

ISO 9001 Registered



VR400 / MR400 / MRA630



DC
Stick

VR400



*Inverter Controlled
High Performance
DC Arc Welding Machine*

DC
Stick

MR400



*IC • Thyristor Controlled
DC Arc Welding Machine*

DC
Stick

MRA630

GOUG
ING



*Digital Controlled
High Performance
DC Welding Machine*

OTC DAIHEN Asia Co., Ltd.

VR400

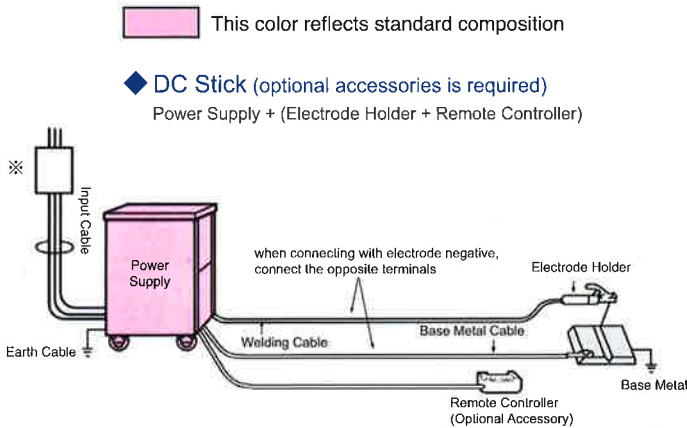
Inverter Controlled High Performance DC Arc Welding Machine

You can weld with Cellulose-coated electrode at any positions

- **Superior Arc Stability**
- **User Friendly Operation**
- **Arc Drive Control**
- **High Efficiency**



Connection Diagram



VR400 Product Features

- **IGBT Inverter Control, Easy Arc Strike**
Equipped with advanced IGBT control module and circuit design, offers stable arc and easy arc strike.
- **Perfect constant current characteristics, welding very stable**
Due to perfect constant current characteristics, welding current is always kept constant no matter conditions such as hand position change, input voltage change, surrounding temperature change, or cable length change
- **Wide range of applications**
Suitable for wide application such as oil and gas, pressure tank, construction, various factory works and repair work.
- **Automatic remote control box recognition. Plug in to use remote control box**
Remote control box (Optional Accessory) for easy setting of welding conditions.
- **Stackable two machines, by place the upper machine's legs fitting to the lower machine's handle**
- **Features input over-voltage protection circuit, input low-voltage protection circuit and input lack-phase protection circuit**
- **Dust-proof structure enables using under harsh environment**
- **Electric shock preventing device (Standard Device)**
Protect operator from electric shock.

Standard Accessories

| Name | Specification | Amount | Remark |
|------|------------------|--------|---------------------------------------|
| Fuse | ZH217 (500 V 5A) | 1PCS | For control circuit protection (PCB5) |
| Plug | CX0525 | 2PCS | For output connection |

Optional Accessories

| Description | Part No. |
|----------------------------|----------|
| Remote Control Box 3 meter | K5741J00 |

MR400

IC · Thyristor Controlled DC Arc Welding Machine

● Stable Arc

Stable and smooth arc by constant current characteristics.

● Heavy Duty Cycle

Especially suitable for medium and thick plate welding.
(Rated duty cycle 60%)

● Safety Design

Using strong materials for cases, the chassis mechanism does not allow small animals into the power supply unit.

● Arc Drive Control


Prevents electrode sticking to base metal during welding. (Standard Device)

● Diversified Applications

Useful for wide range of applications such as pressure tank, construction and on site work.

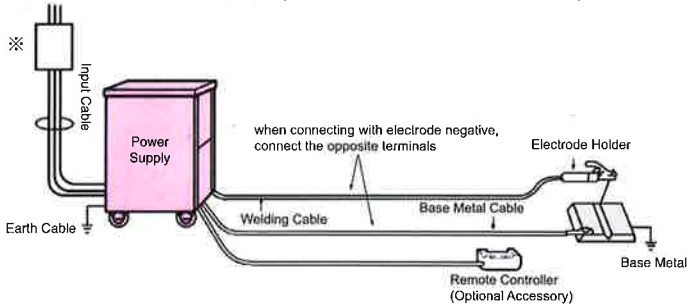


Connection Diagram

 This color reflects standard composition

◆ DC Stick (optional accessories is required)

Power Supply + (Electrode Holder + Remote Controller)



MR400 Product Features

MR400 is ideal DC Arc welding machine with stable arc and less spatter by adopting high quality IC-Thyristor technology.

● Arc drive control (Standard Device)

Arc drive control is standard function and it prevents a sticking of electrode to base metal during welding and enables smooth welding operation.

● Perfect constant current characteristics

Constant current characteristics features stable welding and its welding current always kept constant.

● Remote Box (Optional Accessory) for easy setting of welding conditions.

Part No. C0035K00

Standard Accessories

| Part Name | Description | Q'ty |
|----------------------|-----------------|------|
| Fuse | Refer to Manual | 1 |
| Cup Square Neck Bolt | M10 x 30 | 2 |
| Nut | M10 | 2 |
| Washer | M10 | 2 |
| Spring Washer | M10 | 2 |

Optional Accessories

| Description | Part No. | Q'ty |
|----------------|----------|------|
| Remote Control | C0035K00 | 1 |


MRA630

Digital Controlled High Performance DC Welding Machine

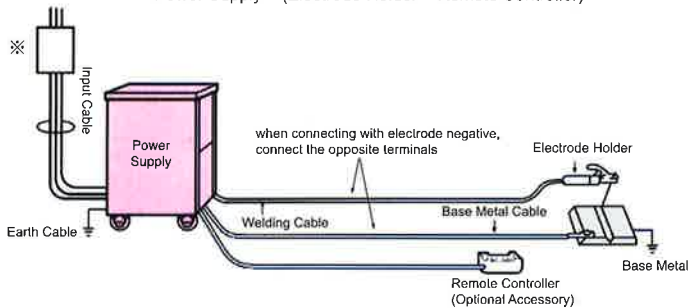
- Micro processor control**
 Stable arc with low spatter; most suitable current at high efficiency
- Diversified applications**
 Suitable for Low carbon steel, High-strength steel, Heat-resistant steel, Stainless steel and Copper alloy.
- User friendly design**
 Safety design, multiple protection, easy maintenance.



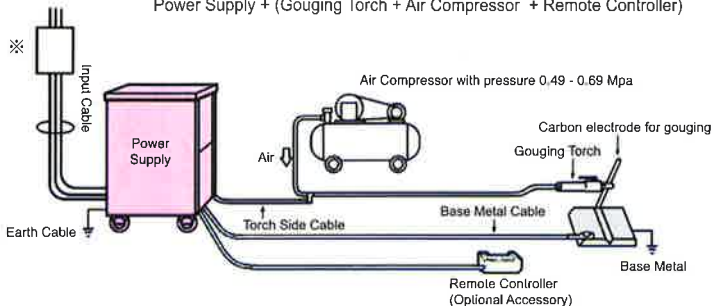
Connection Diagram

 This color reflects standard composition

◆ DC Stick (optional accessories is required)
 Power Supply + (Electrode Holder + Remote Controller)



◆ DC Gouging (optional accessories is required)
 Power Supply + (Gouging Torch + Air Compressor + Remote Controller)



Standard Accessories

| Part Name | Description | Q'ty |
|----------------------|-------------|------|
| Glass Enclosed Fuse | 5 A 250 V | 1 |
| Cup Square Neck Bolt | M10 x 30 | 2 |
| Nut | M10 | 2 |
| Washer | M10 | 2 |
| Spring Washer | M10 | 2 |

Optional Accessories

| Description | Part No. |
|----------------|-------------|
| Remote Control | C0223K00 |
| Gouging Torch | GT-11 Model |



Gouging Torch Model GT-11

Max Current 700A
 Duty Cycle 70%
 Carbon Electrode ϕ 4~ ϕ 11
 Compress Air 0.49~0.69MPa

Specification



| Model | VR-400 | | MR-400 | | | MRA-630 | | |
|---------------------------------|--|------------------|--|-------------------|-------------------|--|--------------------|--------------------|
| Power Source Voltage | 380 V ±10% | 415 V ±10% | 220 V ±10% | 380 V ±10% | 415 V ±10% | 220 V ±10% | 380 V ±10% | 415 V ±10% |
| Number of Phase | 3 | | 3 | | | 3 | | |
| Rated Frequency | 50 / 60 Hz | | 50 / 60 Hz | | | 50 / 60 Hz | | |
| Rated Input Power | 18.8 kVA 16.4 kW | 19.1 kVA 16.5 kW | 26.3 kVA 20.4 kW | | | 47.7 kVA 36.8 kW | | |
| Rated Output Current | 400 A | | 400 A | | | 630 A | | |
| Rated Load Voltage | 36 V | | 36 V | | | 44 V | | |
| Rated Output Current Range | 10~400 A | | 40~400 A | | | 60~630 A | | |
| Rated Output Voltage Range | 20.4 ~ 36 V | | 21.6 ~ 36 V | | | 22.4 ~ 44 V | | |
| Rated No-load Voltage | 66.9 V | 73.0 V | 65.0 V | | | 82 V | 82 V | 84 V |
| Rated Duty Cycle | 60 % | | 60 % | | | 60 % | | |
| Class of Insulation | Main Transfer : Class C ; DC reactor : Class 200°C | | Main Transfer : Class C ; DC reactor : Class 200°C | | | Main Transfer : Class C ; DC reactor : Class 200°C | | |
| Usable Temperature Range | -10 ~ +40°C | | -10 ~ +40°C | | | -10 ~ +40°C | | |
| Protection Rating | IP21S | | IP21S | | | IP21S | | |
| External Dimensions (W x D x H) | 329 x 608 x 598 (mm) | | 400 x 607 x 770 (mm) | | | 508 x 724 x 894 (mm) | | |
| Mass | 56.2 kg | | 148 kg | 151 kg | 151 kg | 224 kg | 232 kg | 242 kg |
| Input Cable and Grounding Cable | 8 mm ² or more | | 14 mm ² | 8 mm ² | 8 mm ² | 38 mm ² | 14 mm ² | 14 mm ² |
| Fuse / Breaker Capacity | 40 A | | 75 A | 50 A | 50 A | 150 A | 100 A | 100 A |

In accordance with DAIHEN's policy to make continuing improvements, design and/or specifications are subject to change without notice and without any obligation on the part of manufacturer.



OTC DAIHEN Asia Co., Ltd.

Head Office & Factory

60/86 Mu 19, Navanakorn Industrial Estate Phase3, Klong Nueng, Klong Luang, Pathumthani 12120 Thailand
TEL : (+66) 2529-2130-1, 2529-3335-7, 2909-4163-5 FAX : (+66) 2529-2132, 2909-4166

Bangkok (Sales) Office

23/43, Fl.16th Sorachai Bldg., 23 Soi Sukhumvit 63, Klongtonnua, Wattana, Bangkok 10110 Thailand
TEL : (+66) 2714-3201(Auto 5 Lines) FAX : (+66) 2714-3204

E-mail : otcda@otc.co.th URL : <http://www.otcdaihenasia.com>

Branch Office :

Laemchabang

Representative Offices :

India, Indonesia and Malaysia
