



# PowerTIG 210EXT

GTAW-P/ SMAW

## Specifications

<b>Process:</b>	GTAW-P/ SMAW	<b>Input:</b>	120/240V 1Ph	<b>TIG Range:</b>	120/240V	DC TIG: 3-125A/3-210A AC TIG: 5-125A/5-210A	<b>I1Max (Inrush):</b>	120/240V	26.8/23.5A	<b>I1Eff (Rated)</b>	120/240V	21/19A
<b>TIG Duty Cycle:</b>	120V: 60% @ 125A/15V 240V: 60% @ 210A/18.4V	<b>OCV:</b>	80V	<b>Stick Amp Range:</b>	120/240V	DC Stick: 20-100A/20-160A	<b>TIG Pulse Frequency DC:</b>	.1-500 Hz	<b>TIG Torch Type:</b>	9 and 26 Series Rigid 12.5 Ft (Air-Cooled)	<b>TIG Pulse Frequency AC:</b>	.1-250 Hz
<b>Stick Duty Cycle:</b>	120V: 35% @ 100A/24V 240V: 35% @ 160A/26.4V	<b>Weight:</b>	62 lbs.	<b>Dimensions:</b>	26"L x 17.5"H x 9.75"W		<b>AC TIG Frequency:</b>	20-250Hz	<b>AC TIG Balance:</b>	5-90% + (positive)		

## Everything You Need.

### 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.

### 60% Duty Cycle

Notice the extra venting? The multiple fan design and generous venting of the machine of this machine helps to set the standard for commercial class machines. 60% Duty Cycle at 210A is 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 35mm<sup>2</sup> 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, or Triangular wave form for better control on thin materials.

### AC/DC Pulse with Additional Advanced AC Pulse

If fine control over heat wicking and puddle spreading 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. When set correctly, the Advanced AC pulse can turn this machine into a monster that many 300A TIG machines can't keep up with when welding Aluminum.

### 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? This also includes free warranty shipping during the first 3 years of ownership and second owner warranty transfer!

## Uses: Industrial Production Welding, Commercial Fabrication, HVAC, Motor Sports

### A Unit with a Purpose

### A Welder That Will Grow With You.

Whether you are a beginner or a seasoned professional the PowerTIG 210EXT has the dynamic ability to grow with you. The features and overall design make it easy for the novice or the pro user without weighing them down with hidden background menus and bottlenecks. Everything you need is right out front.

The dual voltage design allows the user to take the unit virtually anywhere there is power available. If you are just starting out in your garage, the 120V operation is nice and quite capable (up to 1/8") until you can get 240V installed. If you are professional, the 120V allows you to go almost anywhere without knowing exactly what kind of power is available. The Advanced pulse, in the hands of a capable user, can offer welding thicknesses up to 3/16 and 1/4" while operating on 120V. Whatever the case the dual voltage design really does expand the usefulness of this AC/DC TIG/Stick welder.

Even though you may not use them at first, features like the Standard AC/DC pulse, and the Advanced AC Pulse are there when you are ready for them to add additional heat control and range. The pulse function helps to lower heat input, and control warping and alloy migration. Any pro welder knows

the value of a tool that helps control the heat.

The unit is a good little stick welder as well for those projects that require a different approach. While welding E7018, you will find that nothing welds quite as smooth as this machine. The hot start and arc force control perfectly manage the arc as you weld. This unit will weld smoothly with just about any welding rod except E6010. If you need a cellulosic rod to do the job however, consider using E6011 in its place.

Sooner or later, every welder encounters a unique challenge in which he has to come up with new or different settings than he is used to. The memory function of the machine has you covered if this happens to be the case. The unit can save up to 9 programs that can be recalled in an instant. You won't have to fumble around to find or approximate your settings for repeating that job you did "last year". Now you can recall it just by selecting the program number where you saved it.

A fully adjustable machine like this wouldn't be complete without 2T and 4T control for use with the sequencer. By using the 2T and 4T controls, the user can virtually eliminate the need for a foot pedal.

## Up Close

### Memory

Select, and save up to 9 different programs.

### Weld Sequence Graph Features

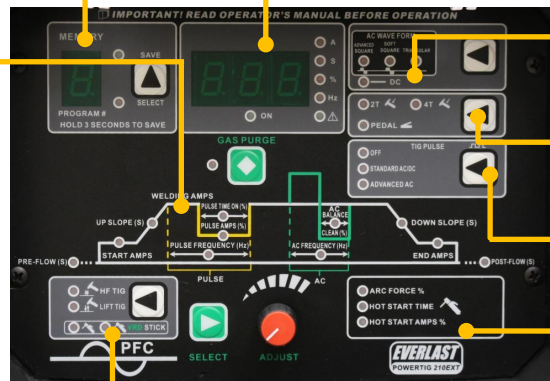
This graph represents the weld cycle and the adjustable features from the beginning of the weld to the end of the weld. Features included are:

Pre-Flow: 0-25 Seconds  
 Start Amps: 3 (5) - 210A  
 Up Slope: 0-25 Seconds  
 Welding Amps: DC: 3-210A, AC: 5-210A  
 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)-210A

### 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.

## 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:** 5/16"

**Maximum Multi-Pass DC TIG Weld:** 5/8"

**Maximum Single Pass AC TIG Weld:** 1/4"

**Maximum Multi-Pass AC TIG Weld:** 1/2"

**Minimum Weld Thickness All Voltages:** DC: .004", AC: .005"

**Stick Weld Maximum Electrode Diameter:** 1/8 -5/32"(Depending upon mfg. and type/class)

## Standard Equipment and Options

### Standard Equipment:

- 12 ft (4m) 26 Series Air-Cooled Rigid neck (Straight Head) TIG Torch
- 12 ft (4m) 9 Series Air-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)
- 240V to 120V Adapter



### 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?

Simply put: Yes, it can. 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 8,500 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 void the welder warranty.

**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.

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