

Invertec® V155-S

Processes

Stick, DC TIG

Product Number

K2605-1 120/230V

K2606-1 Ready-Pak® Package

See back for complete specs

Input Power

120/230V/1/50/60

Rated Output

Stick 75A/23.0V/100% Duty Cycle

TIG 105A/14.2V/100% Duty Cycle

Input Current @ Rated Output

24.0A

21.5A

Output Range

5-155 Amps DC

Max OCV: 75V

Weight/Dimensions (H x W x D)

14.7 lbs. (6.7 kg)

11.3 x 6.2 x 15.4 in.

(288 x 158 x 392 mm)

Portable. Professional. Rugged. Affordable.

The Invertec® V155-S offers much more than you would expect from a welder this size. Weighing in at just under 15 lbs. (6.8 kg) the Invertec® V155-S is no lightweight contender. It packs the full punch of a heavyweight professional that you can take to the most demanding job sites. It features 120/230V auto reconnect operation and can operate from a portable generator. It can also plug into a 200 ft. (61 m) 230V extension cord so you can weld just about anywhere.

FEATURES

- ▶ **Two stick modes**, SOFT and CRISP, provide the right arc characteristics for different types of electrodes.
- ▶ **Fan-As-Needed™ (F.A.N.™)** reduces noise and dust inside the machine.
- ▶ **Auto-Adaptive Arc Force** minimizes electrode sticking in the puddle without compromising arc stability or increased spatter.
- ▶ **Automatic Hot Start** boosts the current during starting to make striking an arc easier.
- ▶ **Touch Start TIG® mode** – it's like getting a TIG welder for free!

APPLICATIONS

- ▶ Light Duty Metal Fabrication
- ▶ Maintenance
- ▶ Autobody/Farm



Shown:
K2605-1 Machine only
with Stick Accessories

WHAT'S INCLUDED

K2605-1 Machine Only Includes:

- ▶ Invertec® V155-S
- ▶ Stick electrode holder, cable and Twist Mate™ plug
- ▶ Work cable and clamp with Twist Mate™ plug
- ▶ Fully adjustable shoulder strap
- ▶ 120/230V input cord, 6.6 ft. (2 m) with a 120V 15 Amp plug
- ▶ Extra 120V 20 Amp plug

INPUT



OUTPUT



Two Year Extended
Warranty Available in
the U.S.A. and Canada

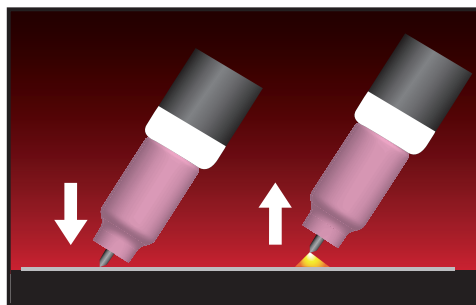




1. Stick/Touch Start TIG® Modes
2. Status Lights
3. Output Control
4. Twist Mate™ Connectors

Touch Start TIG® Mode

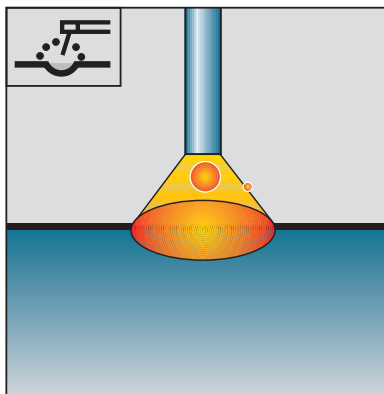
Machine has a low open circuit voltage in TIG mode to reduce tungsten contamination. Simply touch the tungsten to the work piece and lift off. The machine will instantly ramp up the voltage and current to establish the arc without the use of high frequency.



Two Stick Modes

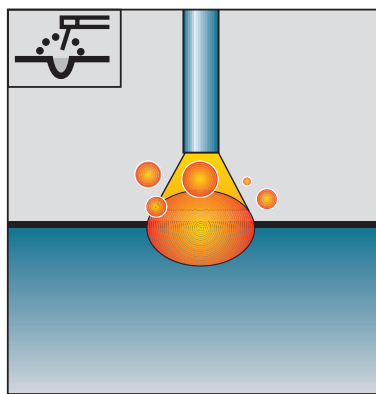
Soft Mode

Provides a lower arc force level to deliver a smooth arc with reduced spatter. It provides a clean flat fillet weld with excellent wetting and bead appearance. For stainless electrodes such as Red Baron® 308L (E308L-16), rutile electrodes such as Fleetweld® 37 (E6013), and low hydrogen electrodes such as Excalibur® 7018 MR.



Crisp Mode

Provides a more dynamic arc characteristic for welding in all positions. For cellulosic electrodes such as Fleetweld® 35 (E6011).



SYSTEM SELECTION

TIG Ready-Pak® Welding Package

Order a TIG Ready-Pak® Package and get a complete welding package.

Each Package Contains:

- Invertec® V155-S
- Stick electrode holder and cable, 10 ft. (3.0 m) with Twist Mate™ plug
- Work clamp and cable, 10 ft. (3.0 m) with Twist Mate™ plug
- Fully adjustable shoulder strap
- 120/230V input cord, 6.6 ft. (2 m) with a 120V 15 Amp plug
- Extra 120V 20 Amp plug
- Gas Regulator
- PTA-17V TIG torch with Ultra-Flex™ cable and Twist Mate™ adapter
- PTA-17 TIG accessory kit (KP508)
- Easy-Store/Easy-Carry Suitcase

Order:

K2606-1 Invertec® V155-S TIG Ready-Pak® Package

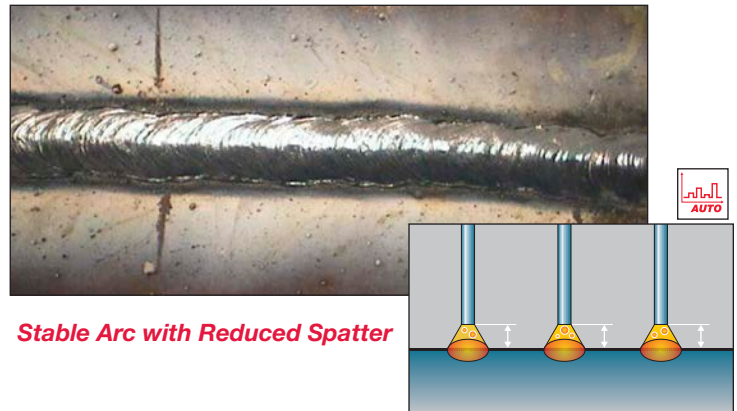


Shown:
K2606-1 Ready-Pak® Package

A CLOSER LOOK

Invertec® V155-S — Auto Adaptive Arc Force™

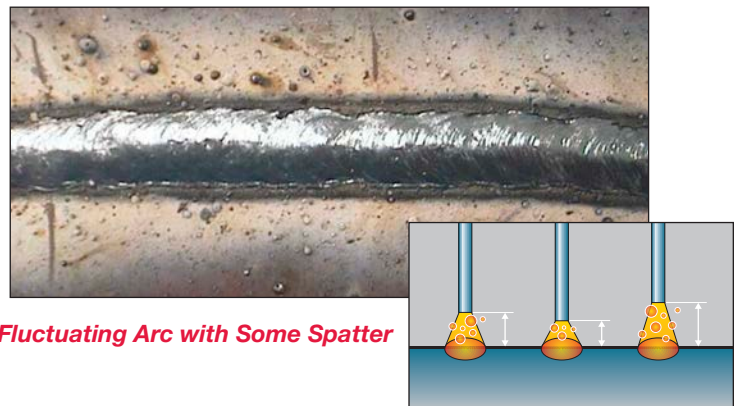
Auto Adaptive Arc Force™ continuously measures the arc voltage to adapt the optimum value of Arc Force. This optimizes the arc stability without the risk of electrode sticking and minimizes spatter.



Stable Arc with Reduced Spatter

Competition — Standard Arc Force

With Standard Arc Force, the peak welding current that prevents the electrode from sticking in the weld pool is pre-set. The fixed peak may react aggressively, causing spatter and an unstable arc.



Fluctuating Arc with Some Spatter

RECOMMENDED ACCESSORIES

GENERAL OPTIONS



Welding Cart

Full-featured cart is designed to store and transport a welder, 80 cubic foot gas cylinder, welding cables and accessories. Includes an angled top shelf for easy access to welder controls, a lower tray for added storage space, a sturdy handle also used as a convenient cable wrap hanger. **Order K2275-1**

Twist Mate™ Cable Plug Kit

Twist Mate™ plug for connecting welding cable to output terminal. Contains one plug. **Order K852-25**



TIG OPTIONS

PTA-17FV Flex Head Gas Valve TIG Torch with Ultra-Flex™ Cable (12.5 ft., 1 pc.)

150 amp air-cooled compact and durable flexible head TIG torch with integral gas valve for gas control at the torch. Gas nozzle not included.

Order K1782-13
(requires K960-2 Twist Mate™ Adapter)



1-Piece TIG Torch Adapter

For connection of PTA-9V or PTA-17V torches (1-piece cable) to power sources without gas passing through the Twist Mate™ connection.

Order K960-2



Cut Length Consumables

TIG welding filler metals are available for welding stainless steel, mild steel, and copper alloys.

Request Lincoln Publication C1.10 for more information.



TIG Torch Parts Kits

Parts kits are available for the PTA-9FV and PTA-17FV TIG torch. These kits include back cap, collets, collet bodies, nozzles and tungstens.

Order KP508 for PTA-17 torches (See publication E12.150 for parts kits breakdown)
(A full line of TIG torches and parts kits in various lengths and types are available. Request Lincoln Publication E12.150 for more information.)

Deluxe Adjustable Gas Regulator & Hose Kit

Accommodates CO₂, argon, or argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3 m) gas hose.

Order K586-1



PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽¹⁾	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Invertec® V155-S	K2605-1 (Machine Only) and K2606-1 (Ready-Pak® Pkg.)	120V/1/50/60	75A/23.0V/100% Stick 100A/24.0V/30% Stick 105A/14.2V/100% TIG 130A/15.2V/30% TIG	24.0A 33.8A 21.5A 28.8A	5-155 Amps DC Max OCV: 75V	11.3 x 6.2 x 15.4 (288 x 158 x 392)	14.7 (6.7)
		230V/1/50/60	100A/24.0V/100% Stick 145A/25.8V/30% Stick 100A/14.0V/100% TIG 155A/16.2V/30% TIG	21.0A 31.0A 14.1A 22.8A			

⁽¹⁾ Input amps on 60 Hz input.

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details

CUSTOMER ASSISTANCE POLICY

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