



MR315T

IC-Thyristor Controlled
DC TIG Pulse Welding Machine



Multi mode for high performance



MR315T

**Multi mode for
High performance**

High Welding quality and high efficiency with DC TIG, Pulsed DC TIG and DC Stick.

**High quality with
DC TIG welding**

Multi function such as low pulse control(0.5-15Hz), initial current, up slope, down slope and crater fill control.

**High efficiency with
DC Stick welding**

High efficiency with low spatter is achieved with from 2.6 to 5mm stick electrode.

Wide application

Powerful performances for pressure vessel, pipes, plant maintenance, and etc...

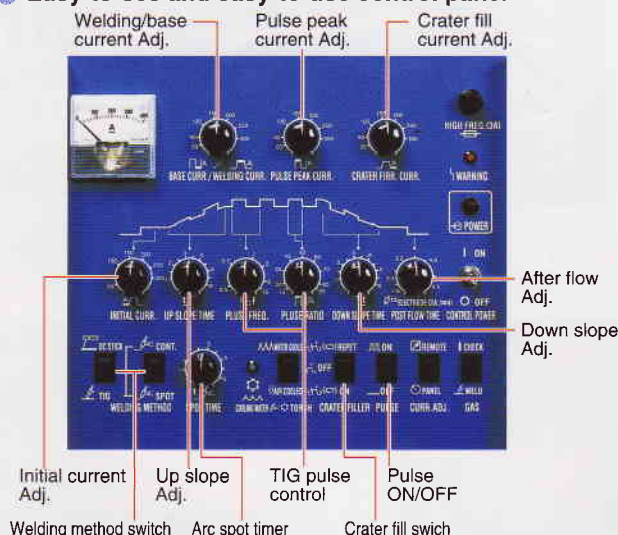
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Features

- High welding quality and high efficiency for mild steel, stainless steel, nickel alloy with DC TIG, Pulsed DC TIG and DC Stick as standard modes.
- High performance function for TIG and Pulsed TIG
- TIG Pulse function (0.5~15Hz)
Ultimate URANAMI (full penetration welding) and bead appearance are achieved with pulsed TIG function. Also, High performance for different material, different thickness and gap.
- High quality and High efficiency for multi-layer welding
First layer with Pulsed TIG for URANAMI. DC TIG for high welding speed from second layer.



- Easy-to-see and easy-to-use control panel



Information

Specification

Model Name	MR315T
Model Number	MRHP-315
Rated input voltage	Indicate primary voltage when ordering
Phases	3ph.
Rated frequency	50/60 Hz
Rated input power	16kVA (10kW)
Rated output current	315A
Crater fill/Initial current range	5-315A
Pulse/Base current range	5-315A
Rated out put voltage	22.6V(32.6V at Stick welding)
Max.open circuit voltage	57V
Rated duty cycle	40%
Down-slope time	0.1-5sec
Up-slope time	0.1-5sec
Gas pre-flow time	0.3/0.6sec
Gas after-flow time	3-20sec
Crater fill control	ON/OFF/Repeat
Pulse ratio	15-85%
Pulse frequency	0.5-15Hz
Dimensions (WxDxH)	348mmx592mmx 642mm
Weight	120kg

Standard Accessories

Description	Specification	Q'ty	Remark
Bolt, Nut, Washer	M5	3 set	on input terminal
Bolt, Nut, Washer	M10	1set	for output terminal ⊖
Bolt	M8-20	1	for output terminal ⊕

Connection with power source

Input terminal	M5
Output terminal ⊖ (torch)	φ11 for air-cooled torch 7/8-14UNF for water-cooled torch
Output terminal ⊕ (base metal)	M8
GAS fitting	9/16-18UNF
Water inlet/outlet fitting	5/8-18UNF

Standard composition (Recommend)

Welding power source	MRHP-315
TIG Torch	AW-18 (4m)
Cable & Hose	BAB-350

Options

Remote box (4m)

- Part number : C0031K00
- Optional remote box is available instead of output current adjustment on front panel.



Remote foot control (8m)

- Part number : 4259-036

Torch, Cable, Hose

Model Number	AW(F)-17	AW(F)-26	AW-18

Torch specification

	150A	200A	300A
Rated Current	150A	200A	300A
Cooling Method	Air-cooled	Air-cooled	Water-cooled
Duty cycle	DC 50%, AC 35%	DC 50%, AC 35%	DC 100%, AC 70%
Electrode	0.5-2.4mm	0.5-4.0mm	0.5-4.0mm
Torch length	4m or 8m	4m or 8m	4m or 8m
Remark	included 4m torch switch(K1108A00) or 8m(K1109A00)		

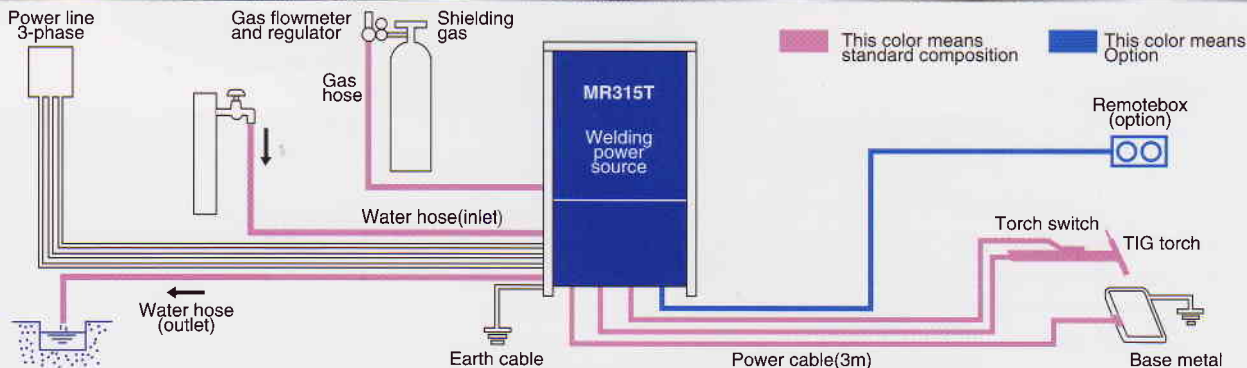
Cable & Hose

Part Number	BMRHP-3001	BAB-3501
Remark	3m power cable for base metal & 3m Gas hose	3m power cable for base metal, 3m Gas hose and 2ea, 5m Water hose etc.

Extension cable for Torch

	BAWH-1504	BAWH-2004	BAWS-3004
+4m	BAWH-1504	BAWH-2004	BAWS-3004
+11m	BAWH-1511	BAWH-2011	BAWS-3011
+16m	BAWH-1516	BAWH-2016	BAWS-3016

Connection Diagram



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.

DAIHEN Corporation

5-1. Minamisenrioka, Settu, Osaka 566-0021, Japan
Phone : (Country code 81) 6-6317-2506
Fax : (Country code 81) 6-6317-2583

Distributed by:
Dayachand Engineering Industries (P) Ltd.,
F-2 Industrial Estate, Begrajpur,
Muzaffarnagar (U.P.)-251203
Ph. 9997722300, 9897501661
Web: www.fairweld.com
Email: info@fairweld.com

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