



# PowerTIG 400EXT

GTAW-P/ SMAW

## Specifications

<b>Process:</b>	GTAW-P/ SMAW	<b>Input:</b>	240V 1 / 3 Ph 480V 1 Ph Opt.	<b>TIG Range:</b>	DC TIG: 5-400A AC TIG: 10-400A	<b>I1Max (Inrush) 240V 1/3 Ph Optional 480V 3 Ph</b>	87A /52A 23.1	<b>I1Eff (Rated)240V1/3 Ph Optional 480V 3 Ph</b>	50A/30A 14A
<b>TIG Duty Cycle:</b>	35% @ 400A/26V	<b>OCV:</b>	60V VRD<24V	<b>Stick Amp Range:</b>	DC Stick: 20-315A	<b>TIG Pulse Frequency DC:</b>	.1-500 Hz	<b>TIG Torch Type:</b>	26 and 18 Series Rigid 12.5Ft. (Air and Water-cooled)
<b>Stick Duty Cycle:</b>	35% @ 315A/32.6V	<b>Weight:</b>	120 lbs. Shipping	<b>Dimensions:</b>	26" L x 20"H x 11"W	<b>TIG Pulse Frequency AC:</b>	.1-250 Hz	<b>AC TIG Balance:</b>	5-90% + (positive)
						<b>AC TIG Frequency:</b>	20-250Hz		

### Bigger is Better.

#### Sturdy Steel Case Design

The case design is robust with heavy gauge metal. Although the unit isn't our lightest, the and weight and size still makes it a good candidate for portable use.

#### 9 Program Memory

Set and save up to 9 programs that you commonly use so that they can be recalled at a moment's notice. Great for fast setup.

#### 35% Duty Cycle

Notice the extra venting? The large fan design and generous venting of the machine of this machine helps to set the standard for larger machines. 35% Duty Cycle at 400A on single phase or three phase 240V is the best you'll find in its class.

#### Weld Cycle Graph

Select and set Pre-Flow, Start Amps, Up Slope, Welding Amperage, Pulse Parameters, AC Balance, AC Frequency Control, Down Slope, End Amps and Post flow using this visual guide. These features work in conjunction with 2T and 4T operation.

#### Easy Change of Polarity

This unit makes changing from TIG to Stick and back again an easy task via the use of 35mm<sup>2</sup> DINSE Type Connectors.

#### Quick Gas Connection

Everlast has pioneered the use of gas quick connects in the industry. Now others are following. Rather than needing a couple of wrenches and about five minutes of change over time, you can now remove or change your torch in mere seconds instead of the usual time it takes.



#### Water-Cooler Ready

Take a peek around back and you'll see that the unit is designed to operate in with the stackable PowerCool 400 water cooler. The plug is built right into the back of the unit so the cooler can be turned on and off with the main power switch of the welder. Combined with the PowerCart 300, this makes a complete package.

#### AC Wave Form Control

This unit is designed with three different useful wave forms for AC welding of Aluminum. Select from Advanced Square for quick wet-in, Soft Square for a softer, more gentle feel, Triangular Wave form for better control on thin materials and Sine wave for a traditional soft feel and broad puddle.

#### AC/DC Pulse with Additional Advanced AC Pulse

If heat control is needed, the unit offers a pulse feature, up to 500 Hz DC, and 250 Hz AC (Adv Square Wave only, up to 10 Hz other wave forms). For those needing extra power, or an ability to weld well over the rating of the unit on Aluminum, the Advanced AC Pulse combines the best features of AC and DC operation to provide balanced cleaning with an extra punch of penetration.

#### E6010 Setting

Stick weld with all rods even E6010, which is more difficult to run.



#### 5 Year Parts and Labor Warranty

Simply the best warranty in the business. Who else offers this without paying extra, or giving you a long list of exclusions?

## Uses: Industrial Production Welding, Commercial Fabrication, HVAC, Marine, Pipe

### Loaded With Power and Features

### Our Biggest AC/DC TIG/DC Stick Unit Just Got BIGGER.

The PowerTIG 400EXT now sits on top of our product line with 400A of TIG welding power. It now has even greater capability on Aluminum and steel. Combined with the "Advanced AC Pulse" that alternates between AC and DC Electrode Negative polarity this unit hits more like a 600A machine when welding Aluminum. It's truly something that has to be tried to believe.

But power isn't everything. You also want features that perform and make the job easier, especially with Aluminum. Features such as AC Wave form control, Pulse, Advanced AC Pulse, AC Frequency Control and AC balance control offer you plenty of features to give you maximum capability and quality of weld while welding Aluminum. Of course, 350A of welding power with a 35% duty cycle gives you plenty of punch to start a puddle on thick plate.

Welding Steel, Stainless Steel, Titanium and even Deoxidized copper is a simple task with the hallmark stable arc of the PowerTIG 400EXT. You will

notice the quiet, smooth arc as it quickly wets in and remains rock solid. In pulse mode, with frequencies up to 500Hz, the unit can put you in complete control over heat wicking and over melting on outside corner joints on sheet metal.

One of the main features that should not be overlooked is the stick welding capability of this machine. With a Cellulose/E6010 setting, there isn't a welding rod this machine isn't capable of handling. The unit puts out 315A while welding Stick for an electrode capacity up to 1/4" on certain rods. Arc force and Hot start controls enable this machine to make even beginners look like stick welding wizards.

When you add the 5 year warranty, it's going to be hard to beat the long list of features found on the PowerTIG 400 EXT when you compare to almost any brand. But the competitive pricing is the real head turner. Priced at a 1/3 or less of the competition, you won't find much that this machine won't do, including save your budget.

## Up Close

### Memory

Select, and save up to 9 different programs.

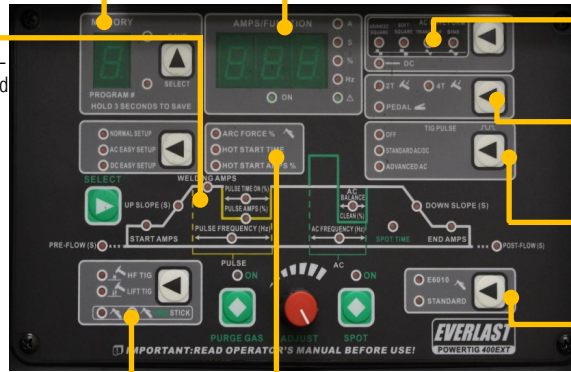
### Weld Sequence Graph Features

This graph represents the weld cycle and the adjustable features from the beginning of the weld to the end of the weld. Features included are:

- Pre-Flow: 0-25 Seconds
- Start Amps: 5(10) - 400A
- Up Slope: 0-25 Seconds
- Welding Amps: DC: 5-400A, AC: 10-400A
- Pulse Time ON: 5-100%
- Pulse Amps: 5-99%
- Pulse Frequency: DC: .1-500Hz, AC .1-250Hz, Advanced AC: .1-9.9 Hz
- AC Frequency: 20-250Hz
- AC Balance: 5-95% of EP
- Down Slope: 0-25 Seconds
- End Amps: 5(10)-400A
- Spot Timer: 0-10 Seconds

### Start Type/Process Selector

The unit can use HF to start the TIG arc or a lift start can be selected for use with the pedal or torch switch. The stick function allows standard start or VRD start (<24V).



### Digital Display

Accurately select and know the Amperage and other functions indicated on the panel.

### Wave Form Control

Select different wave forms for AC output for welding Aluminum, or select DC output for stainless, steel and other metals

### 2T/4T Control or Pedal Control

Select whether you want to use the included torch switch to control the weld sequence, or the foot pedal to manually control the slope and other functions.

### Pulse

Control arc cone spread, heat input and directability of the arc with the standard pulse. With the Advanced AC pulse you can extend the capability while welding aluminum.

### Stick Hot Start and Arc Force Control

Change the arc start for better starts and weld characteristics while stick welding to provide a softer or more penetrating arc feel.

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## Welding Thickness Limits\*:

\*Welding thickness limits are typically described in single pass and multi-pass terms. Multiple pass welds on thicknesses 1/4" and over are typically prescribed as "best practice" welds, whereas a single pass weld, may not yield the best or strongest weld but is used to give a comparative idea of the machines capability. For maximum welding limits, you have to take into consideration the ultimate size of the weldment. Larger weldments will require more welding amperage to make the same weld as a smaller weldment because of heat dissipation capability.

**Maximum Single Pass DC TIG Weld:** 3/4"

**Maximum Multi-Pass DC TIG Weld:** 1+"

**Maximum Single Pass AC TIG Weld:** 3/4"

**Maximum Multi-Pass AC TIG Weld:** 1+"

**Minimum Weld Thickness All Voltages:** DC: .005", AC: .010"

**Stick Weld Maximum Electrode Diameter:** 1/16 - 1/4" (Depending upon mfg. and type/class)

## Standard Equipment and Options

### Standard Equipment:

- 12 ft (4m) 26 Series Air-Cooled Rigid Neck (Straight Head) TIG Torch
- 12 ft (4m) 18 Series Water-Cooled Rigid Neck (Straight Head) TIG Torch
- 400A Work Clamp and 10 ft (3m) Cable
- 350A Stick Electrode Holder 10 ft (3m) Cable
- Brass Billet Floating Ball Type Argon Regulator
- 6.5 ft. Power Cord (No plug)
- Starter Consumable Kit (No Tungsten)



### Customer Favorite Options:

- PowerCool 400 Water Cooler: **SKU# PCW-400-240**
- NOVA Wireless Pedal: **SKU# NVA-WL-FP200-EV07**
- PowerCart 300: **SKU# PC300-M**
- NOVA Rotaflex Water-Cooled 20 Torch, 12.5 ft. : **SKU# NOVA-RF-20-35QD**

## Will this unit operate on a generator?

Yes it can. However, due to the size of the unit, only large industrial generators can meet the inrush demand of the unit. You'll need a minimum of 22,000 watts to power the unit for 1 phase 240V use. Additionally you must provide the following requirements:

- The generator must be rated as "Clean Power Output", This means that it provides 5% or less Total Harmonic Distortion. The generator manufacturer determines this rating. Consult with the manufacturer of the generator before your purchase.
- The generator must be grounded per manufacturer's directions.
- **Notice:** Switch the welder off before powering down the generator. Do not run the generator out of fuel while the welder is switched on.
- Do not run on ECO idle. Always run at full generating speed.
- Failure to follow these recommendations may cause damage and void the welder warranty.

Notice: This unit does not include a power plug since it is a 1 and 3 phase operating unit. There is no plug suitable for both phases. The 1 phase operation requires only 3 wires to be used. On 3 phase, all 4 wires will be used.

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