

# MasterTig MLS 2300 / 3003 ACDC

## MLS control for the finest TIG welding quality



### + In brief

- TIG and MMA process eg: DC-/DC+/AC/MIX TIG
- Power cost efficient, compact dimensions
- MasterCool option for high duty applications
- MicroTack for fast, low heat tack welding

### + Applications

- Metal fabrication workshops
- Shipyards and offshore industry
- Chemical and process industry
- Mechanised welding



Energy efficient

## Key features

The best tools make demanding work easy. MasterTig MLS ACDC offers TIG welding professionals the necessary control to meet their exacting needs. Whatever the application, enjoy the performance. Model choice includes a 230A version with 1-phase 230V power supply, and 300A versions with 3-phase 400V or 230/460V power supply. MasterTig MLS ACDC is a precise aluminium welding specialist that suits all welded materials. Modular design allows you to build the package that best suits your needs.

Choose from either ACS or ACX control panels allowing fast adjustment of base parameters including: pre/post gas time, AC arc frequency and slope time values. ACS provides all necessary controls for DC, AC and MIX TIG welding with either HF or contact ignition. ACX offers additional functions including MicroTack, memory channels and pulsed welding function.



All MasterTig MLS ACDC welding devices can be equipped with an ACX or ACS control panel introducing numerous additional features that make welding easier and more efficient.

# MasterTig MLS 2300 / 3003 ACDC

## Technical specifications

| MasterTig MLS              |              | 2300 ACDC                | 3003 ACDC                         |
|----------------------------|--------------|--------------------------|-----------------------------------|
| Connection voltage         | 50/60 Hz     | 1~, 230 V (±15 %)        | 3~, 230 V (-10 %)...460 V (+10 %) |
| Rated power at 100 % ED    | TIG          | 5.7 kVA                  | 9.2 kVA                           |
|                            | MMA          | 6.0 kVA                  | 10 kVA                            |
| Connection cable           | H07RN-F      | 3G2.5 (3.3 m)            | 4G2.5 (5 m)                       |
| Fuse recommendation (slow) |              | 15 A                     | 20/16 A                           |
| Output 40 °C               | 40 % ED TIG  | 230 A/19.2 V             | 300 A/22 V                        |
|                            | 60 % ED TIG  | 200 A/18 V               | 230 A/19.2 V                      |
|                            | 100 % ED TIG | 170 A/16.8 V             | 190 A/17.6 V                      |
|                            | 40 % ED MMA  | 180 A/27.2 V             | 250 A (230 V AC 30 %)/30 V        |
|                            | 60 % ED MMA  | 150 A/26 V               | 230 A/29.2 V                      |
|                            | 100 % ED MMA | 120 A/24.8 V             | 190 A/27.6 V                      |
| Welding range              | TIG          | 3 A/10 V–230 A/19.2 V    | 3 A/10.0 V–300 A/22 V             |
|                            | MMA          | 10 A/20.5 V/180 A/27.2 V | 10 A/20.5 V–250 A/30 V            |
| Open circuit voltage       |              | 58 V DC                  | 58 V DC                           |
|                            | AU models    | 20 V DC/VRD              | -                                 |
| Power factor at 100% ED    |              | 0.99                     | 0.95                              |
| Efficiency at 100% ED      |              | 82 %                     | 81 %                              |
| Stick electrode, MMA       | ∅            | 1.5...4.0 mm             | 1.5...5.0 mm                      |
| External dimensions        | L x W x H    | 430 x 180 x 390 mm       | 500 x 180 x 390 mm                |
| Weight                     |              | 15 kg                    | 25 kg                             |

| Cooling unit               |           | MasterCool 20           | MasterCool 30           |
|----------------------------|-----------|-------------------------|-------------------------|
| Connection voltage         |           | 230 V (±15 %)           | 24 V DC                 |
| Rated power at 100 % ED    |           | 50 W                    | 50 W                    |
| Cooling power              |           | 1.0 kW                  | 1.0 kW                  |
| Maximum pressure           |           | 400 kPa                 | 400 kPa                 |
| Recommended cooling liquid |           | 20...40 % ethanol/water | 20...40 % ethanol/water |
| Tank volume                |           | 3 l                     | 3 l                     |
| External dimensions        | L x W x H | 500 x 180 x 260 mm      | 500 x 180 x 260 mm      |
| Weight                     |           | 8 kg                    | 8 kg                    |

## Ordering information

| Power Sources                  |            |
|--------------------------------|------------|
| MasterTig MLS 2300 ACDC        | 6162300    |
| MasterTig MLS 2300 ACDC VRD AU | 6162300AU  |
| MasterTig MLS 3000 ACDC VRD    | 6163000VRD |
| MasterTig MLS 3003 ACDC        | 6163003    |
| Cooling units                  |            |
| MasterCool 20                  | 6162900    |
| MasterCool 30                  | 6163900    |
| Control panels                 |            |
| ACS                            | 6162805    |
| ACX                            | 6162804    |