



## PowerTIG 315LX

GTAW-P/SMAW

### Specifications

<b>Process:</b>	GTAW-P/ SMAW	<b>Input:</b>	240V 1Ph	<b>TIG Range:</b>	DC TIG: 10-315A, AC TIG: 20-315A	<b>I1Max (Inrush)</b>	53A	<b>I1Eff (Rated)</b>	31A
<b>TIG Duty Cycle:</b>	60% @ 315A /22.6V	<b>OCV:</b>	70V	<b>Stick Amp Range:</b>	DC Stick: 10-250A	<b>TIG Pulse Frequency DC:</b>	.5-750 Hz	<b>TIG Torch Type:</b>	18 Series Rigid 12.5 Ft (Water-Cooled)
<b>Stick Duty Cycle:</b>	35% @ 250A/30V	<b>Weight:</b>	100 lbs.	<b>Dimensions:</b>	21" L x 24"H x 11"W	<b>TIG Pulse Frequency AC:</b>	.5-750 Hz	<b>AC TIG Balance:</b>	20-80% + (positive)
						<b>AC TIG Frequency:</b>	20-500Hz		

### Ready for a Workout.

#### Sturdy Case Design

The case is well built and solid. Although it is quite solid, the unit is still light and small enough to be carried where you need it by the handle without a roll back truck. But we do have carts too if you prefer to pull it around.

#### Analog Knobs/Digital Control

While the unit enjoys the improved reliability and serviceability of internal digitally controlled components, the interface is still analog style to preserve that traditional feel, and at-a-glance knob

#### 60% Duty Cycle

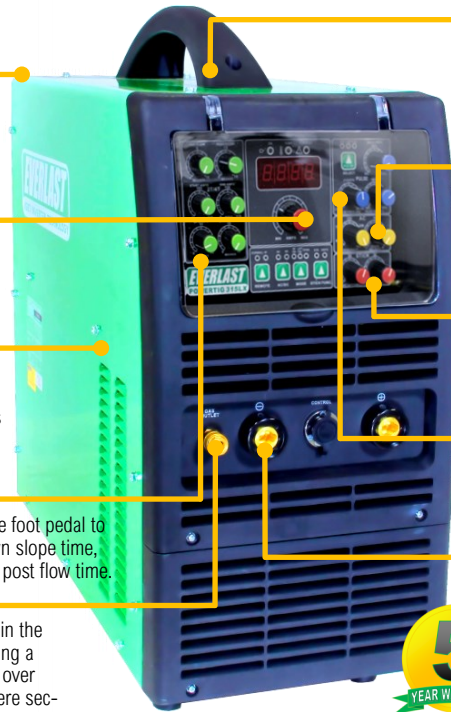
Did the extra venting give it away? The large high flow fan and generous venting of the machine of this machine helps to set the standard for industrial class machines. 60% Duty Cycle at 315A is perfect for pounding out parts and repairs day in and day out.

#### 2T/4T Torch Trigger Control

The torch trigger (included) can be used in lieu of the foot pedal to control the weld. Features such as arc up slope/down slope time, arc start/end amps are adjustable, as well as pre and post flow time.

#### 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 cart, this makes a complete package.

#### Adjustable AC Frequency and Balance

This is something you won't find on any other welders in this class, especially the range of adjustment that this unit offers. When welding in AC on Aluminum, AC frequency goes up to 500Hz to improve arc cone focus and control. A wide range of AC balance helps to keep.

#### Stick Arc Force Control and Hot Start

Improves stick welding experience by using an adjustable arc force control to control spatter and rod wet-in and Hot Start to stop rod sticking. This unit will weld with any stick rod you put to it, including E6010.

#### Fully Adjustable Pulse Function

This unit offers excellent pulse characteristics with full adjustability of all pulse functions including Pulse Amperage, Pulse Time-On, and a Pulse Frequency from .2 to 750Hz.

#### Easy Change of Polarity

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

#### 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

### A Production Minded Machine

#### Packs a Punch.

A unit with the credentials like the PowerTIG 315LX is sure to plow through any tough welding chore you may dream up. With 60% duty cycle at 315A, this unit can go the distance in any production setting where parts may be pounded out day in and day out. For serious pipe and structural fabrication, the PowerTIG 315LX has been a proven performer in the field as well.

The size and weight of this unit may be a bit heavier than some of our other units, but the unit is still small and light enough to squeeze into side cabinets on service trucks or into gang boxes so that it can be transported to right where it is needed.

Whether you are in a shop or are having to transport the machine to where it is needed, the PowerTIG 315LX has about every basic feature you could name that most customers look for in a serious commercial/industrial machine, like adjustable AC frequency up to 500Hz, adjustable AC balance control that can be adjusted between 20 and 80%, and a fully adjustable pulse in AC or DC that can go up to 750Hz if desired. Other features such as 2T and 4T torch switch (remote) control is also standard for those that find a foot pedal doesn't meet their needs. (Of course, fitted with a new,

optional wireless pedal from NOVA, the user may also find this a great alternative to a conventional wired pedal.)

For those that need both TIG and Stick features, the latest version of the PowerTIG 315LX features E6010 stick welding capability along with hot start and arc force control for easy arc starting and weld control in stick mode. You'll find that E7018 is buttery smooth and effortless to run. This machine is perfect for pipe and structural, whether you need to make a stick or TIG root pass, you can weld all the way out with this machine.

Whether it's AC or DC mode, the unit features a smooth TIG arc, among the best in the industry. The smooth, stable arc that Everlast is known for is exemplary in this machine. That's one reason why this machine is still being sought out by old-school professionals.

With 240V single phase input requirement, the unit can comfortably operate in many commercial environments, wherever there is 240V 1 phase power. If your needs are for three phase operation, Everlast can provide this upon special order to custom meet your needs. Just call us and specify your phase and voltage needs.

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All specifications, accessories and options are subject to change without notice.

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## Layout of the Panel Explained

### LED Warning Center

After confirming the unit is on and ready for use, the unit is designed to sense and report any major problems. Whatever the issue, the LED will light and unit will indicate a code in the display and out-pull will be interrupted until the issue is corrected.

### Pre/Post Flow Function

0-10, 0-30 Seconds. This helps the user to protect the weld from oxidation immediately before and after the weld by providing an adjustable amount of gas flow time before or after the weld actually takes place.

### Start/End Amps

The beginning and ending Amperage can be adjusted for improved starting and arc tail-off.

### Up/Down Slope Function

0-30/0-30 Seconds. These features are designed for exclusive use with the 2T and 4T functions with the torch switch. This controls the amount of time it takes to ramp up or taper off the welding Amps after start and before termination.

### 2T/4T or Pedal Operation

When swapping processes, the unit will briefly remind you to change the torch and polarity so you won't forget.



### AC and DC Pulse Operation

0-750Hz. The advanced pulse controls put you completely in charge of all pulse features such as **pulse frequency, pulse amperage, and pulse balance**. The pulse allows you to reduce heat related warping and burn through or improve bead appearance.

### Digital Display

Accurately select and know the Amperage.

### AC Frequency Control

20 to 500Hz. The adjustable frequency allows the user to improve arc focus and control heat spread while welding Aluminum.

### AC Balance (Cleaning) Control

10 to 90%. Control etching and amount of AC positive input while welding aluminum. Less AC positive input means the weld will have less side etching and more penetration.

### Stick Hot Start and Arc Force Control

0-100%. Change the arc start for better starts and weld characteristics while stick welding to provide a softer or more penetrating arc feel.

### TIG Start Type or Stick Welding Selector

Select TIG with HF start (controlled by the torch switch or foot pedal), TIG with lift start (also controlled by the torch switch or foot pedal) or Stick welding output.

### AC/DC Selection

Select AC to weld Aluminum and Magnesium in TIG mode. Select DC for all other weldable metals.

### Standard and E6010

In stick mode, choose between using E6010, and all other common welding rods (std. mode)

## 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: 5/8"

Maximum Multi-Pass DC TIG Weld: 1+"

Maximum Single Pass AC TIG Weld: 5/8"

Maximum Multi-Pass AC TIG Weld: 1+"

Minimum Weld Thickness All Voltages: DC: .013", AC: .023"

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

## Standard Equipment and Options



### Standard Equipment:

- 12 ft (4m) 18 Series Water-Cooled Rigid neck (Straight Head) TIG Torch
- 350A Work Clamp and 10 ft (3m) Cable
- 250A 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 375: SKU# PC330-H
- NOVA Rotaflex Water-Cooled 18 Torch, 12.5 ft. : SKU# NOVA-RF-18-35QD

## Will this unit operate on a generator?

Simply put: Yes, it can. However, the output of this machine may limit the practicality of operation on all but the largest common portable generators. The unit should never be run on an undersized generator, even at less than maximum amperages. We want you to get the best life and performance out of the unit while operating on a generator, so please follow these guidelines when choosing this welder and using your generator to match these additional 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 provide at least 13,500 Surge Watts.
- **Notice:** 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 follow these recommendations may cause damage and

**Notice:** This unit comes standard with a NEMA 6-50 240V 1 phase power plug (North American Market). This is considered the standard welder plug used in all single phase 240V welders in the USA and Canada. If you are wiring your facilities for service, contact and use a local, licensed electrician. Welders have a special code section in the NEC, under article 630 which deals specifically with welding machines. Have the electrician use and follow this code. Do not attempt to rewire the machine. The machine meets the wiring requirements for both conductor and plug size.

Everlast makes every effort to ensure accuracy of stated specifications and kit contents at time of publication. However, due to continual our efforts to improve our products and offerings, stated specifications, accessory kit content or product appearance may change without notice. Any change in specification, kit contents, appearance, length, etc. can be verified by calling toll-free @ 877-755-9353. In the event of these changes, Everlast will not be liable to provide product, kit contents, or accessories exactly as depicted or described in this publication. Please review warranty details @ <https://www.everlastgenerators.com/standard-warranty>. The 5 year parts and labor warranty covers only the power source and does not cover accessories or consumables. While this publication may be used in multiple distribution markets, the 5 year warranty only applies to US products only. Canada and other countries maintain different warranty periods and policies. Consult directly with your country's distributor about your warranty details. Accessories, including all NOVA products are covered under a separate warranty. Consumables and consumable kits are not warrantied except against manufacturer defect. Since Everlast cannot know every situation and detail of customer's application, any statement of other warranty, expressed or implied, or statement concerning suitability of this product for a specific customer use or application is specifically disclaimed. The customer is responsible for ensuring safe and practical operation of the unit and is solely responsible for the proper use and application of this product and accessories.