

INTELLIGENT REVOLUTION

TPS 3

WELDING PACKAGE **PMC**

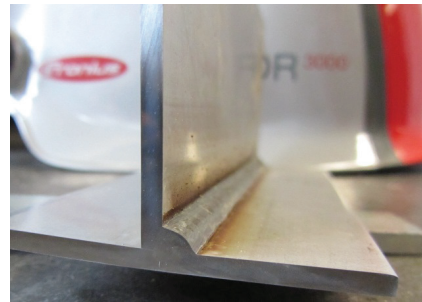
# PMC

## PULSE MULTI CONTROL

PMC has an extensive range of tailored synergic lines for many different applications and huge benefits over conventional pulsed welding.

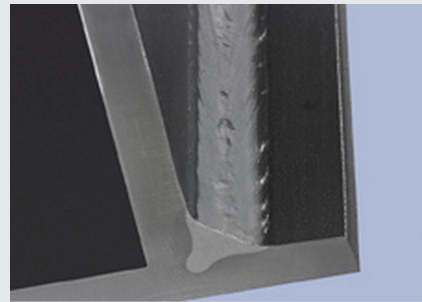
### PMC UNIVERSAL

Suitable for all common welded joints.  
Steel, aluminium, stainless steels all possible, plus many more!  
Low heat input - low distortion  
Very low spatter  
Permanently short arc due to new stabilizers  
Consistent penetration due to new stabilizers  
Faster than conventional pulse due to high speed arc regulation



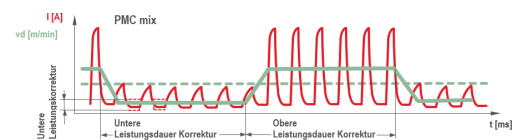
### PMC PCS (PULSE CONTROLLED SPRAY)

Perfect pulse welding in the low power range  
Pulsed induced spray arc at the high power range  
Gives maximum penetration  
Concentrated arc allows for single sided weld preps  
Available for steel, stainless steel and aluminium



### PMC MIX

Specialised program designed for vertical up welds with solid wires  
No weaving necessary - much faster travel speeds  
Steel and stainless steel programs with more in development  
Less operator skill needed for difficult positional welding



### PMC DYNAMIC

High frequency pulsed program  
High arc pressure with excellent penetration  
Short arc gives faster travel speeds  
Consistent penetration due to stabilizers



## The new Pulsed program for the TPS/i MIG/MAG welding power source

### ARC LENGTH STABILIZER

This new feature keeps the pulsed arc permanently independent of travel speed, torch angle and stick out.

Arc length **A** = Arc length **B**



The stabilizer can be set between 0.1 - 5. The higher the setting, the shorter the arc becomes. Once set, the arc length will remain constant even when changing welding positions e.g. down hand butt weld to an overhead fillet weld. The arc length remains the same.

#### BENEFITS OF ARC LENGTH STABILIZER

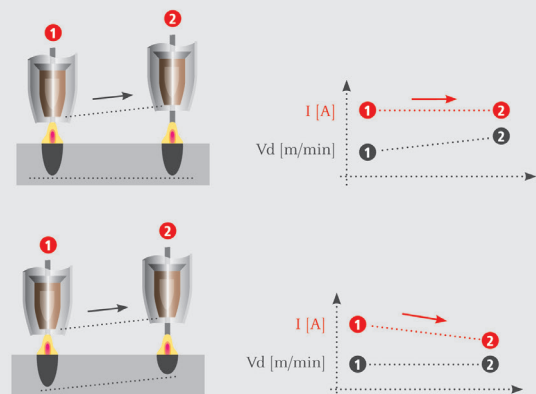
- / Faster travel speeds due to short arc regulation
- / Less chance of undercut on weld toes
- / Lower heat input
- / Welder has better feel of control
- / Combine with Penetration Stabilizer - repeatable result

## PMC PULSE MULTI CONTROL

PMC allows for precise control of heat input. Due to fast processing capabilities, high arc stability is generated allowing high travel speeds and easy operation with reduced energy per unit length, making welding with it more cost effective than ever before. PMC has two stabilizers which give faster travel speeds and consistent penetration.

### PENETRATION STABILIZER

This new feature maintains the penetration even when there are changes to CTWD (contact tip to work distance)



When stick out is increased (2) the amperage will decrease and penetration will be lost. This is due to the constant voltage behaviour of the MIG/MAG process. With our PMC process we can set our wire feed speed to vary if the stick out changes which will keep the penetration more consistent.

#### BENEFITS OF PENETRATION STABILIZER

- / Repeatable results
- / Unforeseen stick out changes less critical
- / Gives the welder more flexibility when space is an issue