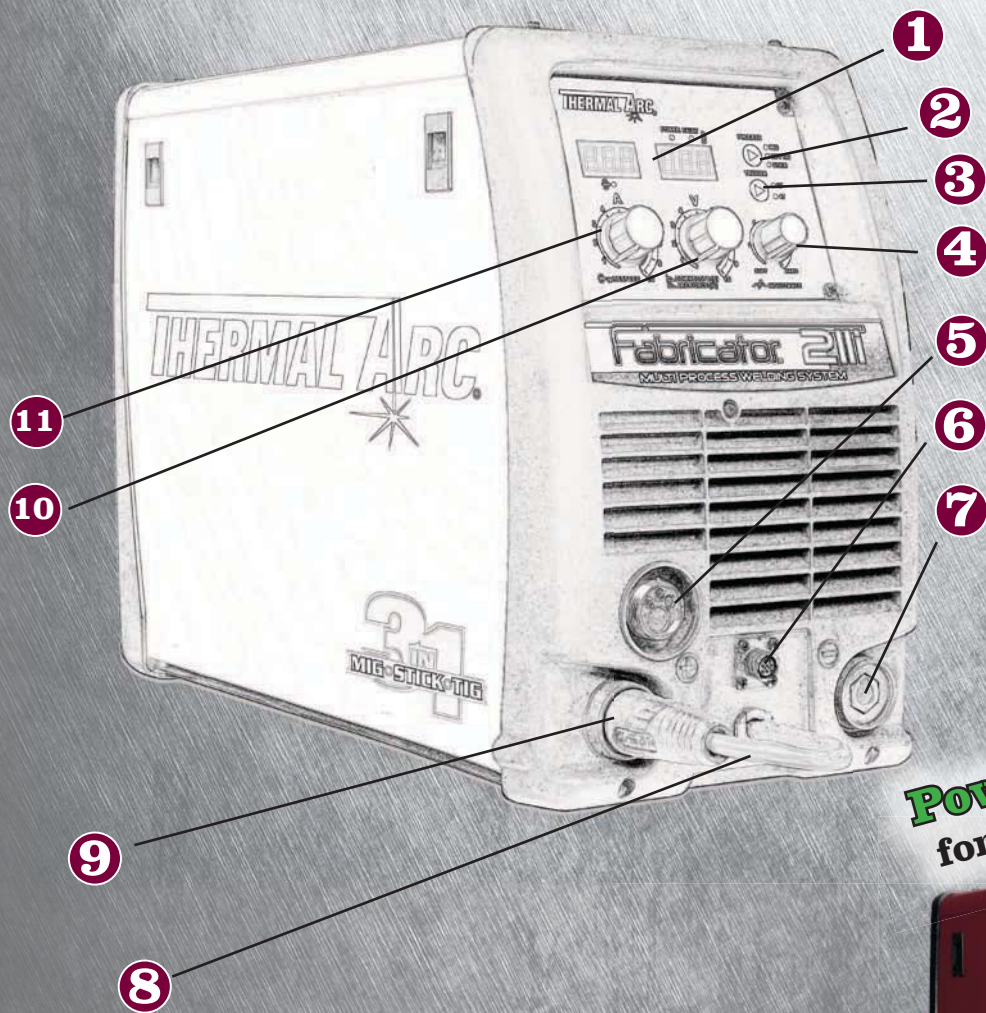


# 211i INVERTER

## MULTIPROCESS WELDING SYSTEM



- 1) Digital Meters
- 2) Process Selection
- 3) Trigger Latch Function
- 4) Arc (Inductance) Control
- 5) MIG Torch Euro Connector
- 6) 8 pin Remote Control Socket
- 7) Negative Weld Output 50 mm Dinse Terminal

Featuring  
**Power Factor Correction**  
 for more efficient operation

- 8) MIG Torch Polarity Cable
- 9) Positive Weld Output 50mm Dinse Terminal
- 10) Multifunction Control - Voltage, Down Slop, Arc Force
- 11) Amperage Control



**Fabricator 211i**  
 MULTI PROCESS WELDING SYSTEM

**DC**

**200  
AMP**

**DUAL  
VOLTAGE  
230/110V**

**1  
PHASE**

**CC  
CV**





# Fabricator 211i

MULTI PROCESS WELDING SYSTEM

The Thermal Arc Fabricator 211i is a dual-voltage, full multi process, digital control, DC, CC/CV, MIG/ Stick/Lift TIG inverter power supply designed for precision MIG, DC TIG and Stick welding. This unit is equipped with an integrated wire feed unit, voltage reduction device (applicable in stick mode only), power factor correction, digital voltage and amperage meters and a host of other features in order to fully satisfy the broad operating needs of the modern welding professional.

## SYSTEM FEATURES



### Three Process Capability:

**MIG** (GMAW/FCAW), **STICK** (SMAW), **TIG** (GTAW).

#### MIG:

- \* **Infinite Voltage Control** with optimized starting performance.
- \* **Inductance Control** for arc stability and spatter control.
- \* **Tweco MIG Gun** with 3m cable and industry standard Euro connection.
- \* **Durable Metal Feed Plate** features 2 roll drive system, quick change reversible drive rolls and easy-to-set single scaled wire tension knob.
- \* **100, 200, or 300mm Spool Capacity** allows easy installation of wire spool sizes.
- \* **Spool Gun** ready.

#### STICK:

- \* **Adjustable Arc Force Control** for optimum STICK electrode performance.

#### TIG:

- \* **Lift TIG Start:** Provides TIG arc starting without use of high frequency.

### Other Features:

- \* **Dual Voltage:** 230V Input allows up to 210A welding output for use in workshops. 110V Input allows up to 140A welding output for on-site work.
- \* **PFC Power Factor Correction:** Up to 40% more electrically efficient than conventional MIG Welders.
- \* **Digital Meters:** Voltage and Amperage meters.
- \* **Excellent Portability:** Lightweight, only 26kg.
- \* **Comprehensive Setup Chart:** Weld set up guide for optimum welding performance over a wide range of materials and shielding gases.
- \* **Trigger Control:** 4T (Latch) eliminates operator fatigue.
- \* **Remote Receptacle:** Enables connection of remote control devices and Spool Gun. (Remote function not available in Stick mode.)
- \* **Quick Change Polarity:** Simple quick change polarity (no tools required) from the front of the power source.
- \* **Overload Protection:** Shuts down the power source to protect the internal electrical components from overheating.
- \* **IP23S:** Suitable for outdoor use.

## CONTROL PANEL

### Power Indicator

The Green power indicator illuminates in the presence of power on the control circuitry

### Digital Meters WFS / AMPS and Volts

### Left Knob

Adjust weld Process value

- MIG - Wirefeed speed
- TIG - Amperage
- STICK - Amperage

### Middle Knob

Voltage, down slop and arc force control

### Right Knob

Arc (Inductance) control



### Fault Indicator

The Fault will illuminate yellow when any of the faults are detected

### Process Mode Button

Depress to change process:

- MIG (GMAW/FCAW)
- TIG (GTAW)
- STICK (SMAW)

### Trigger Latch Button

Depress to change Trigger Fn:

- 2T (On/Off)
- 4T (Trigger Hold)
- Once the weld arc has started, release the trigger and continue welding
- Activate the trigger again or brake the welding arc to finish welding

WELDING DC		
	230V Input	110V Input
Maximum Output	210 Amps	140 Amps
MIG (GMAW/FCAW) Welding Output @ 40°C	210A / 24.5V @ 20% Duty Cycle 130A / 20.5V @ 60% Duty Cycle 101A / 24.1V @ 100% Duty Cycle	140A / 21.0V @ 20% Duty Cycle 99A / 19.0V @ 60% Duty Cycle 77A / 17.9V @ 100% Duty Cycle
STICK (SMAW) Welding Output @ 40°C	200A / 28.0V @ 25% Duty Cycle 160A / 25.2V @ 60% Duty Cycle 101A / 24.1V @ 100% Duty Cycle	125A / 25.0V @ 25% Duty Cycle 80A / 23.2V @ 60% Duty Cycle 60A / 22.4V @ 100% Duty Cycle
TIG (GMAW) Welding Output @ 40°C	200A / 18.0V @ 20% Duty Cycle 130A / 15.2V @ 60% Duty Cycle 101A / 14.4V @ 100% Duty Cycle	150A / 16.0V @ 35% Duty Cycle 115A / 14.6V @ 60% Duty Cycle 90 A / 13.6V @ 100% Duty Cycle



DIMENSIONS AND WEIGHT	
Dimensions H x W x D	435 mm x 266 mm x 617 mm
Weight	26 kg
TECHNICAL FEATURES	
Primary Voltage	230VAC / 110VAC
Supply Voltage Range	230V ± 10% / 110V ± 10%
Number of Phases	Single Phase
Supply Frequency	50/60 Hz
Generator Requirement	7 kVA (230V) / 4.5 kVA (110V)
Open Circuit Voltage	79V
Input Current	15A (230V) 18.3A (110V)
Current Range	10-210 A (230V) / 10-140 A (110V)
Wirefeed Speed Range	2.5 – 18 m/min
Warranty Period	2 Years
Approvals	IEC 60974-1 (CE)
Protection Class	IP23S





## System Package Part W1004207 - includes:

- Fabricator 211i Power Source
- Tweco MIG Gun (3m)
- Feed Roll 0.6/0.8mm V groove (hard)
- Electrode Holder with lead (4m)
- Work Clamp with lead (4m)
- Shield Gas Hose assembly
- Operating Manual



## Options and Accessories

Tweco WeldSkill 220A MIG Gun (10ft / 3m)	WS220XE-10-3035
Tweco WeldSkill 220A MIG Gun (12ft / 4m)	WS220XE-12-3035
Tweco TWE2 250A MIG Torch with 3m cable	161.550.307
Tweco TWE2 250A MIG Torch with 4m cable	161.550.407
26V TIG Torch (4m)	310.090.001
Spool Gun (required for aluminium welding)	SG160XTA12-3035
Basic Utility Cart	W4014700
Single Cylinder Professional Cart	W4015001
Dual Cylinder Professional Cart	W4015002
Consumables Storage Box	872726
Remote Foot Control, 7.6m	10-4016
Tweco WeldSkill Helmet	WHF41001
Replacement Gas Hose	W7004930



## Drive Rolls

Feed Roll 0.6/0.8mm V groove (hard), (fitted)	62020
Feed Roll 0.9/1.2mm V groove (hard)	62022
Feed Roll 0.8/0.9mm U groove (soft)	62179
Feed Roll 1.0/1.2mm U groove (soft)	62024
Feed Roll 0.8/0.9mm V knurled (flux cored)	62028



Single Cylinder Cart

Dual Cylinder Cart

