



## **TransPocket** 2500 / 3500

Rod electrode & TIG DC welding



PERFECT WELDING



# Intelligent mind meets tough body

## GENERAL REMARKS

### A fast-forwarding development in every regard

It all began with a very bright idea: Putting resonant intelligence “inside” the lower power classes of the TransPocket series. The idea has “resonated” so well with the welding public that it has been extended into higher power classes as well. To do this, it needed an even tougher body. And now it has one. Fully loaded with all the developmental advances that you would expect from a crossbreed of this class:

- all-digitally controlled welding machine with 250 and 350 A
- ideal characteristic ensuring a stable arc, even with e.g. up to 100 m long mains supply leads or fluctuating mains voltages (250 to 506 V) or in generator-powered operation
- guaranteed to weld all types of electrode of up to 5 mm in diameter – including V-down compatible welding of Cel-electrodes
- has an “armour plated” housing
- is still compact, lightweight and portable

## FIELD OF USE

### For doing things together, any time, any place

The TransPocket 2500/3500 units are the ideal appliances for using both out in the field and in production operations. Their light weight and standard carrying handle make them easily portable, while their robust design makes them shockproof and just about indestructible. The higher-placed ventilation slots stop any water getting in, and the integral dust filter provides reliable protection against dirt.

The units run on either single or three-phase current and are generator-compatible, so are always ready for action wherever in the world they are deployed. They are ideal for use in sectors ranging from plant engineering, container construction, structural steelwork, mechanical engineering, building trades and the construction industry to the construction of chemical plants, pipeline construction, site-erection firms and shipbuilding – to name but a few.





# Attaining the ideal welding state

## WELDING PROPERTIES

### Stability means dependability

When it comes down to it, the resonance concept is simply this: an extremely stable arc at all times, no matter how long the mains supply leads are. And even if the mains voltage fluctuates.

This stability is delivered by the appliances' electronic system. This is like a continuous automatic feedback from the arc to the power parameters. In this way the arc regulates the process on its own, responding instantly to every change. There is plenty of power in reserve whenever it's needed. The result is an arc characteristic that's always perfect and constant. And superlative welding properties coupled with maximum process reliability.

While on the subject of the arc: The Arc Force Control function ensures troublefree welding of coarse-droplet electrodes.

### Ignition: hot & soft

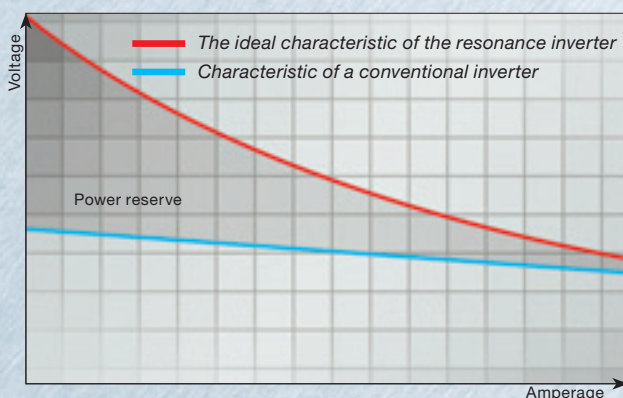
The TransPocket 2500/3500 machines are designed to work with any type of electrode – whether rutile, basic or Cel. And with Cel-electrodes in the vertical-down position, of course, professionals are quick to tell the difference. For all of these electrodes, then, the ideal ignition settings are already stored.

The Hot-Start function facilitates ignition of Cel and rutile electrodes. Soft-Start was specially developed for basic electrodes.

### TIG applications

In TIG applications, a microprocessor-controlled ignition sequence ensures precise, absolutely reliable operations. The TIG pulsed-arc function makes for better mastery of the weld-pool in out-of-position work and when bridging gaps.

And then there is TIG Comfort Stop, a special digital feature which cures the TIG arc of its annoying habit of breaking at the end of welding. A defined motion of the welding torch causes the welding current to drop automatically. A really convenient feature. Look forward to using it!



*The resonance concept makes possible a near-perfect approximation to the principle of the ideal characteristic.*



*Soft-Start delivers a stable arc for basic electrodes that ignite at low welding amperages.*





## HANDLING

### Straightforward and easy to handle

The TransPocket 2500/3500 machines are simplicity itself to operate. The whole operator panel is logically structured and reduced to the absolute essentials; its self-explanatory symbols make it easy to understand. Also, the rotary knob is big enough for you to grasp comfortably even with gloves on.

Data for every type of electrode is stored. The “Comfort” control panel also offers Synergic Mode: Simply set the type of electrode and the welding amperage, and all the other parameters will adjust themselves accordingly.

The carrying handle – integrated as standard – and the shoulder strap make it easy for you to take these sturdy lightweight units with you wherever you go. If you wish, you can operate your machine directly from the welding workplace using a convenient remote-control unit. The multi-operator rack lets you transport up to six machines at a time, in an easy and protected way, and includes a 6-way power distributor.



*Manual electrode welding and extra TIG function. Large rotary knob for ease of operation even when wearing gloves*



*E-manual welding and TIG additional function, also remote control interface for direct on-site control.*



*Manual electrode and perfect TIG welding with the TIG pulsed-arc function, for immaculate welds. Also features gas solenoid valve and remote-control connection.*



*Easy menu navigation and plain-text display. Job Mode stores individual settings. Synergic Mode optimises welding parameters for freely selectable types and diameters of electrode.*





# Comes with some impressive qualifications

## ECONOMY

### Could be the start of a lifelong partnership

The new robustness of the TransPocket 2500/3500 makes for the very greatest operational reliability, and thus also for long service life and high operational availability. The word “protection” was written very large indeed in the design and development stage:

Protecting the control panel by recessing the control elements, protecting the current socket by integrating it in the front of the housing, protection against soiling by incorporating a dust filter and thermostat-controlled fan as standard, protecting the unit against overheating by integrating an overtemperature cut-out ... High operational reliability thus results as a matter of course, which also means that downtimes are minimised.

The machines also feature a stand-by mode which lightens the load on the power source and uses 88 % less power than normal.



*Lightweight and portable, and so right at home on every worksite.*

## SAFETY

### Reliability in person

Providing the very highest levels of safety is part-and-parcel of being a serious supplier. For Fronius, this is a minimum requirement to be met by every welding system. Of course, the new TransPocket 2500 and 3500 machines come with all the necessary national and international certificates: S, CE, CSA and CCC marks and many other national marks of conformity. Not to mention “Degree of protection IP 23”.



## TECHNICAL DATA

		TP 2500		TP 2500 MVm		TP 3500		TP 3500 MVm
Mains voltage +/- 10 % 50/60 Hz		3 x 380 - 460 V		3 x 380 - 460 V*		3 x 380 - 460 V		3 x 380 - 460 V*
Mains fuse protection (slow-blow) 200 - 240 V		-		20 A		-		40 A
Mains fuse protection (slow-blow) 380 - 460 V		16 A		16 A		25 A		25 A
Primary continuous power (100 % )		7,1 kVA		7,1 kVA		11 kVA		11 kVA
Cos phi		0.99		0.99		0.99		0.99
Efficiency		89 %		89 %		87 %		87 %
Welding current range continuous	Electrode	15 - 250 A		15 - 250 A		10 - 350 A		10 - 350 A
	TIG	15 - 250 A		15 - 250 A		10 - 350 A		10 - 350 A
Welding current at 10 min/40°C (104°F)		35 % d.c 250 A		35 % d.c 250 A		35 % d.c 350 A		35 % d.c 350 A
		100 % d.c 175 A		100 % d.c 175 A		100 % d.c 230 A		100 % d.c 230 A
Open-circuit voltage		88 V		88 V		89 V		89 V
Standardised working voltage	Electrode	20.6 - 30 V		20.6 - 30 V		20.4 - 34 V		20.4 - 34 V
	TIG	10.6 - 20 V		10.6 - 20 V		10.4 - 24 V		10.4 - 24 V
Degree of protection		IP 23		IP 23		IP 23		IP 23
Type of cooling		AF		AF		AF		AF
Insulation class		F		F		F		F
Dimensions LxWxH		430x180x320 mm		430x180x320 mm		490x190x390 mm		490x190x390 mm
		16.93x7.09x12.6 inches		16.93x7.09x12.6 inches		19.29x7.48x15.35 inches		19.29x7.48x15.35 inches
Weight		12.5 kg		13.5 kg		18 kg		19.5 kg
		27.56 lb.		29.76 lb.		39.68 lb.		42.99 lb.

\* for phase failure, the welding current is limited to 140 A.



## CHECKLIST

General	TP 2500/3500	TP 2500/3500 RC	TP 2500/3500 TIG	TP 2500/3500 C	Displays	TP 2500/3500	TP 2500/3500 RC	TP 2500/3500 TIG	TP 2500/3500 C
Anti-stick function	●	●	●	●	Mode	●	●	●	●
Touchdown ignition	●	●	●	●	Plain text				●
Earth current watchdog	○	○	○	○	Mains voltage monitor	●	●	●	●
Vertical-down compatible welding (cellulose electrodes)	●	●	●	●	Overtemperature	●	●	●	●
Remote control facility		●	●	●	<b>Settable parameters</b>				
Gas test function			●	●	Dynamic	●	●	●	●
Generator-compatible	●	●	●	●	Falling characteristic	●	●	●	●
Hot start function	●	●	●	●	Freely programmable parameters				●
Soft start function	●	●	●	●	Stepless welding power	●	●	●	●
Temperature-controlled fan	●	●	●	●	TIG pulse			●	●
TIG Comfort stop			●	●					
Overtemperature protection	●	●	●	●					
VRD (Voltage reduction device)	○	○	○	○					

● as standard ○ optional

Axson Teknik är certifierade  
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Medlem i

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