

ISO 9001 Registered

CAT. NO. B420701



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

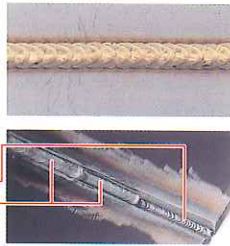
High efficiency with low spatter is achieved with from 2.6 to 5mm stick electrode.

Wide application

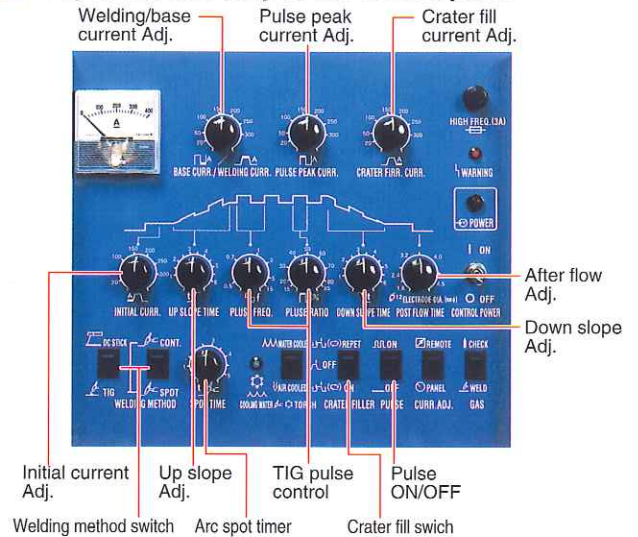
Powerful performances for pressure vessel , pipes , plant maintenance , and etc...

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
	included torch switch (K1108A00)
	Power cable/gas hose/water hose etc.

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)		

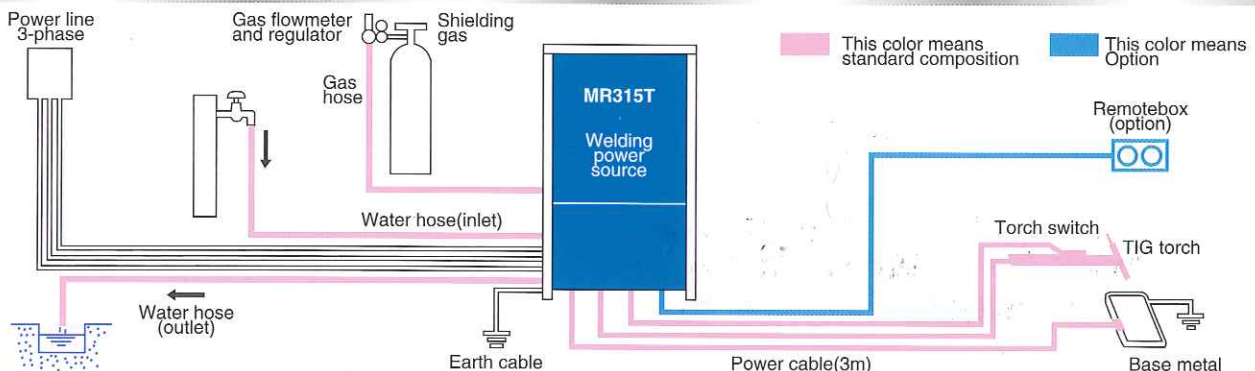
Cable & Hose

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

4-1.Koyochonishi, Higashinada-ku,
Kobe, Hyogo 658-0033, Japan
Phone : (Country Code 81) 78-275-2006
Fax : (Country Code 81) 78-845-8159

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