



# TransPulsSynergic 3200 / 4000 / 5000

## Processes

MIG welding  
MIG/MAG pulsed arc welding  
MIG brazing  
TIG-DC  
Manual electrode (MMA) welding  
Arc-air gouging (TPS 5000)

## Recommended base metals

Constructional steels  
Coated constructional steels  
Ferritic / austenitic CrNi steels  
Duplex steels  
Nickel-based materials  
Aluminium materials  
Special materials  
Copper materials (TPS 5000)  
Special materials (TPS 5000)

## Recommended areas of use

Automobile and allied vendor industries  
Construction of special vehicles and construction machinery  
Maintenance and repair  
Construction of plant, containers, machinery, structural steel  
Robot welding  
Industry plant & pipeline construction, site-erection firms  
Construction of rail vehicles & rolling stock  
Shipbuilding and offshore engineering

## Standard equipment

2-1/4-roller drive  
Automatic cooling-unit cut-out  
Wire-inching without gas or current  
Earth leakage monitoring  
Automatic burn-back control  
Gas-test button  
Job mode  
Manual welding  
Synergic mode  
S-mark, CE-mark  
Thermostat-controlled fan

UpDown control from torch  
Overtemperature protection  
2-step mode, 4-step mode  
Manual-/Spot-welding  
Aluminium welding start-up  
Digital display  
Wire coil adapter

## Options

Remote control  
PullMig mode  
Robot interface  
"Human" hosepack boom  
Keylock switch  
Welding programs from databank  
Spatter-free ignition SFI  
SynchroPulse  
JobExplorer / WIN RCU  
Weld Process Data  
Special step mode  
Calibrationdocument

Power source		TPS 3200	TPS 3200 MV	TPS 4000	TPS 4000 MV	TPS 5000	TPS 5000 MV
Mains voltage	+/-10 % 50/60 Hz		3 x 200 – 240 V		3 x 200 – 240 V		3 x 200 – 240 V
	+/-10 % 50/60 Hz		3 x 380 – 460 V		3 x 380 – 460 V		3 x 380 – 460 V
	+/-15 % 50/60 Hz	3 x 400 V		3 x 400 V		3 x 400 V	
Cos phi		0,99 (320 A)	0,99 (320 A)	0,99 (400 A)	0,99 (400 A)	0,99 (500 A)	0,99 (500 A)
Welding current range		3 – 320 A	3 – 320 A	3-400 A	3-400 A	3-500 A	3-500 A
Welding current at	10 min/40° C 40 % d.c.	320 A	320 A		400 A	500 A	500 A
	10 min/40° C 50 % d.c.			400 A			
	10 min/40° C 60 % d.c.			365 A	365 A	450 A	450 A
	10 min/40° C 100 % d.c.	210 A	190 A	320 A	300 A	360 A	320 A
	10 min/25° C 100 % d.c.			365 A		450 A	
Open-circuit voltage		70 V	70 V	68 – 78 V	68 – 78 V	68 – 78 V	68 – 78 V
Operating voltage		14,2 – 30,0 V	14,2 – 30 V	14,2 – 34,0 V	14,2 – 34,0 V	14,2 – 39,0 V	14,2 – 39,0 V
Protection class		IP 23	IP 23	IP 23	IP 23	IP 23	IP 23
Weight	lbs. / kg	76.28 / 34,6	76.28 / 34,6	77.61 / 35,2	77.61 / 35,2	78.48 / 35,6	78.48 / 35,6
Dimension l x w x h	inch	24.61 x 11.42 x 18.70	24.61 x 11.42 x 18.70	24.61 x 11.42 x 18.70	24.61 x 11.42 x 18.70	24.61 x 11.42 x 18.70	24.61 x 11.42 x 18.70
	mm	625 x 290 x 475	625 x 290 x 475	625 x 290 x 475	625 x 290 x 475	625 x 290 x 475	625 x 290 x 475

## Wire feed unit

		VR 2000	VR 4000	VR 4000 Yard	VR 7000
Wire Ø	inch	0.03 – 0.06	0.03 – 0.06	0.03 – 0.06	0.03 – 0.06
	mm	0,8 – 1,6	0,8 – 1,6	0,8 – 1,6	0,8 – 1,6
Wire feed speed	ipm	19.69 – 866.14	19.69 – 866.14	19.69 – 866.14	19.69 – 866.14
	m/min	0,5 – 22	0,5 – 22	0,5 – 22	0,5 – 22
Weight	lbs. / kg	19.84 / 9	35.27 / 16	24.69 / 11,2	38.58 / 17,5
Dimension l x w x h	inch	20.47 x 12.60 x 8.46	25.59 x 11.42 x 16.14	24.02 x 8.72 x 15.75	25.20 x 10.24 x 16.93
	mm	520 x 320 x 215	650 x 290 x 410	610 x 210 x 400	640 x 260 x 430

## Cooling unit

		FK 4000*	FK 4000 R
Cooling capacity (25° C) Q = 1/min		1120 W	1360 W
Max. throughput	gal./min / l/min	0.42 / 1,6	0.92 / 3,5
Coolant volume	gal. / l	1.45 / 5,5	1.45 / 5,5
Weight (without coolant)	lbs. / kg	31.09 / 14,1	35.94 / 16,3
Protection class		IP 23	IP 23
Dimension l x w x h	inch	27.56 x 11.42 x 9.84	27.56 x 11.42 x 9.84
	mm	700 x 290 x 250	700 x 290 x 250

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\* recommended to max. 5m connection hose pack and with low duty circle.

-2 = with separate wire feed unit • 2R = wire feed unit 2 wheel drive • 4R = wire feed unit 4 wheel drive • D = Dinse connection • E = Euro connection • I-kit= installation kit • F = F connection • R = rotation pump • F++ = Fronius connection with external water • G = gascooled • MV = Multivoltage • ø = diameter • SFI = spatter free ignition • C-kit = conversion kit • W = watercooled • H = semicircular groove smooth • R = semicircular groove knurled • MZ = with teeth • OZ = without teeth • T = trapezoid groove