



PowerTIG 325EXT

GTAW-P/ SMAW

Specifications

Process:	GTAW-P/ SMAW	Input:	240V 1/3Ph Opt. 480V 3Ph	TIG Range:	DC TIG: 5-325A AC TIG: 10-325A	I1Max (Inrush):	50A	I1Eff (Rated)	30A
TIG Duty Cycle:	35% @ 325A/22.9V	OCV:	90V VRD<24V	Stick Amp Range:	DC Stick: 20-250A	TIG Pulse Frequency DC:	.1-500 Hz	TIG Torch Type:	9 and 20 Series Rigid 12.5Ft. (Air and Water-cooled)
Stick Duty Cycle:	35% @ 250A/30V	Weight:	69 lbs.	Dimensions:	26" L x 17.5"H x 9.75"W	TIG Pulse Frequency AC:	.1-250 Hz	AC TIG Balance:	5-90% + (positive)

Get more than you think.

Sturdy New Case Design

The new case design is more robust, with additional carrying options with the combination of front and rear handles and a center handle. The size is compact enough and light enough to be easily carried right to where it is needed.

9 Program Memory

Set and save up to 9 programs that you commonly use so that they can be recalled at a moment's notice. Great for fast setup.

35% Duty Cycle at Max Output

Notice the extra venting? The fan design and generous venting of the machine of this machine helps to set the standard for commercial class machines. 60% Duty Cycle is attainable at 245A and is still one of the best you'll find in its class.

Weld Cycle Graph

The weld cycle graph gives you a visual indicator of how each function interplays with the other, and where you are along the weld process. Select and set Pre-Flow, Start Amps, Up Slope, Welding Amperage, Pulse Parameters, AC Balance, AC Frequency Control, Down Slope, End Amps and Post flow using this visual guide.

Easy Change of Polarity

This unit makes changing from TIG to Stick and back again and easy task via the use of 35mm² DINSE Type Connectors.



Water-Cooler Ready

Take a peek around back and you'll see that the unit is designed to operate in with the stackable PowerCool 375 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.

AC Wave Form Control

This unit is designed with three different useful wave forms for AC welding of Aluminum. Select from Advanced Square for quick wet-in, Soft Square for a softer, more gentle feel, Triangular Wave form for better control on thin materials and Sine wave for a traditional soft feel and broad puddle.

AC/DC Pulse with Additional Advanced AC Pulse

If heat control is needed, the unit offers a pulse feature, up to 500 Hz DC, and 250 Hz AC. For those needing extra power, or an ability to weld well over the rating of the unit on Aluminum, the Advanced AC Pulse combines the best features of AC and DC operation to provide balanced cleaning with an extra punch of penetration.

E6010 Setting

Stick weld with all rods even E6010, which is more difficult to run.

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.



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

Loaded With Power and Features

What more could you want?

What are you looking for in a TIG welder? Chances are that the PowerTIG 325EXT has everything you are wanting. Take the power output for example: 325 Amps. That's enough power to convince anyone that you are serious about your TIG welding capability. The duty cycle the PowerTIG 325 has is a strong 35%. We bet you'll give up before it does.

If you are wanting more features in a TIG welder, well the PowerTIG 325EXT has practically every basic function you can put on a TIG welder. It even has a spot timer for making consistently sized tack welds. Another significant feature is the full weld sequencer function with 2T, 4T, 2T Pedal, 4T Pedal, and Pedal operations. The sequencer in 2T and 4T modes are designed to help the user operate without the need of a foot pedal. By programming the sequencer, ramping the amperage up or down automatically can be accomplished, helping the customer to complete the welds similarly to what you would using a foot pedal to start "hot" or to taper off and fill the crater. Of course, pedal mode allows you to control the unit's amperage independently up and down as desired throughout the preset maximum range.

As a Stick Welder, the unit easily welds any 3/16" welding rod (including E6010 with the newly added E6010 setting). The unit features hot start and arc force control for those who have serious stick welding needs.

It's clear the PowerTIG 325EXT can be used as a powerful tool in your shop. Part of having power is the ability to harness it. The pulse TIG function adds to that capability, whether you need to use the pulse function to control heat wicking, or you want it to improve weld appearance the standard AC/DC pulse function is fully adjustable.

While Pulse is a big feature of this machine, the Advanced AC pulse makes this unit stand taller any other 325 to 350A welder in its class. By alternating the pulse between AC and DC, you can increase penetration up to 50%. This means this unit can do more than most 400A machines while welding aluminum. Quite simply, it means this unit is more powerful than the specifications show. Customers have reported results that this unit can penetrate aluminum 1+" in the Advanced AC pulse mode!

The wave form control also adds to the Aluminum welding capabilities by adding 4 wave forms that help you get the arc feel you are looking for.

Up Close

Memory

Select, and save up to 9 different programs.

Weld Sequence Graph Features

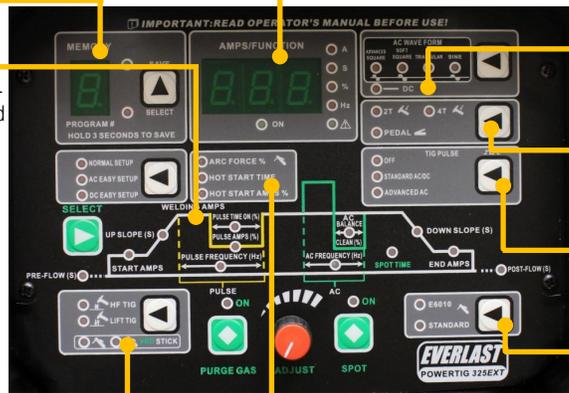
This graph represents the weld cycle and the adjustable features from the beginning of the weld to the end of the weld. Features included are:

Pre-Flow: 0-25 Seconds
 Start Amps: 3 (5) - 210A
 Up Slope: 0-25 Seconds
 Welding Amps: DC: 3-255A, AC: 5-255A
 Pulse Time ON: 5-100%
 Pulse Amps: 5-99%
 Pulse Frequency: DC: .1-500Hz, AC .1-250Hz,
 Advanced AC: .1-9.9 Hz

AC Frequency: 20-250Hz
 AC Balance: 5-95% of EP
 Down Slope: 0-25 Seconds
 End Amps: 3(5)-255A
 Spot Timer: 0-10 Seconds

Start Type/Process Selector

The unit can use HF to start the TIG arc or a lift start can be selected for use with the pedal or torch switch. The stick function allows standard start or VRD start (<24V).



Digital Display

Accurately select and know the Amperage and other functions indicated on the panel.

Wave Form Control

Select different wave forms for AC output for welding Aluminum, or select DC output for stainless, steel and other metals

2T/4T Control or Pedal Control

Select whether you want to use the included torch switch to control the weld sequence, or the foot pedal to manually control the slope and other functions.

Pulse

Control arc cone spread, heat input and directability of the arc with the standard pulse. With the Advanced AC pulse you can extend the capability while welding aluminum.

Stick Hot Start and Arc Force Control

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

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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: 1/2"

Maximum Multi-Pass DC TIG Weld: 1+"

Maximum Single Pass AC TIG Weld: 1/2"

Maximum Multi-Pass AC TIG Weld: 1+"

Minimum Weld Thickness All Voltages: DC: .005", AC: .010"

Stick Weld Maximum Electrode Diameter: 1/8 - 3/16"(Depending upon mfg. and type/class)

Standard Equipment and Options

Standard Equipment:

- 12 ft (4m) 9 Series Air-Cooled Rigid Neck (Straight Head) TIG Torch
- 12 ft (4m) 20 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 375 Water Cooler: SKU# PCW-375-240
- NOVA Wireless Pedal: SKU# NVA-WL-FP200-EV07
- PowerCart 330: SKU# PC330-H
- NOVA Rotaflex Water-Cooled 20 Torch, 12.5 ft. : SKU# NOVA-RF-20-35QD

Will this unit operate on a generator?

Yes it can. And many customers do with no issues. Keep in mind, however, the unit should never be run on an undersized generator, even at less than maximum amperages just to "get by". 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 13,000 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 void the welder warranty.

Notice: This unit does not include a power plug due to it's 1 and 3 phase configuration. For single phase use, purchase 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. For 3 Phase use you will need to use a 240V 3 phase compatible plug. There are several options for plugs when using 3 phase 240V power.

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 warranted 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.