

# INVERTEC® CC 400-T/TP

The INVERTEC® CC400-T/TP is designed and manufactured with the latest digital IGBT technology. This machine has superior arc performance and may be operated in harsh environments due to its robust outer casing.

Rugged, lightweight, portable, full functionality, and easy operation to meet the requirements from all types of different users.

As a professional TIG machine, The INVERTEC® CC400-T/TP features four welding modes: MMA, Lift TIG ignition, HF TIG ignition and HF TIG Spot ignition. The machine also is capable of 2 or 4 step trigger, HF/LF pulse, parameters memory, variable upslope/downslope current control, and preflow/postflow gas control.

This machine is equipped with variable frequency pulse control to provide an adjustable welding arc. This unique function enables adjustments to best suit the welding application to optimize bead appearance, reducing heat input to control deformation, and increasing travel speed.

The INVERTEC® CC 400-T/TP is a standard air cooled machine which may be converted to water cooled by adding an optional water cooling tank.



## Description

Output   Input  

## Application

Manufacturing, Aerospace, Pressure Vessel, Stainless Steel

## Processes

TIG, STICK

## Features:

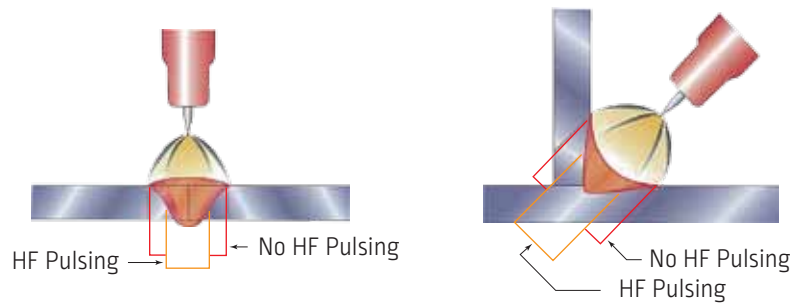
- ★ Advanced inverter technology for superior TIG arc performance
- ★ Numeric display for easy setup of all welding parameters
- ★ Parameter memory with 10 settable locations
- ★ HF, Lift ignition and HF spot welding modes for different welding needs
- ★ Complete TIG parameter presets
- ★ High speed pulse arc adjustment to decrease deformation and increase welding speed
- ★ Superior stick welding performance with arc force and hot start settings
- ★ Completely portable welding performance
- ★ Rugged and durable case design
- ★ IP23 rating for use in harsh environments

## Technical Specifications

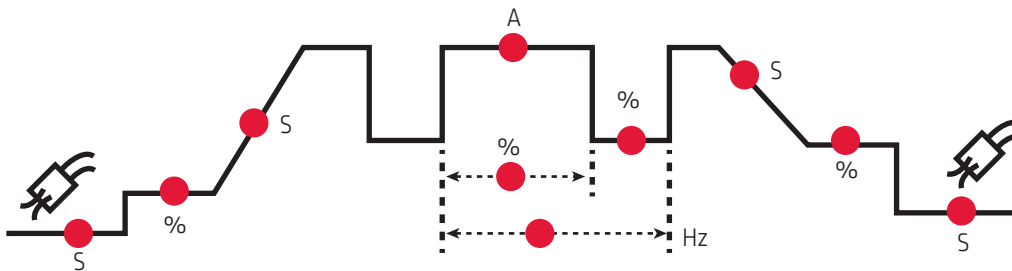
Product	Product Number	Primary Voltage	Mode	Output Range	Rated Output	Power Input at Rated Output	Height x Width x Depth	Net Weight
INVERTEC® CC 400-T	K60098-1	380V-415V 3Ph	MMA	10-400A 20.4-36V	400A/36V/60% 310/32.4V/100%	17 KW	480x350x730 mm	34 KG
			TIG	5-400A 10.2-26V	400A/26V/60% 310/22.4V/100%			
INVERTEC® CC 400-TP	K60098-3		MMA	10-400A 20.4-36V	400A/36V/60% 310/32.4V/100%			
			TIG	5-400A 10.2-26V	400A/26V/60% 310/22.4V/100%			

# Technical Description

## HF Pulse



## Output waveform and parameter list



Mode	Displayed Parameter Name 	Parameter	Selectable Value Range 	Step	Factory Configuration	Displayed Value 	
GTAW	<i>PrE</i>	Preflow	0.1~15S	0.1S	0.5S	Current Selected Value (s)	
	<i>SrA</i>	Start Current	0~100%	1	50%	Current Selected Value (%)	
	<i>UPs</i>	Upslope	0~15S	0.1S	0.5S	Current Selected Value (s)	
	<i>000</i>	Set Current	5~400A	1A	150A	Current Selected Value (A)	
	<i>dUc</i>	Duty Cycle	5%~95%	1	50%	Current Selected Value (%)	
	<i>FrE</i>	Frequency	Not	---	---	---	Current Selected Value (Hz)
			LF	0.2~20Hz	0.1Hz	2Hz	
			HF	10~300Hz	1Hz	30Hz	
	<i>bAc</i>	Background	0~100%	1	50%	Current Selected Value (%)	
	<i>dDw</i>	Downslope	0~15S	0.1S	0.5S	Current Selected Value (s)	
<i>CrA</i>	Crater	0~100%	1	50%	Current Selected Value (%)		
<i>POS</i>	Postflow	0.1~15S	0.1S	0.5S	Current Selected Value (s)		
SMAW	<i>Uo</i>	Set Current	5~400A	1A	150A	Current Selected Value (A)	
	---	Hot Start	0~10	1	0	Current Selected Value (Proportion)	
	---	Arc Force	0~10	1	5	Current Selected Value (Proportion)	
SPOT TIG	<i>000</i>	Set Current	5~400A	1A	150A	Current Selected Value (A)	
	<i>SPD</i>	Spot Time	0.1~5S	0.1S	1S	Current Selected Value (s)	

## Front Panel

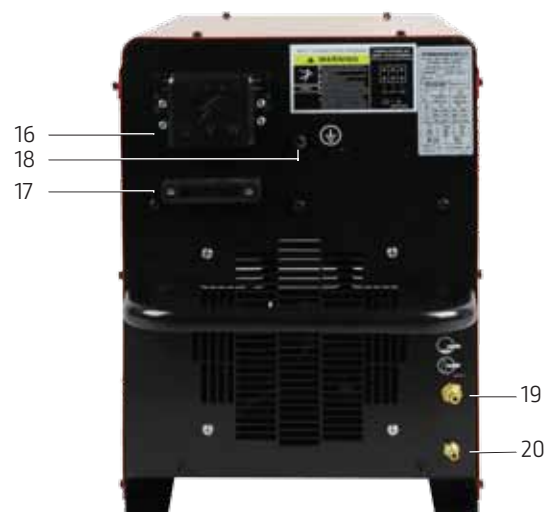


1. ON/OFF POWER SWITCH
2. PULSE FREQUENCY SELECTION
3. CRATER MODE SELECTION
4. PARAMETER SELECTION
5. MODE SELECTION
6. DIGITAL CURRENT DISPLAY METER
7. DIGITAL VOLTAGE DISPLAY METER

8. PARAMETER STORAGE
9. PARAMETER TRANSFER
10. PARAMETER ADJUSTMENT
11. COOLED WATER OUTPUT TERMINAL
12. PROTECTIVE GAS OUTPUT TERMINAL
13. NEGATIVE OUTPUT TERMINAL
14. AMPHENOL SOCKET
15. POSITIVE OUTPUT TERMINAL

## Rear Panel

16. INPUT BOX
17. INPUT CABLE HOLDING BRACKET
18. GROUND CABLE CONNECTION
19. COOLED WATER INPUT TERMINAL
20. PROTECTIVE GAS INPUT TERMINAL



## Recommended Accessories



**Air cooled TIG torch**

### Air cooled TIG torch

Air cooled TIG torch 200A@60%

Order no:

K60100-4 4m

K60100-8 8m



**Water cooled TIG torch**

### Water cooled TIG torch

Water cooled TIG torch 350A@60%

Order no:

K60101-4 4m

K60101-8 8m



**Work cable with clamp**

### Work cable with clamp

Used to connect work piece, with clamp

Order no:

K60027-50-4M

Work cable with clamp 4m, 50mm<sup>2</sup>

K60027-70-4M

Work cable with clamp 4m, 70mm<sup>2</sup>



**AIR Gas Regulator**

### Shielding Gas Regulator

Shielding gas regulator

Order no:

K60012-5



**Cart with water cooled tank**

### Cart with water cooled tank

Unit includes water cooler tank, hose, power cord

Designed for INVERTEC® CC 400-T/TP mounting and gas cylinder

Max weight:1000kg

Cart packing size:770\*770\*1100(H)mm

Cart net weight: 39kg

Tank:Input power: 380V/1Ph

Tank capacity: 6.5L

Cooling capacity: 1.7KW(1L/Min)

Order no:

K60099-1



**Remote output control**

### Remote output control

Remote control current range

Order no:

K69023-8M 8M

K69023-15M 15M

K69023-30M 30M



**Foot Amptrrol**

### Foot Amptrrol

Provides remote arc starting/ending and current control for TIG welding

6-pin plug

Order no:

K60103-4 4m

K60103-8 8m

### Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

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## THE SHANGHAI LINCOLN ELECTRIC CO., LTD.

No.195, Lane 5008, Hu Tai Road, Shanghai China 201907

TEL: 86-21-6673 4530

FAX: 86-21-6602 6621

[www.lincolnelectric.com.cn](http://www.lincolnelectric.com.cn)

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### Authorized Distributor: