



# MASTERWELD™

The Ultimate Welding Machine

## Masterweld 221 DC

**Masterweld 221** is a powerful **single Phase** Inverter for TIG DC and MMA welding with complete set of functions and excellent arc characteristics. Its reliable industrial construction is suitable for workshop use, on site and outdoor operations.

**Masterweld 221** main applications are: maintenance, food industry, hydraulics, piping and chemical plants.

Pre-set balanced parameters, stored in the **Synergic Pulse TIG DC SYN** curve, simplify Pulsed welding by **adjusting only welding current**.

Tuning of welding current can be also set from **Up-Down torch**.

Masterweld **Special HF control** provides 100% rapid and precise arc ignition.

**Friendly-user digital interface** allows precise parameters setting and includes **50 program memories**.

TIG DC standard functions include **Pre Gas, Post Gas, Up Slope, Down Slope, Start Current, Final Current**.

A wide range of adjustable **pulse frequency** together with extra parameters control (Base Current and Duty Cycle) allow operating in slow pulse and fast pulse.

Trigger control sets **2T/4T/Bi-Level** and **Spot Welding**.

**Adjustable Hot Start** and **Arc Force** and automatic **Anti Sticking** facilitate operations with **up to 3.25mm** diameter electrodes in MMA welding.



### Features

- Microprocessor controls real time welding parameters
- Slow Pulse TIG DC for thin plate and welding with TIG rod
- Fast Pulse TIG DC: focused arc, thinner welding material and lower deformations
- Remote Controlled by TIG-torch( UP-DOWN, potentiometer), pedal or RC unit
- Cooling Unit available

### Accessories

Masterweld 161T	
OVERCUT (Generator Protection)	
Electrode Holder	
Earth Cable and clamp	
WP17 TIG Torch	
Argon Regulator	
Flowmeter	
TIG Adapter	

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## Details

Input voltage	1 x 230V voltage protected $\pm$ 15% / 50-60 Hz					
Amperage draw	16A			25A		
Duty cycle	TIG			MMA		
% (40°C)	40%	60%	100%	60%	-	100%
Amps	220A	190A	160A	180A	-	150A
Amps - Min & Max	5A - 220A			10A - 180A		
Open circuit voltage (OCV)	81 - 5V					
P <sub>1MAX</sub>	5.9kVA - 5.8KW					
IP	23S					
Dimensions	460 x 230 x 325mm					
Weight	18.6Kg					

Processes: TIG DC - MMA

CE Directives: 2002/95/CE, 2004/108/CE,  
2006/95/CE

CE Standards: EN 60974-1, EN 60974-10

### Power Inverter Inside

- Higher efficiency
- Lower energy demand

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