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# Buddy™ Arc 400i

# Buddy™ Arc 400i XC

## Industrial-Duty Inverter Welder

### Robust and powerful

The Buddy™ Arc 400i & 400i XC are industrial-duty, fan cooled, inverter controlled power sources meant for MMA / TIG (scratch-start) welding.

### MMA Welding

A wide current range and powerful welding performance make the Buddy™ Arc machines suitable for a wide range of applications and electrode types such as:

- General purpose
- Low-hydrogen
- Stainless steel
- Cellulosic

The Arc 400i XC model has controlled welding dynamics that provides excellent weld properties for welding pipe root passes.

### TIG Welding

The Buddy™ Arc machines are capable of performing TIG welding with precise current control. All you need is an optional TIG-torch with a gas valve, a gas regulator and a cylinder of gas. You can weld mild steel or stainless steel material with or without filler material.

### Voltage Reduction Device - VRD

In some areas a voltage reduction device, or VRD, is required. VRD is a safety function that limits the open circuit voltage from the machine to less than 35 V. The Buddy™ Arc are prepared for VRD and the function can easily be activated inside the power source.

### Easy settings

The simple control panel of the Buddy™ Arc makes it easy to optimise settings, reducing the time taken for achieving the best weld characteristics. These units are equipped with hot start and arc force with the possibility to adjust parameters during welding. Hot start helps to avoid starting problems while arc force sets the intensity of the arc for improved weld quality.

As an option the Buddy™ Arc can be equipped with a remote control unit.

### Applications

- Shipbuilding
- Civil construction
- Pipe workshops
- General steel fabrication



### Energy Efficient

The Buddy™ Arc machines are constructed to maintain a high power factor and efficiency, thus keeping the energy cost to a minimum without affecting the weld quality.

### Safety & Reliability

The Buddy™ Arc machines conform to International Standards that ensures the reliability & safe use of these machines.

These units are equipped with overheating and mains over/under voltage protection that will temporarily switched off the machines automatically to prevent any potential damage that the components might sustain.

- **Inverter controlled** – more efficient power usage
- **Light weight** – improved mobility
- **Easy-to-use control panel** – quick setup
- **Adjustable hot start** – easy to strike the electrode. Helps you to avoid starting problems.
- **Adjustable arc force** – sets the intensity of the arc for improved weld quality.
- **Wide mains voltage tolerance** – stable welding controls

## Technical data

|   |   |
|---|---|
| <b>Product name</b>                     | <b>Buddy™ Arc 400i</b><br><b>Buddy™ Arc 400i XC</b> |
| <b>Mains voltage, V/Ph Hz</b>           | 400V ± 15%, 3ph, 50Hz                               |
| <b>Effective input current, A</b>       | 21.4A   |
| <b>Fuse (slow), A</b>                   | 32  |
| <b>Mains cable, Ø mm<sup>2</sup></b>    | 4C x 4  |
| <b>Permitted load at (MMA)</b>          |   |
| 60% duty cycle, A/V                     | 400 / 36  |
| 100% duty cycle, A/V                    | 310 / 32.4  |
| <b>Permitted load at (TIG)</b>          |   |
| 60% duty cycle, A/V                     | 400 / 26  |
| 100% duty cycle, A/V                    | 310 / 22.4  |
| <b>Power factor at maximum current</b>  | 0.93  |
| <b>Efficiency at maximum current, %</b> | 85  |
| <b>Setting range (TIG/MMA), A</b>       | 20 - 400  |
| <b>Open circuit voltage (OCV), V</b>    | 68 (400i)<br>78 (400i XC)                           |
| <b>Reduced OCV (VRD), V</b>             | <35   |
| <b>Dimensions l x w x h, mm</b>         | 540 x 280 x 510                                     |
| <b>Weight, kg</b>                       | 29 (400i)<br>31 (400i XC)                           |
| <b>Operating temperature</b>            | -10 till 40°C                                       |
| <b>Enclosure class</b>                  | IP21  |
| <b>Application class</b>                | S   |
| <b>Standards</b>                        | IEC 60974-1<br>IEC 60974-10                         |



## Ordering information

|   |              |
|---|--------------|
| Buddy™ Arc 400i   | 0700 300 900 |
| Buddy™ Arc 400i XC  | 0700 300 901 |
| Supplied with 3m mains cable & 2 pcs of male quick connectors |              |

|  |                           |
|--|---------------------------|
| <b>Optional Accessories:</b>               |                           |
| MMA Kit (Ready-to-weld)                    | 0700 300 910              |
| 5 m + 3m welding cables, 50mm <sup>2</sup> |                           |
| Remote Control, 10m                        | 0700 300 911              |
| TXH™ 200V, Tig torch, OKC 4m               | 0460 012 841              |
| TXH™ 200V, Tig torch, OKC 8m               | 0460 012 881              |
| Argon Regulator                            | As per local requirements |

### Quality accessories for the quality welder

ESAB offers a wide range of accessories. The complete range, along with product information, is available at our local web-sites, look at [www.esab.com](http://www.esab.com) or contact your local ESAB dealer.

### Unrivalled service and support

Our commitment and ability to deliver the expected service and support starts immediately after the order is confirmed. We endeavour to offer our customers an After Sales service, which is second to none. A strong and skilful service organisation is prepared to offer service and maintenance, calibration, validation and upgrading of equipment and software. The service organisation will offer standardised solutions for the reconditioning or modification of existing products.

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