

CITOTIG 240 & 310 AC/DC

TIG AC/DC machine for highly demanding welding specialists



CITOTIG AC/DC

CITOTIG AC/DC machines are designed to meet the expectations of the most demanding welders. Optimum performance is associated with the ruggedness necessary for daily work both in the workshop and on site.



CITOTIG AC/DC

- High quality welding results on carbon and stainless steels and light alloys.



- For high demanding sectors of activity.

Boiler making



Offshore



Petrochemicals



Shipbuilding



Piping



CITOTIG AC/DC



Improving your AC quality and productivity is our target. CITOTIG AC/DC machines are the most advanced equipment available on the market for the applications.

The technical characteristics that make the difference.

- CITOTIG AC/DC are designed for manual TIG welding of all metals, including aluminium and stainless steel. They can also be easily used for MMA welding.
- You can choose single- or 3-phase primary alimentation in 2 intensity range
 - CITOTIG 240 AC/DC is a 230 A @ 40% in a single phase power source, for joining aluminium up to 5 mm thick,
 - CITOTIG 310 AC/DC is a 300 A @ 40% in a three phase power source.
- All the characteristics that TIG welding need. CITOTIG AC/DC permits TIG welding with any type of current: AC, DC+, and DC-.

Additional features for improved results:

TACK FOR THIN device

Is a dedicated process for welding thin sheet. Developed with a strict focus on assembly and welding thin sheet.



The difference in the tack welds is clearly visible. TACK FOR THIN was used to weld the piece on the bottom, and regular TIG was used on the piece on the top.

COMPOTIG

Sturdy and robust process that uses simultaneously AC and DC. The composition of the two different processes can be regulated to obtain complete penetration and effective cleaning. More AC for better cleaning and more DC for better penetration.



The COMPOTIG function combines the beneficial qualities of both direct and alternating current. It simplifies joining aluminium alloys and decreases the number of defects.

Pulsed TIG and "synergic" pulsed TIG

The pulsed TIG process, due to the possibility of regulation of all parameters, allows improved control of the weld pool. In order to simplify the regulation, there is an additional process, synergic pulsed TIG. With the synergic pulsed system, there is no need to adjust the welding current or other pulse parameters that are pre-programmed.

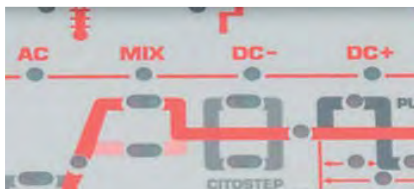
The pulse frequency gives a highly concentrated arc and increases welding speed.



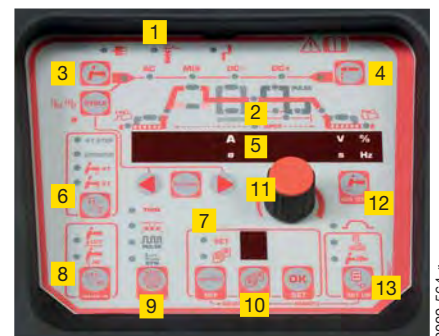
CITOSTEP

With the CITOSTEP function, two current levels can be chosen, the welding current and the base 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.



An easy to use front panel



- 1 Safety and operation indicators
- 2 Welding cycle layout
- 3 TIG operation selection
- 4 MMA operation selection
- 5 Parameter value display
- 6 Torch cycle selection
- 7 Parameter selection
- 8 Striking selection HF/ Lift
- 9 Pulse / Spot selection
- 10 Program management
- 11 Main regulation knob
- 12 Gas test
- 13 Remote control operations



2003-201

Comply with the EN 61000-3-2/12 standard effective since december 2010, that limits the harmonic currents produced by equipment connected to public low-voltage systems



2009-562



2010-636

	CITOTIG 240 AC/DC	CITOTIG 310 AC/DC
PRIMARY		
Power supply	1 Ph - 50/60 Hz 230 V (+/-15%)	3 Ph - 50/60 Hz 400 V (+/-10%)
Maximum primary consumption (100%)	3.9 kVA	7.9 kVA
Fuses	16 A	
SECONDARY		
Open circuit voltage	58 V	63 V
Welding range TIG	3 A - 230 A / 19.2 V	3 A - 300 A / 22 V
Welding range MMA	10 A - 180 A / 27.2 V	10 A - 250 A / 30 V
Duty cycle	40%	230 A
	60%	200 A
	100%	180 A
APPLICATION		
Processes TIG	DC - AC - Mix AC/DC - Pulsed	
Processes MMA	AC - DC- - DC+	
Additional Feature	BI LEVEL CURRENT - TACK FOR THIN - COMPOTIG	
Programs	10	
GENERAL		
Standard	EN 60974-1	✓
	EN 60974-10	✓
	EN 61000-3-2/12	✓
Protection index	IP 23C	
Dimensions (l x w x h)	475 x 200 x 405 mm	505 x 195 x 440 mm
Weight	17 kg	25 kg

These equipment are designed for industrial and professional use only. The CITOTIG 310 AC/DC does not comply with EN 61000-3-2/12. If it is connected to a public low voltage system, it is the responsibility of the installer or user of the equipment to ensure, by consultation with the distribution network operator if necessary, that the equipment may be connected. (See also the instruction manual)

Options and accessories

Remote control



2006-649

RC1
5 m or 10 m long

Foot-operated control pedal



2006-651

FP1
5 m long



2006-731

Trolley

T3

Cooler



2010-631

	COOLERTIG II	COOLERTIG III
PRIMARY		
Power supply	230 V (+/- 15%)	24 V DC
Cooling unit power	1.0 kW	
Maximum pressure	4 bar	
GENERAL		
Dimensions (l x w x h)	475 x 200 x 405 mm	525 x 198 x 295 mm
Weight	9 kg	8 kg

To order		
Power source	CITOTIG 240 AC/DC W000275842	CITOTIG 310 AC/DC W000278470
Cooler	COOLERTIG II W000275844	COOLERTIG III W000278471
Trolley	TROLLEY T3 W000277087	TROLLEY T3 W000277087
Remote control	RC1 - 5 m long W000263311	RC1 - 5 m long W000263311
	RC1 - 10 m long W000270324	RC1 - 10 m long W000270324
Foot pedal	FP1 W000263313	FP1 W000263313

TIG torches



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

The adapted models are CITORCH T 30 for the air cooled torches and the CITORCH T 10 W for the water cooled models.

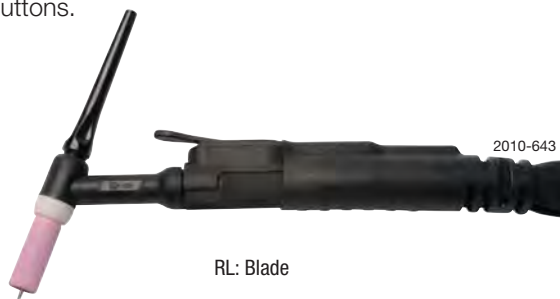
They come either with trigger as a blade: RL models or as a button: EB types.

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.



	CITORCH T NG 30 RL C5B		CITORCH T NG 10 W RL C5B		CITORCH T NG 30 EB C5B		CITORCH T NG 10 W EB C5B	
Cooling	Air		Water		Air		Water	
Duty Cycle	200 A @ 35%		250 A @ 100%		200 A @ 35%		250 A @ 100%	
To order	5 m	8 m	5 m	8 m	5 m	8 m	5 m	8 m
	W000278988	W000278989	W000278992	W000278993	W000278384	W000278385	W000278388	W000278389
Cat. number maintenance box	W000306443		W000306441		W000306443		W000306441	



RL: Blade



EB: Button

Modular system:

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

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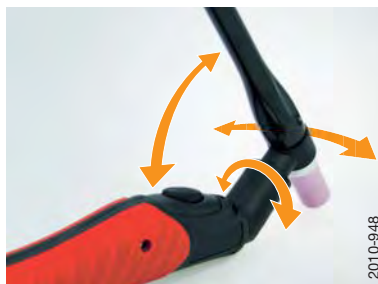


- 1 Horizontal potmeter - W000279370
- 2 Vertical potmeter - W000279246
- 3 Double button - W000279242
- 4 Blade - W000279245

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.



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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