

Overview of Global Heat Treatment Ltd. main products

1. Welding machine with coated electrodes			
<i>Legatee (50 Hz)</i>		<i>With inverter</i>	
Type	Parameters	Type	Parameters
SG 162 DC	Welding current 100 % b.i: 140A 80 % b.i: 60 % b.i: 160A Setting province: 10A/20,4V - 160A/26,4V Open circuit voltage: 65V Primer tenseness: 3x400V Nominal electric power: 7,2 kVA Useful electrode: Ø1,5 - Ø3,25 Nominal mains electricity: 15A Weight: 68kg	SG 140i	Welding current 100 % b.i: 110A 80 % b.i: 60 % b.i: 140A Setting province: 10A/20,4V - 140A/25,6V Open circuit voltage: 85V Primer tenseness: 230V Nominal electric power 4,5 kVA Useful electrode: Ø1,5 - Ø3,25 Nominal mains electricity: 18A Weight: 15,5 kg
SG 252 DC	Welding current 100 % b.i: 210A 80 % b.i: 60 % b.i: 250A Setting province: 10A/20,4V - 250A/30V Open circuit voltage: 70V Primer tenseness: 3x400V Nominal electric power: 11 kVA Useful electrode: Ø1,5 - Ø5 Nominal mains electricity: 25A Weight: 95kg	SG 200i	Welding current 100 % b.i: 115A 80 % b.i: 35 % b.i: 200A Setting province: 10A/20,4V - 200A/28V Open circuit voltage: 85V Primer tenseness: 3x400V Nominal electric power: 7,2 kVA Useful electrode: Ø1,5 - Ø4 Nominal mains electricity: 12A Weight: 15kg
SG 402 DC	Welding current 100 % b.i: 310A 80 % b.i: 350A 60 % b.i: 400A Setting province: 20A/20,8V - 400A/36V Open circuit voltage: 74V Primer tenseness: 3x400V Nominal electric power: 26 kVA Useful electrode: Ø1,5 - Ø6 Nominal mains electricity: 40A Weight: 180 kg.	SG 250i	Welding current 100 % b.i: 220A 80 % b.i: 250A 60 % b.i: Setting province: 10A/20,4V - 250A/30V Open circuit voltage: 85V Primer tenseness: 3x400V Nominal electric power: 9 kVA Useful electrode: Ø1,5 - Ø5 Nominal mains electricity: 16A Weight: 40kg
SG 602 DC	Welding current 100 % b.i: 465A 80 % b.i: 520A 60 % b.i: 600A Setting province: 20A/20,8V - 600A/44V Open circuit voltage: 74V Primer tenseness: 3x400V Nominal electric power: 40 kVA Useful electrode: Ø1,5 - Ø8 Nominal mains electricity: 58A Weight: 325kg	SG 350i	Welding current 100 % b.i: 300A 80 % b.i: 60 % b.i: 350A Setting province: 10A/20,4V - 350A/34V Open circuit voltage: 85V Primer tenseness: 3x400V Nominal electric power: 17 kVA Useful electrode: Ø1,5 - Ø6 Nominal mains electricity: 25A Weight: 48kg

2. CO₂ protective gas

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Type	Parameters	Type	Parameters
SG 120 C MIG	Welding current 100 % b.i: 100A 80 % b.i: 120A 60 % b.i: Setting province: 20A/15V - 120A/20V Open circuit voltage: 24V Primer tenseness: 230V Nominal electric power: 3,2 kVA Nominal mains electricity: 14A Weight: 51kg Useful wire: Ø0,6 - Ø1	S 163 imp MIG	Welding current 100 % b.i: 140A 80 % b.i: 60 % b.i: 160A Setting province: 20A/15V - 160A/22V Open circuit voltage: 40V Primer tenseness: 3x400V Nominal electric power: 4,5 kVA Nominal mains electricity: 10A Weight: 48kg Useful wire: Ø0,6 - Ø1,2
SG 162 C MIG	Welding current 100 % b.i: 140A 80 % b.i: 160A 60 % b.i: Setting province: 20A/15V - 160A/22V Open circuit voltage: 35V Primer tenseness: 3x400V Nominal electric power: 4,8 kVA Nominal mains electricity: 14A Weight: 68kg Useful wire: Ø0,6 - Ø1,2	S 253 imp MIG	Welding current 100 % b.i: 220A 80 % b.i: 60 % b.i: 250A Setting province: 20A/15V -250A/26,5V Open circuit voltage: 46V Primer tenseness: 3x400V Nominal electric power: 10 kVA Nominal mains electricity: 14A Weight: 72kg Useful wire: Ø0,6 - Ø1,2
SG 252 C MIG	Welding current 100 % b.i: 180A 80 % b.i: 60 % b.i: 250A Setting province: 20A/15V - 250A/26,5V Open circuit voltage: 40V Primer tenseness: 3x400V Nominal electric power: 9,2 kVA Nominal mains electricity: 14A Weight: 78kg Useful wire: Ø0,6 - Ø1,2	S 403 imp MIG	Welding current 100 % b.i: 320A 80 % b.i: 60 % b.i: 400A Setting province: 20A/15V - 400A/34V Open circuit voltage: 52V Primer tenseness: 3x400V Nominal electric power: 21 kVA Nominal mains electricity: 35A Weight: 87kg Useful wire: Ø0,6 - Ø1,6
SG 402 C MIG	Welding current 100 % b.i: 360A 80 % b.i: 400A 60 % b.i: Setting province: 40A/16V - 400A/34V Open circuit voltage: 43V Primer tenseness: 3x400V Nominal electric power: 20,4 kVA Nominal mains electricity: 31A Weight: 193kg Useful wire: Ø0,6 - Ø1,6	S 603 imp MIG	Welding current 100 % b.i: 480A 80 % b.i: 550A 60 % b.i: 600A Setting province: 50A/16V - 600A/44V Open circuit voltage: 62V Primer tenseness: 3x400V Nominal electric power: 40 kVA Nominal mains electricity: 55A Weight: 140kg Useful wire: Ø0,6 - Ø2,4
SG 602 C MIG	Welding current 100 % b.i: 535A 80 % b.i: 600A 60 % b.i: Setting province: 60A/17V - 600A/44V Open circuit voltage: 62V Primer tenseness: 3x400V Nominal electric power: 39 kVA Nominal mains electricity: 59A Weight: 325kg Useful wire: Ø0,6 - Ø2,4		

3. AWI direct current

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SG 162 DC TIG	Welding current 100 % b.i: 140A 80 % b.i: 60 % b.i: 160A Setting province: 10A/20,4V - 160A/26,4V Open circuit voltage: 65V Useful electrode: Ø1,5 - Ø3,25 Wolfram: Ø1-Ø2,5 Primer tenseness: 3x400V Nominal electric power: 7,2 kVA Nominal mains electricity: 15A Weight: 78kg	SG 140i TIG	Welding current 100 % b.i: 110A 80 % b.i: 60 % b.i: 140A Setting province: 10A/20,4V - 140A/25,6V Open circuit voltage: 85V Useful electrode: Ø1,5 - Ø3,25 Wolfram: Ø1-Ø2,5 Primer tenseness: 230V Nominal electric power: 4,5 kVA Nominal mains electricity: 18A Weight: 17 kg
SG 252 DC TIG	Welding current 100 % b.i: 210A 80 % b.i: 60 % b.i: 250A Setting province: 10A/20,4V - 250A/30V Open circuit voltage: 70V Useful electrode: Ø1,5 - Ø5 Wolfram: Ø1-Ø3,2 Primer tenseness: 3x400V Nominal electric power: 11 kVA Nominal mains electricity: 25A Weight: 105kg	SG 200i TIG	Welding current 100 % b.i: 115A 80 % b.i: 35 % b.i: 200A Setting province: 10A/20,4V - 200A/28V Open circuit voltage: 85V Useful electrode: Ø1,5 - Ø4 Wolfram: Ø1-Ø3,2 Primer tenseness: 3x400V Nominal electric power: 7,2 kVA Nominal mains electricity: 12A Weight: 18kg
SG 402 DC TIG	Welding current 100 % b.i: 310A 80 % b.i: 350A 60 % b.i: 400A Setting province: 20A/20,8V - 400A/36V Open circuit voltage: 74V Useful electrode: Ø1,5 - Ø6 Wolfram: Ø1-Ø5 Primer tenseness: 3x400V Nominal electric power: 26 kVA Nominal mains electricity: 40A Weight: 190 kg.	SG 250i TIG	Welding current 100 % b.i: 220A 80 % b.i: 250A 60 % b.i: Setting province: 10A/20,4V - 250A/30V Open circuit voltage: 85V Useful electrode: Ø1,5 - Ø5 Wolfram: Ø1-Ø3,2 Primer tenseness: 3x400V Nominal electric power: 9 kVA Nominal mains electricity: 16A Weight: 43kg
SG 602 DC TIG	Welding current 100 % b.i: 465A 80 % b.i: 520A 60 % b.i: 600A Setting province: 20A/20,8V - 600A/44V Open circuit voltage: 74V Useful electrode: Ø1,5 - Ø8 Wolfram: Ø1-Ø6 Primer tenseness: 3x400V Nominal electric power: 40 kVA Nominal mains electricity: 58A Weight: 335kg	SG 350i TIG	Welding current 100 % b.i: 300A 80 % b.i: 60 % b.i: 350A Setting province: 10A/20,4V - 350A/34V Open circuit voltage: 85V Useful electrode: Ø1,5 - Ø6 Wolfram: Ø1-Ø5 Primer tenseness: 3x400V Nominal electric power: 17 kVA Nominal mains electricity: 25A Weight: 51kg

4. AWI alternating current

<i>Legatee (50 Hz)</i>		<i>With inverter</i>	
Type	Parameters	Type	Parameters
		SG 250i TIG AC/DC	Welding current 100 % b.i: 220A 80 % b.i: 250A 60 % b.i: Setting province: 10A - 250A Open circuit voltage: 85V Primer tenseness: 3x400V Nominal electric power: 9 kVA Nominal mains electricity: 16A Weight: 48kg
		SG 350i TIG AC/DC	Welding current 100 % b.i: 300A 80 % b.i: 60 % b.i: 350A Setting province: 10A - 350A Open circuit voltage: 85V Primer tenseness: 3x400V Nominal electric power: 17 kVA Nominal mains electricity: 25A Weight: 56kg

5. Additional equipments

Type	Parameters	Type	Parameters
SG 42 T Wire-pusher	Supply voltage: 42/24V 50Hz Welding current: 400A Wire diameter: Ø0,8-Ø2,6 Weight: 12kg	SG 8 VH Water refrigerator circle	Coolant quantity: 8 l Primer tenseness: 230V Nominal electric power: 300 VA Weight: 12 kg
SG 402 AWI HF. Lighter unit	Nominal welder current: 400A Primer tenseness: 230V Weigh: 12kg	FET 7/450 Electrode dyer	Capacity: 7kg / 450mm Primer tenseness: 24V 50Hz Nominal electric power: 100 VA Weight: 4kg

6. Inverter galvanising power sources

Type	Parameters	Type	Parameters
S 350 Gi	Max. output current: 350A On a voltaic tub: I _{ki} =350A U _{ki} = 2V I _{primer} =3*3A Open circuit voltage: 40V Primer tenseness: 3x400V Nominal electric power: 2,5 kVA Weight: 48kg	S 600 Gi	Max. output current: 600A On a voltaic tub: I _{ki} =600A U _{ki} = 7V I _{primer} =3*18A Open circuit voltage: 70V Primer tenseness: 3x400V Nominal electric power: 12 kVA Weight: 62kg

7. Heat-treters of welded joints

Type	Parameters	Type	Parameters
VHVT-6 100A	Outgoing current/channel: 100A Temperature: max. 1000 °C Outgoing voltage: 60V Primer tenseness: 3x400V Nominal electric power: 36 kVA Weight: 350kg	VHVT-6 200A	Outgoing current/channel: 200A Temperature: max. 1000 °C Outgoing voltage: 60V Primer tenseness: 3x400V Nominal electric power: 72 kVA Weight: 500kg
VHVT-8 100A	Outgoing current/channel: 100A Temperature: max. 1000 °C Outgoing voltage: 60V Primer tenseness: 3x400V Nominal electric power: 48 kVA Weight: 400kg	VHVT-8 200A	Outgoing current/channel: 200A Temperature: max. 1000 °C Outgoing voltage: 60V Primer tenseness: 3x400V Nominal electric power: 96 kVA Weight: 630kg
VHVT-12 100A	Outgoing current/channel: 100A Temperature: max. 1000 °C Outgoing voltage: 60V Primer tenseness: 3x400V Nominal electric power: 72 kVA Weight: 520kg	VHVT-12 200A	Outgoing current/channel: 200A Temperature: max. 1000 °C Outgoing voltage: 60V Primer tenseness: 3x400V Nominal electric power: 144 kVA Weight: 730kg