



TIG DA300P

AC+DC Hybrid Pulse TIG Welding Machine

D Digital Inverter
Welding Machine
SERIES

AC+DC Hybrid Pulse TIG Welding Machine Redefining the meanings of “High Quality” and “Ease of Use”

- Easily regulate current via hand torch switch
- Improve quality at every welding place through a wide variety of welding modes
- Improve welding performance of thin plates with silent pulse function
- Improved arc concentration allows for better workability of fillet and butt welding



Redefining the meanings of "High Quality"

The DA300P was designed to meet our users requirements. We have met this challenge by providing improved weld modes, weld quality, and more.

High Quality

Improved & Added Features Provide the Highest Quality of Welding

High quality

1 New AC Frequency Variable Control (50-200 Hz)

Increase Weld Performance of Thin Aluminum Plates via High AC Frequency

- Improved arc concentration allows for better workability of fillet and butt welding
- By controlling heat input (via improved heat input efficiency), bead width increases in thin plate butt welding, and melt through becomes easier to control.

Butt of pipes



Pulsed current 200A, Base current 20A, Pulse frequency 2Hz
AC frequency: 150Hz, Welding speed: 20cm/minute, Plate thickness: 4mm (A6062)

Corner joint



Welding current: 130A, AC frequency: 150Hz
Welding speed: 25cm/minute, Plate thickness: 3mm (A6063 + Casting)

Even when the AC frequency is raised, there is only a slight decrease in welding current, resulting in consistent weld quality.

<Relationship between AC frequency and depth of penetration>

Frequency	50Hz	100Hz	200Hz
Macroscopic cross section			
	Bead is wide.	Bead is narrow (The depth of penetration is fixed).	

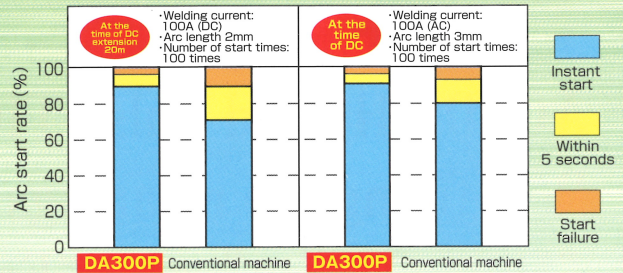
Welding current: 200A, Welding speed: 40cm/minute, Plate thickness: 6mm (A5052)

High quality

2 Assured Arc Starts

- Instant arc starts are improved, even when extension cables are used.
- Effectively eliminates start failures that occur during multi-pass aluminum AC welding.

Comparison of start rate

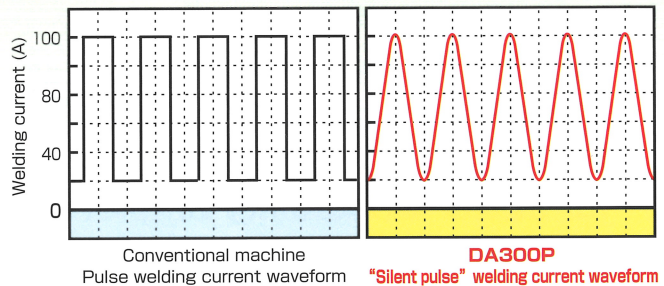


High quality

3 Realizing high-quality welding results Newly-developed "Silent Pulse Function"

(Available only during DC Pulse mode)

- By using the restrictive effects of heat input, you can also prevent from melt-through of thin plates.
- The sound of the arc is reduced, improving the work environment.



User-friendly Touch Panel Provides Improved Operability & Feedback

One Key - One Operation Touch Panels and Large LED Panels Provide Improved Operability & Visibility

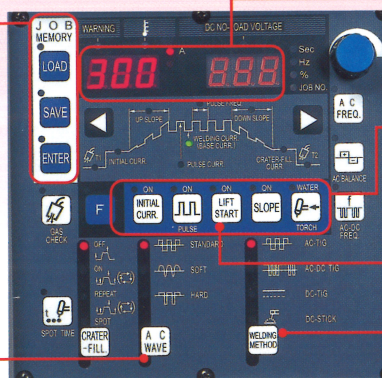
Recordable Welding Conditions for Optimal Reproduction (Stores up to 100 Conditions)

The DA300P is capable of storing up to 100 different welding conditions for optimizing reproduction of welding conditions. Custom tailor your own welding conditions to meet your needs.

Optimized AC Waveform Modes for High-Quality Aluminum Welding

AC Waveform Modes and Feature Examples

Basic welding waveform	Appearance of bead	Welding speed	Arc sound	Thin plate butt joint corner	Thin plate fillet welding	Thick plate	Use of filler rod	Penetration	Electrode consumption
AC-DC hybrid TIG	◎	○	◎	△	◎	◎	△	◎	◎
AC rectangular wave	Standard	○	◎	○	○	◎	◎	○	○
	Hard	○	◎	△	◎	△	◎	○	○
AC sine wave	Soft	○	◎	◎	△	◎	◎	△	○
AC frequency	High	○	◎	△	◎	△	◎	○	○
	Low	○	◎	◎	○	○	◎	○	○



Large LED Display

Monitors current during weld and displays average output current after welding ends. Also displays program number and error codes.

Plentiful Welding Functions

Start Method Selection

In addition to high frequency starts, touch start is also included as a standard feature.

Four Types of Welding Processes (Standard)

Corresponds to various kinds of welding needs.

Quality and Ease of Use

AC+DC Hybrid Pulse TIG Welding
DA300P

...sts for high quality results and ease of use.

...time current control, and crater-time oxidation prevention.

Ease of use

1

I Want to Regulate the Current During Welding!

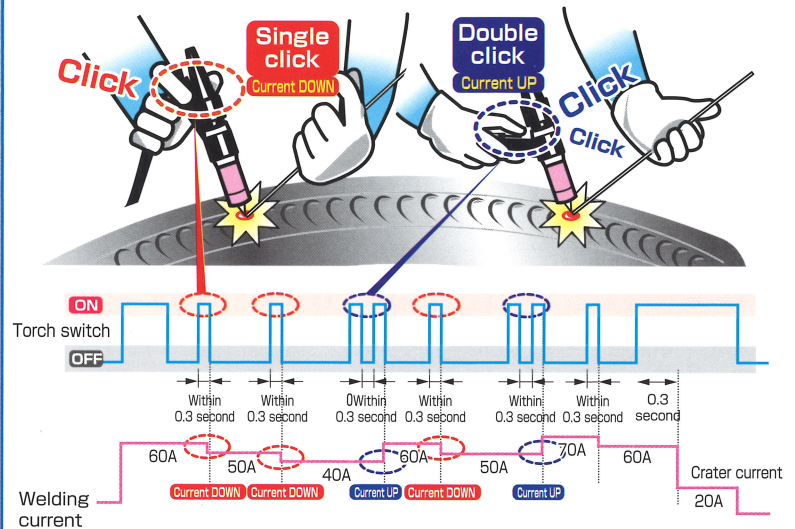
User Request

Weld Current Regulating Function via Torch Switch

The DA300P comes with a newly-developed weld current regulating function that allows the user to change the output weld current during mid-weld. By clicking on a switch on the torch, the user can increase or decrease weld output, allowing for optimal welding conditions. The step amount of current change is arbitrarily defined by the user.

This feature provides optimal control for more delicate metals, such as Aluminum, which typically requires slight current regulation.

Ideal for Varying Plate Thickness or Large Gaps



Ease of use

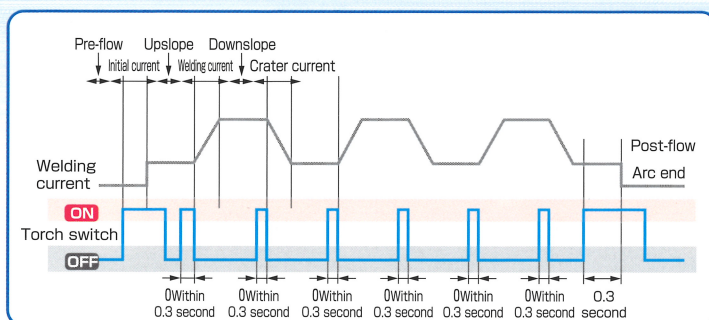
2

I Want to Prevent the Oxidation of Craters!

User Request

Crater (Repeat) Function

It is now possible to send the command for the Crater (Repeat) Function at the end of the weld via the torch switch. This helps prevent from oxidation at the crater and on the Tungsten electrode, which created problems in conventional methods.



Unique, User-Friendly Design

Advanced Double Operation System

OTC's unique control allows for system operation via both the machine panel and remote controls. Both analog and digital remote controls are offered as an option. In addition to the conventional analog remote control, OTC now offers a fully digital remote control for full weld condition control.



Analog remote control

Part number : K5048B00

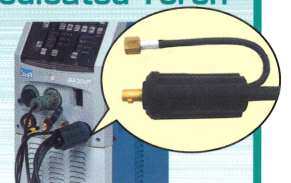


Digital remote control

Type : E-2452

Simplified Connections of Dedicated Torch

OTC standard TIG torches now utilize DINSE connectors, thereby making torch switching a breeze. Conventional torches may also be attached with dedicated adapters.

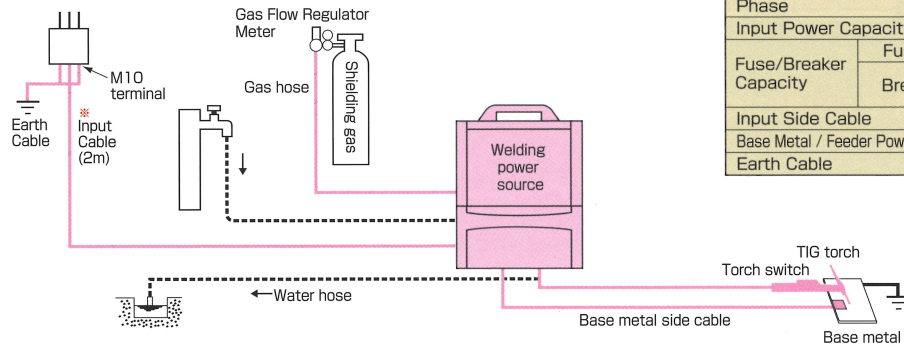


Dust-Proof Filters

Eliminates harmful dust and grime from entering the body of the DA300P, which helps prolong the machines life.

● Connection Diagram

Colors indicate standard composition



*2m Input Cable is attached to Welding Power Source.

■ Input Power Capacity and Cable Specifications

Item	Model name	DA-300P
Power Source Voltage	V	400±15%
Phase	-	3 phase
Input Power Capacity	kVA	more than 13.2
Fuse/Breaker Capacity	Fuse	A 50
	Breaker	A 50
Input Side Cable	mm ²	more than 4
Base Metal / Feeder Power Cable	mm ²	more than 38
Earth Cable	mm ²	more than 4

● Standard Specifications

General Names		DA300P		
● Welding Power Source	Type	DA-300P		
Phase		3 phase		
Rated Input Voltage	V	400±15%		
Rated Input	AC TIG	12.5 (9.4kW)		
	DC TIG	11.9 (8.9kW)		
	DC STICK	13.2 (10.0kW)		
Rated Duty Cycle	%	40		
Max. No-load Voltage	V	58		
Rated Load Voltage	AC TIG	22		
	DC TIG	22		
	DC STICK	30		
Range of Output Current (DC)	DC TIG	4~300		
	DC STICK	10~250		
Range of Output Current (AC)	Hard	10~300		
	Standard	10~300		
	Soft	10~200		
AC+DC Hybrid Output Current	Hard	10~300		
	Standard	10~300		
	Soft	10~200		
Initial/Crater Filler Current	Hard	10~300		
	Standard	10~300		
	Soft	10~200		
	DC	4~300		
Gas Pre-Flow	Sec.	0.1~20		
Gas Post Flow	Sec.	0.1~30		
Up-slope	Sec.	0.1~10		
Down-slope	Sec.	0.1~10		
Pulse Frequency	Hz	0.1~500		
Pulse Width	%	50 (Possible to change functionkey 5~95%)		
AC Frequency	Hz	50~200		
AC Balance		-20~20 (Percentage of positive electrode period, 5~50%)		
AC+DC Switching Frequency	Hz	0.1~50		
Crater Filler Control		[on] [off] [Repeat] change type		
Arc Spot	Sec.	0.1~10		
Max. Program Storage		100		
External Dimensions (W x D x H)	mm	250×640×544 (Except handle)		
Weight	kg	44		
Start Type		High frequency start/Touch start		
● Welding Torch	Type	AWD-17	AWD-26	AWD-18
Rated Current	A	150 (DC), 130 (AC)	200 (DC), 160 (AC)	300 (DC), 260 (AC)
Rated Duty Cycle	%	50	50	100
Cooling Method		Air cooling	Air cooling	Water cooling
Applicable Electrode Diameter	mm	(0.5), (1.0), (1.6), (2.0), (2.4) *1	(0.5), (1.0), (1.6), (2.0), (2.4), (3.2), (4.0) *2	
Cable Length	m	4, 8		

*1.Option is necessary to use Tungsten electrode except for 1.6.

*2.Option is necessary to use Tungsten electrode except for 2.4.

● Welding torch



* Please contact your distributor for questions regarding combinations of other torches

Option

■ Remote control

Convenient for operating away from power source.

● Analog remote control

	Part number
Analog remote control	K5048B00

● Digital remote control (Need the following 3-piece set)

	Part number
Digital remote control	E-2452
Control cable	(10m) BKCAN-0410
	(20m) BKCAN-0420
CAN Communication Board	K5422B00



Analog remote control



Digital remote control

■ Torch adapter

Necessary to connect a conventional torch to the welding power source.

	Part number
For air-cooled AW-17	BBAWD-1701
For air-cooled AW-26	BBAWD-2601
For water-cooled AW-18	BBAWD-1801

■ Torch extension cable

The conventional extension cable can be used for both AW and AWD model torches, however, the AW requires the above mentioned Torch Adapter.

Type	For 4m	For 11m	For 16m
Air-cooled AW (D)-17	BAWE-1504	BAWE-1511	BAWE-1516
Air-cooled AW (D)-26	BAWE-2004	BAWE-2011	BAWE-2016
Water-cooled AW (D)-18	BAWE-3004	BAWE-3011	BAWE-3016

■ Extension remote control cable

	For 4m	For 11m	For 16m
	BKCPJ-0404	BKCPJ-0411	BKCPJ-0416

In accordance with DAIHEN's policy to make continuing improvements, design and/or specifications are subject to change without notice and without any obligation on the part of manufacturer.

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