



for Welding Excellence

25 Years
Consistency
in quality
& service

INVA TIG series (IGBT)

INVA TIG & INVA PULSETIG

Main Features

- Soft switch technology, Improved IGBT switching and Reliable
- Robust and sturdy design.
- TIG, PULSETIG and MMAW welding facility.
- Smooth and 100% Arc striking suitable for automation.
- Pulsetig facility to minimize the job distortion.
- Adjustable Gas Pre-and Post flow.
- Adjustable upslope and down slope time for welding current.
- 2 step / 4 steps facility for torches.
- All the Major parts like IGBT module, Power devices, Relay, and Rectifier and so on are world famous brand with high reliability.



BUILT IN FUCTION FOR HIGH QUALITY PULSETIG WELDING

Initial current control: To prevent burn through for thin sheets and to confirm the ignition of the Arc.

Upslope time control: To retained the weld quality at welding start by smooth changing from initial current with upslope control.

Pulse current control: Able to choose any pulse current as desired.

Pulse frequency control: To change number of welding bead ripple and bead width.

Welding current control: The welding current and the crater can be continuously adjusted even during the welding from minimum current of 5 Amps to the rated current through the remote control unit or the potentiometer mounted on the power source.

Down slope time control: Down slope time control from smooth and perfect finish of welding. To prevent crater and defect in welding like crack etc.

Post flow timer for shielding gas: To prevent oxidation of weld bead at the end of welding and to increase the life of tungsten Electrode.

Arc spot timer control: To ensure tack welding of the plates before the actual welding.

Perfect Welding... Higher Productivity

TECHNICAL SPECIFICATIONS

INVA PULSETIG

Parameter	Model	
	INVA TIG-300 P (IGBT)	INVA TIG-400P (IGBT)
Input supply voltage (V/Hz)	3 Ph ~415VAC, + 10%, 50/60 Hz	
Rated input power(KVA)	10.9	15.3
Rated input current (A)	16.6	23.2
Open circuit voltage (V)	74	
Rated welding voltage (V)	22.6	26
Current Adj. Range (A)	10 ~ 300	10 ~ 400
Current Upslope time (Sec)	0.1 ~ 2.5 adjustable	
Current Down slope time (Sec)	0.1 ~ 12 adjustable	
Gas Pre-flow time (Sec)	0.1 ~ 0.3	
Gas Post-flow time (Sec)	4 ~ 6	
Spot welding time (Sec)	(4 - 6) ~ (11 - 13) adjustable	
Pulse current range (A)	10 ~ 300	10 ~ 400
Pulse current time range (Sec)	0.005 ~ 2.5	
Background current range (A)	10 ~ 300	10 ~ 400
Background current time range (Sec)	0.005 ~ 2.5	
Rated duty cycle (%)	60 %	
Insulation Class	F	
Protection Grade	I P 2 1 S	
(L x W x H) Dimensions (mm)	625 x 310 x 570	
Weight (Kg)	43	45



WATER COOLING UNIT

Suitable for InputSupply	: 230 V
Tank capacity	: 75 Ltrs.
Output signal	: No Contacts
Over all size	: Length 700 mm
	Width 400 mm
	Height 550 mm

Along with built in Radiator, Cooling Fan, Pump Motor and Pressure Switch.

INVA TIG

Parameter	Model		
	INVATIG - 300S (IGBT)	INVATIG - 400S (IGBT)	INVATIG - 500S (IGBT)
Input supply voltage (V/Hz)	3 ~ 415VAC, + 10%, 50/60 Hz		
Rated input power(KVA)	10.9	15.3	19.9
Rated input current (A)	16.6	23.2	30.3
Open circuit voltage (V)	75	75	80
Rated welding voltage (V)	22.6	26	30
Current Adj. range (A)	10 ~ 300	10 ~ 400	10 ~ 500
Current upslope time (Sec)	0.1 ~ 2.5 adjustable		
Current Down slope time (Sec)	0.1 ~ 12 adjustable		
Gas pre-flow time (Sec)	0.1 ~ 0.3		
Gas post-flow time (Sec)	4 ~ 6		
Rated duty cycle (%)	60 %		
Insulation Class	F		
Protection Grade	I P 2 1 S		
(L x W x H) Dimension (mm)	625 x 310 x 570		
Weight (Kg)	43	45	50



Gas cooled
Model SR - 26

Water cooled
Model WP - 18



REMOTE CONTROLLER

Adjustment	0 to maximum current continuous variable
Cable Length	5 meters

STANDARD SCOPE OF SUPPLY

Power source	01 No.
Gas cooled torch 4m length of appropriate capacity	01 No.
Argon regulator cum flow meter	01 No.
Gas hose of 3 mtrs. Length	01 No.
Earthing cable of 3 mtrs.length	01 No.

OPTIONAL ACCESSORIES (AT EXTRA COST)

Remote control unit
Water cooling unit
Water cooled torch
Auto Tig feeding systems

*Standard supply covers roller / contact tips shown in the brackets. Others sizes are optional at extra cost.



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(In view of continuous development, we reserve the right to modify the design and / or dimensions without notice)