

# GALA ELECTRONICS 221ACDC

## Gala Electronics

Ref:2200221ACDC



Gala Electronic 221 AC/DC is a high sophisticated single Phase Inverter TIG AC/DC portable welding machine.

In TIG DC mode this inverter generator can easily weld ordinary steels, stainless steel and copper.

Gala Electronic 221AC/DC is particularly indicated for extremely precise constructions, in petrochemical plants, food industry and other activities which require very high welding performance.

The EXTRA FUSION function allows to shift the waveform towards the negative part with respect to zero. This makes it possible to create a highly penetrative and precise fusion bath, so that very light gauge sheets can be welded with an electrode tip comparable to that of an electrode for DC- TIG welding.

The MIX AC-DC wave allows to combine the efficacy of AC TIG welding with the high penetration of DC TIG welding, thus obtaining high welding speed and creating the weld puddle rapidly on a cold work piece. It is also possible to weld heavier aluminium gauges with lower amperage compared to standard AC/DC TIG welding.

The PULSE AC/DC welding is besides useful when welding for long time, in order to reduce the deformation on the base material.

50 programs can be loaded and saved in memory

Mains voltage	1x230V~± 15%/50-60 Hz					
Mains protection	16A DELAYED					
Welding mode	MMA			TIG		
Duty cycle (40°C)	40%	60%	100%	35%	60%	100%
Welding current (A)	180	150	120	220	180	160
Welding load voltage (V)	27,2	26	24,8	18,8	17,2	16,4
Maximum absorbed power (KVA)	6,2	4,7	3,6	5,4	4,2	3,6
Maximum absorbed voltage (A)	30	22,3	16,3	25,7	20,2	16,3
Max. absorbed effective voltage (A)	18,9	17,2	16,3	15,2	15,6	16,3
No-load voltage (V)	80					
Insulation class	H					
Protection degree	IP23					
Cooling	AF					
Manufacturing standards	EN 60974-1/-10					
Generator dimensions (L x P x H)	230 x 460 x 325mm					
Generator weight	18 Kg					



# Welding solutions

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