

# Caddy™ Tig 1500i/2200i, TA 33/34

## 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 and aluminium 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

The Caddy™ Tig machines are equipped with a PFC circuit making it possible to use the full range of the machines on a 16 A fuse. The PFC also protects the machine against fluctuating mains voltage and makes them safer to use with a generator. Caddy™ Tig 1500i/2200i can operate with extra long mains cables, over 100 m, giving you a very larger working radius.



Control panels

The Caddy™ Tig machines are available with two different control panels. Both have all the necessary functions to weld TIG (DC), with HF-start or LiftArc™, and MMA.

Control panel Caddy™ TA33 is the easy way to weld TIG. You only need to set the plate thickness, and the machine will control the rest, allowing you to produce a high quality TIG weld. You can also control the welding current, slope down and post-gas manually.

The more advanced control panel Caddy™ TA34 allows you to weld Pulsed TIG giving you better control of the heat input. It also has Micro Pulse which allows you to set pulse times down to 0,001 s. Caddy™ TA34 has two memories where you can store all your settings and you can switch between the memories from the panel or from the torch trigger, even when welding. You can also set slope up/down, post-gas and connect a remote control.

Both panels are easy to understand and set, even when wearing welding gloves.

### Applications

- Professional welding tool
- In and outdoor installation, repair and maintenance on site
- In and outdoor production, fabrication and civil construction
- Process industry

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Voltage Reduction Device - VRD

In some areas a voltage reduction device, or VRD, is required. VRD is a safety function for MMA that limits the open circuit voltage from the machine to 24 V. Both control panels are prepared for VRD and the function can easily be activated inside the power source.

MMA with ArcPlus™ II

Caddy™ Tig supplies direct current and you can weld most metals including alloyed and non alloyed steel, stainless steel and cast iron. With Caddy™ Tig 1500i you can weld most electrodes from Ø1.6 -3.2 mm and some 4 mm electrodes. Caddy™ Tig 2200i welds most electrodes up to Ø 4 mm. Both control panels have the latest regulator, ArcPlus™ II, that 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.

- **Designed for quality TIG-welding in alloyed, non-alloyed and stainless steel.**
- **Easy to use** - all welding parameters presented in clear layout.
- **ESAB 2-program function** – the ability to pre-program and change program during welding.
- **Pulsed TIG welding** - increased control of heat input and the weld pool.
- **Micro Pulse** – minimise heat affected zone especially on thin material
- **ArcPlus™ II** - better welding characteristics, simplifies your work and gives you better weld quality with less after treatment.
- **True MMA welding characteristics** - Hot start and Arc force setting
- **VRD** – Voltage Reduction Device – a safety function when welding in MMA mode
- **Extra long mains cable capability** – gives extra large working radius

## Technical data

	Caddy™ Tig 1500i	Caddy™ Tig 2200i
Mains voltage V/ph Hz	230/1 50/60	230/1 50/60
Fuse (slow), A	16	16
Recommended generator size, kVA	10	12
Permitted load at 40°C, TIG		
25% duty cycle, A/V	150/16	220/18.8
60% duty cycle, A/V	120/14.8	150/16.0
100% duty cycle, A/V	110/14.4	110/14.4
Permitted load at 40°C, MMA		
25% duty cycle, A/V	150/26	170/26.8
60% duty cycle, A/V	100/24	130/25.2
100% duty cycle, A/V	90/23,6	110/24.4
Setting range TIG (DC), A	3 - 150	3 - 220
Setting range MMA (DC), A	4 - 150	4 - 170
Open circuit voltage, V	72	72
Power factor at max. current (MMA)	0.99	0.99
Power factor at max. current (TIG)	0.98	0.99
Efficiency at max. current (MMA), %	80	81
Efficiency at max. current (TIG), %	77	75
Open circuit voltage limit (VRD active), V	35	35
Dimensions l x w x h, mm	418 x 188 x 208	418 x 188 x 208
Weight, kg	9.2	9.4
Enclosure class	IP 23	IP 23
Application classification	S	S
Standards	IEC/EN 60974-1, IEC/EN 60974-3, IEC/EN 60974-10	



### Water cooling unit CoolMini :

Coolant volume, l	2.2
Max flow, l/min	2
Max pressure, 50/60 Hz bar	2.3 bar
Weight, kg	4.5/6,7
External dimension, mm l x w x h	418 x 188 x 137

### Control panels :

	Caddy™ TA34	Caddy™ TA33
Slope up, sec	0-10	0-9.9 *
Slope down, sec	0-10	0-10
Gas pre-flow *, sec	0-5	0-5
Gas post-flow, sec	0-25	0-25
Pulse-/background time, sec	0.01-2.5	-
Micro pulse* time, sec	0.001-0.250	-
Plate thickness setting, mm	-	0.1-7.3

\* Hidden function

## Ordering information

Caddy™ Tig 1500i, TA33 package incl. 3 m MMA cable kit compl. and Tig torch TXH 150, 4m

0460 450 880

Caddy™ Tig 2200i, TA33 package incl. 3 m MMA cable kit compl. and Tig torch TXH 200, 4m

0460 450 881

Caddy™ Tig 2200i, TA34 package incl. 3 m MMA cable kit compl. and Tig torch TXH 200, 4m

0460 450 883

Caddy™ Tig 2200iw, TA33 package incl. water cooler, 3 m MMA cable kit compl. and Tig torch TXH 250w, 4m

0460 450 884

Caddy™ Tig 2200iw, TA34 package incl. water cooler, 3 m MMA cable kit compl. and Tig torch TXH 250w, 4m

0460 450 885

**Delivery content:** 3 m mains cable with plug, 2 m gas hose and 2 hose clamps

### ACCESSORIES

Shoulder strap	0460 265 003
Trolley (for 20 to 50 l gas cylinder)	0459 366 886
Trolley (for 20 to 50 l gas cylinder)	0460 330 880
Remote control AT1 CoarseFine CAN	0459 491 884
Connection cables for remote controls:	
5 m cable CAN	0459 554 880
10 m cable CAN	0459 554 881
15 m cable CAN	0459 554 882
25 m cable CAN	0459 554 883
TIG torch TXH™ 150 OKC50, 4m	0460 011 842
TIG torch TXH™ 150 OKC50, 8m	0460 011 882
TIG torch TXH™ 200 OKC50, 4m	0460 012 840
TIG torch TXH™ 200 OKC50, 8m	0460 012 880
TIG torch TXH™ 250w OKC50, 4m	0460 013 840
TIG torch TXH™ 250w OKC50, 8m	0460 013 880
New-Tech™ 9-13 ADC auto-darkening helmet	0700 000 281
Chipping hammer SH2	0000 663 000
Welding gloves TIG Supersoft	0700 005 006