



Handy Electronic TIG
The small welding rectifier for TIG
and hand welding





Handy Electronic TIG is a manual welding rectifier which can be used for just about every type of welding work. It is the ideal machine for small repairs and production uses, service workshops, light gauge metal industries, and maintenance work in public buildings, hospitals and schools etc. In addition, the Handy Electronic TIG is ideal for hobby pastimes thanks to the ease with which it is used and handled.

Technical data

Load capacities

130 A/25 V at 20 % duty cycle
85 A/23 V at 60 % duty cycle
65 A/22 V at 100 % duty cycle

Setting range

5–130 A DC

Open circuit voltage

62 V

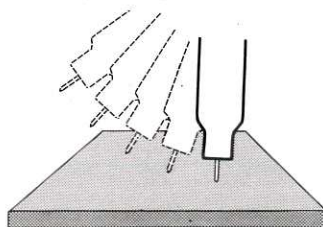
Construction

Handy Electronic TIG is a thyristor-controlled single-phase rectifier. A potentiometer on the front panel gives stepless welding current settings between 5 and 130 A. The mains switch incorporates a pilot lamp which shows when the rectifier is alive. TIG welding is done with thorium-alloyed tungsten rods \varnothing 1.6 mm and hand welding with covered rods of \varnothing 1.6 mm to \varnothing 3.25 mm.

All weldable metals can be manually welded with covered rods, including non-alloy and low-alloy steels, stainless steel, aluminium, copper and bronze. The high open circuit voltage of 62 V makes striking easy.

TIG welding

Tungsten rods are struck by moving the rod in a circular movement down against the workpiece. Just a light scratch is sufficient to strike the arc. Lift off approximately 3–4 mm after striking which will give just the right TIG arc. To avoid visible "striking marks" on the



Mains connections:

Voltage V 380
Primary current A 8
Fuse (slow) A 16

Weight

32 kg

Dimensions

With platform and wheels: Height 310 mm, Width 260 mm, Depth 330 mm.

workpiece, it is advisable to strike in a joint so that subsequent welding will cover the mark. You can weld thin plate and stainless steel materials both with and without filler material. Shielding gas is Argon.

BTB 130 G

An extremely small and versatile gas-cooled torch for low-welding currents. The BTB 130 G has a built-in gas valve and requires no operating switch. Just open the gas valve fully before "scratch starting" the TIG arc.



The standard version of the Handy Electronic TIG is for stationary use. When you buy a Handy Electronic, you get everything needed for manual welding with covered rods – mains cable (2.5 m), welding and earth-return cables (2x3 m) complete with rod holder and earth return clamp. In addition, the kit includes a welding screen, a chipping hammer and a wire brush. For TIG welding you will require the BTB 130 G which has standard features, a clamping sleeve, gas cowl and holder for \varnothing 1.6 mm rods.

A TIG trolley with a shelf for a gas bottle is available as an optional extra.

Order numbers

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| Handy Electronic | |
| 38 V/50 Hz | 347 140-881 |
| BTB 130 G | 365 425-880 |
| OKC 25, coupling for TIG | 160 360-880 |
| Thorium-alloy tungsten rods \varnothing 1.6 mm | 151 574-002 |
| TIG trolley | 365 145-880 |
| Spare parts for BTB 130 G | |
| Gas cowl no. 5 | 365 310-045 |
| Clamping sleeve \varnothing 1.6 mm | 365 310-029 |
| Rod holder \varnothing 1.6 mm | 365 310-038 |



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