

The **TITANIUM 321 AC/DC** is a high-performance TIG AC/DC power source that offers a wide choice of welding processes (TIG AC, DC, MMA). It can be used to weld various materials, including mild steel, stainless steel, aluminium, copper and titanium. Also ideal for welding thin material, the Pulse mode reduces deformation and delivers better arc control. Intuitive and extremely practical, the XXL digital interface offers straightforward control of the welding parameters.

6 TIG WELDING MODES

DC	DC Standard: smooth current welding on most ferrous materials.
	DC Pulse: for welding workpieces together while limiting the heat input (pulses up to 20 kHz).
	FastPulse: up to 20 kHz pulse for specialist steels.
AC	AC Standard: for welding aluminium alloys (Al, AlSi, AlMg, AlMn, etc).
	AC Pulse: precise control of penetration by setting the AC frequency (frequency up to 2.5 kHz).
	AC Mix: alternating AC and DC currents to increase welding speed.

TIG WIZARD SOLUTION

- **Patented synergic mode** for maximum productivity when tacking and welding aluminium, steel, stainless steel and copper parts, with or without filler metal.
- **5 types of joint:** Butt (BW), Lap (FW), Internal corner (BP), External corner and wire splicing.
- **Wizard Lab** for creating sophisticated weld cycles.

OPTIMISED SETTINGS

- **4 tacking modes:**
 - **Spot / Multi Spot:** traditional tacking before welding thin material.
 - **Tack / Multi Tack:** ultra-precise, oxidation-free tacking to reduce the risk of deformation.
- **3 types of ignition:** Lift, HF and Touch.HF (timed high-frequency ignition).
- **3 trigger management modes:** 2T, 4T and 4T LOG
- **AC waveform settings** for arc control and penetration.
- **E-TIG mode** ensures that the welder maintains the correct welding power regardless of where the torch is positioned in relation to the workpiece (control of welding energy).

MAXIMUM CONNECTIVITY

- Accurately measured energy input.
- Synchronised welding (2 welders), automatic and reliable synchronisation of the 2 electric arcs.
- Traceability of all weld beads in accordance with EN 3834.
- Calibration mode for welding accessories (fine-tunes energy calculation).
- Can be connected to a robot via an optional kit (037960).
- User mode for sharing the product with several users.
- Free online interface customisation tool.
- Backup of user JOBS (up to 500) and machine configuration via USB stick.
- Compatible with lamella, double button, potentiometer and Up & Down torches.
- Complete machine and synergy updates via USB stick.
- Remote controls can be connected without the need for tools.
- Optional cooling unit (083363).
- MMA, MMA AC and MMA pulse modes (welding electrodes up to Ø 8 mm).
- VRD (Voltage Reduction Device) can be activated to reduce no-load output voltage to < 35 V.



Supplied without accessories

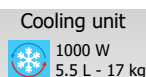


- Intuitive, multilingual, customisable 7-inch XXL colour interface.
- 3 user interface levels: Easy, Expert and Advanced

ACCESSORIES (options)



TIG18B - 4 m
084063



KOOLWELD 3
083363



10m³ L trolley
075498

Remote control:



RC-FA2 - 5 m
083356



RC-HD3
079700

50/60 Hz	I ₂ TIG DC	I ₂ TIG AC	I ₂ MMA	INTEGRATED TECHNOLOGY			TIG AC/DC		MMA		U ₀	U _R	mm ²	cm	kg	IP	Protected & compatible power generator (+/-15%)	
				TIG DC PULSE	TIG AC PULSE	MMA PULSE	EN 60974-1 (40°C) IA (60%)	100%	EN 60974-1 (40°C) IA (60%)	100%								
400 V - 3~	32	3 → 320	5 → 320	5 → 320	0.1 → 20 kHz	0.1 → 2.5 kHz	0.4 → 20 Hz	320 A	310 A	270 A	220 A	81	25.6	35/50	72 x 30 x 56	30.5	IP 23	13 kW