

# CITOTIG 240 AC/DC

The only TIG AC/DC machine for demanding TIG welding specialists that offers high performance and reliability in a portable single phase welding unit



# CITOTIG 240 AC/DC



0285-27

**CITOTIG AC/DC** is 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. The complete welding cycle includes 2 current levels with the CITOSTEP function.

## Power

More power: 230A in a single phase AC/DC power source, for joining aluminium up to 5 mm thick.

## Performance

Very good arc stability.

## TACK FOR THIN device

Is a dedicated tack process for fabricating 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.



2004-294

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

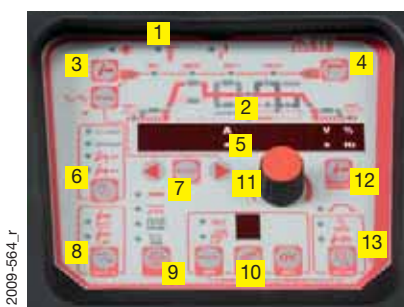


**High Performance in TIG welding**



2000-499

2009-567



2009-564\_I

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



### 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.



### 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.



2003-201



2008-759



2003-202x

Designed for demanding aluminium welding applications, fully portable for on-site, offshore and repair applications using TIG and MMA welding.

CITOTIG 240 ACDC	
<b>PRIMARY</b>	
Power supply – 1 Ph - 50/60 Hz	230 V ( +/-15%)
Maximum primary consumption (100%)	3.9 kVA
Fuses	16 A
Power factor	0.99
<b>SECONDARY</b>	
Open circuit voltage	58 V
Welding range TIG	3 A - 230 A / 19.2 V
Welding range MMA	10 A - 180 A / 27.2 V
Duty cycle 40%	230 A
Duty cycle 60%	200 A
Duty cycle 100%	180 A
<b>APPLICATION</b>	
Processes TIG	DC - AC - Mix AC/DC - Pulsed
Processes MMA	AC - DC - DC+
Additional Feature	CITOSTEP - TACK FOR THIN - COMPOTIG
Programs	10
<b>GENERAL</b>	
Standard	EN 60974-1 - EN 60974-10
Protection index	IP 23C
Dimensions (l x w x h)	475 x 200 x 405 mm
Weight	17 kg

COOLERTIG II	
<b>PRIMARY</b>	
Power supply - 1 Ph - 50/60 Hz	230 V (+/- 15%)
Cooling unit power	1.0 kW
Maximum pressure	4 bar
<b>GENERAL</b>	
Dimensions (l x w x h)	525 x 198 x 295 mm
Weight	9 kg

## Options and accessories

### Remote control



2006-649

RC1  
5 m or 10 m long

### Foot-operated control pedal



2006-651

FP1  
5 m long

### Trolley



2006-731

T3

### Cooler



2009-568

To order		
Power source	<b>CITOTIG 240 AC/DC</b>	<b>W 000 275 842</b>
Cooler	COOLERTIG 2	W 000 275 844
Trolley	TROLLEY T3	W 000 277 087
Remote control	RC1 - 5 m long	W 000 263 311
	RC1 - 10 m long	W 000 270 324
Foot pedal	FP1	W 000 263 313



2001-317



2001-316



2004-298



## Contacts

### BELGIUM

AIR LIQUIDE WELDING BELGIUM SA  
Z.I. West Grijpen - Grijpenlaan 5 - 3300 TIENEN  
Tel.: +32 16 80 48 20 - Fax: +32 16 78 29 22

### CHINA

SAF SHANGHAI REP.OFF.  
Rm 722 Pine City Hotel  
777 Zhao Jia Bang Lu - SHANGHAI 200032  
Tel.: +86 21 64 43 89 69 - Fax: +86 21 64 43 58 97

### CZECH REPUBLIC

AIR LIQUIDE CZ S.R.O. - Welding and Cutting  
Podnikatelská 565 - Areál SVUM - 190 11 PRAHA 9 - Búchovice  
Tel.: +420 274 023 163 - Fax: +420 274 023 233

### FRANCE

AIR LIQUIDE WELDING FRANCE  
13, rue d'Épluches - BP 70024 Saint-Ouen l'Aumône  
95315 CERGY PONTOISE Cedex  
Tel.: +33 1 34 21 33 33 - Fax: +33 1 34 21 31 30

### GERMANY

OERLIKON SCHWEISSTECHNIK GmbH  
Industriestrasse 12 - D-67304 EISENBERG/PFALZ  
Tel.: +49 6351 4760 - Fax: +49 6351 476 335

### HUNGARY

AIR LIQUIDE HUNGARY - Welding & Cutting  
Krisztina krt. 39/b - H-1013 BUDAPEST  
Tel.: +36 1 339 8650 - Fax: +36 1 339 8649

### ITALY

AIR LIQUIDE WELDING ITALY  
Via Torricelli 15/A - 37135 VERONA  
Tel.: +39 045 82 91 511 - Fax: +39 045 82 91 536

### LUXEMBOURG

AIR LIQUIDE WELDING LUXEMBOURG S.A.  
5 rue de la Déportation - BP 1385 - L-1415 LUXEMBOURG  
Tel.: +352 48 54 56 - Fax: +352 48 54 57

### MALAYSIA

SAF-OERLIKON MALAYSIA SDN BHD  
No 10, Jalan TPP 5/1  
Taman Perindustrian Puchong - 47100 PUCHONG, SELANGOR  
Tel.: +603 8060 8638 - Fax: +603 8061 620

### NETHERLANDS

AIR LIQUIDE WELDING NETHERLANDS  
Rudonk 6 B - NL 4824 AJ BREDA  
Tel.: +31 76 541 00 80 - Fax: +31 76 541 58 96

### POLAND

AIR LIQUIDE WELDING POLSKA - SP. Z.o.o  
UL. Porcelanowa 10 - 40-246 KATOWICE  
Tel.: +48 32 609 04 50 - Fax: +48 32 609 04 60

### PORTUGAL

AIR LIQUIDE SOLDADURA LDA  
Rua Dr. António Loureiro Borges, 4-2° Arquiparque  
Miraflores - 1495-131 ALGÉS  
Tel.: +351 21 41 64 900 - Fax: +351 21 41 69 40

### ROMANIA

DUCTIL  
Aleea Industriilor Nr 1 - 120224 BUZAU  
Tel.: +40 238 722 058 - Fax: +40 238 716 861

### RUSSIA

AIR LIQUIDE WELDING  
17 Vorontsovskaya Str. - 109147 MOSCOW  
Tel.: +7 495 641 28 98 - Fax: +7 495 641 28 91

### SCANDINAVIA

OERLIKON SKANDINAVIEN AB  
Krossverksgatan 7 - 216 16 LIMHAMN  
Tel.: +46 (0)40 670 15 00 - Fax: +46 (0)40 670 15 01

### SLOVAKIA

AIR LIQUIDE WELDING CENTRAL EUROPE S.R.O.  
Hlohovecká 6 - 951 41 NITRA - LUŽIANKY  
Tel.: +421 37 692 4610 - Fax: +421 37 651 28 04

### SPAIN

OERLIKON SOLDADURA SA  
Poligono Industrial la Noria Carretera de Castellon  
Km-15,500 - 50730 El Burgo de Ebro - ZARAGOZA  
Tel.: +34 976 10 47 00 - Fax: +34 976 10 42 67

### SWITZERLAND

OERLIKON SCHWEISSTECHNIK AG  
Mandachstrasse 54 - CH 8155 NIEDERHASLI  
Tel.: +41 44 3076 111 - Fax: +41 44 3076 112

### THAILANDE

AIR LIQUIDE WELDING THAILAND Co. Ltd.  
40 Moo 6 - Ramindra Road Km 9.5 - KHANNAYAO, BANGKOK 10230  
Tel.: +66 29 43 2250 - Fax: +66 29 43 2256

### UAE

AIR LIQUIDE WELDING MIDDLE EAST FZE  
Jebel Ali free zone warehouse No. FZS1AH05  
P.O. BOX 18734 - Jebel Ali - DUBAI  
Tel.: +971(0)48861606 - Fax: +971(0)48861608

### U. K.

AIR LIQUIDE WELDING Ltd  
Low March / London Road - DAVENTRY - Northants NN11 4SD  
Tel.: +44 1 327 70 55 11 - Fax: +44 1 327 70 13 10

### UKRAINE

AIR LIQUIDE WELDING UKRAINE, Lic.  
Moskovskij Prospect 199 - Office 339 - 61037 KHARKOV  
Tel.: +38 057 728 08 52 - Fax : +38 057 728 08 53

## Contacts for other countries:

### ALW Export Department Italy

Via Torricelli15/A  
37135 VERONA  
Tel.: +39 045 82 91 511 - Fax: +39 045 82 91 536  
E-mail: export.alwitally@airliquide.com

### ALW Export Department France

13, rue d'Épluches  
BP 70024 Saint Ouen l'Aumône  
95315 CERGY-PONTOISE Cedex  
Tel.: +33 1 34 21 33 33 - Fax: +33 1 30 37 19 73  
E-mail: export.alwfrance@airliquide.com

### ALW Export Department Switzerland

OERLIKON WELDING LTD  
Mandachstrasse 54  
CH - 8155 Niederhasli  
Tel.: +41 44 3076 111 - Fax: +41 44 3076 212  
E-mail: export.oerlikonwelding@airliquide.com



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