

TRANSPULS SYNERGIC 2700

/ MIG/MAG, TIG DC & rod electrode (MMA) welding



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**DIGITAL
REVOLUTION**

GENERAL REMARKS

A HIGH-PERFORMANCE SYSTEM

/ The TPS 2700 is a very special power source indeed: It is totally digitised, so it delivers high-precision welding results. Its “synergic mode” makes it extremely simple to operate. Weighing only 27 kg, it is portable and suitable for any type of on-site/maintenance use, thanks also to its integral wirefeed drive. What’s more, it comes with just the right accessories for every possible application. From torches to cooling units to remote-control units. All exactly fine-tuned to the capabilities of the power source, and optimised as a complete overall system.

UTILISATION

VERSATILE PROFESSIONALS

/ The TPS 2700 machines offer an amazingly wide spectrum of possible applications. This is partly because of their portability, which makes them so ideal for the construction site, the workshop, and for repair and maintenance work. It is also due to their multiprocess capability – which means that you can weld using any welding process, be it MIG/MAG, TIG or MMA, all with one and the same machine. Another reason is that there are so many different versions of the machine for you to choose from.



ONE MACHINE, MANY VARIANTS

/ The TPS 2700 AluEdition, for instance – a solution developed specially for welding aluminium. Complete with extensive aluminium-specific functions and accessories; for classic aluminium applications or for working with very soft aluminium wires and/or long hosepacks.

/ And then there is the TPS 2700 Duo: On this version, an extra wirefeeder can be mounted on the machine. This allows you to weld two different materials without having to constantly retool the machine with a different torch and welding wire.



/ TPS 2700 Duo: Makes it easy to weld two different materials at once using an extra wirefeeder

/ Finally, there is the TPS 2700 TIG, which comes with some special TIG-welding capabilities. Like TIG Comfort Stop, for example. This function cures the arc of its annoying habit of breaking at the end of welding. Uninterrupted gas shielding is ensured, and the end crater is filled to perfection.



/ TPS 2700 TIG: Perfect TIG welding, thanks to special functions and multiprocess capability

PERFECTION IS THE MEASURE OF ALL THINGS

WELDING PROPERTIES

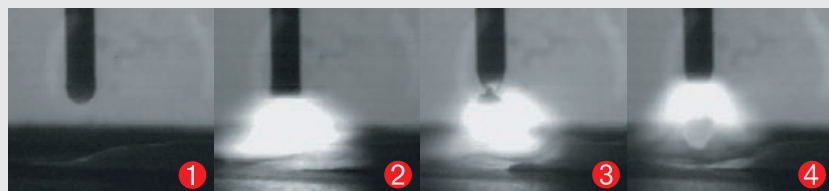
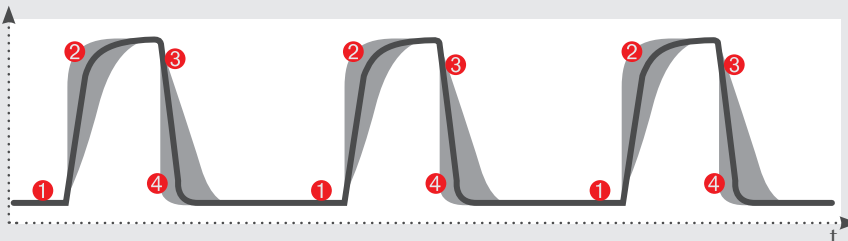
IDEALLY PROGRAMMED IGNITION SEQUENCE

/ What prompted the development of the digital machines was a desire to achieve absolute perfection in the welding process, and 100 % reproducibility of any welding result once this has been optimised. This may be seen first and foremost in the ignition. The TPS 2700 features an ignition sequence that has been optimised and programmed right down to the very last detail, and that is available time and time again, in the same high quality.

/ Depending on the application in question, there are various different ignition variants. One of these is conventional welding start-up. Here, the ignition parameters are precisely matched to the diameter and quality of the wire. Quiet, jerk-free ignition is the result. At the end of welding, a controlled current pulse sheds the last molten droplet, preventing a solid globule from forming at the tip of the electrode. And in conjunction with the PT-Drive push-pull torch, SFI ignition makes spatter-free welding start-ups a reality.

START-UP PROGRAM FOR ALUMINIUM

/ There is an extra ignition variant for aluminium: In order to prevent fusion defects, the base metal has to start being melted right away, in the start-up phase. For this reason, ignition is effected at considerably higher power. After this, the welding power is lowered again. However, in order to avoid any risk of drop-through, it is also possible to immediately lower the welding power down to the crater-fill current.



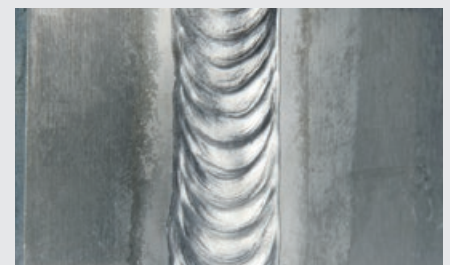
The pulsed MIG/MAG arc features a controlled, short-circuit-free material transfer. The droplet size is adjustable.

THE CUSTOM-TAILORED ARC

/ With digital machines, all sorts of things become possible. They adapt to any and every task. Particularly in the case of the arc, very different requirements may be made, depending on the application. The digital inverter power source permits tailor-made solutions here. When it comes to pulsed arcs, for example, there is a special pulse-form to go with every material. The TPS 2700 functions so precisely that only one single droplet of filler metal is detached for each current pulse. This results in virtually spatter-free welding, and means that for the first time, precision working is possible at the lower end of the power range: a 0.6 mm aluminium sheet can be welded under a pulsed arc using a 1.2 mm wire electrode with no difficulty at all.

/ The digital arc-length control opens up wholly new perspectives as well. It works with such speed and precision that the arc length remains constant at all times; even when the stick-out changes, there is hardly any spatter.

/ In addition, the SyncroPuls function was developed for the machines. This function superimposes a low-frequency pulse over the normal pulse, resulting in seam quality that is comparable with that of a TIG weld, and ensuring immaculate weld-seam appearance.



COST EFFICIENCY AND SERVICING

IT PAYS TO BE INTELLIGENT

/ The well thought-out modular principle of these machines not only makes them so easy and pleasant to work with, it also has a direct impact on their efficiency and ease of servicing. For instance, the Fronius welding systems have a loss-free gas supply to the torch.

SAVINGS ARE ALL PART OF THE DEAL

/ What is more, some very handsome savings are generated all the time, as a direct result of the machines' digital intelligence. Some examples: practically spatter-free welding (meaning next-to-no post-weld machining), automatic cooling-unit cut-out, low open-circuit power, high efficiency, updates via laptop, easy accessibility for servicing.

EXTREMELY SERVICE-FRIENDLY

/ While we're on the subject of servicing: Because the TPS 2700 power sources are designed for simplicity, with a small number of separate subassemblies, all the components are easily accessible. To make service work easier still, the machines display service codes such as "No shielding gas". And thanks to the machines' digital core, you can simply upload updates from your laptop, keeping you right up with the "state of the art" of welding technology.

SAFETY

TAKE IT FOR GRANTED

/ Safety – need one say more? Every Fronius machine has to pass a maximum of testing. And this is no different for the TPS 2700. Far from it. Indeed, it offers even more safety. To begin with, there's the earth fault-current watchdog. In the event of a malfunction, this prevents any welding current flowing through the earth (ground) lead and destroying the PE (protective earth) system. This watchdog comes as standard. Secondly, there is the thermostat-controlled fan, which reduces dirt accumulation inside the machine because it only runs when it's actually needed. And everything else can be taken for granted: S mark, CE mark to EN 60 974/1 and EN 50 199 (including tilt test), degree of protection IP 23 for suitability for use in the field.





/ JobMaster with integral remote-control functionality



/ "PT-Drive" push-pull manual welding torch



/ The right remote-control unit for every requirement: TR 2000 MIG programmable remotecontrol unit; TR 4000 universal remote-control unit; TR 4000 C deluxe remote control

HANDLING

MAKE YOUR CHOICE, AND OFF YOU GO

/ For all its technological versatility, the TPS 2700 is very easy to operate. The reason is its "synergicmode" operation: One dial is all you need, to control everything. Select the material and the sheet thickness – that's all. Then off you go! The digital TPS 2700 now automatically accesses its integrated expert knowledge and controls the entire welding process.

STAY IN CONTROL – RIGHT WHERE YOU ARE

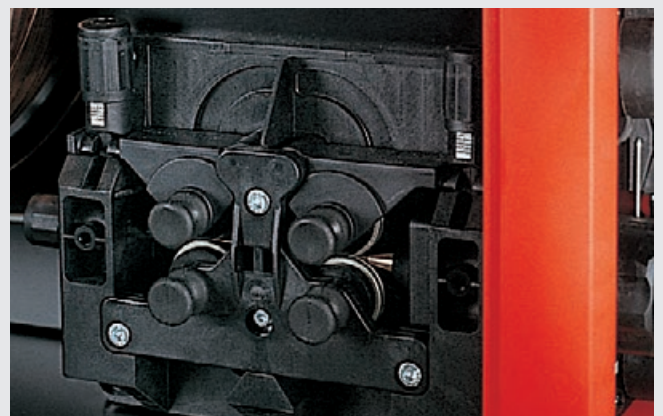
/ No matter where the power source happens to be standing, you can keep on working right where the action is. With the TPS 2700, you'll always have the right remote-control unit for all manner of different applications. Or you can even operate the machine directly from the torch, with the up/down control or the integral remote-control functionality offered by the JobMaster version.

PERFECT INTERPLAY WITHIN THE SYSTEM

/ The TPS 2700 is more than just a power source – it is designed as an entire system. A system containing all the components that you need for successful welding: torch, wirefeed, hosepacks, communications, weld data management – it's all been thought of. With every single item perfectly co-ordinated with all of the others.

INTELLIGENT WIREFEED

/ For any welding process, the wirefeed is hugely important. It has a direct impact on the welding result, and has to be reliable, precise and as smooth as possible. The TPS 2700 has a high-grade 4-roller drive integrated within it. A planetary drive "PT Drive" is available as an option for soft aluminium wires. The digitally controlled motor speed allows the wirefeed speed to be set continuously anywhere between 0 and 22 m/min, accurately and reproducibly.



/ 4-roller drive integrated within the power source, for smooth, precision wirefeed

TECHNICAL DATA

POWER SOURCE	TP 2700
Mains voltage	3 x 400 V
Mains voltage tolerance	± 15 %
Mains fuse protection (slow-blow)	16 A
Primary continuous rating (100 % d.c.)	4.5 kVA
Cos phi	0.99
Efficiency	87 % (70 A)
Welding-current range	
MIG/MAG	3 – 270A
Electrode (MMA)	10 – 270A
TIG	3 – 270A
Welding current at	
10 min / 25° C	270 A 60 % d.c. 210 A 100 % d.c.
10 min / 40° C	270 A 40 % d.c. 210 A 60 % d.c. 170 A 100 % d.c.
Open-circuit voltage	50 V
Operating voltage	
MIG/MAG	14.2 – 27.5 V
Electrode (MMA)	20.4 – 30.8 V
TIG	10.1 – 20.8 V
Degree of protection	IP 23
Type of cooling / Insulation class	AF / B
Dimensions L / W / H	625 / 290 / 475 mm 24.63 x 11.43 x 18.72 in.
Weight	27 kg / 59.4 lb



COOLING UNIT	FK 4000
Mains voltage 50 Hz	230 / 400 V
Power consumption	0.5 A
Cooling capacity at	
Q = 1 l / min, + 20° C	1600 W
Q = 1 l / min, + 40° C	900 W
Q = max, + 20° C	1600 W
Max. delivery rate	1.6 l / min
Max. pump pressure	4.5 bar
Pump	Vibrating armature pump
Coolant volume	5.5 l
Degree of protection	IP 23
Dimensions L / W / H	725 / 290 / 230 mm 28.5 x 11.43 x 9.07 in.
Weight (without coolant)	14.1 kg / 9 lb

CHECKLISTE

GENERAL REMARKS
4-roller drive
Automatic burn-back control
Automatic cooling unit cut-out
Burn-back impulse (perfect wire-end, optimum re-ignition)
Continuous adjustment of welding current directly from torch
Digital weld-process control
Feeder creep
Feeder inching, without gas or current
Earth leakage detection
Gas-test function
Job mode
Microprocessor control
Multiprocess – MIG/MAG, TIG and MMA
Overtemperature protection
Synergic operation
Thermostat controlled fan

ADJUSTABLE PARAMETERS

Arc-force dynamic
Arc-length / droplet-detachment correction
Burn-back time
Continuously adjustable welding power
Crater-fill current
Gas pre/post-flow time
Hot-Start

OPTIONAL

End-of-wire watchdog
Gas economiser valve
PullMig mode
Robot interface, analogue / digital
Spatterfree ignition
SyncroPuls
TIG Comfort Stop
Welding programs from databank

DIGITAL DISPLAY OF
"a"-dimension
Arc-force dynamic, arc-length and droplet-detachment correction
Globular (intermediate) arc
"Hold" function
Job number
Manual operation
Motor current
Operating mode and process
Overtemperature
Service codes
Sheet thickness
Welding speed
Welding amperage and voltage (actual and guideline values)
Wirefeed speed

OPERATING MODES

2-step mode
4-step mode
Aluminium welding start-up (special 4-step mode)
Special 2-step mode
Spot welding

/ Perfect Welding / Solar Energy / Perfect Charging

WE HAVE THREE DIVISIONS AND ONE PASSION: SHIFTING THE LIMITS OF POSSIBILITY.

/ Whether welding technology, photovoltaics or battery charging technology – our goal is clearly defined: to be the innovation leader. With around 3,000 employees worldwide, we shift the limits of what's possible - our record of over 1,000 granted patents is testimony to this. While others progress step by step, we innovate in leaps and bounds. Just as we've always done. The responsible use of our resources forms the basis of our corporate policy.

Further information about all Fronius products and our global sales partners and representatives can be found at www.fronius.com

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Fronius Canada Ltd.
2875 Argentia Road, Units 4,5 & 6
Mississauga, ON L5N 8G6
Canada
Telephone +1 905 288-2100
Fax +1 905 288-2101
sales.canada@fronius.com
www.fronius.ca

Fronius USA LLC
6797 Fronius Drive
Portage, IN 46368
USA
Telephone +1 877 FRONIUS
sales.usa@fronius.com
www.fronius-usa.com

Fronius UK Limited
Maidstone Road, Kingstons
Milton Keynes, MK10 0BD
United Kingdom
Telephone +44 1908 512 300
Fax +44 1908 512 329
info-uk@fronius.com
www.fronius.co.uk

Fronius International GmbH
Froniusplatz 1
4600 Wels
Austria
Telephone +43 7242 241-0
Fax +43 7242 241-953940
sales@fronius.com
www.fronius.com