

Caddy™ Arc 251i

Portable solutions for professional welding

The Caddy™ name has always been synonymous with robust and durable welding tools designed for the professional welder. Introducing the fifth generation of portable welding equipment from ESAB the latest Caddy™ machines have over 30 years experience in inverter technology built in..

Designed for durability

The machines are equipped with the large OKC 50 cable connectors for higher durability. The compact design, with its impact resistant polymer casing is light and easy to carry, yet the size does not compromise the important cooling of the internal components. Large heat sinks and clever design make for a cooler running machine with a longer life expectancy when used in harsh working environments. The design also helps to keep all sensitive parts inside the machine clean and dust free. Caddy™ is built in accordance with IP23, which means it can be used outdoors – even in the rain. The control panels are easy to understand and use. The durable design and the superior welding performance give you a machine that you can rely on day after day.

Power factor correction - PFC

Caddy™ Arc 251i is a 400 V three-phase power source equipped with a PFC circuit making it possible to use the full range of the machine on a 10 A fuse. The PFC also protects the machine against fluctuating mains voltage and makes it safer to use with a generator. Caddy™ Arc 251i can operate with extra long mains cables, over 100 m, giving you a very larger working radius.



Control panels

Caddy™ Arc 251i has two control panels to choose from, both with a digital display and a remote control function. The basic panel Caddy™ A32 has a choice of MMA or TIG welding with LiveTig™ start in TIG mode. Apart from that you only need to set the welding current. The more advanced Caddy™ A34 panel gives you hot-start and arc force control to fine tune the welding, a choice of MMA or TIG welding, LiveTig™ start in TIG mode, two memories and remote control facility. In MMA mode you can choose your electrode type and the machine will optimise the welding performance automatically.

Both panels are easy to understand and set, even with your gloves on.

Applications

- Professional welding tool
- In and outdoor installation on site
- In and outdoor repair and maintenance on site
- In and outdoor fabrication
- Shipbuilding and offshore
- Power generation
- Process industry



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 below 35 V. Caddy™ Arc 251i is prepared for VRD and the function can easily be activated inside the power source.

MMA welding

Caddy™ Arc supplies direct current and you can weld most metals such as alloyed and non alloyed steel, stainless steel, cast iron, etc. With Caddy™ Arc 251i you can weld all types of electrodes from Ø1,6 -5 mm; basic, rutile, cellulosic and highrecovery, with excellent welding performance. The latest regulator, ArcPlus™ II, gives a more intense, yet smooth and stable arc that is easy to control. Arc Plus™ II generates smaller droplets, the arc burns smoothly and there is no need to pause at the edges when weaving. ArcPlus™ II offers even better welding characteristics, simplifies your work and gives you better weld quality with less need for post weld treatment.

TIG welding

With Caddy™ Arc you can easily TIG-weld. All you need is a TIG-torch with a gas valve, a gas regulator and a cylinder of gas. LiveTig™ start electronically controls the start current giving you a safe start without damaging the electrode. You can weld mild steel or stainless steel with or without filler material.

- **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.
- **Electrode type selection** – sets the characteristics of the machine according to the electrode you want to weld.
- **ArcPlus™ II** - better welding characteristics, simplifies your work and gives you better weld quality with less after treatment.

Technical data

Caddy™ Arc 251i

Mains voltage V/ph Hz	400/3 50/60
Fuse (slow), A	16
Permitted load at 40°C, MMA	
30% duty cycle, A/V	250/30
60% duty cycle, A/V	190/27,6
100% duty cycle, A/V	150/26
Permitted load at 40°C, TIG	
30% duty cycle, A/V	250/20
60% duty cycle, A/V	190/17,6
100% duty cycle, A/V	150/16
Setting range MMA (DC), A	4 - 250
Setting range TIG (DC), A	3 - 250
Open circuit voltage, V	65
Open circuit voltage limit (VRD active), V	35
Dimensions l x w x h, mm	418 x 188 x 208
Weight, kg	10,5
Enclosure class	IP 23
Application classification	S
Standards	EN60974-1, EN60974-10



Ordering information

Description	Code
Caddy™ Arc 251i, A32 package	1620607384
Caddy™ Arc 251i, A34 package	1620607396

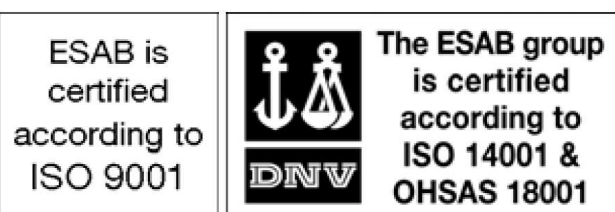
Delivery content:
 3 m of mains cable with plug
 3 m MMA welding and return cable kit

Function	Setting range	A32	A34
Current	4 max 1)	x	x
Active panel	OFF or ON	x	x
Remote control unit	OFF or ON	-	x
Hot start	0 - 99%	x 2)	x
Arc force	0 - 99%	x 2)	x
Drop welding	OFF or ON	x 2)	x 2)
VRD -		x	x

- 1) The setting range is dependent on the power source used.
- 2) Hidden function

Optional accessories

Shoulder strap	on request
Remote control MMA 1(with A34)	1620607337
TIG torch TXH™ 200V OKC50, 4m	1620607292
TIG torch TXH™ 200V OKC50, 8m	1620607293



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