



WALTER · SERBIA/EUROPE

WALTER 250 DC CELL PIPELINES

INFO FLASH:

TIG DC and AC/DC - 250A. MMA - 200A. DUTY:100%/150A(TIG)/150A(MMA).



TECHNICAL CHARACTERISTICS - WALTER 250 DC CELL:

- **MAGIC WAND** - single click setup.
- DC pulse from 0.1Hz up to 1000Hz.
- **Spot and Micro Spot** in both DC welding mode (for tacking of metal sheets and butt welding of wires from 0.4mm).
- Wide range of metal sheets welded – 0.2mm to 10mm.
- **Automatic adjustment of current pulse during HF ignition.**
- Program for increased precision for currents of 1A – 10A.
- 10-90% Duty Cycle
- Programmable start, upslope, downslope and stop currents.
- Option: Remote control - foot pedal or handheld.
- Programmable pre/post flow of the protective gas.
- Efficient overtemperature protection with exact temperature displayed.
- 2S/4S - two-stroke and four-stroke modes of welding.
- 15kV HF arc ignition. Direct output polarity.
- Measurement and display of actual current and arc voltage.
- **Diesel generator friendly.**
- 1A minimum DC current.
- User interface with 128x64 LCD display.
- **Can memorize up to 30 TIG welding programs.**

TECHNICAL CHARACTERISTICS: TABLE:

WALTER DC CELL 250		DC CELL 250
Input Voltage	1ph	<u>230Vac +/-15%</u>
Input Volt. Frequency	Hz	<u>50/60Hz</u>
Input Power	kW	<u>10</u>
Fuse 230/400Vac	T/A	<u>32/25</u>
Welding Current TIG	A	<u>1 - 250A</u>
Welding Current MMA	A	<u>10 - 200A</u>
O.C.V. TIG	V	<u>10V</u>
O.C.V. MMA	V	<u>80V</u>
Arc Voltage: TIG	V	<u>11V - 32V</u>
Arc Voltage: MMA	V	<u>22V - 34V</u>
Duty Cycle at 40°C/50°C	Imax	<u>250A/200A/40%</u>
TIG/MMA	40°C	<u>170A/160A/100%</u>
	50°C	<u>120A/120A/100%</u>
Arc Ignition		<u>HF</u>
AC mode		<u>NO</u>
Pulse Frequency (DC)	Hz	<u>0.1Hz – 990Hz</u>
Duty Cycle	%	<u>10% - 90%</u>
Start/Stop Current	sec	<u>0.1s - 20s</u>
Upslope/Downslope Curr.	sec	<u>0.1s - 20s</u>
Pre/Post gas	sec	<u>0.1s - 20s</u>
LCD Digital Display	LCD	<u>128x64 LCD</u>
Cellulosic MMA		<u>YES</u>
Memory		<u>30 slots</u>
Remote control/foot pedal		<u>YES</u>
Remote control/TIG torch		<u>YES</u>
Mechanical Protection Class	IP	<u>23</u>
Dimensions	mm	<u>195x300x450</u>
Weight	kg	<u>13</u>

Zavarivanje Ltd. is proud to be the recipient of "**A Step Into the Future**" Special Recognition Award at the 53rd Belgrade international fair of technology and technical accomplishments for **WALTER 220 AC/DC** industrial welder in the category of electrical engineering and industrial electronics.

ABSOLUTE MAXIMUM RATINGS - WALTER 220 DC CELL:

- Maximum current 250A(TIG). 40%/40°C, 20%/50°C.
- Maximum basic electrode diameter 3.25 -- at 160A /100%.
- Maximum basic electrode diameter 4.00 -- at 200A/40%.
- MMA applied in metal fabrication -- YES.
- MMA applied in pressure pipes welding -- YES.
- TIG applied in pressure pipes welding -- YES. TIG DC -- 120A/100%/50°C
- The minimal supply input voltage while working in TIG is 100Vac.
- The output current while working in TIG at 100Vac is -- 110A.
- Maximum supply input voltage -- 275Vac.
- Maximum stand by voltage -- 300Vac.
- Suitable for work on generator -- YES.
- Minimal generator for TIG welding -- 6kVA.
- Minimal generator for MMA welding -- 8kVA.
- Welding of tow trucks sides -- up to 10mm - 250A/DC.
- Auto body panel welding -- YES.
- Minimal steel sheet welded -- 0.2mm.
- **Professional welding with cellulosic coated electrodes 3.25mm -- YES.**

ACCESSORIES:

DELIVERED IN PACKAGE WITH WALTER 250 DC CELL

- TIG TORCH SR26 – 4m. Air Cooled. 140A/100%. Water Pump is not included in basic package.
- Electrode holder 200A with cable for MMA welding (3m, 25mm²).
- Earth clamp 200A with cable (3m, 25mm²).



NOT INCLUDED IN BASIC PACKAGE:
Additional charges apply.

- Water pump for TIG torch.
 - Foot pedal remote control.
 - Handheld remote control.
 - Spare parts set.
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GALERIJA:



THE USE AND LIMITATIONS.

BORDER AREAS OF APPLICATION - DC OPERATION:

Maximum current at which high pressure pipes can be professionally welded (high-alloy steels and stainless steels) is about 140A. Although 170A is declared current at 100% duty cycle, working conditions for welding of these tubes are significantly heavier than those in which the machines are rated. Most often, this refers to the operating temperature of the environment (often greater than 50°C), the cooling conditions (large amount of metal or other dust and small available space). An additional complicating factor is the need to work in two or three shifts and with several welders per shift working on one machine. The work on the generator may or may not be an aggravating factor, depending on the generator quality. 6kVA generator or higher will provide enough quality voltage for operation.

CELLULOSIC COATED ELECTRODES WELDING:

WALTER 250 DC CELL is designed for welding cellulosic coated electrodes with maximum current up to 200A or 160A / 100%, and professional welding results are expected if the welder power source is provided with quality power supply (230Vac / + 10% / - 10%) and if quality and dry electrodes are used.

WALTER 250 DC CELL is designed for MMA welding in technologically demanding applications. This primarily relates to the welding of boiler, gas and other pressure pipes. If this kind of welding required in your business, the CELL model is WALTER's preferential proposal.

THE USE AND LIMITATIONS.

MAINS POWER AND GENERATORS:

WALTER 250 DC CELL is designed to be able to work even in very poor conditions of the power supply. **Nominal voltage is 1x230Vac.**

The power source will successfully weld in DC TIG welding even at a voltage of about 100Vac in the network. Maximum output current of the machines will in this case be approximately 140A. At very low voltages in the network, it would be more difficult to weld in MMA mode. However, the boundaries in which these difficulties might happen, take place in circumstances which are considered emergency operation for power grid and power supply would already be cut off by the power grid companies. In any case, the machine will not be damaged in any low voltage network. Too high a voltage can cause malfunction of the appliance if its value is permanently 300Vac or higher or in the short-term over-voltages of about 330Vac.

WALTER 250 DC CELL is designed to operate on the diesel generator and welding characteristics will be the same as when running on the public network if the voltage generator is within the declared value (230Vac +/- 15%).

Recommendation: Generator rated 8kVA or higher. The voltage on generators of poor quality can exceed the value of 330Vac and may cause malfunction of the appliance.

Operation on a poor network or a poor generator can have a strong negative impact on the MMA welding procedure. The quality of TIG welding in such conditions will not be reduced, but it is possible that the welder will not be able to give out the maximum rated current.

In any case, it will not be damaged if the power supply voltage in the range of 110Vac to 275Vac.

In the case of connecting the permanent voltage of over 300Vac, the welder power source will be damaged.

ENVIRONMENT TEMPERATURE:

The machine is designed for normal operation within the industrial temperature range (-20 ° C to + 40 ° C).

If the ambient temperature exceeds over the nominal value (+ 40 ° C), it may cause a decrease in operational performance of the welder power source.

If the operating temperature is below -20 ° C, the device will not start working.

LIMITED GLOBAL WARRANTY.

WALTER 250 DC CELL (PRODUCT) is designed and tested for professional applications and heavy duty environment. This machine is world wide covered with manufacturers limited warranty for a period of two (2) years from the date of purchase.

WALTER LIMITED WARRANTY AGREEMENT

1. Product Limited Warranty - replacement parts and technical support.

Walter warrants that its Products will be free from defects in materials and workmanship for the Limited Warranty Period. During the Limited Warranty Period, Walter will provide replacement parts and technical support necessary to repair the Product with no additional fees. Transportation costs from the nearest Walter Service Office shall be covered by Walter during the first Year of Limited Warranty Period. Replacement parts will be new or serviceably used, comparable in function and performance to the original part and warranted for the remainder of the original warranty period or, if longer, 90 days after they are shipped to You.

2. Hardware Technical Support.

The scope of technical support consists of helping You diagnose and resolve problems with defects in Products covered by this Agreement, and reinstalling the factory-installed hardware and software to restore it to the original factory configuration. Walter may provide technical support via on-line, telephone and other methods. Walter may change the means through which it provides technical support at any time without notice to You.

During the Limited Warranty Period, Walter will provide free of charge Product technical support. After the expiration of the Limited Warranty Period, hardware technical support is available for a fee. The fee will be charged to your credit card when You call technical support. Please note that when contacting Walter via telephone, long distance and other charges may apply, depending upon your calling area.

3. Software Support for Operating System Software. Walter is the manufacturer of the incorporated embeded software and does guarantee that software and operating systems will be free from errors, either in isolation or in combination with hardware. For your Product, Walter will assist the customer with:

(i) installation of any operating system software purchased from Walter; (ii) configuration of the operating system software;(iii) setup of the operating system software; (iv) troubleshooting issues associated with the operating system software.

LIMITED GLOBAL WARRANTY - CONCLUSION.

4. Limitations and Exclusions

The following conditions are not covered under the terms of warranty:

Defects due connection to incorrect or faulty mains supply voltage, mechanical damages and transport or storage damage, fire or damage due to natural causes, lightning or flooding.

The warranty does NOT cover:

Expenses for troubleshooting, direct or indirect travelling costs except described in chapters 1, 2 and 3 of this agreement.

Welding cables, torches and their consumable parts are not covered under the warranty.

Direct or indirect damage as well as any loss of earnings are not covered under the warranty.

The Manufacturer shall in no event be responsible for any third party expenses or any indirect or consequential expenses/costs.

Manufacturer is not responsible for incidental, consequential, punitive or liquidated damages.

The warranty is void if modifications are made to the product without the prior written approval of the Manufacturer.

To the fullest extent allowed by law, the Manufacturer will have no other obligation whatsoever with regard to the products except as stated in this limited warranty.

Warranty Length/Type 2 Year/Limited: Parts & Labor, Mail In or Carry In.

Hardware Technical Support - 2 Year / Software Support - 90 days from the date of purchase.

Service Website

<http://www.wweld.com/support>

Service Phone Number

00 381 11 2456064

00 381 64 6418143

WhatsApp Support

00 381 64 6418144

Service Address:

Cara Nikolaja Drugog 22,

Belgrade, Serbia (Europe)
