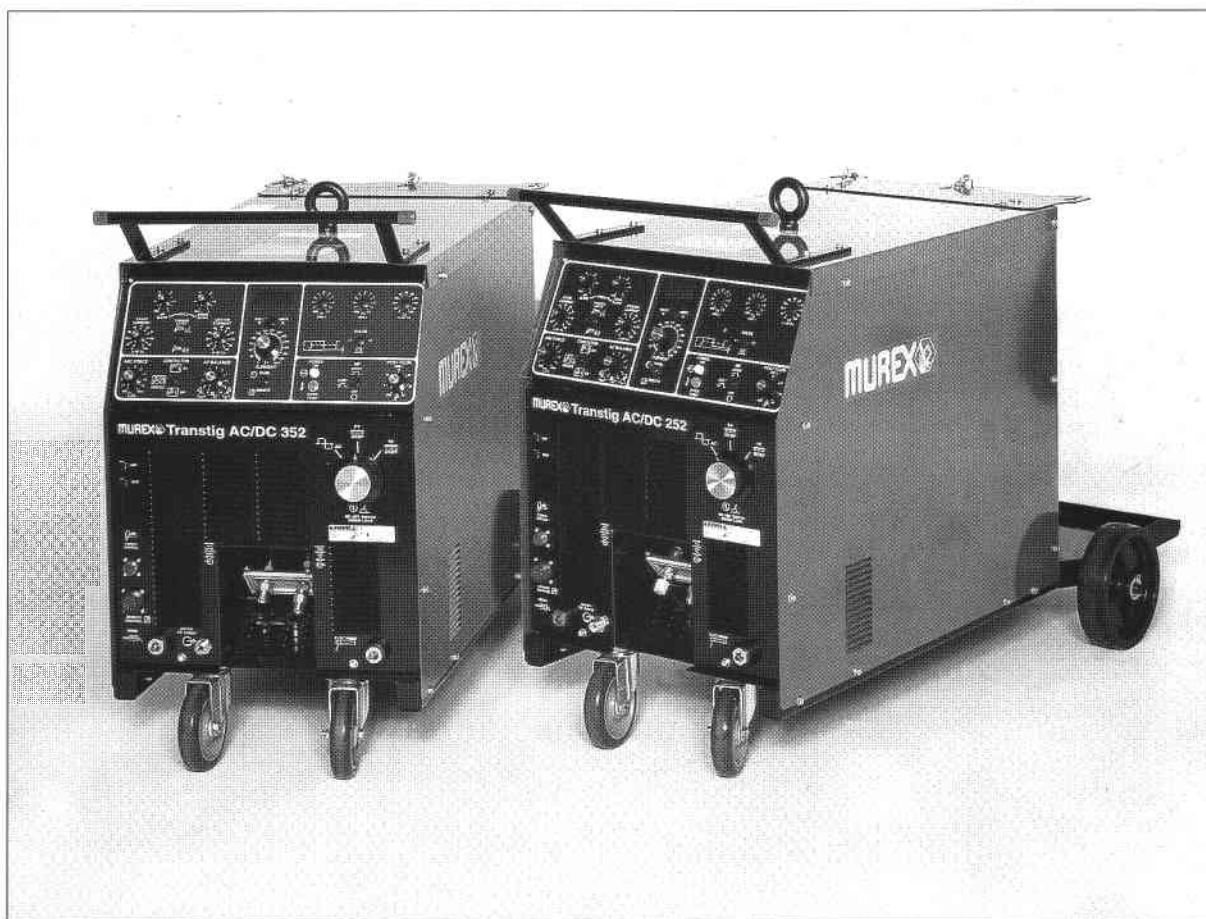




# Operating Manual

## Transtig AC/DC 252 & 352 Square Wave



**Please ensure that this  
Instruction Manual and Parts List  
is made available to the user of  
the equipment**



# DECLARATION OF CONFORMITY

## Murex Welding Products Ltd.

Declare hereby that:

**Murex Transtig AC/DC 252 & 352 Power Sources**

Part No. 1415320 & 1415321

Manufactured after 1st January 1996

- are manufactured in accordance with the Council Directive 73/23/EEC (1973-02-19) and 89/336/EEC (1989-05-03) amended by Council Directive 93/68/EEC relating to electrical equipment designed for use within certain voltage limits.
- conform with the protection requirements of Council Directive 89/336/EEC, amended by Council Directives 91/263/EEC, 92/31/EEC and 93/68/EEC relating to electromagnetic compatibility.
- are manufactured in accordance with EN60974-1 Safety Requirements for Arc Welding Equipment
- are manufactured in accordance with EN50199 Electromagnetic Compatibility for Arc Welding Equipment.

On behalf of Murex Welding Products Ltd.

Hertford Road  
Waltham Cross  
Herts. EN8 7RP  
England

A handwritten signature in cursive script, appearing to read "P. Karlsson".

-----  
P.Karlsson  
Managing Director  
Esab Welding Equipment AB  
1st January 1996

Manufactured by Esab Welding & Cutting Products  
Florence, SC. USA

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## WARNING



This welding equipment has been designed, manufactured and tested to the highest standards to ensure long and trouble free life. However, regular maintenance is an essential part of keeping the machine operating in a reliable and safe manner and your attention is drawn to any maintenance instructions that are contained in this manual.

In general, all welding equipment should be thoroughly inspected, tested and serviced at least annually. More frequent checking will be required when the equipment is heavily used.

Wear and tear, particularly in electro-mechanical and moving components, are gradual processes. Caught in time, repair costs are small and the benefits in performance reliability and safety are significant. Left alone, they can put the equipment, and you, at risk.

Have this equipment regularly inspected and maintained by an approved service centre.



## WARNING



**ARC WELDING AND CUTTING CAN BE INJURIOUS TO YOURSELF AND OTHERS. TAKE PRECAUTIONS WHEN WELDING. ASK FOR YOUR EMPLOYER'S SAFETY PRACTICES WHICH SHOULD BE BASED ON MANUFACTURERS' HAZARD DATA.**

### **ELECTRIC SHOCK - Can Kill**

- Install and earth the welding unit in accordance with applicable standards.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves, or wet clothing.
- Insulate yourself from earth and work.
- Ensure your working position is secure.

### **FUMES AND GASES - Can be Dangerous to Health**

- Keep your head out of the fumes.
- Use ventilation, extraction at the arc, or both, to keep fumes and gases from your breathing zone and the general area.

### **ARC RAYS - Can Injure Eyes and Burn Skin**

- Protect your eyes and body. Use the correct welding screen and filter lens and wear protective clothing.
- Protect bystanders with suitable screens or curtains.

### **NOISE- Excessive noise can damage hearing**

- Protect your ears. Use ear defenders or other hearing protection.
- Warn bystanders of the risks.

**READ AND UNDERSTAND THE INSTRUCTION MANUAL  
BEFORE INSTALLING OR OPERATING AND SEE WMA PUBLICATION 237  
'The arc welder at work' AVAILABLE FROM THE MANUFACTURER.**

**PROTECT YOURSELF AND OTHERS**

## SAFETY

In any arc welding or gouging operation, it is the responsibility of the user to observe certain safety rules to ensure his personal safety and to protect those working near him.

Read all safety articles relevant to arc welding published by the WMA. Pay particular attention to any **CAUTION** or **WARNING** Notes included in this manual. **CAUTION** indicates possible equipment damage. **WARNING** indicates possible hazard to life.

⚠ **WARNING** ⚠

*The ON/OFF switch on this equipment does not isolate the unit from the mains electrical supply. **AC POWER IS PRESENT ON THE ON/OFF SWITCH TERMINALS.***

*The On/Off lamp is an indication that the supply is switched on and does not imply that the unit is isolated from the supply. **BEFORE REMOVING THE COVERS FOR MAINTENANCE, ISOLATE THE UNIT FROM THE MAINS ELECTRICAL SUPPLY.***

### 1. Electrical

- ⚠ Treat electricity with respect. Even the open circuit voltage of this equipment can be dangerous. Adjustments to the torch or replacement of torch parts should be undertaken with the mains supply isolated from the unit.  
If damaged torch cables or torch components are found, the unit must be disconnected from the mains and defective parts must be replaced using only Murex spare parts.
- ⚠ Do not work on live circuits or cables. Disconnect the main power supply before checking the machine or performing any maintenance operation.
- ⚠ Be sure the case of the welding machine is properly connected to a good electrical earth.
- ⚠ Have the wiring for the welding machine installed by a qualified electrician. All connections must be made according to specifications in force and to general safety standards.
- ⚠ Do not stand in water or on damp floors while using an arc welder or cutter. Do not use in the rain.
- ⚠ Do not operate with worn or poorly connected cables. Inspect all cables frequently for insulation failure, exposed wires and loose connections.
- ⚠ Do not overload cables or continue to operate with overheating cables. Cables which are too small for the current carried will overheat, causing rapid deterioration of the insulation.
- ⚠ Pay attention that live parts of the torch do not touch any metal which is connected to the earth cable. Fix an insulated hook to hang the torch on when it is not in use.

### 1. Ventilation

- ⚠ Do not weld or cut on containers which have held combustible or flammable materials, or materials which give off flammable or toxic vapours when heated, without proper cleaning.
- ⚠ Locate the welding/cutting operation far enough from any vapour-type degreaser using trichlorethylene or other chlorinated hydrocarbons as solvents. The ultraviolet light from the arc can decompose these vapours into toxic gases at a considerable distance from the arc, even though the concentration of the gases is low enough to be undetectable by smell.
- ⚠ Be sure to provide adequate ventilation for removal and dilution of fume and gases. Fume exhaust facilities near the arc, or a ventilated helmet should be used when cutting in confined spaces or on toxic material.

### 2. Glare

- ⚠ Never look at the arc without wearing eye protection. Always use the proper protective clothing, filter glasses, and gloves. Be careful to avoid exposed skin areas. Do not use cracked or defective helmets or shields.
- ⚠ Never strike an arc when there is someone near who is not protected from the strong light of the arc.
- ⚠ Warn bystanders who are not aware of the dangers of ultraviolet light.

### 3. General

- ⚠ Take care when lifting the unit.
- ⚠ Ensure that cylinders are secured by chains.
- ⚠ Locate the unit so that there is adequate air flow to the ventilation louvres.
- ⚠ Always dress correctly to protect against glare, radiation and spatter.

### 4. Fire

- ⚠ Ensure that the correct type of fire extinguisher is available in the welding area.
- ⚠ Do not weld near flammable materials or liquids, in or near explosive atmospheres, or on pipes carrying explosive gases.

### 5. Vehicle Electrics

- ⚠ When working on motor vehicles, remove the battery and any circuitry which may be damaged by the arc.
- ⚠ Whilst welding be aware of the possibility of 'hidden wires' behind panels or bulkheads.

## INTRODUCTION

The Transtig AC/DC 252 and 352 are single or 2 phase thyristor controlled AC square wave and DC output machines designed for TIG and MMA welding applications, this includes metals such as aluminium, stainless steel, titanium and copper based materials.

The equipment features:-

- AC Waveform balance control
- Pre and Post weld gas flow
- Slope up and slope down controls
- Two stroke/Four stroke torch switch latching facilities
- MMA Arc force control
- Mains Voltage compensation
- Power Factor correction
- Polarity selector switch
- Remote control socket

Fittings on the lower front panel permit easy and quick connections of either water or air cooled TIG torches.

The built in high frequency generator can be used to provide non-contact arc initialisation in either AC or DC TIG modes. The High Frequency can also be set to continuous for AC TIG arc maintenance if required.

Internal components are cooled by a fan which draws in air through inlets in the front panel and expels it through vents in the rear panel. Thermal switches located within the units protect against overheating. A front panel indicator lamp is illuminated in the event of the thermal switch operating.

## NOTE

*In the event of the unit overheating the welding output will be cut off. If this occurs allow the unit to cool with the fan running.*

Internal circuitry is protected by front and rear panel mounted manually resettable circuit breakers.

## Transtig AC/DC 252 & 352 Technical Specification

	<b>TRANSTIG AC/DC 252</b>	<b>TRANSTIG AC/DC 352</b>
<b>INPUT</b>		
Voltage	400V ±10%	400V ±10%
Fuses	60 A slow	60 A slow
Frequency	50 Hz	50 Hz
Phase	1 (2)	1 (2)
KVA	20 KVA	25 KVA
PF	0.76	0.88
Primary Cable	3 x 10mm <sup>2</sup>	3 x 10mm <sup>2</sup>
<b>OUTPUT</b>		
Welding Range	10-320A	10-380A
Duty 40%*	250A/30V	350A/34A
60%*	200A/28V	280A/31V
100%*	160A/26V	225A/29V
OCV (AC&DC)	75V	75V
<b>CONTROLS</b>		
Pre Flow	0-5 sec (int. adj)	0-5 sec (int. adj)
Slope Up Time	0.1-5 sec	0.1-5 sec
Slope Down Time	0.1-5 sec	0.1-5 sec
Peak Time	0.05-1sec	0.05-1sec
Back Ground Time } Optional	0.05-1sec	0.05-1sec
Post Flow	3-30sec	3-30sec
<b>DIMENSIONS (excl undergear)</b>		
Length	826mm	826mm
Height	635mm	635mm
Width	463mm	463mm
Weight	190kg	215kg

\* Balanced mode - increasing imbalance reduces duty capability.

## INSTALLATION

### WARNING

*Review the safety section at the front of this manual and comply with all applicable precautions. Follow the instructions included elsewhere in this manual relative to proper installation to reduce radio interference.*

To prepare the unit for installation, several items should be checked. Clear all packing materials from around the unit and carefully inspect for damage which may have been caused by shipping. Be sure to read all the instructions before attempting to operate the unit. If a fork lift is used for lifting the unit, be sure that the lift forks are long enough to extend completely through under the base.

### IMPORTANT

*The use of lift forks too short to extend out of the opposite side of the base could cause internal damage should the tip of the lift forks penetrate the bottom of the unit. See 'Safety'.*

### Location

A proper installation site should be selected for the welding equipment if the unit is to provide dependable service, and remain relatively maintenance free.

The site should allow air movement into and out of the welding unit, and be free from excessive dust, dirt, moisture, and corrosive vapours. The location should also permit easy removal of the welding unit panels for maintenance.

### IMPORTANT

*Do not place any filtering device over the air intake passages of the unit as this will restrict the movement of air and could cause overheating and possible failure. Warranty is void if any type of filtering device is used.*

### IMPORTANT

*Electricity equipment utilising high frequency energy is capable of radiating interference. Problems, caused to equipment sensitive to HF radiation, can be reduced or eliminated by correct installation (see pages 8/9)*

## Electrical Input Connections

### WARNING

*Before making electrical input connections to the welding unit, use 'machinery lockout procedures': If the connection is to be made from a mains disconnect switch, the switch should be padlocked in the off position. If the connection is made from a fuse box, remove the fuses from the box and padlock the cover in the closed position. If locking facilities are not available, attach a red tag to the mains disconnect switch (or fuse box) to warn others that the circuit is being worked on.*

*Placing the welding unit power switch in the 'Off' position does not shut off all power within the equipment.*

*Be sure that the switch box is attached directly or by cable to a suitable ground such as a water pipe or ground rod. Do not ground to gas piping or electrical conduits. Comply with local ordinance and electrical inspection authorities.*

### Input Electrical Requirements

This AC/DC welding unit is a SINGLE-phase unit and must be connected to a SINGLE-phase power line or any two phases of a three-phase system of the proper voltage.

If there is any question about the type of the system used locally, or the proper connections to obtain single-phase primary input voltage to the welding unit, consult the local power authorities.

### Input Connections

The welding unit should be operated from a separately fused or circuit breaker-protected circuit. The maximum capacity of the welding unit is affected by the mains voltage and if the circuit is overloaded, the performance of the welding equipment will be impaired.

### NOTE

*As standard the unit is delivered for 400 - 415 v 50Hz mains input supply.*

### CAUTION

*Connect the input cable to the unit before making connections to the electricity supply lines. See Technical Specification later in this manual for input cable sizes.*

*Be sure when installing the welding unit that an earth wire is connected from the ground lug to a suitable ground. This is absolutely necessary as any development of stray currents may give a severe shock should anyone touch the welding unit and at the same time touch any grounded object. The ground lug is connected to the welding equipment chassis and is for ground purposes only. If the welding unit is to be connected to two phases of a three-phase line, do not connect the third wire from a three-phase line to the ground lug as this will result in a 'live' welding unit chassis.*

The input cable wires connect to terminals on the rear panel power ON/OFF switch accessed by removing the top panel/lid. A third conductor, the ground connection, (green/yellow) should be fastened to the ground lug located on the 'A' frame. When a commercial supply is not available the other end of the ground conductor should be attached to a suitable ground such as a water pipe, ground rod, etc. Use a grounding means that is acceptable to the local electrical inspection authorities. Clamp the mains cable firmly and leave sufficient slack in the earth wire so that, in the event of strain on the cable, the earth wire is the last to be affected.