

STH 270

Stick/TIG Welding
Power Source



Quick Specs



IP23S

Industrial Applications

Petro/Chemical
Mechanical Contractors
Shipboard Installation
Process Piping

Processes

Stick (SMAW)
TIG (GTAW) Lift-Arc
Pulsed TIG (GTAW-P)

Input Power 400 V, 3-Phase Power

Amperage Range 5–270 A

Rated Output 270 A, 30.8 V @ 40% Duty Cycle

Weight 24 kg (52.9 lb)

The Power of Blue.®



Portable in the shop or at the job site —at 24 kg the STH 270 easily moves from location to location.

Inverter-based, DC power source has a **simple-to-use operator interface** providing only the necessary controls in a compact machine.

Thermal overload protection with indicator light helps prevent machine damage if the duty cycle is exceeded or airflow is blocked.

Lift-Arc™ start provides TIG arc starting without the use of high frequency.

VRD function is a simple design that reduces the open-circuit voltage to 12 volts when the welding power source is not in use.

Built-in pulsing capabilities allow the operator to select from four fixed pulse frequencies to satisfy the application.

Adjustable postflow gives operator better control of the gas parameters affecting weld zone.

Remote amperage control provided through 14-pin receptacle on front of the machine. This permits use of standard remote amperage control devices.

Selectable trigger configuration allows the operator to choose 2T or 4T trigger method.

HF start for non-contact arc starting that eliminates tungsten or material contamination.

Adjustable Hot Start™ for Stick arc starts. Adjust the optimal start current for the application. The current auto-matically increases the output amperage at the start of a weld.

Adjustable Arc force™ prevents sticking. Adjust the optimal arc force value. Adjustable arc force supports positional welding by increasing the output amperage.

Digital Meter – preset amperage/voltage or actual while welding.

Built-in gas solenoid eliminates the need for a bulky torch with gas valve.

Built-in upslope/downslope function helps provide better arc starts and reduces craters.

Lift-Arc™ start provides TIG arc starting without the use of high frequency or the risk of tungsten contamination.

Specifications (Subject to change without notice.)



Input Power Three Phase AC 50/60 Hz Voltage	Rated Welding Output		Max. Open Circuit Voltage	Amperage/ Voltage Range DC	KVA/KW @ Duty Cycle	Dimensions (in.)	Weight
	100%	40%					
STH 270							
400 Volts Stick	180A 27.2V	270 A 30.8 V	50 V	5–270 A 20 – 30.8 V	11.4 KVA/ 10.3 KW @ 40 % DC 7.9 KVA/ 7.0 KW @ 100% DC	L: 568 mm (22.4 in.) W: 219 mm (8.6 in.) H: 345 mm (13.6 in.)	Net: 24 Kg (52.9 lb) Ship: 26Kg (57.3 lb)
400 Volts TIG	180A 17.2V	270 A 20.8 V	50 V	5–270 A 10 – 20.8 V	7.7 KVA/ 6.7 KW @ 40% DC 4.8 KVA/ 4.0 KW @ 100% DC		



Warranted for 3 years, parts and labor.



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Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
STH 270	#059 016 024	400 VAC, 3 phase 50/60 Hz		
Water Coolant Systems				
HydraCool 270	#028 042 107	Water cooling system, 400VAC, 1 phase 50Hz		
Running Gear				
MH	#018 035 026	MH-two wheels cart		

Date:

Total Quoted Price:



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