

Caddy™ Tig 1500i / 2200i DC



- Designed for high quality DC TIG & Stick welding in alloyed, non-alloyed and stainless steel
- Easy to use - all welding parameters presented in clear layout. Large digital meter with preset and display-and-hold
- ESAB 2-program function (Caddy™ Tig 2200i) – the ability to pre-program and change program during welding
- Pulsed TIG welding (Caddy™ Tig 2200i) - increased control of heat input and the weld pool
- Micro Pulse (Caddy™ Tig 2200i)– minimize heat affected zone especially on thin material
- ArcPlus™ II - better Stick welding characteristics, simplifies your work and gives you better weld quality with less post-weld cleanup
- Flexible – Choose between LiftArc™ or high-frequency start for TIG
- Professional Welding Applications – indoor and outdoor repair, maintenance, fabrication, and construction



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 aluminum casing is light and easy to carry. 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 internal parts clean and dust free. Caddy™ Tig is built in accordance with IP23, which means it can be used outdoors – even in the rain. The durable design and the superior welding performance give you a machine that you can rely on day after day.

Control Panels

The Caddy™ Tig machines are available with two different control panels. Both have all the necessary functions to weld DC Stick and DC TIG, with HF-start or LiftArc™ start. The panels are easy to understand and set, even when wearing welding gloves.

The Caddy™ Tig 1500i includes the TA33 panel for easy TIG welding - set the plate thickness, and the machine will control the rest. You can also control the welding current, slope down and post-gas manually.

The Caddy™ Tig 2200i includes the more advanced TA34 panel which 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. The TA34 panel has two memory settings. 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.

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 Amp fuse. The PFC also protects the machine against fluctuating input voltage and makes them safer to use with a generator. Caddy™ Tig 1500i/2200i can operate with extra long input power cables over 100 m (325 ft.), providing a very large working radius.

Voltage Reduction Device - VRD

In some areas a voltage reduction device, or VRD, is required. VRD is a safety function for Stick welding 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.

DC Stick Welding

Caddy™ Tig 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 1/16" (1.6 mm) to 1/8" (3.2 mm). Caddy™ Tig 2200i can weld with electrodes up to 5/32" (4 mm). Both control panels have ESAB's most advanced arc control electronics, 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 cleanup.

Ordering Information

Caddy™ Tig DC Packages

Each package includes Caddy™ Tig power source, THX 150 or TXH 200 TIG torch 4m (13 ft.), Heliarc accessory kit, stick electrode holder with 3 m (10 ft.) cable, R-33 flowmeter/regulator, 2m (7 ft.) gas hose, 4.5m (15 ft.) work cable and ground clamp, 3m (10 ft.) input power cable and plug.

Caddy™ Tig 1500i, TA33, TXH 150 TIG/Stick Pkg..... 460450880
 Caddy™ Tig 2200i, TA34, TXH 200 TIG/Stick Pkg 460450883

Options & Accessories

Shoulder Strap, padded..... 460265003
 Trolley (for small gas cylinder)..... 459366885
 Trolley (for large gas cylinder)..... 459366886
 R-33-FM-580 Flowmeter/Regulator..... 21557
 TIG Accessory Kit (HW-17/18/26, TXH-150/200)..... 999126
 Electrode holder, 150A, 3m (10 ft.) cable/ OKC 50 700006898
 Electrode holder, 200A, 3m (10 ft.) cable/ OKC 50 700006900

Remote Controls:

Foot Control T1 CAN, 5 m (16.4 ft.) cable 460315880
 Hand Control AT1 CAN** 459491883
 Hand Control AT1 CoarseFine CAN** 459491884

Interconnection cables for AT1 Remote Hand Controls:

Connection Cable CAN, 5 m (16.4 ft.)..... 459554880
 Connection Cable CAN, 10 m (33 ft.) 459554881
 Connection Cable CAN, 15 m (50 ft.) 459554882
 Connection Cable CAN, 25 m (82 ft.)..... 459554883

TIG Torches, Air-cooled with on/off contactor:

TXHT™ 150, 4 m (13 ft.) 460011842
 TXHT™ 150F Flex-head, 4 m (13 ft.) 460011845
 TXHT™ 200, 4 m (13 ft.) 460012840
 TXHT™ 200F Flex-head, 4 m (13 ft.) 460012842

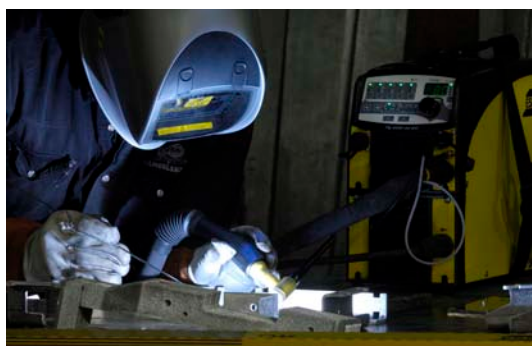
** Remote hand controls do not include connection cable. Must order separately.

Control Panels:	TA34 (1500i)	TA33 (2200i)
HF / LiftArc™ Start	•	•
2/ 4 stroke trigger selector	•	•
Panel / Remote Selector	•	•
2-Program memory	•	-
Arc Force	•	-
Hot Start	•	-
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 - 0.25	-
Plate thickness setting, mm (in.)	-	0.1 – 7.3 (.004 – 0.29)

* Hidden Function

Specifications

	Caddy™ Tig 1500i	Caddy™ Tig 2200i
Input voltage V/ph Hz	230/1 50/60	230/1 50/60
Fuse (slow), A	16	16
Permitted load at 40°C, TIG		
25% duty cycle, A/V	150/16	220/18.8
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	4 - 150	4 - 220
Setting range STICK (DC), A	4 - 150	4 - 170
Open circuit voltage, V	72	72
Open circuit voltage limit (VRD active), V	35	35
Dimensions LXWXH, mm (in.)	418 x 188 x 208 (16.5 x 7.4 x 8.2)	418 x 188 x 208 (16.5 x 7.4 x 8.2)
Weight, Kg (lbs.)	9.2 (20.3)	9.4 (20.7)
Enclosure class	IP 23	IP 23



TA33 Control Panel (Caddy™ Tig 1500i)



TA34 Control Panel (Caddy™ Tig 2200i)



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