

STICK

- HIGHLIGHTS
- SYSTEM OVERVIEW
- AREA OF APPLICATION
- CONTROL
- TECHNICAL DATA



## Professional welding properties and simple operation with maximum ease-of-use

- 100 % suitable for construction sites – optimised for tough assembly work applications
- Simple transport
- Simple operation with maximum ease-of-use
- Reproducible, safe ignition
- Exceptional welding properties
- Safe and reliable to use



## 100 % suitable for construction sites – optimised for tough assembly work applications

- Optimised casing design for reduced contamination in the machine: enclosed casing trough; large, high feet; increased air inlet openings; control unit foil; dirt filter for the especially tough environment (optional) – but no direct suction of dirt particles, e.g. from the ground
- High mains voltage tolerance (-25% - +20%) for unrestricted operation on generators, on weak mains supplies, on cable drums and long mains cables
- Protection classification IP23 (open-air operation), S - safety sign (boiler welding)
- VRD-Safety function for open circuit voltage reduction (optional)



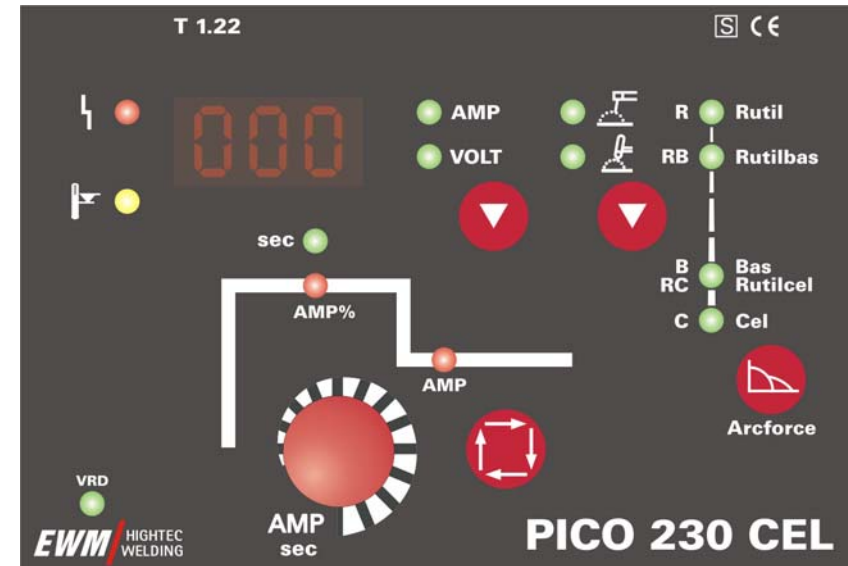
### Simple transport

- Small, compact design and low weight for effortless transport using the easy-to-use bar, the grips or the practical carrying strap, e.g. on stairs, ladders, in steel constructions and on scaffolding



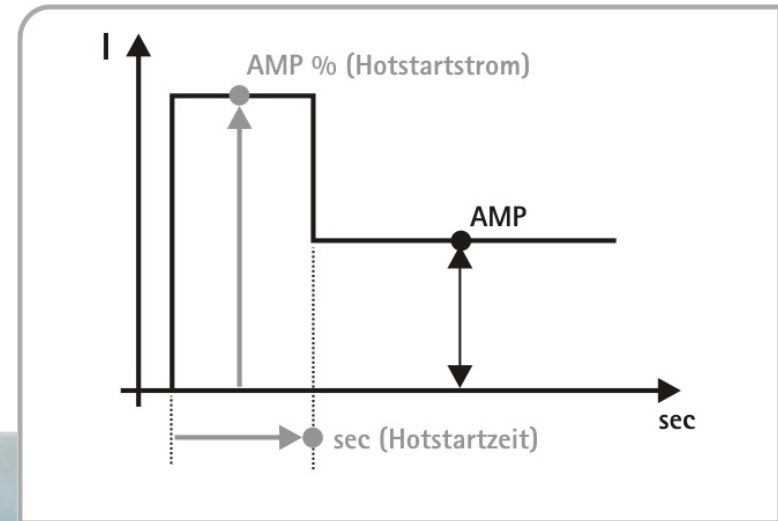
### Simple operation with maximum ease-of-use

- Self-explanatory operating interface with one-dial operation
- Reproducible setting of all welding parameters on the digital display
- Hold function for simple reading and problem-free recording of welding current and voltage after welding
- Standard remote control connection for setting the welding current directly on the workstation



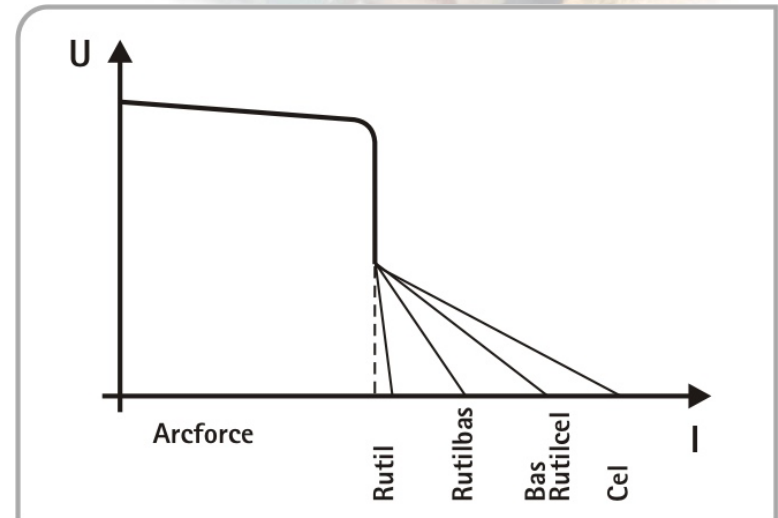
### Reproducible, safe ignition

- Automatic management depending on the electrode being used
- Infinite adjustment of hotstart current and time
- High open circuit voltage



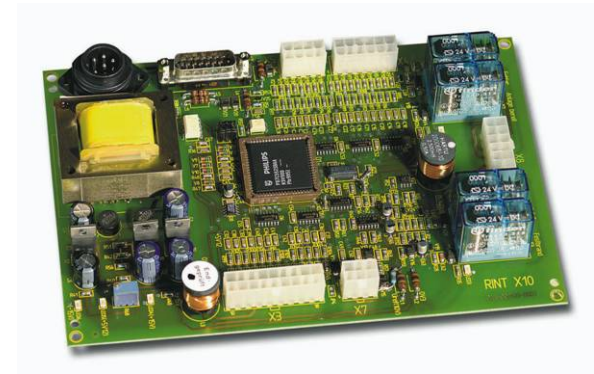
### Exceptional welding properties

- Innovative inverter technology with digital control for a stable arc, easy-to-master weld pool, improved and problem-free welding of critical electrodes, e.g. cellulose and basic electrodes
- Adjustment option of the welding characteristic (arcforcing) to all electrode types for large bandwidth in the area of application
- 100 % vertical-down safety when welding cellulose electrodes in the vertical position, especially also in the lower power range (Pico 230 CEL)



### Safe and reliable to use

- Integrated temperature monitor for protection against overload
- Positioning of the electronics in low-dust areas
- Simple error diagnostics via the display
- Operating controls in protected position
- Robust metal







### Remote control



RTF 1

### Foot-operated remote control, current

- Infinitely adjustable welding current (with foot pedal)



RT 1

### Manual remote control, current

- Infinitely adjustable welding current setting

### MMA electrode holder / TIG welding torch



TIG welding torch, gas-cooled, with rotating gas valve

## Applications

- Repair and production of machines, plant, construction and agricultural machines, rail cars, ships, chemical plants, boilers, closed containers, equipment construction, pipelines, pipe construction, cast components, etc.
- Assembly and construction site usage, outdoor work, offshore

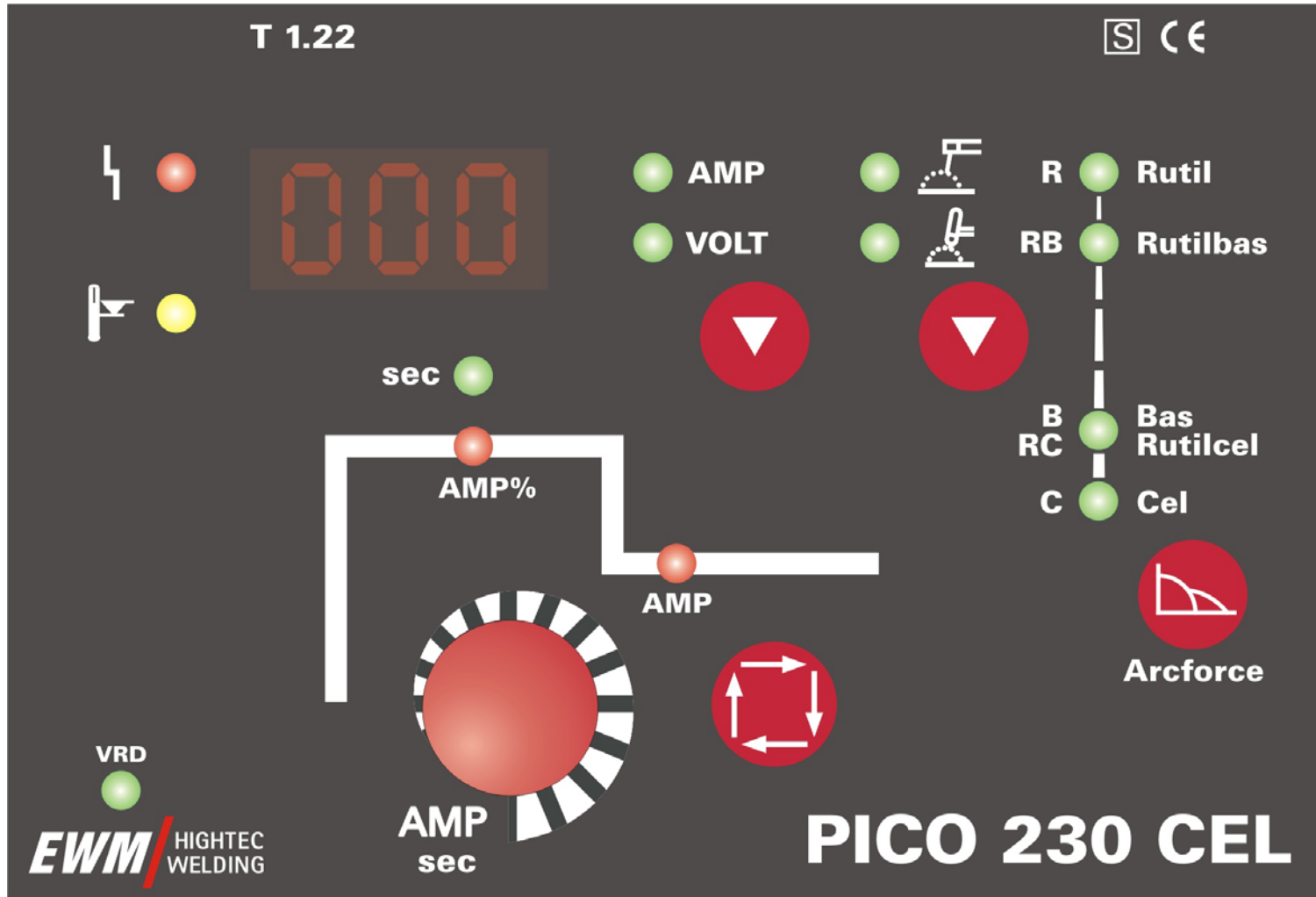
## Materials

### Coated electrodes:

- **PICO 230:**  
Rutile (R), rutile/basic (RB), basic (B), rutile cellulose (RC)
- **PICO 230 CEL:**  
Rutile (R) , rutile/basic (RB), basic (B), rutile cellulose (RC), cellulose (C)
- **Unalloyed, low-alloy and high-alloy steels, Nickel, copper and aluminium alloys**



T1.20



### T 1.22

## SIMPLEST POSSIBLE OPERATION

### Display

**Display, 3-digit**

- Welding current
- Welding voltage
- Welding parameter values

**Fault / message displays (LED)**

**VRD open circuit voltage reduction (optional)**

### Setting

**Selected welding parameters**

### Selection

**Display parameters**

- Welding current
- Welding voltage

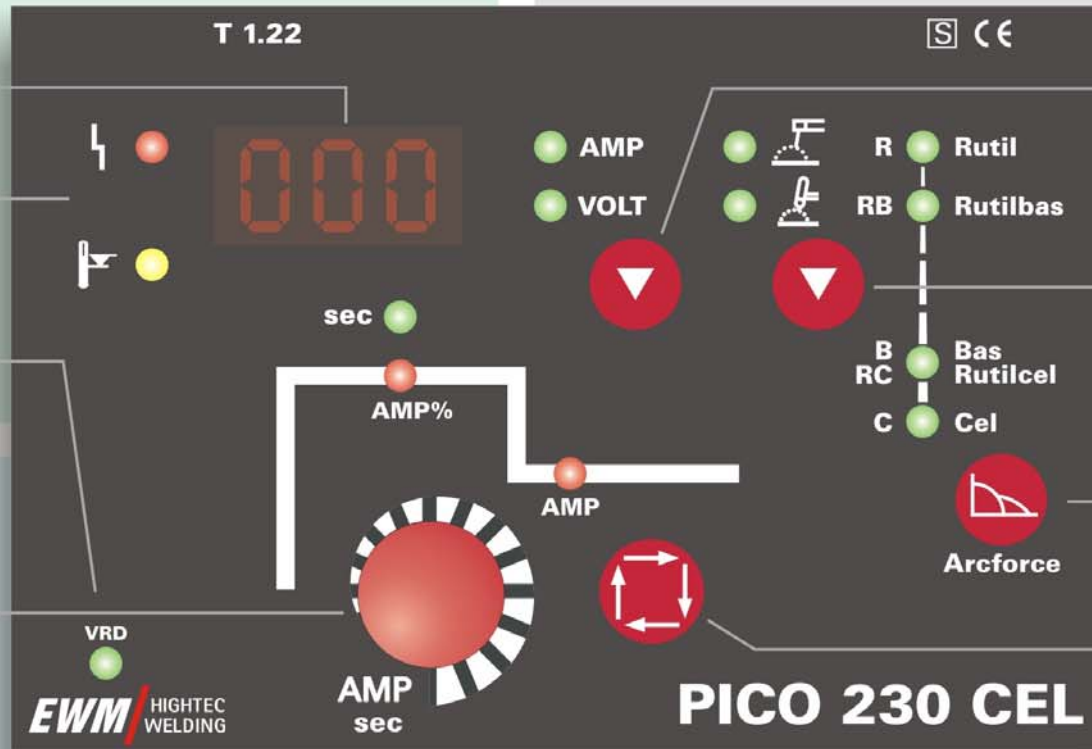
**Welding process**

- MMA
- TIG

**Arcforce depending on electrode type**

- Rutile
- Rutilbas
- Bas/Rutilcel; \*Bas
- Cel; \*Rutilcel

**Welding parameters**



e.g. welding machine controller T 1.22

\* PICO 230

## Function specification

### Buttons

- Electrode type (rutile / basic / cellulose)
- Welding process (MMA / TIG)
- Display parameters (welding current / welding voltage)
- Hotstart and other welding parameters

### Rotary dial

- Main current [AMP]
- Hotstart current and Hotstart time
- Other welding parameters

### Message displays (LED)

- Excess temperature
- Collective interference
- VRD open circuit voltage reduction (optional)

### Display, 3-digit

- Welding current and Welding voltage
- Welding parameter values

### Technical data

Power source	PICO 230		PICO 230 CEL	
	TIG	MMA	TIG	MMA
Welding current setting range	10A - 260A	10A - 230A	10A - 260A	10A - 230A
Welding voltage setting range	10,4V - 20,4V	20,4V - 29,2V	10,4V - 20,4V	20,4V - 29,2V
Duty cycle (dc) at 20° ambient temperature				
50 % dc	260 A	-	260 A	-
55 % dc	-	230 A	-	230 A
60 % dc	240 A	220 A	240 A	220 A
100 % dc	200 A	180 A	200 A	180 A
Duty cycle (dc) at 40° ambient temperature				
40 % dc	260 A	230 A	260 A	230 A
60 % dc	210 A	200 A	210 A	200 A
100 % dc	160 A	150 A	160 A	150 A
Open circuit voltage	20V	99V	20V	99V
Open circuit voltage VRD (optional)	20V	20V	20V	20V
Mains voltage (tolerances)		3 x 400 V (+20 % - -25 %)		3 x 415 V (+15 % - -25 %)
Mains frequency		50/60 Hz		
Mains fuse (safety fuse, slow-blow)		3 x 16A		
Max. connected load		10,1 kVA		
Recommended generator rating		13,7 kVA		
Cos phi / efficiency		0,99 / 88%		
Dimensions L x W x H [mm]		490 x 186 x 350		
Weight approx.		16,5 kg		