

PowerUltra 206Pi



Analog Input DC TIG/Stick/Plasma



Portable Possibilities.

- ▶ Carry to site to weld or cut. All in one package.
- ▶ TIG weld at 200A. Stick Weld at 160A. Cut at 50A.
- ▶ Take on more with 60% TIG/35% Stick and Plasma Duty Cycle.
- ▶ DC TIG for welding most metals except Aluminum/Magnesium.
- ▶ DC Stick for welding with welding rods such as E7018/E7014.
- ▶ Switch over to Plasma quickly with quick disconnect gas line.
- ▶ Simple Pulse function for increased versatility and heat control.

More than meets the eye.

All you need if you don't want to weld aluminum.

Let's face it. Not everyone will need to weld aluminum. Nor does everyone need to TIG weld or cut 1 inch plate. Nor does everyone need to stick weld with E6010 electrodes. In fact, most people don't ever consider it. This is why we've introduced the PowerUltra 206Pi. This new generation unit is DC only and is more than competent to handle day to day welding chores of hobbyists, small farms, and light fabrication shops. This unit is small and light and can be carried over the shoulder to exactly where you need it. In fact, if coupled with the right generator (clean power output types) this unit can be the ultimate in portable welding capability. To run this unit on a generator, you only need to have a 7500 watt generator and you are good to hook up and weld on the back forty. If it is a plow or a roll cage, this unit can weld it, and cut it. In pulse mode, you can either choose to manage the heat on thin edges, or even improve the aesthetics, depending upon which frequency you select.

Smooth, stable performance.

The arc quality of the PowerUltra 206Pi is evident as soon as you start the arc. It does everything you expect and a bit more. For TIG, you will experience one of the smoothest DC TIG arcs you will ever see. Low amp starts down to 5 amps make this unit more than capable for any steel or stainless weld sheet metal. Of course 200 amps in TIG is more than enough to get you well over the 1/2" hump if needed on steel when you multi-pass weld it. When plasma cutting, this unit is great for 3/8" and 1/2" plate steel that is so common in fabrication and agricultural products. For stick, this unit works well with common fabrication rods such as E7014 and E7018. Stainless rods work well too. With 160 amps of welding power in stick mode, this is enough to handle many rods up to 5/32" in diameter. The digital control of the unit makes welding and cutting a breeze and improves the final result.



Specifications

Process: DC Pulse TIG/DC Stick/Plasma
Input Amps: 11MAX: 120V 30A, 240V 28A ;11EFF: 120V 19A, 240V 18A
Plasma Torch Type: S-45 12.5ft. (non HF, Blowback type)
OCV: 70V (250V Plasma)
Weight: 16kg (35 lbs.)
E6010/Cellulose (Stick): Not capable

Output: TIG: 5 -200A TIG/Stick: 5-160A/Plasma 20-60A
Input Voltage: 120/240V
Pulse Hz: 1 or 25Hz, other settings pre-programmed
Fan Type: Full Time, Single Fan
Dimensions: 15"Lx11"Hx7"W
TIG Torch Type: 26 Series 12.5ft (air-cooled)

Duty Cycle: TIG: 60%@200A; TIG/Plasma 35% @ 160/50A, 40°C
Down Slope: 0-10 Seconds
Post Flow: 0-50 Seconds
Classification: Portable/Fabrication/Agricultural
Input Cable Length: 6'
DINSE Type/Size: 16-25mm²

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

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Panel Configuration and Details



1. On/OverTemp/Over Current Indicator/Psi. On verifies that power has been successfully switched on. Over Temp. indicates the duty cycle has been exceeded. Over Current indicates a power fault. PSI-ok-to-cut light indicates minimum safe cutting pressure has been reached.
2. Downslope. Adjusts the decline time of the amperage when using in 2T or 4T modes with the torch switch
3. Post Flow Sequencer. Controls gas flow time for after the weld. Is used with 2T/4T or foot pedal.
4. 2T/4T/Pedal. Select between 2T/4T torch sequencer operation or foot pedal operation.
5. TIG, Cut, Stick Mode Selector. Select desired mode for DC TIG, Plasma Cutting or DC Stick.
6. Pulse Selector. Select between off, 1 Hz pulse or 25 Hz. 1 Hz is used for timing and spacing the "dips" to improve appearance. 25 Hz is used to help control heat on welds that are prone to burn through or warping.
7. Purge Gas. Use this function to purge the gas and allow the gas to flow without triggering the arc. Aids in flow meter setup.
8. Amp Control. Adjust Welding or Cutting Amperage.
9. Air Pressure. This indicates air pressure while cutting. OK to Cut indicates minimum safe operating air pressure has been achieved in item #3. (approx. 40 psi)
10. Amp Display. Displays static (set) and dynamic (operating) amperage.

Standard Equipment and Options



Standard Kit:

- Stick Electrode Holder and 9 ft. Cable (DINSE 35 Type Adapter)
- Work Clamp and 9ft. Cable (DINSE 35 Type Adapter)
- S45 50A Plasma torch with 12.5 ft Cable/Adapter.
- 26 Series Air-Cooled TIG torch and 12.5 ft Cable (DINSE 16-25 mm2 Type Adapter)
- Argon Regulator (Floating Ball type)
- Foot Pedal (Standard Type) and torch switch
- Consumable Starter Kits for TIG and Plasma
- Adjustable Air Regulator and filter for Plasma
- 240V to 120V Pigtail adapter



Customer Favorite Options:

- PowerCart 250 SKU/ # PC250-M
- NOVA 17 Rotaflex TIG torch w/25 ft. Ultra-Flex Cable and DINSE 35 SKU/ # NVA-RF17-250-35QD
- Stubby Kit SKU/# E-WP17-26-18-SKT
- Nova Foot Pedal (long life) SKU/# EV-FP22NWI

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