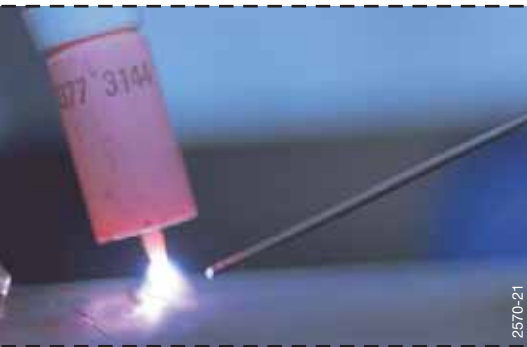


# ***CITOTIG II DC*** ***Industrial range***

The best of TIG welding using inverter technology for the most demanding welders.



# CITOTIG II DC Industrial range



Single or three-phase portable inverters for MMA and TIG DC high quality work on non-alloyed or stainless steels.

## CITOTIG II 200 DC, 300 DC (W), 400 DC (W)

Reduced weight and size, high-resistance steel cabinet, maximum safety with the built-in VRD (Voltage Reduction Device), unit transportable using dedicated carriages for work in severe conditions. Possibility to connect to a remote control or foot-operated pedal and separate gas to torch connection, protection against dust and spatter, the user friendliness is increased due to the controls grouped on the front panel.

### Product advantages:

- Multi-process unit: TIG DC, MMA (all stick electrode)
- Continuous, spot, pulsed welding
- Complete welding cycle 2 current levels with CITOSTEP function)
- HF or "contact" arc striking
- Synergic pulsed system
- Automatic hot start for easier arc striking according to type of coated electrode used
- Adjustable arc dynamics to optimize electrode melting according to electrode type (rutile, basic or cellulosic)
- Modular: air or water cooled
- VRD available

- HF arc striking
- 2T / 4T
- Adjustable pre and post-gas
- Adjustable arc dynamics

**CELLULOSIC**



**VRD**



## Technical characteristics

	CITOTIG II 200 DC	CITOTIG II 300 DC (W)	CITOTIG II 400 DC (W)
Primary power supply,	230 V single-phase (+/-10%)	400 V three-phase (+20% / -15%)	
Absorbing power at maxi. intensity	6.5 kVA	8.4 kVA	13.8 kVA
Open circuit voltage	80 V	80 V	80 V
Duty cycle at 40 °C	at 35%	200 A	300 A
	at 60%	150 A	230 A
	at 100%	130 A	200 A
Welding current	5 to 200 A	5 to 300 A	5 to 400 A
Electrode diameter max.	4.0 mm	5.0 mm	6.0 mm
Dimensions (l x w x h)	Power source	410 x 180 x 390 mm	500 x 180 x 390 mm
	Power source + Cooling unit	-	500 x 180 x 650 mm
Weight	Power source	15 kg	22 kg
	Power source + Cooling unit	-	33 kg
			23 kg
Standards	EN 60974-1 ; EN 60974-10		

This equipment are designed for industrial and professional use only

		To order	
Power source		W000279732	W000279733
			W000279734
		Option and accessories	
COOLERTIG II DC		W000279722	
Trolley T3		W000277087	
Manual remote control	5 m	W000263311 (RC1)	
	10 m	W000270324 (RC1)	
Foot-operated remote control		W000263313 (FP1)	

# CITOTIG II DC Industrial range

## Ultimate performance in all conditions



3551-009

Designed to meet the expectations of the most demanding welders, **CITOTIG II DC** welding units were developed in detailed correlation with on-going changes in requirements. They provide optimum performance associated with the ruggedness necessary for daily work both in the workshop and on site. They all have a complete welding cycle including 2 current levels with the CITOSTEP function.



2011-101



2011-105



2011-105

### CITOTIG II DC

- High quality welding results on carbon and stainless steels.
- For high demanding sectors of activity.



2001-316



2010-835



Petrochemicals



2001-317



2008-760

Offshore



Shipbuilding



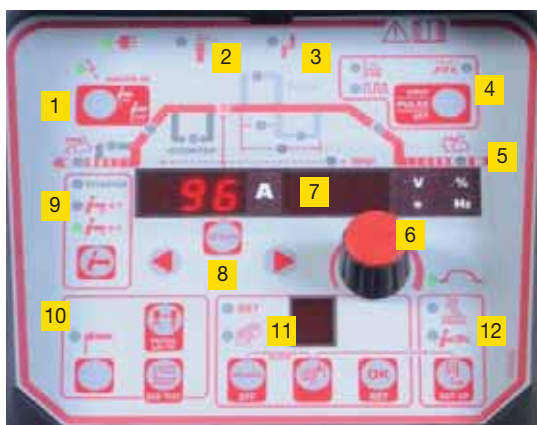
2010-810

Piping



With the CITOSTEP function, two current levels can be chosen, the welding current and the basic current. This facilitates the change from one to the other by rapidly pressing the torch trigger. The CITOSTEP function can be used to adjust heat input momentarily, to change welding positions or to replenish the filler metal supply without having to stop welding.

### CITOTIG II front panel



- 1 Power on indicator
- 2 Thermal safety indicator
- 3 Supply voltage defect indicator
- 4 Pulsed TIG / Synergic pulsed TIG / Spot TIG selection
- 5 Post-gas adjustment
- 6 Welding parameters adjustment
- 7 Display
- 8 Welding parameter selection keys
- 9 2T / 4T / CITOSTEP selection
- 10 MMA welding selection
- 11 Memorization parameters selection
- 12 Local/remote control selection

### Pulsed TIG and “synergic” pulsed TIG

Because all pulse parameters can be adjusted, the pulsed TIG process allows better control of the weld pool. The synergic pulsed system is an additional mode proposed to make adjustment of the unit easier. With the synergic pulsed system, there is no need to adjust the welding current or other pulse parameters that may have been pre-programmed. The pulse frequency gives a high, concentrated arc and increases welding speed.



### Options and accessories for CITOTIG II DC

#### Remote control



	To order	
RC1 for direct current range	5 m	W000263311
	10 m	W000270324

#### Foot-operated control pedal



	To order	
FP1 for direct current range	5 m	W000263313



#### Trolley T3

A trolley for easy transport of:

- CITOTIG II
- COOLERTIG II cooling unit
- Gas cylinder (size B20 max.)
- Torches and accessories that can be carefully stored or rolled

	To order
Trolley T3	W000277087

# TIG torches



The new range of CITORCH T NG TIG torches perfectly fit with the high level of quality provided by the CITOTIG DC professional range.

The adapted models are CITORCH T 20, 40, 10W or 35W (air or water cooled torches). They come:

- either with trigger as a blade: RL models
- or as a button: EB types.

The EB types are modular as they can be modified with the different type of buttons.

See complete range in the CITORCH T NG brochure



RL: Blade

	CITORCH T NG 20 RL C5B	CITORCH T NG 40 RL C5B	CITORCH T NG 10W RL C5B	CITORCH T NG 35W RL C5B
Cooling	Air		Water	
Duty Cycle	150 A at 35% 100 A at 60%	250 A at 35% 200 A at 60%	250 A at 100%	350 A at 100%
To order	5 m: W000278986 8 m: W000278987	5 m: W000278890 8 m: W000278991	5 m: W000278992 8 m: W000278993	5 m: W000278994 8 m: W000278995
Cat. number maintenance box	W000306442	W000306444	W000306441	W000306444



EB: Button

	CITORCH T NG 20 EB C5B	CITORCH T NG 40 EB C5B	CITORCH T NG 10W EB C5B	CITORCH T NG 35W EB C5B
Cooling	Air		Water	
Duty Cycle	150 A at 35% 100 A at 60%	250 A at 35% 200 A at 60%	250 A at 100%	350 A at 100%
To order	5 m: W000278382 8 m: W000278383	5 m: W000278386 8 m: W000278387	5 m: W000278388 8 m: W000278389	5 m: W000278390 8 m: W000278391
Cat. number maintenance box	W000306442	W000306444	W000306441	W000306444

## Modular system:

All torches are delivered with a single button module. If you want another control module, order it separately.



- 1 Horizontal potmeter - W000279370
- 2 Vertical potmeter - W000279246
- 3 Double button - W000279242
- 4 Blade - W000279245

For potmeter adapt the wiring to the welding machine using the 7 pins plug - W000271826

## In option: Adjustable heads

As an option, adjustable torch bodies are available. Welding in inaccessible locations becomes easier. You have the choice of 2 heads, small and large to be mounted on air cooled or water cooled bodies.



Choose one body and one head to get a complete torch.

Air cooled body - W000279381

Water cooled body - W000279382

Head CITORCH T NG 10 - W000279383

Head CITORCH T NG 20-30 - W000279384



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