



# PowerArc 280STH

## Specifications

<b>Process:</b>	SMAW/ GTAW-P (DC Output Only)	<b>Input:</b>	220/240V 1/3Ph 480V Optional	<b>Operating Range:</b>	Stick: 5-250A/10.2-30V TIG: 5-180A/10.2-21.2V	<b>I1Max (Inrush) 1/3Ph:</b>	52/30A	<b>Stick E6010 Capable:</b>	Yes
<b>Stick Duty Cycle:</b>	35% @ 250A	<b>OCV:</b>	70V(VRD<24)	<b>Foot Pedal Capable</b>	Yes	<b>I1Eff (Rated) 1/3Ph:</b>	30/18A	<b>Stick VRD:</b>	Yes
<b>TIG Duty Cycle:</b>	35% @ 280A	<b>Weight:</b>	60 lbs.	<b>Dimensions:</b>	17" L x 9.75"W x 25"H	<b>2T/4T Weld Sequencer</b>	Yes	<b>TIG Pulse:</b>	0-250Hz
						<b>TIG Start Type:</b>	Remote Lift/HF		

## Ready For Work.

### DC Stick and DC TIG Inverter Output

The Digital Inverter design of the PowerARC 280STH speaks for itself. It's simple, reliable and compact. It's just the right size to carry in the truck or to stick under the welding table ready to go to work whenever or wherever it is needed.

### LED Display and Simple Layout

You won't have to keep guessing what the function does or what value you are adjusting. The display and the LEDs tell you exactly what and how much you've adjusted every feature.

### 2T/4T Weld Sequencer

The welder features full control of all the functions if the unit is not to be used with the included foot pedal. Functions include Pre/Post Flow, Start/End Amps, Up/Down Slope.

### E6010 Capable

This unit provides a smooth stable arc with almost any kind of rod. The special E6010 setting allows the unit to tackle not just E6010 rods, but almost any cellosic type of welding rod. Combined with arc force, the E6010 performance can be crisp as needed.

### Standard DINSE 35 Type Connector

The unit is equipped with the DINSE 35 Type connector, which is the universal standard for connections for all major brands of welders.

### Quick Connect Gas Fitting

The quick coupler makes changing between processes fast and simple. No tools needed to connect or remove the TIG torch.

### Protective Cover

To help provide years of service, the unit is equipped with a protective cover that flips up and down. This cover can add valuable years of service to the unit by protecting the digital controls from dust, sparks and flying debris that are often created during the welding process.

### Pulse TIG up to 250Hz

For optimal control on heat sensitive materials such as sheet metal and stainless, the Pulse function is fully adjustable with not only a frequency adjustment, it also has both pulse amperage and pulse balance adjustment.

### PowerSet Function Facilitates Setup

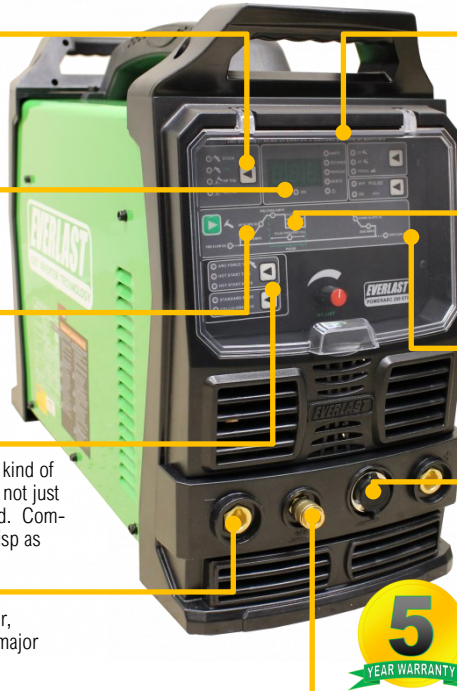
The Single control knob is used to adjust all parameters of the unit. For precise control, just turn it up or down. For rapid control, the user only needs to push in on the knob and turn, adjusting in larger increments.

### Front Control Connector

For TIG, the unit can be used with either the foot pedal, torch switch, or optional amp control slider. This type of TIG welder requires a remote connection to control the arc start whether it's High Frequency or Lift Start. The arc is never live until it is switched on for safety.

### 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, Automotive, Marine, Agricultural, Pipeline, and Portable Repair

### Ready for the shop or field.

For customers looking for the best performance for both DC TIG and DC stick welding in a compact inverter frame, the PowerARC 280STH fits the bill. The PowerARC line has long been one of our most popular products, well known for their performance and durability. The PowerARC 280STH is no exception. It features professional level features in both TIG and Stick modes that are a necessity for modern inverter welders.

The TIG feature of this unit offers provides the professional welder with many different tools to do the job. When coupled to either the foot pedal or the remote torch switch the unit offers the choice of High Frequency (contactless) start or Lift start to allow the unit to be used for DC TIG in all types of work environments. The weld sequencer works flawlessly with the torch switch in either 2T or 4T mode to control the weld cycle with pre-programmable settings such as starting and ending amperage as well as up a down slope. Of course for those that need to control heat wicking while welding or need to help prevent warping or over melting in general,

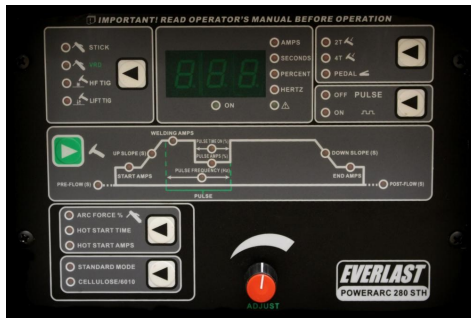
the Pulse function is fully adjustable and provides a range of .1 to 250Hz.

As a Stick welder, the PowerARC 280STH will shine in almost any type of operation, whether it is welding root passes with the special E6010 setting, or laying fill and cap passes with 7018 in the standard mode. You'll find few units that can rival the smooth spatter free welds that this unit offers in low-hydrogen welding. Of course, the unit packs enough power to operate up to 3/16" welding rods and larger. With 35% duty cycle at 250A and 60% at 200A, you'll be hard pressed to push this unit beyond it's capacity on day to day welding chores. Of course there are other pro-level features like hot start and arc force control which help start and keep the arc going when conditions aren't perfect for welding. The unit is also equipped with a VRD mode to help prevent serious shocks and injuries.

To complete the package, all controls are right on the front of the panel. There are no complicated hidden menus or confusing button presses to access certain functions, making setup a smooth easy process for even beginners.

**More details...**

## Operator Panel and Features



- Select between, Stick, Stick with VRD, HF Start TIG, and Lift Start TIG.
- Full Weld Sequencer Control for use with torch switch.
- 2T or 4T function of the Torch Switch.
- Full range of control from 5-250A for Stick and 5-280A for TIG.
- Set Pre and Post Flow for better starts and ends to TIG welds.
- Pulse function is fully adjustable.
- Set Stick Arc Force and Hot Start for smoother starts and operation.
- E 6010 stick mode can be used for all Cellulosic type stick rods.
- Standard stick mode delivers smooth low-spatter welds on other rods.
- VRD mode can be used to reduce OCV while in stick mode.
- 240 single or three phase operation. 480V optional.

## Rear View



## What's Included



- 250A Stick Electrode Holder 9.5 Ft.
- 300A Work Clamp, 9.5 Ft Cable
- Floating Ball Type Brass Regulator
- Foot Pedal
- 26 Series Air-Cooled TIG torch 12.5 Ft.
- TIG Consumable Starter Kit
- Power Cable 6.5 Ft.

## 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.

### Minimum/Maximum TIG Weld:

Maximum Single Pass DC TIG Weld: 1/2"

Maximum Multi-Pass DC TIG Weld: 1+"

Minimum Weld Thickness All Voltages: DC: .005"

### Maximum Stick Electrode Diameter

3/16"(Depending upon mfg. and type/class )

## Standard Options



## Customer Favorite Options:

- NOVA TIG Torch and Pedal Kit **Sku/Part# NVA-EPT-280STH**
- NOVA Amp Control Slider **SKU/Part# NVA-AMP-SLDR-TIG-15**
- Nova 375LF Welding Cart **SKU/Part# NVA-375LF-CART**

## Can this welder operate on a generator?

The PowerARC 280STH is a prime candidate for use with a generator due to its size and power. However, there are a few rules you need to observe if you want to operate this welder with a generator. See below for more details:

- 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 them before your purchase.
- The generator must provide at least 12,500 Surge Watts. Switch the welder off before powering down the generator. Do not run the generator out of fuel while the welder is switched on.
- Failure to do follow these recommendations may void the welder warranty.

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