



# Product Manual

## INVERTER BASED WELDING MACHINE



**We weld the relations**

**S.R.ELECTRICAL Co.**

<http://www.srelectricals.co.in>

**SRE S.R.ELECTRICAL Co.**

### DIRECTORY

1. ARC series Inverter DC arc welding machine 220V/380V (IGBT single tube)  
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2. ARC series Inverter DC welding machine (IGBT single tube)  
.....
3. WS Inverter type DC TIG welding machine (IGBT single tube)  
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4. NBC Inverter CO<sub>2</sub> gas shield welding machine (Split) (IGBT Single tube)  
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5. NBC Inverter CO<sub>2</sub> gas shield welding machine (one-piece) (IGBT Single tube)  
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6. ZX7 series Inverter Type DC arc welding machine (MOS)  
.....
7. WS Inverter type DC TIG welding machine (MOS)  
.....
8. ARC series Inverter DC arc welding machine 220V/380V (MOS)  
.....
9. ZX7 series Inverter DC Argon arc welding (IGBT dual module industrial models)  
.....
10. ZX7 series Inverter DC arc Welding machine (IGBT dual module industrial models)  
.....
11. NBC series Inverter gas shielded welding machine (IGBT dual module industrial models)  
.....
12. MZ series Inverter automatic submerged arc welding machine (IGBT dual module industrial models)  
.....
13. CUT series Inverter air plasma cutting machine (IGBT dual module industrial models)  
.....

### PERFORMANCE FEATURE

It adopts IGBT invert technology.

Compact design, simple operation, accurate preview of 220V welding current of single phase, three phase power supply can be used 380V, circuit automatic identification.

Using 220V single-phase power maximum electrode diameter 4.2mm, using 380V three-phase power maximum electrode diameter 5.2mm.

Suitable for acidic, alkaline, cellulose, stainless steel, cast Iron, all kinds of electrode.

Efficient energy-saving environmental protection, saving more than 80% than Ac welding machine.

Applied to the generator for power steel structure, field construction and other harsh environment.



200A-500A

### PARAMETER

Parameter / Model	ARC-250D	ARC-315D	ARC-400D
Power voltage (V)	220V/380V±15%	220V/380V±15%	
Rated input capacity (kVA)	7.1KVA	11.4KVA	20KHz
Inverter frequency (HZ)	20KHz	20KHz	20KHz
No-load voltage (V)	60V	62V	64V
Duty cycle (%)	60%	60%	60%
Current adjustment range	20-250A	20-315A	20-400A
Suitable for welding rod diameter	1.6-4.0mm	1.6-5.0mm	1.6-5.0mm
Efficiency (%)	0.98	0.98	0.98
Insulation class	F	F	F
Dimensions (mm)	460x230x400mm	460x230x400mm	460x230x400mm
Weight (kg)	9kg	11kg	13kg

### SALIENT FEATURES

1. DC Power source suitable for MMA, TIG and Carbon Air Gauging applications.
2. Excellent welding output characteristics.
3. Improve power factor and energy saver.
4. Very low running & maintenance cost.
5. Fitted on heavy duty wheel trolley & pulling handel.

### PERFORMANCE FEATURE

Inverter technique makes the welder runs in high utilization rate of power, low poen circuit loss and has good welding quality.

Suitable for SMWA/MMA welding of low carbon steel with all kinds of electrodes.



200A-500A

### PARAMETER

Parameter / Model	ARC-200D	ARC-200G	ARC-250G	ARC-315G	ARC-400G	ARC-400G
Power voltage (V)	220V/380V±15%	220V/380V±15%	220V/380V±15%	3-AC380	3-AC380	3-AC380
Inverter frequency (HZ)	50/60	50/60	50/60	50/60	50/60	50/60
Rated input capacity (kVA)	5.3	5.3	7.1	11.4	18	26
Rated input current (A)	24	24	32	17.3	24.3	33.4
Rated output voltage (V)	28	28	30	32.6	36	40
Rated welding current (A)	200	200	250	315	400	500
Insulation class	F	F	F	F	F	F
Output current (A)	20-200	20-200	20-250	20-315	20-400	20-500
Duty cycle (%)	60	60	60	60	60	60
Dimensions (mm)	371x155x295	371x155x295	440x230x340	580x340x585	580x340x585	580x340x585
Weight (kg)	7	7	7.5	20	24	36

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**PERFORMANCE FEATURE**

It adopts IGBT invert technology, high frequency arc start desing.  
 It can balance automatic voltage is waving, with high resist to electrical wave (V±15%).  
 It has high efficiency, small unload loss, save over 40% than the traditional welder.  
 It is small and light easily works in high altitude.  
 It is easily arc, small flash, low noise, stable welding arc, wonderful welding shape.  
 With inner stalling protective circuit of overheat, over-current, over-voltage and under-voltage, working safe is reliable.  
 One machine with functions can finish two program of Argon arc welding and handed electrical arc welding.



200A-500A

**PARAMETER**

Parameter / Model	WS-200A	WS-250A	WS-315A	WS-400A	WS-500A
Rated input voltage (V)	AC220V±15%	AC220V±15%	AC380V±15%	AC380V±15%	AC380V±15%
Rated input current (A)	24	32	20	28	32
Rated input capacity (kVA)	5.3	7.1	13	18	26
Rated frequency (HZ)	50/60	50/60	50/60	50/60	50/60
No-load voltage (V)	56	62	70	70	75
Output current (A)	10-100	10-250	10-315	10-400	10-500
Rated working voltage (V)	18	20	22.6	26	30
Duty cycle (%)	60	60	60	60	60
Drive adjustment (A)	-	-	0-100	0-100	0-100
Efficiency (%)	85	85	85	85	85
Power factor	0.93	0.93	0.93	0.93	0.93
Welding thickness (mm)	0.3-6	0.3-10	0.3-12	0.3-15	0.3-20
Weight (kg)	8	17	26	32	35
Diameter of longest needles (mm)	1.6-2.4	1.6-3.2	1.6-3.2	1.6-4.0	1.6-4.0

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**PERFORMANCE FEATURE**

IGBT Inverter technology, current-mode control, reliable quality, stable performance closed-loop feedback, constant voltage output, strong ability of anti-network voltage fluctuation (±15%).  
 Electronic reactor control, stable welding process, small spatter, deep bath, good shape.  
 Welding voltage is preset, no welding size of the table shows the preset voltage, the voltage  
 Simultaneous observation of the welding current, welding voltage.  
 Back to burning time is adjustable.  
 The 2T/4T option to facilitate long welding operations Arcing slow wire feed, the tip ball after welding, the operating range  
 Small size, light weight, simple operation, economical and practical.



270A-350A

**PARAMETER**

Parameter / Model	NBC-270G	NBC-350G
Power voltage (V)	380V±15%	380V±15%
Rated input current (A)	14	14
Power capacity (kVA)	9.4	13.5
Output voltage (V)	16.5-27.5	16.5-31.5
Rated output voltage (V)	27.5	31.5
Rated Output current (A)	270	350
Efficiency (η)	85%	85%
Duty cycle (%)	60	60
Drive adjustment (A)	50-270A	50-350A
Wire diameter (mm)	0.8/1.0	0.8/1.0/1.2
Power factor	0.93	0.93
Host weight (kg)	20	20
Host dimension (mm)	500x230x420	500x230x420
Wire feeder dimension (mm)	500x230x340	500x230x360
Wire feeder Weight (kg)	8	8
Applicable thickness (mm)	0.8	0.8
Insulation class	F	F
Enclosure protection class	IP21S	IP21S

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**PERFORMANCE FEATURE**

IGBT Inverter technology, current-mode control, reliable quality, stable performance closed-loop feedback, constant voltage output, strong ability of anti-network voltage fluctuation ( $\pm 15\%$ ).

Electronic reactor control, stable welding process, small spatter, deep bath, good shape.

Slow wire arcing tip ball after welding, easy arc starting

Suitable for 0.8mm thickness sheet metal welding.

Back to burning time is adjustable.

Small size, light weight, simple operation, economical and practical 0.6mm diameter wire 30A can achieve stable welding can be widely used in the automotive, steel doors and windows, furniture and other industries.

Cost saving, can completely replace the tap welder.



270A-350A

**PARAMETER**

Parameter / Model	NBC-270G	NBC-350G
Power voltage (V)	380V $\pm 15\%$	380V $\pm 15\%$
Rated input current (A)	14	14
Power capacity (kVA)	9.4	19.2
Output voltage (V)	16.5-27.5	16.5-31.5
Rated output voltage (V)	27.5	31.5
Rated Output current (A)	270	350
Efficiency ( $\eta$ )	85%	85%
Duty cycle (%)	60	60
Drive adjustment (A)	50-270A	50-350A
Wire diameter (mm)	0.8/1.0	0.8/1.0/1.2
Power factor	0.93	0.93
Host weight (kg)	26.5	26.5
Host dimension (mm)	500x273x440	500x273x440
Wire feeder dimension (mm)	560x230x360	560x230x360
Applicable thickness (mm)	0.8	0.8
Insulation class	F	F
Enclosure protection class	IP21S	IP21S

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**PERFORMANCE FEATURE**

It adopts Mosfet Inverter technology.

It can balance automatic voltage is waving, with high resist to electrical wave ( $V \pm 15\%$ ).

It has high efficiency, small unload loss, saver over 40% than the traditional welder.

It is small and light, easily work in high attitude.

It is easily arc, small flash, low noise, stable welding arc, wonderful welding shape.

With inner stalling protective circuit of over-heat, over-current, over-voltage and under-voltage, working safe is reliable.



200A-500A

**PARAMETER**

Parameter / Model	ZX7-200	ZX7-250	ZX7-250	ZX7-315	ZX7-400	ZX7-500
Rated Power voltage (V)	AC220V $\pm 15\%$	AC220V $\pm 15\%$	AC220V $\pm 15\%$	AC220V $\pm 15\%$	AC220V $\pm 15\%$	AC220V $\pm 15\%$
No-load voltage (V)	56	70	70	70	70	70
Rated input capacity (kVA)	5.3	7.1	7.1	11.4	18	26
Rated input current (A)	24	15	15	20	28	32
Rated working voltage (V)	28	30	30	32.6	36	40
Drive adjustment (A)	-	-	0-100	0-100	0-100	0-100
Efficiency (%)	85	85	85	85	85	85
Power factor	0.93	0.93	0.93	0.93	0.93	0.93
Output current (A)	20-200	20-250	20-250	20-315	20-400	20-500
Duty cycle (%)	60	60	60	60	60	60
Dimension (mm)	475x205x300	475x205x300	475x205x300	550x326x362	550x326x362	550x326x362
Weight (kg)	15	17	17	24	30	32
Welding thickness (mm)	1.5-10	1.5-12	1.5-12	1.5-12	2-20	2-30

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200A~500A

**PARAMETER**

Parameter / Model	WS-160A	WS-180A	WS-200A	WS-250A	WS-315A	WS-400A	WS-500A
Rated input voltage (V)	AC220V±15%	AC220V±15%	AC220V±15%	AC380V±15%	AC380V±15%	AC380V±15%	AC380V±15%
Rated input current (A)	24	28	32	14.4	20	28	32
Rated input capacity (kVA)	5.3	6.2	7.1	1	13	18	26
Rated frequency (HZ)	50/60	50/60	50/60	50/60	50/60	50/60	50/60
No-load voltage (V)	56	56	60	70	70	70	75
Output current (A)	10~160	10~16	10~200	10~250	10~315	10~400	10~500
Rated working voltage (V)	26.4	27.2	28	30	32.6	36	40
Duty cycle (%)	60	60	60	60	60	60	60
Drive adjustment (A)	-	-	0~70	0~70	0~100	0~100	0~100
Efficiency (%)	85	85	85	85	85	85	85
Power factor	0.936	0.93	0.93	0.93	0.93	0.93	0.93
Welding thickness (mm)	0.3~6	0.3~7	0.3~8	0.3~10	0.3~12	0.3~15	0.3~20
Weight (kg)	8	8	15	17	26	32	35
Diameter of longest needles (mm)	1.6~2.4	1.6~2.4	1.6~2.4	1.6~3.2	1.6~3.2	1.6~4.0	1.6~4.0

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200A~400A

**PARAMETER**

Parameter / Model	ARC-200	ARC-250	ARC-315	ARC-400
Rated input voltage (V)	220V/380A±15%	220V/380A±15%	220V/380A±15%	220V/380A±15%
Rated input current (A)	24	15	20	28
Rated input capacity (kVA)	5.3	7.0	13	18
No-load voltage (V)	56	62	70	70
Output current (A)	20~200	20~250	20~315	20~400
Rated working voltage (V)	28	30	32.6	36
Duty cycle (%)	60	60	60	60
Drive adjustment (A)	-	-	0~100	0~100
Efficiency (%)	85	85	85	85
Power factor	0.93	0.93	0.93	0.93
Welding thickness (mm)	1.5~10	1.5~12	1.5~12	2~20
Weight (kg)	8.5	17	24	30
Overall dimension (mm)	475x205x300	475x205x300	550x326x362	550x326x362

**SALIENT FEATURES**

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5. Fitted on heavy duty wheel trolley & pulling handel.



**PERFORMANCE FEATURE**

MMA Arc welding for ZX& series inverter.  
 Adopting IGBT technology, environment-friendly, saving power small measurement, low weight.  
 Width electric fence and voltage design, above±20%. Full protection feature; Dig splay parameter preparation function.  
 Full range non switch technology coupled with world famous brand element reliable and durable.  
 Having thrust and start arc function, easy welding, remote control, easy using.  
 Large welding capacity excess 100m cable can be add suitable for most welding material.



400A-630A

**PARAMETER**

Parameter / Model	ZX7-400A	ZX7-500A	ZX7-630A
Power voltage (V)	380/50/60	380/50/60	380/50/60
Rated input capacity (kVa)	17	24	33
Open circuit voltage (V)	67.5	80	80
Rated welding voltage (V)	36	40	44
Duty cycle (%)	60	60	60
Rated welding current (A)	400	500	630
Current adjust range (A)	20-400	20-500	20-630
Voltage adjust range (A)	20.8-36	20.8-40	20.8-44
Rated input current (A)	26	36.5	50
Efficiency (%)	≥0.85	≥0.85	≥0.85
Power factor	≥0.93	≥0.93	≥0.93
Dimensions (mm)	576x297x574	576x297x574	686x322x584
Weight (kg)	40	50	58

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**PERFORMANCE FEATURE**

One machine can complete argon arc welding, arc processes two.  
 Significantly reduce the copper loss, improve the welding efficiency, obvious energy saving effect.  
 Digital meter, the welding current can be precisely presets.  
 With easy arc starting, small spatter, stable current, forming good feature.  
 With multiple protection function temperature protection, over current protection, short circuit protection inverter frequency is 20KHZ small volume, light weight.  
 Has the fluctuation of voltage automatic compensation function strong resistance to power fluctuation, the welding current is stable and reliable.  
 Arc force with the welding cable length adjustment, realize remote welding.  
 Can be widely applied to various pH electrodes welding.



400A-630A

**PARAMETER**

Parameter / Model	ZX7-400STG	ZX7-500STG	ZX7-630STG
Supply voltage (V)	380V±15%	380V±15%	380V±15%
Rated input capacity (kVa)	18.4	25	35
Rated input current (A)	36	40	50
No-load voltage (V)	67.5	80	80
Duty cycle (%)	60	60	60
Current adjust range (A)	20-400	20-500	20-630
Enclosure protection class	IP21S	IP21S	IP21S
Best workpiece class	1-15	1-20	1-25
Efficiency (%)	85	85	85
Power factor	0.95	0.95	0.95
Dimensions (mm)	576x297x557	636x322x582	636x322x582
Weight (kg)	43	50	55

**SALIENT FEATURES**

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### PERFORMANCE FEATURE

NBC Series inverter arc welding machine suitable for Co2 gas shield Semiautomatic welding and automatic welding, the best type for increase of efficiency welding.

Adopting IGBT technology, environment-friendly, saving power, small measurement, low weight.

Width electric fence and voltage design, above±20% full protection feature: Digisplay parameter preparation function.

Full range non switch technology couples with world famous brand element Reliable and durable.

Have receive arc select function and electric arc stiffness function easy Welding.

Low current performance exceptional suitable for lamella welding and all-Position welding.

Advance wire feed circuit, wire feed steady stable welding.

Large welding capacity excess, 100m cable can be add, suitable for most Welding material.



350A~630A

### PARAMETER

Parameter / Model	NBC-350	NBC-500	NBC-630
Power voltage (V)	380/50/60	380/50/60	380/50/60
Duty cycle (%)	60	60	60
Open circuit voltage (V)	60	70	70
Rated welding voltage (V)	31.5	39	44
Rated welding Current (A)	350	500	630
Current adjust range (A)	30~350	40~350	50~630
Voltage adjust range (V)	15.5~31.5	16~39	16.5~44
Rated input capacity (KVA)	13.5	21.8	31
Rated input current (A)	18.8	33	46.8
Efficiency (η)	≥0.85	≥0.85	≥0.85
Power factor (cosφ)	≥0.93	≥0.93	≥0.93
Power volume (mm)	576x297x574	686x322x584	686x322x584
Weight	40	48	55

### SALIENT FEATURES

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### PERFORMANCE FEATURE

MZ series inversion type submerged arc welding machine is used for the Submerged arc welding, Carbon arc gouging, manual welding and electroslag welding:

MCU digital circuit, simple human-machine interface. Convenient operation:

It can store the welding regulation, and 9 sets of welding regulation may be pre-Stored:

Adopting IGBT Technology: environment-friendly saving power small Measurement low weight:

Width electric fence and voltage desing above ±20% full protection feature Digisplay parameter preparation function:

Full range non switch technology coupled with world famous brand element Reliable and durable:

The arc current and constant current are continuously adjustable welding Stable, welded joint is beautiful can weld carbon steel stainless steel heat resistant

Steel and composite steel plate:

The diameter of welding stick≥3:

Submerged arc method from scratch compatible withdrawn from the arc and Back arc, arcing high success rate:

It is easy to weld car, wire feed device for the coupled wheel drive elastic

Pressure wire to ensure smooth and reliable for wire



630A~1250A

### PARAMETER

Parameter / Model	MZ-630	MZ-1000	MZ-1250
Power voltage (V)	380/50/60	380/50/60	380/50/60
Duty cycle (%)	100%	100%	100%
Open circuit voltage (V)	SAW Hand Welding	SAW Hand Welding	SAW Hand Welding
Rated welding voltage (V)	44	44	44
Rated welding Current (A)	630	1000	1250
Current adjust range (A)	50~630	50~1000	50~1250
Voltage adjust range (V)	22~44V	22~44V	22~44V
Rated input capacity (KVA)	34	55	69
Rated input current (A)	52	83	105
Efficiency (η)	≥0.85	≥0.85	≥0.85
Power factor (cosφ)	≥0.88	≥0.88	≥0.88
Power volume (mm)	530x320x600	767x352x802	767x352x802
Weight	55	95	108

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**PERFORMANCE FEATURE**

One machine can complete argon arc welding, arc processes two. Significantly reduce the copper loss, improve the welding efficiency, obvious energy saving effect.  
 Digital meter, the welding current can be precisely presets.  
 With easy arc starting, small spatter, stable current, forming good feature.  
 With multiple protection function temperature protection, over current protection, short circuit protection inverter frequency is 20KHZ small volume, light weight.  
 Has the fluctuation of voltage automatic compensation function strong resistance to power fluctuation, the welding current is stable and reliable.  
 Arc force with the welding cable length adjustment, realize remote welding.  
 Can be widely applied to various pH electrodes welding.



70A-120A

**PARAMETER**

Parameter / Model	ZX7-400STG	ZX7-500STG	ZX7-630STG
Supply voltage (V)	380V±15%	380V±15%	380V±15%
Rated input capacity (kVA)	7	15	25
Rated output voltage (V)	108	120	128
Output load voltage (V)	380	400	400
Duty cycle (%)	60	60	60
Cutting gun use air pressure (MPa)	≥0.45	≥0.45	≥0.45
Cutting current adjust range (A)	20-70	20-100	20-120
Rated load voltage (V)	110	120	129
Maximum cutting thickness (mm)	18	30	35
Cutting gas flow (L/min)	250	250	250
Power factor	0.95	0.95	0.95
Enclosure protection class	IP21S	IP21S	IP21S
Dimensions (mm)	576x297x557	576x297x557	576x297x557
Weight (kg)	40	43	43.5

**SALIENT FEATURES**

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**PERFORMANCE FEATURE**

- The function of welding rectifier are forced air-cooled, silicon type and are designed designed to provide a DC welding current where 3 phase, 50 Hz AC mains power is available at voltage ranging from 380 to 440.
- Very low maintenance cost 100% copper winding.
- Simple operation.
- Minimum maintenance
- Low running cost.
- No breakdown.
- Reduces spatter and offer ideal welding results.
- Ideal for site work / construction work.



A-40 D

**PARAMETER**

Parameter / Model	A.40D	A.60.D
Rated input (V/Ph./Hz.)	415/3 Ph./ 50 Hz.	415/3 Ph./ 50 Hz.
Input current at max. output (A)	40	65
Open circuit voltage (OCV) max	75	75
Output current (A) 100% duty cycle	310	460
(B) 60% duty cycle	400	600
Power capacity (kVA)	25.1	34.5
Welding current range (A)	40-400	60-600
Insulation class	F	F
Protection class	IP21	IP21
Type of cooling	Forced air	Forced air
Usable electrodes size (mm)	2.5-5.0	2.5-6.3
Dimension (mm)	725x525x875	725x525x975
Weight (kg)	225	285

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3. Improve power factor and energy saver.
4. Very low running & maintenance cost.
5. Fitted on heavy duty wheel trolley & pulling handel.





NBC-500



NBC



ARC-400



ARC-200

ZXY-5TG





PUG. CUTTER



GAS CUTTING & WELDING

ACCESSORIES



EU-20 Connector

MIG



TIG



PLASMA



PUG. CUTTER



GAS CUTTING & WELDING

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TIG



PLASMA



# Technological Innovation Energy Saving

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