (3), which reduces the current to pilot level again (with slope down, if in use). Releasing the switch again (4) extinguishes the arc and starts gas post-flow.

7.1.3  **HF**

The HF function strikes the arc by means of a spark from the electrode to the workpiece as the electrode is brought closer to the workpiece.

7.1.4  **LiftArc™**

The Lift Arc™ function strikes the arc when the electrode is brought into contact with the workpiece and then lifted away from it.



Striking the arc with the Lift Arc function. Step 1: the electrode is touched on to the workpiece. Step 2: the trigger switch is pressed, and a low current starts to flow. Step 3: the welder lifts the electrode from the workpiece: the arc strikes, and the current rises automatically to the set value.

### 7.1.5 Current

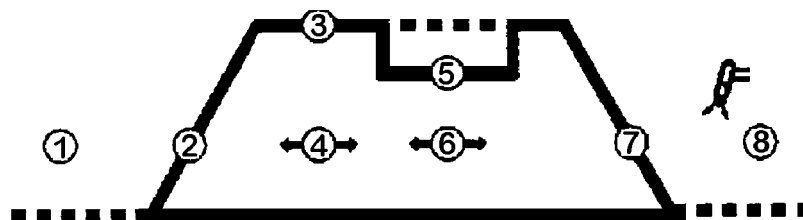
A higher current produces a wider weld pool, with better penetration into the workpiece.

The current set value can be changed irrespective of which menu is displayed. This value is displayed in the main menu only.

### 7.1.6 Pulse

When activating pulse, the power source must be in the position for setting pulse time/pause time.

1. Gas pre-flow
2. Slope up
3. Pulse current or continuous current
4. Pulse time
5. Background current
6. Background time
7. Slope down
8. Gas post-flow



### 7.1.7 Pulse and background time

The setting range for these parameters is normally 0.01–2.5 s. However, by using micro pulse, times down to 0.001 seconds can be set. When the micro pulse function is active, times shorter than 0.25 seconds are displayed without a decimal point.

Micro pulse is a hidden function, to activate micro pulse, follow the description 6.3 “Hidden function”.

#### Pulse time

The time the pulse current is *on* during a pulse period.

#### Background time

Time for background current which, along with the time for pulse current, gives the pulse period.

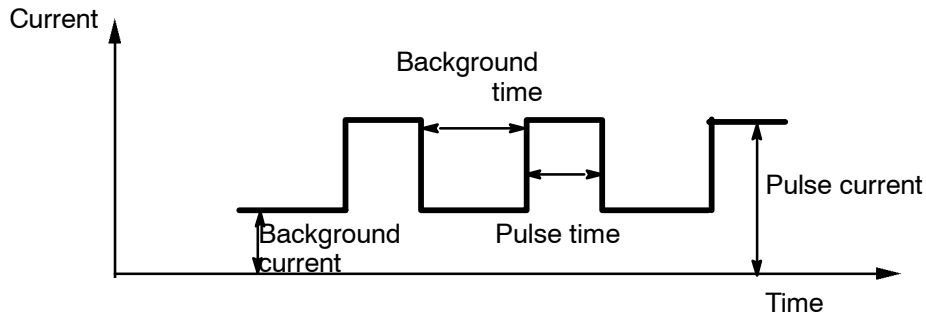
#### Background current

The lower of the two current values in the event of pulsed current.

## Pulse current

A higher current produces a wider weld pool, with better penetration into the workpiece.

The current set value can be changed irrespective of which menu is displayed. This value is displayed in the main menu only.



*TIG welding with pulsing.*

### 7.1.8 Remote control unit

Using the remote control unit socket on the machine, the current can be controlled remotely for both TIG and MMA.

If pulsed current is chosen in TIG mode, it is the pulse current that is remotely controlled. The value set from the remote control unit is shown on the display by browsing to the position where the current would have been set without the remote control unit.

This is confirmed by the green LED lighting up.



### 7.1.9



### Gas pre-flow

This controls the time during which shielding gas flows before the arc is struck.

### 7.1.10



### Slope up

The slope up function means that, when the TIG arc strikes, the current rises slowly to the set value. This provides 'gentler' heating of the electrode, and gives the welder a chance to position the electrode properly before the full current value is reached.

### 7.1.11



### Slope down

TIG welding uses slope down, by which the current falls 'slowly' over a controlled time, to avoid craters and/or cracks when a weld is finished.

### 7.1.12



### Gas post-flow

This controls the time during which shielding gas flows after the arc is extinguished.

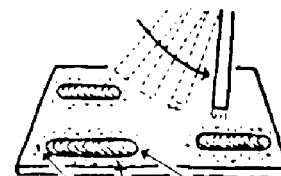
## 7.2 MMA welding

The Transtig gives direct current, and you can weld most metals to alloy and non-alloy steel, stainless steel and cast iron.

The Transtig 150-1 allows you to weld most coated electrodes from  $\varnothing$  1.6 to  $\varnothing$  3.25. The Transtig 200-1 allows you to weld most coated electrodes from  $\varnothing$  1.6 to  $\varnothing$  4.0.

If, when striking the arc, the tip of the electrode is pressed against the metal, it immediately melts and sticks to the metal, rendering continued welding impossible. Therefore, the arc has to be struck in the same way that you would light a match.

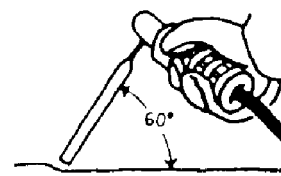
Quickly strike the electrode against the metal, then raise it so as to give an appropriate arc length (approx. 2 mm). If the arc is too long, it will crackle and spit before finally going out completely.



cmha2p11

If you are working on a welding bench, check before attempting to strike the arc that residual waste metal, pieces of electrode or other objects on the bench do not insulate the part to be welded.

Once the arc has been struck, move the electrode from left to right. The electrode must be at an angle of  $60^\circ$  to the metal in relation to the direction of welding.



cmha2p10

When you want to weld wide beads, or when you want the weld to be so thick that you have to weld in a number of layers, however, you have to use lateral movements.

### 7.2.1 Setting regulator - ArcPlus™

The Transtig is supplied with ArcPlus™, a new type of control that, during MMA welding, produces a more intensive, more concentrated and calmer arc. It recovers more quickly after a drop short-circuit, which reduces the risk of the electrode becoming stuck.

### 7.2.2 Arc Force

The Arc Force setting alters the machine's dynamics. A softer/harder arc can be obtained. The arc force is important in determining how the current changes in response to a change in the arc length. A lower value gives a calmer arc with less spatter.

### 7.2.3 Drop welding

Drop welding can be used when welding with stainless electrodes. This technique involves alternately striking and extinguishing the arc in order to achieve better control of the supply of heat. The electrode needs only to be raised slightly to extinguish the arc.

### 7.2.4 Hot Start

Hot start increases the weld current for an adjustable time at the start of welding, thus reducing the risk of poor fusion at the beginning of the joint.

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## 8 WELDING DATA MEMORY



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The Transtig can store 4 different welding data setups in the machine's memory, divided between 2 in TIG mode and 2 in MMA mode.


The following can be stored:

In TIG mode	all settings can be stored.
In MMA mode	only welding current can be stored.

For setting gas pre-flow, TIG MicroPulse, ArcForce and drop welding:

Press button  or  for 5 seconds to store the data in the memory. At the beginning the green LED shines constantly, and then starts flashing when the data has been saved.

To switch between the predefined settings, use button  or .

Change settings with the torch trigger by pressing .  
Press the torch trigger quickly (within 0,3 seconds) to switch between the stored settings.

The Transtig has a back-up battery so that the settings remain even if the machine has been switched off or disconnected from the mains.

## **9 MAINTENANCE**

*Regular maintenance is important for safe, reliable operation.*

**Note!**

*All guarantee undertakings from the supplier cease to apply if the customer himself attempts any work in the product during the guarantee period in order to rectify any faults.*

The Transtig requires little maintenance. In normal cases, it is sufficient to blow it clean using dry compressed air once a year, but this should be done more often if it is set up in a dusty, dirty area.

## **10 FAULT TRACING**

*Try these recommended checks and inspections before sending for an authorised service technician.*

<b>Type of fault</b>	<b>Action</b>
No arc.	<ul style="list-style-type: none"> <li>• Check that the mains power supply switch is turned on.</li> <li>• Check that the welding current supply and return cables are correctly connected.</li> <li>• Check that the correct current value is set.</li> </ul>
The welding current is interrupted during welding.	<ul style="list-style-type: none"> <li>• Check whether the thermal overload trips have operated (indicated by the yellow lamp on the front panel).</li> <li>• Check the main power supply fuses.</li> </ul>
The thermal overload trip operates frequently.	<ul style="list-style-type: none"> <li>• Make sure that you are not exceeding the rated data for the welding power source (i.e. that the unit is not being overloaded).</li> <li>• Check that the dust filter is clean.</li> </ul>
Poor welding performance.	<ul style="list-style-type: none"> <li>• Check that the welding current supply and return cables are correctly connected.</li> <li>• Check that the correct current value is set.</li> <li>• Check that the correct electrodes are being used.</li> <li>• Check the main power supply fuses.</li> </ul>

## 10.1 Fault codes

The Transtig comes with built-in fault monitoring. If a fault occurs, a code is shown in the display.

If any of these fault codes is displayed permanently or recurs often, the machine should be sent to an authorised ESAB service workshop for repair.

Fault	Description	Resetting	Action
E1	Internal RAM fault		Restart the machine. If the fault persists, contact a service workshop
E2	External RAM fault		Restart the machine. If the fault persists, contact a service workshop
E3	EPROM fault		Restart the machine. If the fault persists, contact a service workshop
E4	Fault in RAM with battery backup		Restart the machine. If the fault persists, contact a service workshop
E5	Memory error, variable value outside limits		Restart the machine. If the fault persists, contact a service workshop
E6	Low battery voltage	Reset by pressing a button	If the fault persists, contact a service workshop
E10	+ 20V fault (18.5 – 21.5 V)	Automatic reset once fault has disappeared	
E11	-15V fault (-13.0 - -16.0)	Automatic reset once fault has disappeared	
E13	High temperature	Automatic reset once fault has disappeared	
E14	Current servo fault	Automatic reset once fault has disappeared Also reset by pressing a button	
E99	Bridging fault	The digital control card is bridged in a non-defined combination.	Restart the machine. If the fault persists, contact a service workshop

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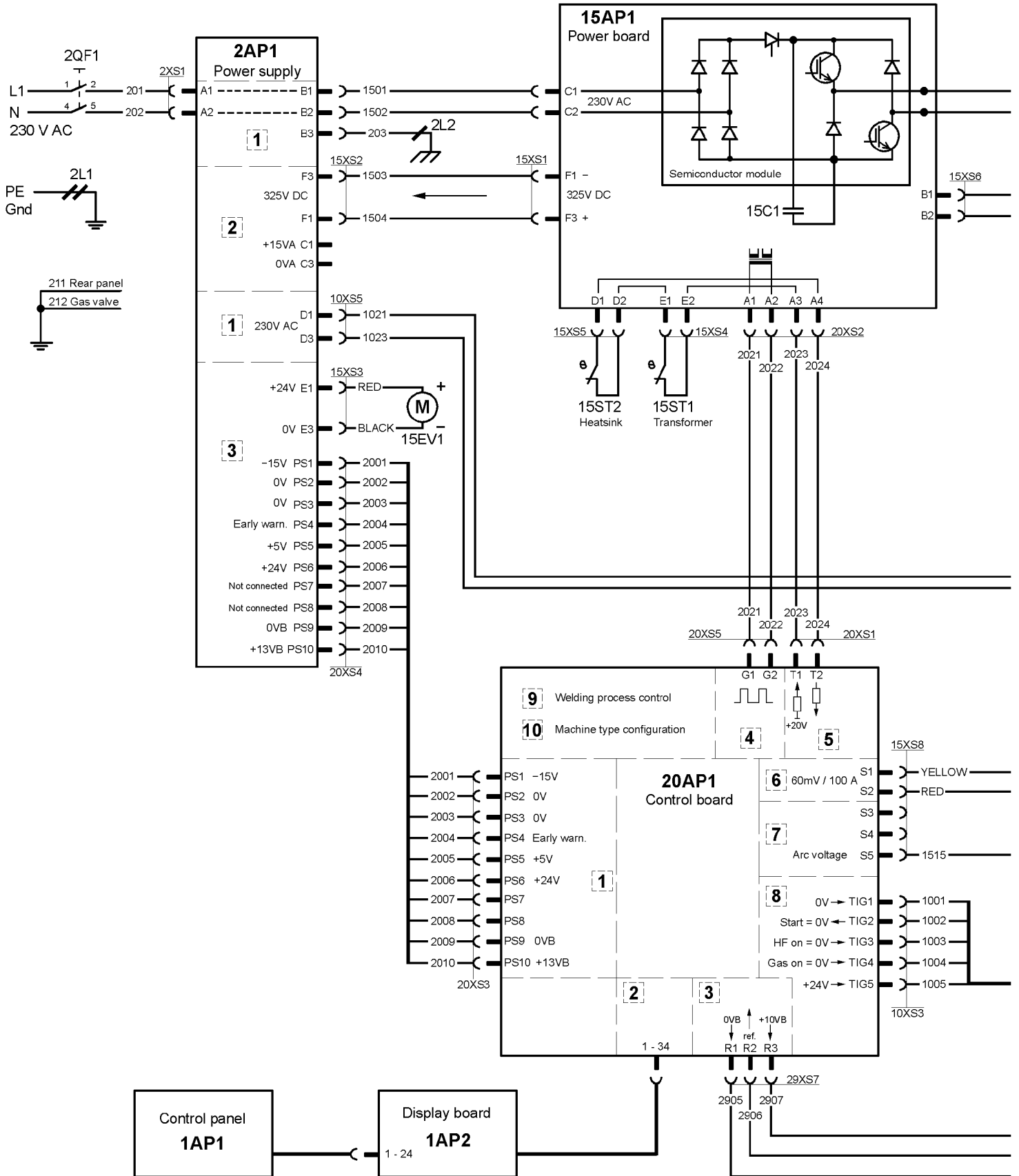
## 11 ORDERING SPARE PARTS

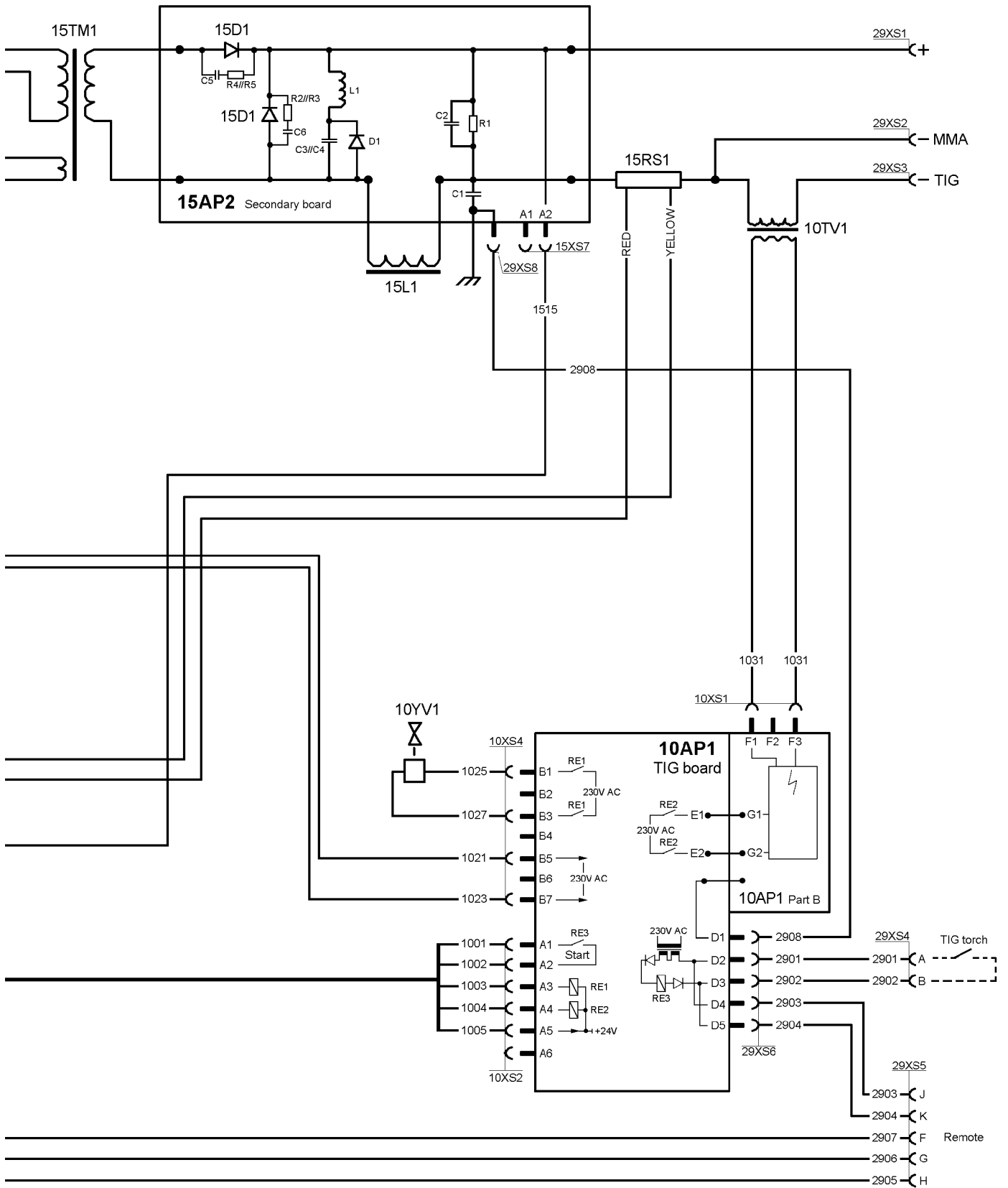
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*Repair and electrical work should be performed by an authorized serviceman.  
Use only original spare and wear parts.*

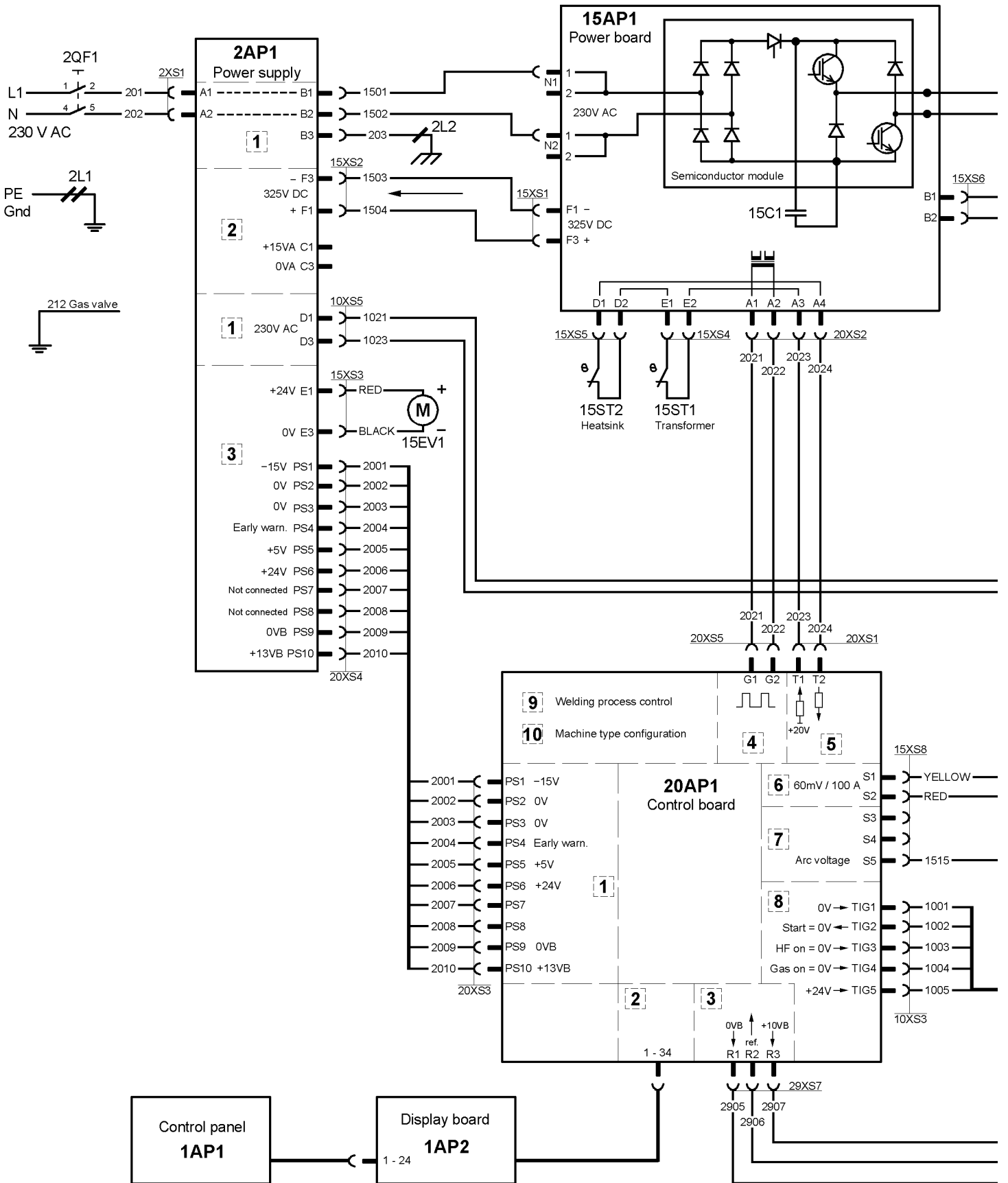
**Transtig 150-1 and Transtig 200-1 are designed and tested in accordance with the international and European standards EN 60974-1/-3 and EN 50199. It is the obligation of the service unit which has carried out the service or repair work to make sure that the product still conforms to the said standard.**

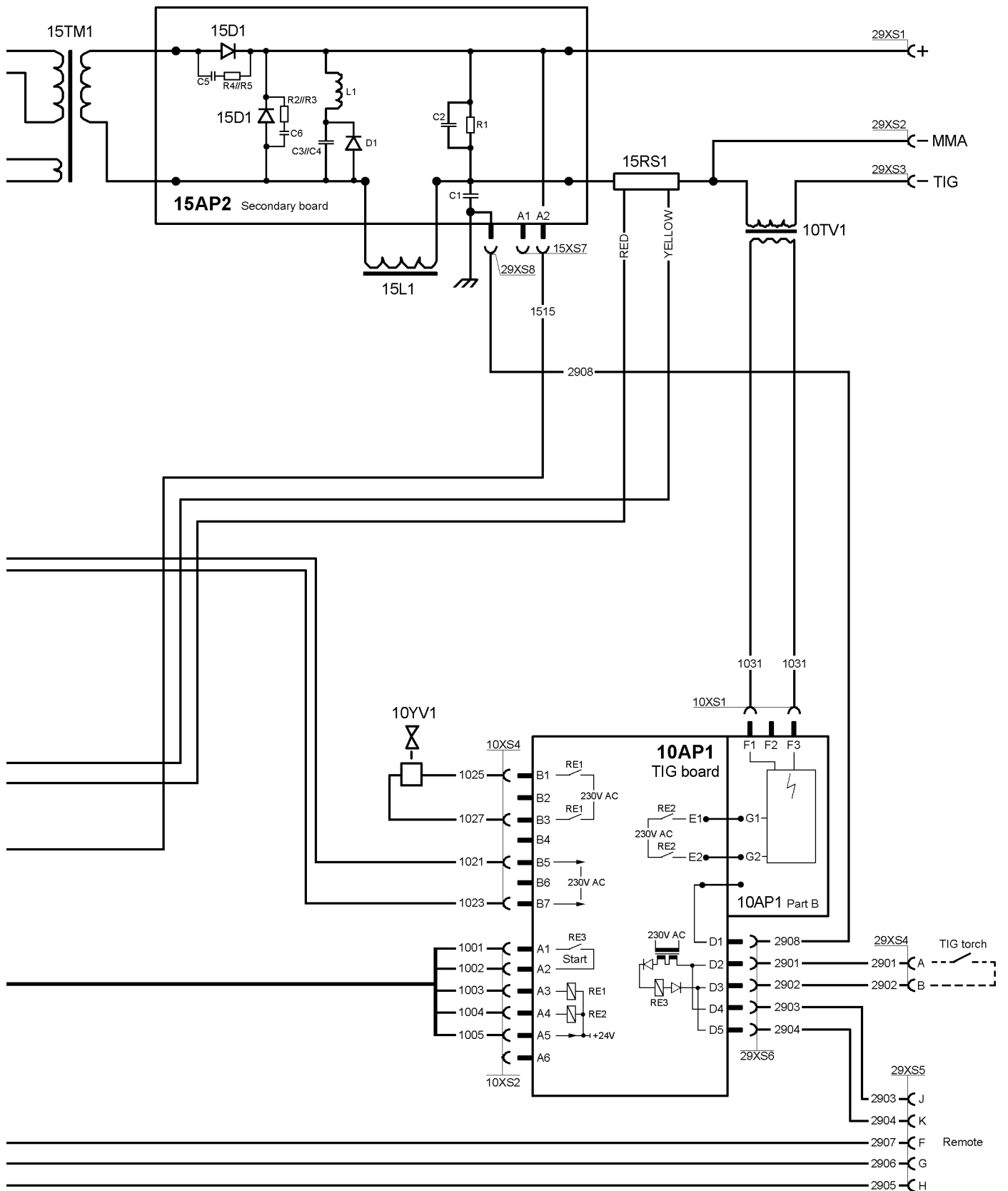
# Diagram



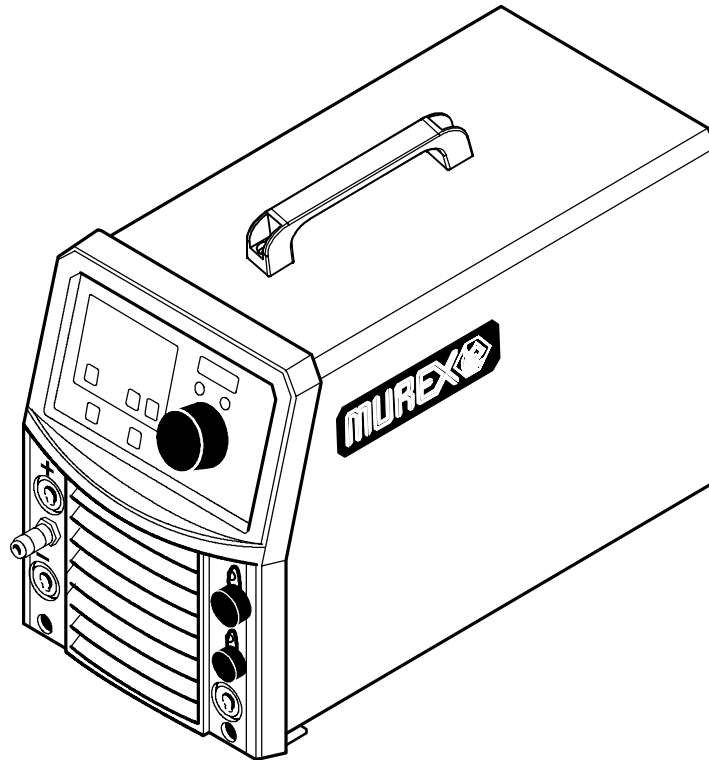


# Diagram





**Spare parts list**



**Valid for serial no. 517-xxx-xxxx**

**Ordering number**

0459 760 893 Transtig 150-1 for 230 V mains voltage

0459 760 894 Transtig 200-1 for 230 V mains voltage

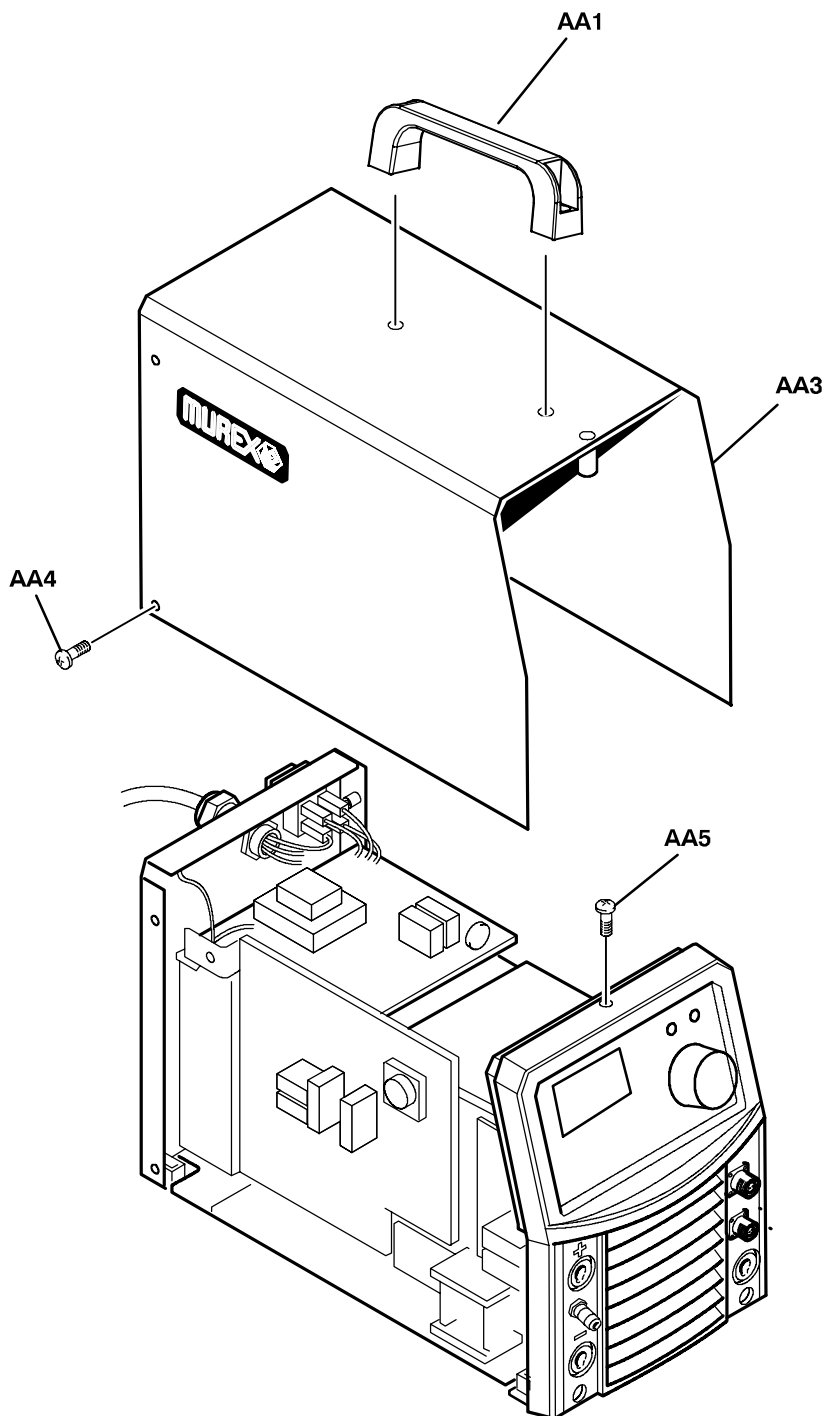
Spare parts are to be ordered through the nearest MUREX agency. Kindly indicate type of unit, serial number, denominations and ordering numbers according to the spare parts list.

Maintenance and repair work should be performed by an experienced person, and electrical work only by a trained electrician. Use only recommended spare parts.

# Transtig 150-1, Transtig 200-1

C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
AA1	1	0459 654 001	Handle		
AA2	2		Screw	M8x50	
AA3	1	0459 173 002	Cover		
AA4	4		Screw	M5x12	
AA5	1		Screw	M5x16 Included in item AB51, see page 24.	



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## Transtig 150-1, Transtig 200-1

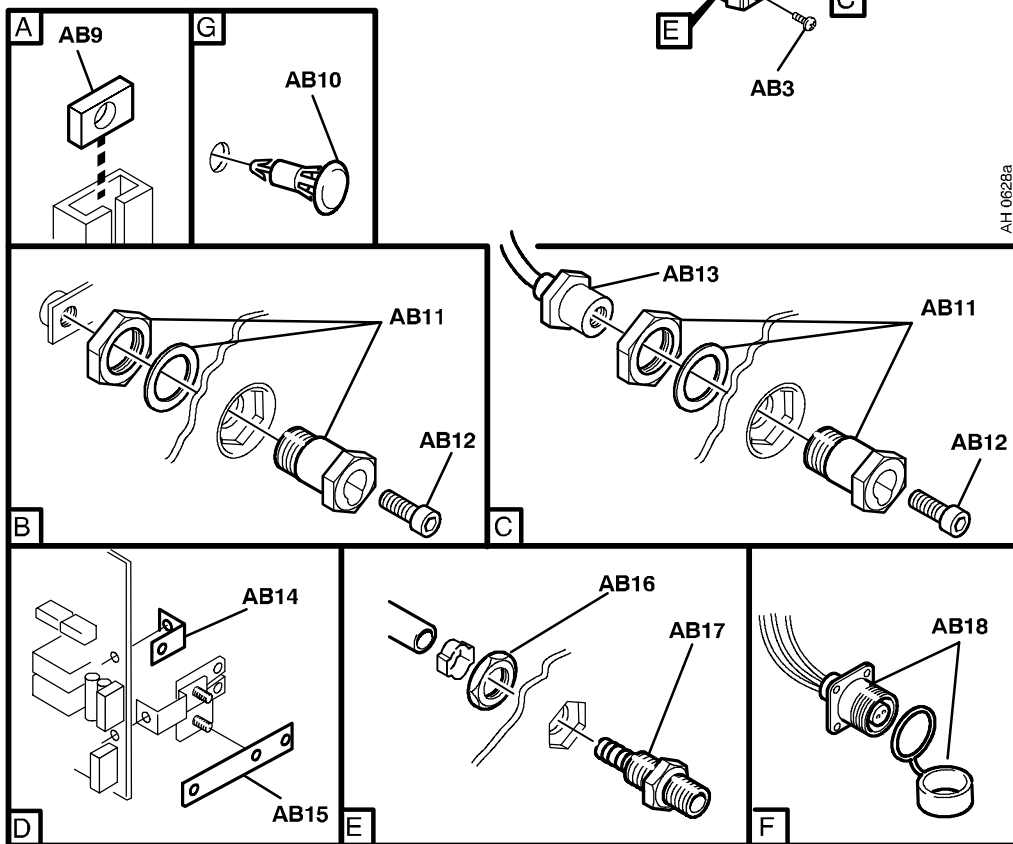
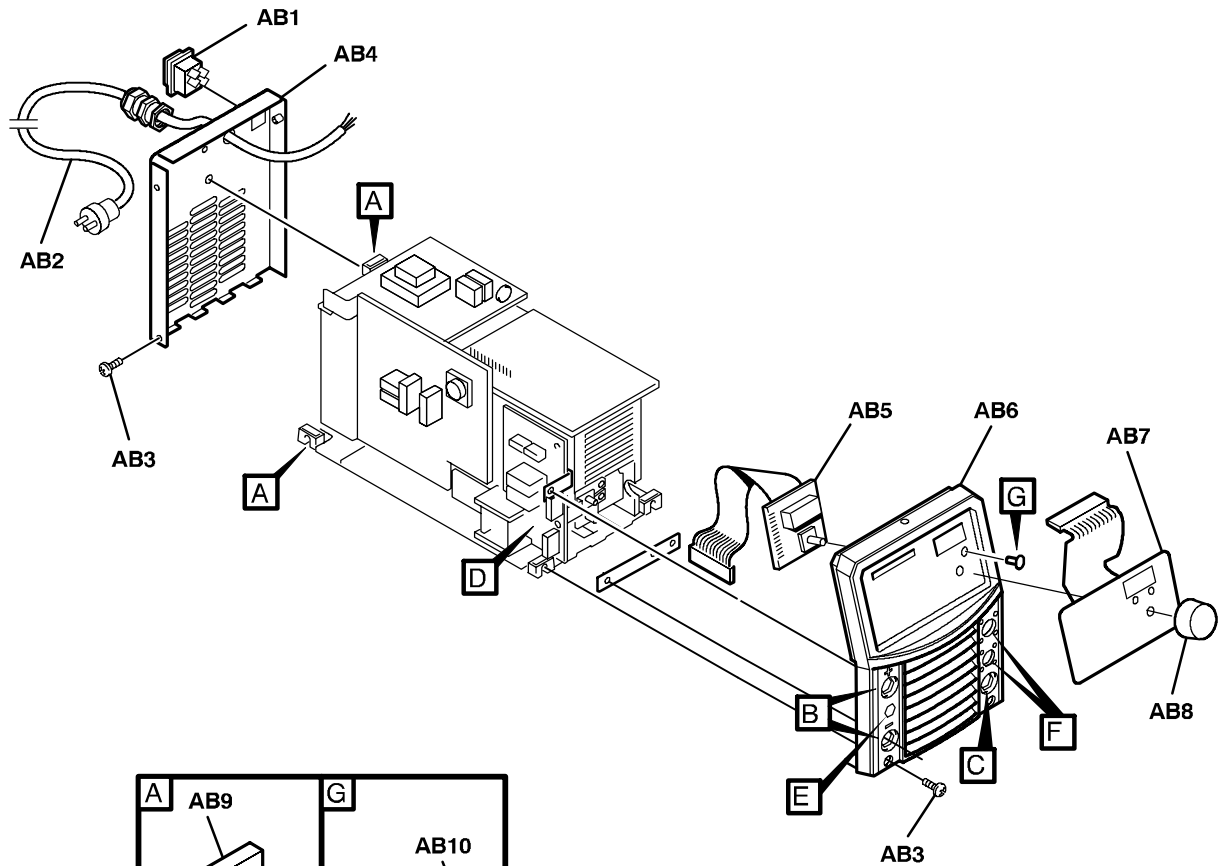
C = component designation in the circuit diagram

Item	Qty	Ordering no.	Denomination	Notes	C
AB1	1	0193 317 001	Switch	Included in item AB50	2QF1
AB2	1		Cord set	Included in item AB50	
AB3			Screw	Included in item AB51 and AB53	
AB4	1	0459 174 001	Rear panel		1AP2
AB5	1	0487 018 880	Display board	Included in item AB51	
AB6	1		Front panel	Included in item AB51 and AB53	1AP1
AB7	1		Control Panel	Included in item AB51	
AB8	1	0321 475 893	Knob	Included in item AB51	
AB9	5	0366 588 001	Nut		
AB10			Spacer	Included in item AB51	
AB11	3	0366 306 883	Connector OKC 25	Included in item AB51	29XS1, 29XS2, 29XS3
AB12	3		Screw	M5x12 Torx. Included in item AB51	
AB13	1		Cable shoe	Included in item AD4, see page 28	
AB14	1	0459 194 003	Busbar, positive		
AB15	1	0459 194 002	Busbar, negative		
AB16	1	0194 130 120	Nut	Included in item AB51	
AB17	1	0459 269 001	Gas connection	Included in item AB51	
AB18	1		Socket	Included in item AB52	29XS4, 29xS5

### SPARE PARTS SETS

Item	Ordering no.	Denomination	Notes
AB50	0459 183 880	Mains module	Includes items: AB1 switch, AB2 mains cable with plug, cable clamp and two ferrite rings 2L1.
AB51	0459 386 888	Front complete, TIG	Includes items: AA5, AB3, AB5, AB6, AB7, AB8, AB10, AB11, AB12, AB16, AB17, AB18
AB52	0459 280 885	Cable set	2 pole socket 29XS4, 5 pole socket 29XS6, 1 pole socket 29XS8 and the wires between them.

**Transtig 150-1, Transtig 200-1**



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## Transtig 150-1, Transtig 200-1

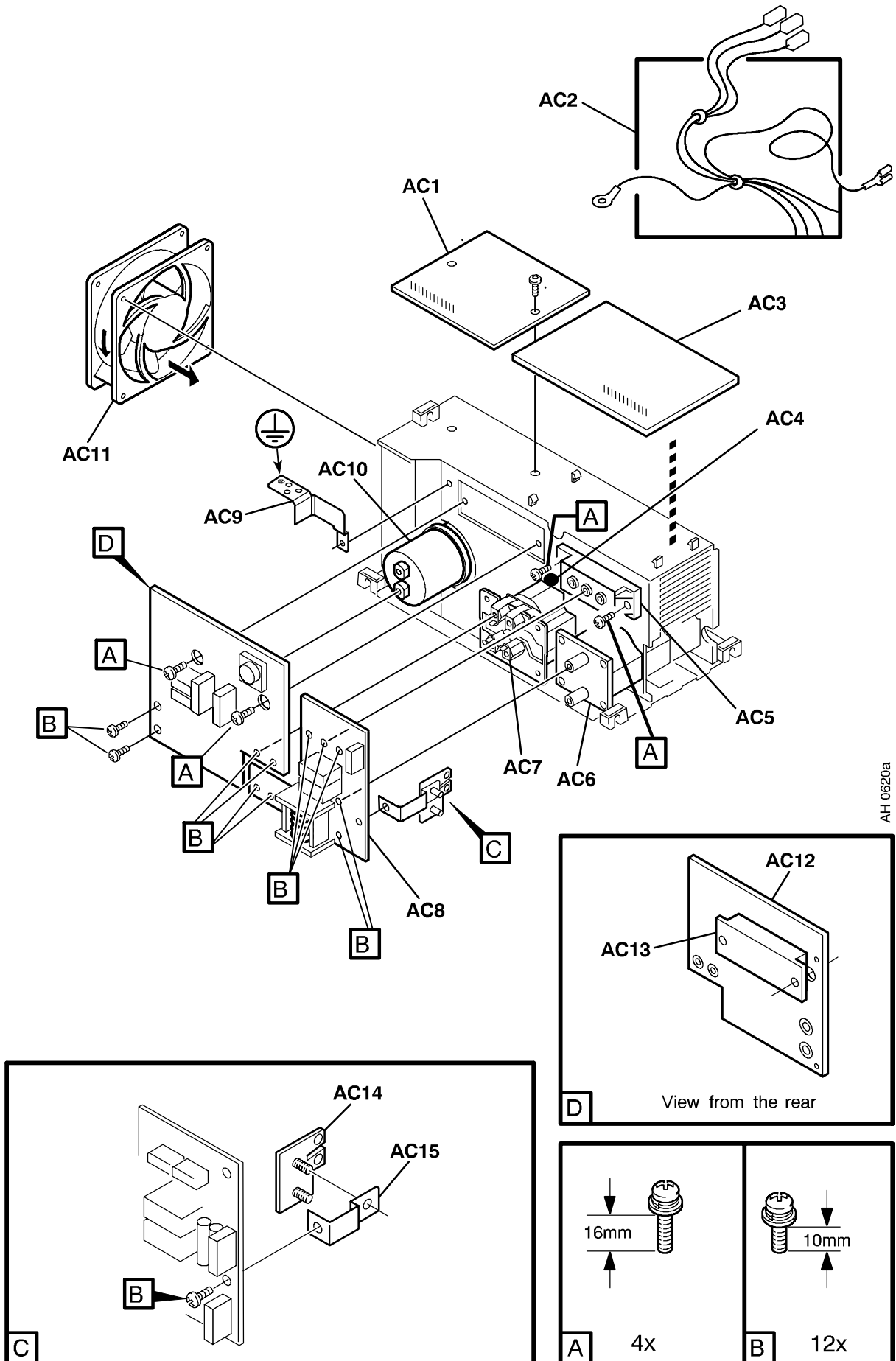
C = component designation in the circuit diagram

Item	Qty 150	Qty 200	Ordering no.	Denomination	Notes	C
AC1	1	1	0487 064 880	Power supply board		2AP1
AC2	1	1	0459 280 880	Cable set	Including wires 1501, 1502 and their sockets	15XS1, 15XS2, 15XS7, 15XS8
AC2	1	1	0459 280 880	Cable set	Including wires 1501, 1502 and their sockets	15XS1, 15XS2, 15XS7, 15XS8
	1	1	0193 700 702	Cable set		20XS3, 20XS4
	1	1	0459 280 881	Cable set		20XS1, 20XS2, 20XS5
AC3	1	1	0459 390 880	Control board kit	Before mounting the board, the strapping must be set up to fit CaddyTig 150 or CaddyTig 200. See the service manual.	20AP1
AC3	1	1	0459 390 880	Control board kit	Before mounting the board, the strapping must be set up to fit OrigoTig 150 or OrigoTig 200. See the service manual.	20AP1
AC4	1		0468 940 004	Thermal switch	Socket connector 15XS5 included	15ST2
		1	0468 940 005	Thermal switch	Socket connector 15XS5 included	15ST2
AC5	1	1		Diode module	See item AC50	15D1
AC6	1	1	0459 177 001	Inductor		15L1
AC7	1	1	0459 355 880	Transformer	Includes: main transformer, socket 15XS4, socket 15XS6, thermal switch 15ST1	15TM1
AC8			0487 060 880	Secondary board		15AP2
AC9	1	1	0459 273 001	Earth bracket		
AC10	1		0194 158 001	Capacitor	1000 uF 400 V DC	15C1
		1	0194 158 002	Capacitor	2000 uF 400 V DC	15C1
AC11	1		0467 801 002	Fan	24 V DC; With cables and socket 15XS3	15EV1
AC11		1	0458 065 002	Fan	24 V DC; With cables and socket 15XS3	15EV1
AC12	1	1		Circuit board	See item AC51	15AP1
AC13	1	1		Semiconductor module	See item AC51	
AC14	1	1	0468 030 880	Shunt		15RS1
AC15	1	1	0459 194 001	Busbar		

### SPARE PARTS SETS

Item	Qty 150	Qty 200	Ordering no.	Denomination	Notes
AC50	1		0459 385 880	Diode module kit	Includes: item AC5 diode module, screws (type A and B), thermal compound and roller.
		1	0459 385 881	Diode module kit	Includes: item AC5 diode module, screws (type A and B), thermal compound and roller.
AC51	1		0459 384 880	Power board kit	Includes: item AC12 power board, item AC13 semiconductor module, screws (type A and B), thermal compound and roller.
		1	0459 384 881	Power board kit	Includes: item AC12 power board, item AC13 semiconductor module, screws (type A and B), thermal compound and roller.
-			0458 910 002	Roller handle	For the roller in the spare parts sets above
-			0192 058 101	Thermal compound	

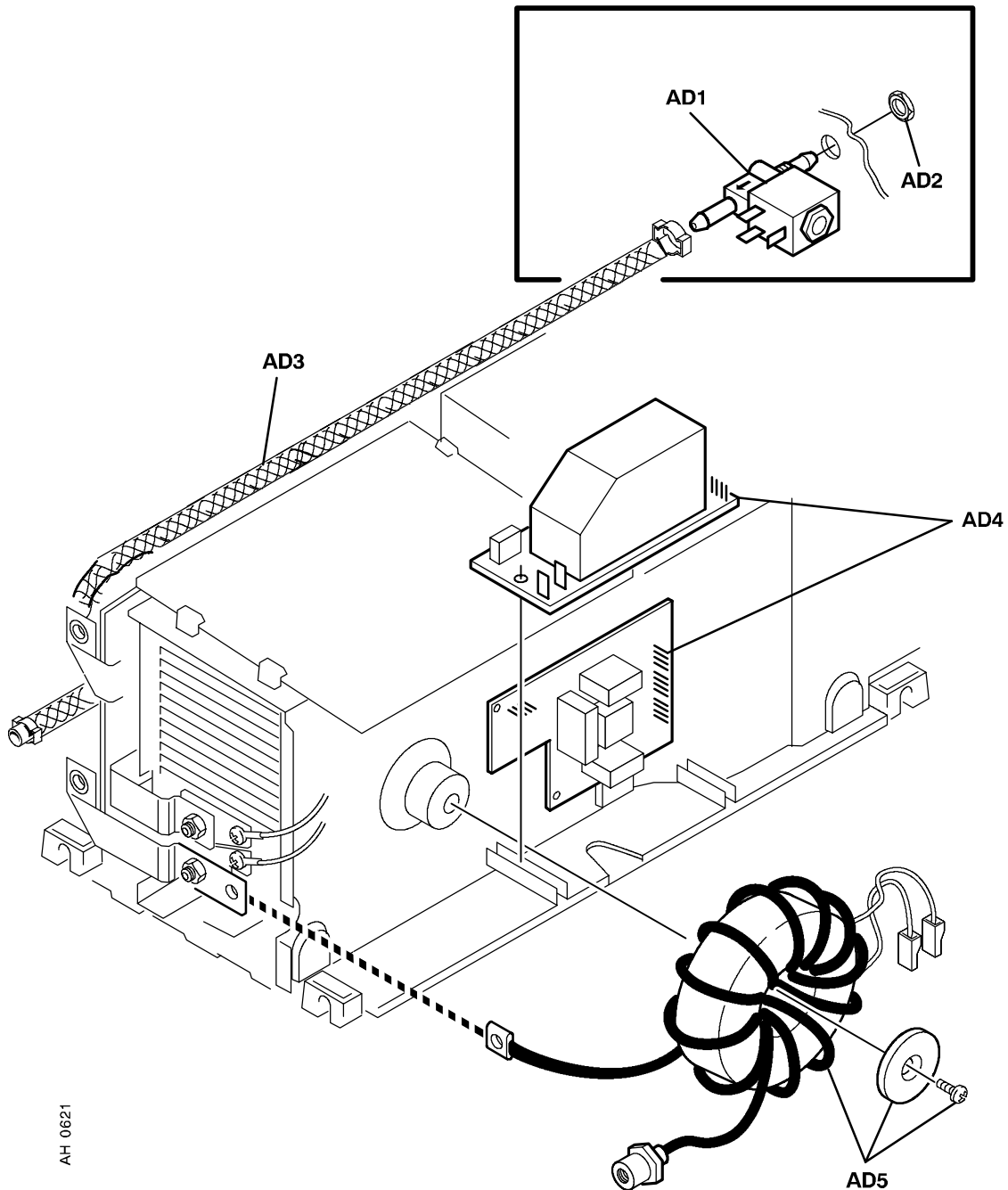
**Transtig 150-1, Transtig 200-1**



# Transtig 150-1, Transtig 200-1

C = component designation in the circuit diagram

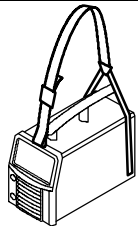
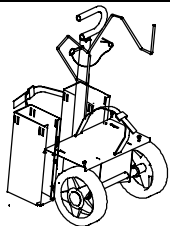
Item	Qty	Ordering no.	Denomination	Notes	C
AD1	1	0193 054 005	Solenoid valve	230 V AC	10YV1
AD2	1	0194 130 120	Nut		
AD3	1	0456 496 001	Hose	D = 9/5 mm, L = 0.57 metre reinforced PVC	
AD4	1	0487 028 880	Circuit board TIG		10AP1
AD5	1	0459 389 880	HF coil, complete		10TV1, 10XS1



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# Transtig 150-1, Transtig 200-1

## Accessories

	<p><b>MMA welding and return cable kit</b> ("crocodile" type holder) ..... 0349 501 078</p> <p><i>Suitable for Transtig 150-1</i></p>
	<p><b>MMA welding and return cable kit</b> ("screwe" type holder) ..... 0349 501 079</p> <p><i>Suitable for Transtig 150-1</i></p>
	<p><b>MMA welding and return cable kit</b> ("screwe" type holder) ..... 0700 006 881</p> <p><i>Suitable for Transtig 200-1</i></p>
	<p><b>Shoulder strap</b> ..... 0459 368 880</p>
	<p><b>Trolley for small gas bottle</b> ..... 0459 366 880</p>







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