



Heliarc® 252/352 AC/DC

- Square wave AC output gives superior welding with improved cleaning and lack of rectification
- AC wave balance control - allows adjustment from maximum cleaning to maximum penetration
- Arc force control - fine tunes arc for stick welding from soft to a high penetration, digging arc
- 100% solid state design with no mechanical contactor - eliminates output drift, lowers maintenance and promotes long life
- Direct connections for Tig torch and quick lock output cable - for maximum convenience
- Adjustable preflow and postflow gas control - protects weld area and extends tungsten life
- 6 ft. (1.8 m) gas hose and water inlet and outlet fittings are factory installed
- Protected against overheating and overcurrent
- 12 Ready-to-Weld Packages, add shield gas and power to weld



Ordering Information

Heliarc® 252 AC/DC Power Source

230/460/575 vac, 1 ph, 60 Hz	36201
252 AC/DC CE, 220/400v 1ph 50 Hz	36205

Heliarc® 352 AC/DC Power Source

230/460/575 vac, 1 ph, 60 Hz	36211
352 AC/DC CE, 220/400v 1ph 50 Hz	36207

Each power source listed above is supplied with 2 male Twist Lock Cable Connectors and a 6 ft. (1.8 m) gas hose.

See other Heliarc® Outfits and Torches on following pages

Tigmaster AC/DC Packages

Tigmaster packages listed below include power source, Heliarc torch-25ft., starter hoses, work cable with clamp, R-33-FM-580 Regulator/flowmeter, Sample 5lb. Value Pack of Stick Electrodes & Heliarc welding handbook

Tigmaster H252 w/HW-17 Torch Outfit, 230/460/575v	36229
Tigmaster H252 w/HW-26 Torch Outfit, 230/460/575v	36674
Tigmaster H252 w/HW-20 Torch Outfit, 230/460/575v	36230
Tigmaster H252 w/HW-18 Torch Outfit, 230/460/575v	36675
Tigmaster H252 w/HW-26 Torch Deluxe Outfit, 230/460/575v (Incls.H252, HW-26 Outfit, TR-23 Truck, and TC-2B control).....	37659
Tigmaster H252 w/HW-20 Torch Deluxe Outfit, 230/460/575v (Incls.H252, HW-20 Outfit, TR-23 Truck,WC-8C Circulator and FC-5C control).....	0558004766
Tigmaster H252 w/HW-18 Torch Deluxe Outfit, 230/460/575v (Incls.H252, HW-18 Outfit, TR-23 Truck, WC-8C Circulator and FC-5C control)	0558004794
Tigmaster H352 w/HW-17 Torch Outfit, 230/460/575v	36231
Tigmaster H352 w/HW-26 Torch Outfit, 230/460/575v	36676
Tigmaster H352 w/HW-20 Torch Outfit, 230/460/575v	36232
Tigmaster H352 w/HW-18 Torch Outfit, 230/460/575v	36677
Tigmaster H352 w/HW-18 Torch Deluxe Outfit, 230/460/575v (Incls.H352, HW-18 Outfit, TR-23 Truck, and TC-2B control).....	37660

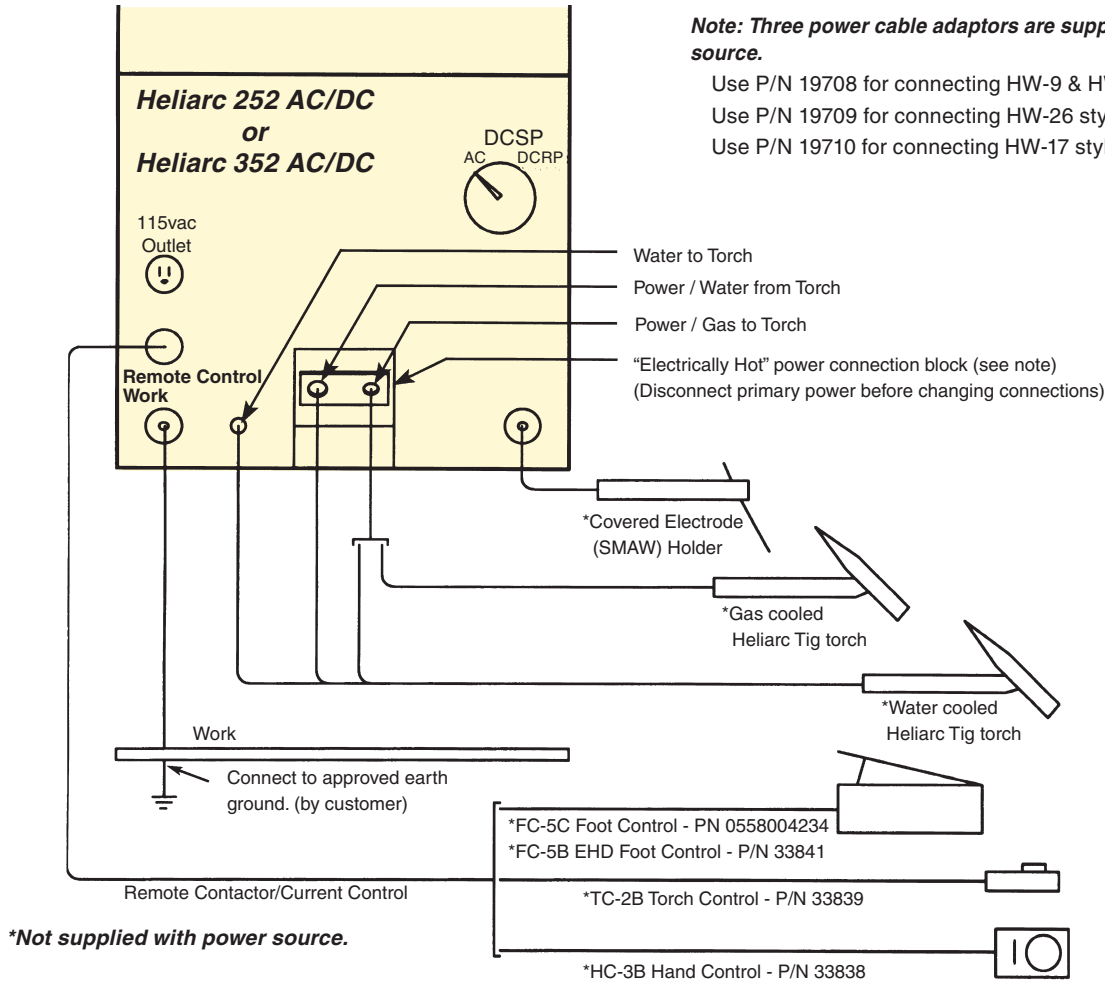
Options & Accessories

Power Factor Correction Kit	36220
(see Specifications for performance comparison)	
Digital Amp/Volt Meter Kit with Current Preset.....	36226
(standard on 352; optional for 252)	
Pulse Control Kit	36227
Current Upslope/Downslope Control - with Trigger Lock	36228
TR-23A Truck Kit - includes wheels & 2-cylinder rack	36224
FC-5B EHD Foot Control - 30 ft. (9.1 m)	33841
FC-5C Foot Control - 30 ft. (9.1 m).....	0558004234
HC-3B Hand Control - 30 ft. (9.1 m)	33838
TC-2B Torch Control - 25 ft. (7.6 m).....	33839
TC-3A Remote Torch Switch - 30 ft. (9.1 m):	
for HW-9, 17, 20, 20A & 24	35783
for HW-18 & 26R.....	36680
Electrode Holder, 300A., 15 ft.	21226
WC-8C Water Cooler	33739
Eye-Tech 5-13 Welding Helmet.....	0700000890
Economy Arc Welding Gloves Large	747F40
Heliarc Gloves Large.....	747F33
Heliarc Gloves Medium.....	747F32
TIG-PEN (for .040-1/8" Filler rod)	0700009026

50 mm Connectors - quick-acting twist lock connectors for attaching output power cables or torches to power source:

Male for 1/0 to 4/0 cable.....	13792513
Female for 1/0 to 4/0 cable.....	13735631
Male for #2 AWG to 1/0 cable.....	13733936
Female for #2 AWG to 1/0 cable	13735632
Quick connector with 1/2 in. threaded stud.....	13735501
Tee connector - 1 male, 2 female	13792804

Instruction Manual	F-15-254
Sales Literature, Heliarc 252/352.....	(12-01-2006) ARC-23013



Specifications

	Heliarc 252	Heliarc 352
Rated output @ 40% Duty Cycle, 10 minute base, AC or DC For 208 vac, 60 Hz or 380 vdc 50 Hz, derate output by 10%	280 amps @ 30 volts	350 amps @ 34 volts
Output Current Range, AC or DC	5 - 320 amps	3 - 380 amps
Open Circuit Voltage (maximum)	79 vac; 72 vdc	79 vac; 72 vdc
Net Weight, 60 Hz models	375 lbs.	432 lbs.
Net Weight, 50 Hz models	415 lbs.	472 lbs.
Approximate Shipping Weight, 60 Hz models	385 lbs.	442 lbs.
Approximate Shipping Weight, 50 Hz models	425 lbs.	482 lbs.
Width x Length x Height (both models)	18.75 in (46cm) x 32.5 in (83 cm) x 25 in (64 cm)	
Primary input voltage & current at rated load of standard model (without power factor correction kit)		
230(208)/460 vac 1 ph, 60 Hz	112(118)/56 amps	152(168)/76 amps
230/460/575 vac 1 ph, 60 Hz	112/56/45 amps	152/76/61 amps
220/400 (380-415) vac 1 ph, 50 Hz	104/57(60-55) amps	153/84(88-81) amps
Primary input voltage & current at rated load of standard model with power factor correction kit		
230/460/575 vac 1 ph, 60 Hz	77/38/31 amps	110/55/43 amps
220/400 (380-415) vac 1 ph, 50 Hz	78/40(42-38) amps	112/58(61-56) amps
Power Factor @ rated load:		
Without power factor correction kit	52%	55%
With power factor correction kit	76%	76%