

VR400 / MR400 / MRA630

NEW

DC
Stick

VR400



*Inverter Controlled
High Performance
DC Arc Welding Machine*

DC
Stick

MR400



*IC • Thyristor Controlled
DC Arc Welding Machine*

DC
Stick

MRA630

GOUG
ING



*Digital Controlled
High Performance
DC Welding Machine*

VR400

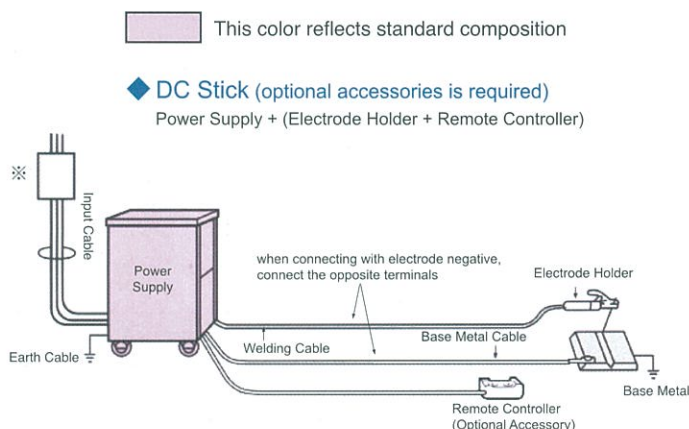
Inverter Controlled High Performance DC Arc Welding Machine

You can weld with Cellulose-coated electrode at any positions

- **Superior Arc Stability**
- **User Friendly Operation**
- **Arc Drive Control**
- **High Efficiency**



Connection Diagram



VR400 Product Features

- **IGBT Inverter Control, Easy Arc Strike**
Equipped with advanced IGBT control module and circuit design, offers stable arc and easy arc strike.
- **Perfect constant current characteristics, welding very stable**
Due to perfect constant current characteristics, welding current is always kept constant no matter conditions such as hand position change, input voltage change, surrounding temperature change, or cable length change
- **Wide range of applications**
Suitable for wide application such as oil and gas, pressure tank, construction, various factory works and repair work.
- **Automatic remote control box recognition. Plug in to use remote control box**
Remote control box (Optional Accessory) for easy setting of welding conditions.
- **Stackable two machines, by place the upper machine's legs fitting to the lower machine's handle**
- **Features input over-voltage protection circuit, input low-voltage protection circuit and input lack-phase protection circuit**
- **Dust-proof structure enables using under harsh environment**
- **Electric shock preventing device (Standard Device)**
Protect operator from electric shock.

Standard Accessories

Name	Specification	Amount	Remark
Fuse	ZH217 (500 V 5A)	1PCS	For control circuit protection (PCB5)
Plug	CX0525	2PCS	For output connection

Optional Accessories

Description	Part No.
Remote Control Box 3 meter	K5741J00

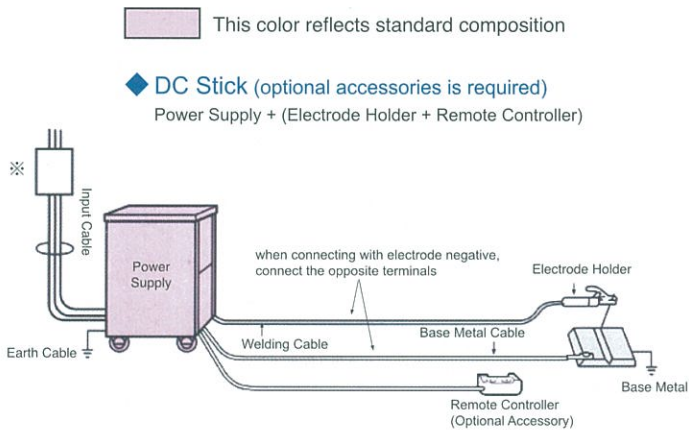
MR400

IC • Thyristor Controlled DC Arc Welding Machine

- **Stable Arc**
Stable and smooth arc by constant current characteristics.
- **Heavy Duty Cycle**
Especially suitable for medium and thick plate welding.
(Rated duty cycle 60%)
- **Safety Design**
Using strong materials for cases, the chassis mechanism does not allow small animals into the power supply unit.
- **Arc Drive Control**
Prevents electrode sticking to base metal during welding. (Standard Device)
- **Diversified Applications**
Useful for wide range of applications such as pressure tank, construction and on site work.



Connection Diagram



MR400 Product Features

MR400 is ideal DC Arc welding machine with stable arc and less spatter by adopting high quality IC-Thyristor technology.

- **Arc drive control (Standard Device)**
Arc drive control is standard function and it prevents a sticking of electrode to base metal during welding and enables smooth welding operation.
- **Perfect constant current characteristics**
Constant current characteristics features stable welding and its welding current always kept constant.
- **Remote Box (Optional Accessory) for easy setting of welding conditions.**
Part No. C0035K00

Standard Accessories

Part Name	Description	Q'ty
Fuse	Refer to Manual	1
Cup Square Neck Bolt	M10 x 30	2
Nut	M10	2
Washer	M10	2
Spring Washer	M10	2

Optional Accessories

Description	Part No.	Q'ty
Remote Control	C0035K00	1

MRA630

Digital Controlled High Performance DC Welding Machine

- Micro processor control**
 Stable arc with low spatter; most suitable current at high efficiency
- Diversified applications**
 Suitable for Low carbon steel, High-strength steel, Heat-resistant steel, Stainless steel and Copper alloy.
- User friendly design**
 Safety design, multiple protection, easy maintenance.

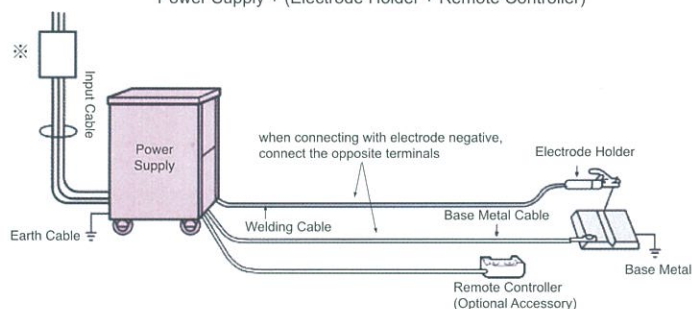


Connection Diagram

 This color reflects standard composition

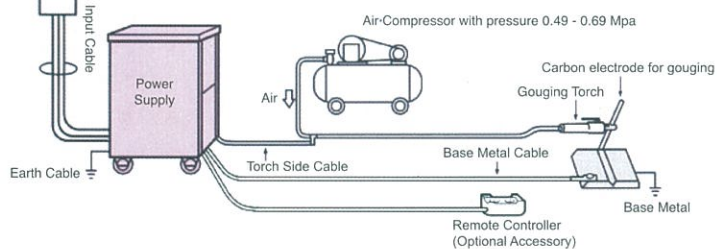
◆ DC Stick (optional accessories is required)

Power Supply + (Electrode Holder + Remote Controller)



◆ DC Gouging (optional accessories is required)

Power Supply + (Gouging Torch + Air Compressor + Remote Controller)



Standard Accessories

Part Name	Description	Q'ty
Glass Enclosed Fuse	5 A 250 V	1
Cup Square Neck Bolt	M10 x 30	2
Nut	M10	2
Washer	M10	2
Spring Washer	M10	2

Optional Accessories

Description	Part No.
Remote Control	C0223K00
Gouging Torch	GT-11 Model



Gouging Torch Model GT-11

Max Current 700A
 Duty Cycle 70%
 Carbon Electrode ϕ 4~ ϕ 11
 Compress Air 0.49~0.69MPa

Specification

								
Model	VR-400		MR-400			MRA-630		
Power Source Voltage	380 V $\pm$ 10%	415 V $\pm$ 10%	220 V $\pm$ 10%	380 V $\pm$ 10%	415 V $\pm$ 10%	220 V $\pm$ 10%	380 V $\pm$ 10%	415 V $\pm$ 10%
Number of Phase	3		3			3		
Rated Frequency	50 / 60 Hz		50 / 60 Hz			50 / 60 Hz		
Rated Input Power	18.8 kVA 16.4 kW	19.1 kVA 16.5 kW	26.3 kVA 20.4 kW			47.7 kVA 36.8 kW		
Rated Output Current	400 A		400 A			630 A		
Rated Load Voltage	36 V		36 V			44 V		
Rated Output Current Range	10~400 A		40~400 A			60~630 A		
Rated Output Voltage Range	20.4 ~ 36 V		21.6 ~ 36 V			22.4 ~ 44 V		
Rated No-load Voltage	66.9 V	73.0 V	65.0 V			82 V	82 V	84 V
Rated Duty Cycle	60 %		60 %			60 %		
Class of Insulation	Main Transfer : Class C ; DC reactor : Class 200°C		Main Transfer : Class C ; DC reactor : Class 200°C			Main Transfer : Class C ; DC reactor : Class 200°C		
Usable Temperature Range	-10 ~ +40°C		-10 ~ +40°C			-10 ~ +40°C		
Protection Rating	IP21S		IP21S			IP21S		
External Dimensions (W x D x H)	329 x 608 x 598 (mm)		400 x 607 x 770 (mm)			508 x 724 x 894 (mm)		
Mass	56.2 kg		148 kg	151 kg	151 kg	224 kg	232 kg	242 kg
Input Cable and Grounding Cable	8 mm ² or more		14 mm ²	8 mm ²	8 mm ²	38 mm ²	14 mm ²	14 mm ²
Fuse / Breaker Capacity	40 A		75 A	50 A	50 A	150 A	100 A	100 A

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.



OTC DAIHEN Asia Co., Ltd.

- Head Office & Factory** 60/86 Mu 19, Navanakorn Industrial Estate Phase3, Klong Nueng, Klong Luang, Pathumthani 12120, Thailand.
TEL : (+66) 2529-2130-1, (+66) 2529-3335-7 FAX : (+66) 2529-2132
E-mail : otcda@otc.co.th <http://www.otcdaihenasia.com>
- Bangkok Sales Office** 23/43, Fl.16th Sorachai Bldg., 23 Soi Sukhumvit 63, Klongtonnua, Wattana, Bangkok 10110 Thailand.
TEL : (+66) 2714-3201 (Auto 5 Lines) FAX : (+66) 2714-3204
E-mail : otcda@otc.co.th
- Rayong FA Center** 500/141 Hemaraj Eastern Seaboard Industrial Estates, Moo 3, Tambol Tasit, Amphur Pluakdaeng, Rayong 21140, Thailand.
TEL : (+66) 38 964-182 FAX : (+66) 38 964-183
- Malaysia Representative Office** 3-23, IOI Boulevard, Jalan Kenari 5 Bandar Puchong Jaya 47100 Puchong, Selangor, Malaysia

OTC DAIHEN INDIA PVT.LTD

D-45, Udyog Vihar, Phase-V Gurgaon - 122016. Haryana, India

PT.OTC DAIHEN INDONESIA

Blok G1A-20, Jl. Kenari II, Delta Silicon V, Lippo Cikarang Industrial Park, Bekasi 17550 Indonesia