



## TRANSARC 161i/Tool Box Kit

Industrial



160  
AMP

CC

DC

1  
PHASE

240  
V

### SPECIFICATIONS

#### SUPPLY VOLTAGE:

220/240 volt

1 phase 50Hz

#### SUPPLY LEAD AND PLUG:

15 amp

#### COOLING:

Fan Cooled

#### MINIMUM RECOMMENDED GENERATOR:

8.0 kVA for maximum welding current

#### WELDING CURRENT RANGE:

5 - 160 amps

#### DUTY CYCLES:

50% @ 160 amps (STICK)

60% @ 160 amps (TIG)

#### DUTY CYCLE TEST PERIOD:

5 & 10 minutes

#### POWER SOURCE WEIGHT:

5.4kg

#### POWER SOURCE DIMENSIONS:

H290mm x W130mm x D215mm

**NEW**



The Transarc 161i Tool Box Kit is the complete portable, professional kit. Including the lightweight 160 amp inverter power plant that will run from any 15 amp standard domestic outlet.

This unit provides the latest in inverter technology with excellent DC welding characteristics for manual arc welding with the capabilities of scratch start TIG welding.

#### Features:

- ▲ Designed to operate on a 15 amp 240 volt power point
- ▲ Compact, lightweight & portable
- ▲ Excellent DC MMAW welding characteristics
- ▲ Anti-stick in MMAW mode
- ▲ Infinitely Variable Welding Current Control from 5 to 160 amps

#### Transarc 161i Plant Contents:

Transarc 161i Power Source, Operating Instructions, Primary lead for factory preset supply voltage, complete lead set, chipping hammer and wire brush in a robust tool box.

#### Transarc 161i Power Source Contents:

Transarc 161i Power Source, Operating Instructions, Primary lead for factory preset supply voltage, 25mm<sup>2</sup> dinse connectors.

#### Ordering Information:

Transarc 161i Plant (Tool Box Kit) Part No. 625801

Transarc 161i (Power Source only) Part No. 625800

Refer to Easyfind page 22 for optimum setup

#### Recommended Process:

DC Stick

DC GTAW – Scratch Start

#### Optional Accessories:

Hiderok Helmet	Part No. 453833
Wire Brush (4 row)	Part No. 646363
TIG Torch Accessories Kit	Part No. BGS AK2
150 amp TIG Torch	Part No. 305710402
Torch Gas Hose Kit (includes fittings)	Part No. 700433
Flowmeter / Regulator	Part No. 301526
TIG welding kit (refer page 118)	Part No. 700706

For the full accessory range turn to the accessories section of this book.

## Technical TIP

### ARC WELDING TECHNIQUE

**A Word to Beginners:** For those who have not done any welding, the simplest way to commence is to run beads on a piece of scrap plate. Use mild steel plate about 6.0mm thick and a 3.2mm electrode. Clean any paint, loose scale or grease off the plate and set it firmly on the work bench so that welding can be carried out in the downhand position. Make sure that the work clamp is making good electrical contact with the work, either directly or through the work table. For light gauge material, always clamp the work lead directly to the job, otherwise a poor circuit will probably result.

**The Welder:** Place yourself in a comfortable position before beginning to weld. Get a seat of suitable height and do as much work as possible sitting down. Don't hold your body tense. A taut attitude of mind and a tensed body will soon make you feel tired. Relax and you will find that the job becomes much easier. You can add much to your peace of mind by wearing a leather apron and gauntlets. You won't be worrying then about being burnt or sparks setting alight to your clothes.

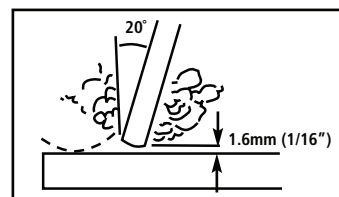
Place the work so that the direction of welding is across, rather than to or from, your body. The electrode holder lead should be clear of any obstruction so that you can move your arm freely along as the electrode burns down. If the lead is slung over your shoulder, it allows greater

freedom of movement and takes a lot of weight off your hand. Be sure the insulation on your cable and electrode holder is not faulty, otherwise you are risking an electric shock.

**Striking the Arc:** Practice this on a piece of scrap plate before going on to more exacting work. You may at first experience difficulty due to the tip of the electrode "sticking" to the work piece. This is caused by making too heavy contact with the work and failing to withdraw the electrode quickly enough. A low amperage will accentuate it. This freezing-on of the tip may be overcome by scratching the electrode along the plate surface in the same way as a match is struck. As soon as the arc is established, maintain a 1.6mm to 3.2mm gap between the burning electrode end and the parent metal. Draw the electrode slowly along as it melts down.

Another difficulty you may meet is the tendency, after the arc is struck, to withdraw the electrode so far that the arc is broken again. A little practice will soon remedy both of these faults.

#### Striking an arc



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A THERMADYNE Company