

CITOTIG II DC ***Industrial range***

The best of TIG welding using inverter technology for the most demanding welders.

2015



CITOTIG II DC Industrial range

Ultimate performance in all conditions



Designed to meet the expectations of the most demanding welders, **CITOTIG II DC** welding units were developed in detailed correlation with on-going changes in requirements. They provide optimum performance associated with the ruggedness necessary for daily work both in the workshop and on site. They have a complete welding cycle including 2 current levels with the CITOSTEP function in the **ADVANCED** version and a simple cycle in the **EASY** version.

CITOTIG II DC

- For high demanding sectors of activity.



- High quality welding results on carbon and stainless steels.



Welding consumables

As a selection of the wide OERLIKON welding consumables range you can see here under TIG rods for the most common applications.

Many other types of steel or alloys are available. Do not hesitate to consult us.

Applications	Classification	Designation	Diameter	Cat. number
Carbon steels	ER 70S-6 (AWS A 5-18) W42 4 W3Si1 (EN ISO 636-A)	CARBOROD 1	1.6 mm	W000383322
			2.0 mm	W000383323
			2.4 mm	W000383324
			3.2 mm	W000383325
Stainless steels	ER 308L (AWS A 5-9) W19 9 L (EN ISO 14343-A)	INERTROD 308L	1.6 mm	W000283415
			2.0 mm	W000283416
			2.4 mm	W000283417
			3.2 mm	W000283418
	ER 316L (AWS A 5-9) W19 12 3 L (EN ISO 14343-A)	INERTROD 316L	1.6 mm	W000283451
			2.0 mm	W000283452
			2.4 mm	W000283453
			3.2 mm	W000283454



With the CITOSTEP function available on ADVANCED version, two current levels can be chosen, the welding current and the basic current. This facilitates the change from one to the other by rapidly pressing the torch trigger. The CITOSTEP function can be used to adjust heat input momentarily, to change welding positions or to replenish the filler metal supply without having to stop welding.

CITOTIG II EASY front panel



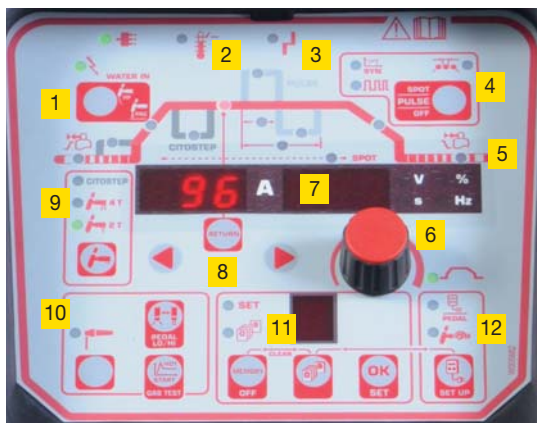
- 1 TIG high frequency or TIG LIFT selection
- 2 Thermal safety indicator
- 3 Supply voltage defect indicator
- 4 Pulsed TIG / Synergic pulsed TIG / Spot TIG selection (advanced version)
- 5 Post-gas adjustment
- 6 Welding parameters adjustment
- 7 Display
- 8 Welding parameter selection keys
- 9 2T / 4T / CITOSTEP selection (advanced version)
- 10 MMA welding selection
- 11 Memorization parameters selection
- 12 Local/remote control selection



Pulsed TIG and “synergic” pulsed TIG (available on advanced version)

Because all pulse parameters can be adjusted, the pulsed TIG process allows better control of the weld pool. The synergic pulsed system is an additional mode proposed to make adjustment of the unit easier. With the synergic pulsed system, there is no need to adjust the low current, ratio and frequency. All parameters depend of the welding current pre-programmed. The pulse mode gives a high, concentrated arc and increases welding speed.

CITOTIG II ADVANCED version front panel



Options and accessories for CITOTIG II DC

Remote control



2006-649

To order		
RC1 for direct current range	5 m	W000263311
	10 m	W000270324

Foot-operated control pedal



2006-651

To order		
FP1 for direct current range	5 m	W000263313

Trolley T3

A trolley for easy transport of:

- CITOTIG II
- COOLERTIG II cooling unit
- Gas cylinder (size B20 max.)
- Torches and accessories that can be carefully stored or rolled

To order	
Trolley T3	W000277087



2010-270

2014-637

2011-117

2011-116

2011-116

TIG torches



The new range of CITORCH T NG TIG torches perfectly fit with the high level of quality provided by the CITOTIG DC professional range.

The adapted models are CITORCH T 20, 40, 10W or 35W (air or water cooled torches). They come:

- either with trigger as a blade: RL models
- or as a button: EB types.

The EB types are modular as they can be modified with the different type of buttons.

See complete range in the CITORCH T NG brochure



RL: Blade

	CITORCH T NG 20 RL C5B	CITORCH T NG 40 RL C5B	CITORCH T NG 10W RL C5B	CITORCH T NG 35W RL C5B
Cooling	Air		Water	
Duty Cycle	150 A at 35% 100 A at 60%	250 A at 35% 200 A at 60%	250 A at 100%	350 A at 100%
To order	5 m: W000278986 8 m: W000278987	5 m: W000278890 8 m: W000278991	5 m: W000278992 8 m: W000278993	5 m: W000278994 8 m: W000278995
Cat. number maintenance box	W000306442	W000306444	W000306441	W000306444



EB: Button

	CITORCH T NG 20 EB C5B	CITORCH T NG 40 EB C5B	CITORCH T NG 10W EB C5B	CITORCH T NG 35W EB C5B
Cooling	Air		Water	
Duty Cycle	150 A at 35% 100 A at 60%	250 A at 35% 200 A at 60%	250 A at 100%	350 A at 100%
To order	5 m: W000278382 8 m: W000278383	5 m: W000278386 8 m: W000278387	5 m: W000278388 8 m: W000278389	5 m: W000278390 8 m: W000278391
Cat. number maintenance box	W000306442	W000306444	W000306441	W000306444

Modular system:

All torches are delivered with a single button module. If you want another control module, order it separately.

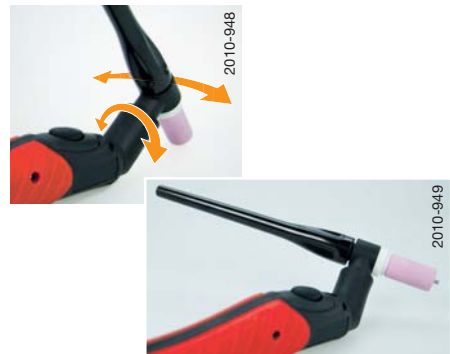


- 1 Horizontal potmeter - W000279370
- 2 Vertical potmeter - W000279246
- 3 Double button - W000279242
- 4 Blade - W000279245

For potmeter adapt the wiring to the welding machine using the 7 pins plug - W000271826

In option: Adjustable heads

As an option, adjustable torch bodies are available. Welding in inaccessible locations becomes easier. You have the choice of 2 heads, small and large to be mounted on air cooled or water cooled bodies.



Choose one body and one head to get a complete torch.

Air cooled body - W000279381

Water cooled body - W000279382⁽¹⁾

Head CITORCH T NG 10⁽²⁾ - W000279383

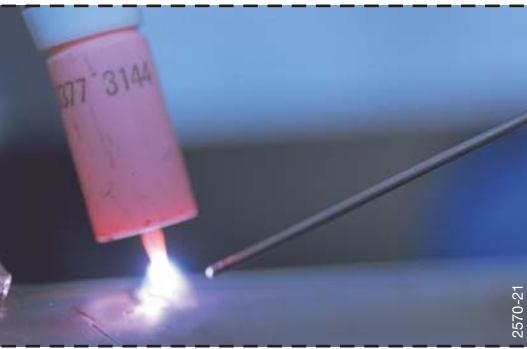
Head CITORCH T NG 20⁽³⁾ - W000279384

(1) : duty cycle : 220 A @100%

(2) : duty cycle : 125 A @ 35%

(3) : duty cycle : 145 A @ 35%

CITOTIG II DC Industrial range



2570-21

Single or three-phase portable inverters for MMA and TIG DC high quality work on non-alloyed or stainless steels.

2015



CITOTIG II 200 DC, 300 DC (W), 400 DC (W)

Reduced weight and size, high-resistance steel cabinet, maximum safety with the built-in VRD (Voltage Reduction Device), unit transportable using dedicated carriages for work in severe conditions. Possibility to connect to a remote control or foot-operated pedal and separate gas to torch connection, protection against dust and spatter, the user friendliness is increased due to the controls grouped on the front panel.

Product advantages:

- Multi-process unit: TIG DC, MMA (all stick electrode)
- Continuous, spot, pulsed welding (on the ADVANCED version)
- Complete welding cycle 2 current levels with CITOSTEP function (on the ADVANCED version)
- HF or "contact" arc striking
- Synergic pulsed system (on the ADVANCED version)
- Automatic hot start for easier arc striking according to type of coated electrode used
- Adjustable arc dynamics to optimize electrode melting according to electrode type (rutile, basic or cellulosic)
- Modular: air or water cooled
- VRD available

- HF arc striking
- 2T / 4T
- Adjustable pre and post-gas
- Adjustable arc dynamics

CELLULOSIC



VRD



2011-130

Technical characteristics

	CITOTIG II 200 DC	CITOTIG II 300 DC (W)	CITOTIG II 400 DC (W)
Primary power supply,	230 V single-phase (+/-10%)	400 V three-phase (+20% / -15%)	
Absorbing power at maxi. intensity	6.5 kVA	8.4 kVA	13.8 kVA
Open circuit voltage	80 V	80 V	80 V
Duty cycle at 40 °C	at 35%	200 A	300 A
	at 60%	150 A	230 A
	at 100%	130 A	200 A
Welding current	5 to 200 A	5 to 300 A	5 to 400 A
Electrode diameter max.	4.0 mm	5.0 mm	6.0 mm
Dimensions (l x w x h)	Power source	410 x 180 x 390 mm	500 x 180 x 390 mm
	Power source + Cooling unit	-	500 x 180 x 650 mm
Weight	Power source	15 kg	22 kg
	Power source + Cooling unit	-	33 kg
Standards	EN 60974-1 ; EN 60974-10		

This equipment are designed for industrial and professional use only and does not comply with EN 61000-3-2/12. If it is connected to a public low voltage system, it is the responsibility of the installer or user of the equipment to ensure, by consultation with the distribution network operator if necessary, that the equipment may be connected. (See also the instruction manual)

		To order		
Power source	EASY version	-	W000379982	-
	ADVANCED version	W000279732	W000279733	W000279734
		Option and accessories		
COOLERTIG II DC		W000279722		
Trolley T3		W000277087		
Manual remote control	5 m	W000263311 (RC1)		
	10 m	W000270324 (RC1)		
Foot-operated remote control		W000263313 (FP1)		



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Creative Oxygen

World leader in gases, technologies and services for Industry and Health, Air Liquide is present in 80 countries with more than 50,000 employees and serves more than 2 million customers and patients. Oxygen, nitrogen and hydrogen have been at the core of the company's activities since its creation in 1902. Air Liquide's ambition is to be the leader in its industry, delivering long-term performance and acting responsibly.