

NEW!

Invertec® V155-S

STICK WELDERS

Portable. Professional. Rugged. Affordable.

The NEW 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. With 120/230V auto reconnect operation, the Invertec® V155-S can operate from a portable generator. It can also plug into a 200 foot (61 m) 230V extension cord so you can weld just about anywhere. The tough dent resistant case is IP23 rated for outdoor use.

Backed by a 3-Year Lincoln warranty, this tough reliable welder is packed with innovative unique features like built-in Hot-Start™, Auto Adaptive Arc Force™, stick soft, stick crisp and Touch Start TIG™ DC modes. The Invertec® V155-S is available in two models: a base unit with stick accessories or a complete Stick/TIG ready to weld package in an Easy-Store/Easy-Carry Suitcase.

Processes
Stick, DC TIG



Shown:
K2606-1 Ready-Pak® Pkg.

Output



Input



Advantage Lincoln

• Portable

- 120/230V auto reconnect input power.
- Long 230V extension cord usage - up to 200 ft. (61 m).
- Engine driven power generator capability.
- Weighs less than 15 lbs. (6.8 kg).

• Professional Performance

- Touch Start TIG™ DC operation allows you to strike the arc easily without high frequency or tungsten contamination.
- 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.
- Two stick modes, SOFT and CRISP, provide the right arc characteristics for different types of electrodes.
- Ideal for stick welding with popular Lincoln® electrodes, including Fleetweld® 35, Fleetweld® 37, Fleetweld® 180 and Excalibur® 7018 MR.

• Tough & Rugged

- Dent resistant case is IP23 rated for outdoor use.
- Auto Restore Fuse protects the machine from input over-current and self resets without any difficult fuse changes.
- Fan-As-Needed™ (F.A.N.™) to reduce noise and dust inside the machine.
- 3-year Lincoln® Warranty.

• Base Unit (K2605-1) 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.

TECHNICAL SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle (104°F, 40°C)	Input Current @ Rated Output ⁽¹⁾	Output Range	Dimensions H x W x D inches (mm)	Net Weight lbs.(kg)
Invertec® V155-S	K2605-1 and K2606-1	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 60Hz input.



SYSTEM SELECTION

TIG Ready-Pak® Welding Package

Order a Lincoln 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 Ultraflex™ 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® Pkg.

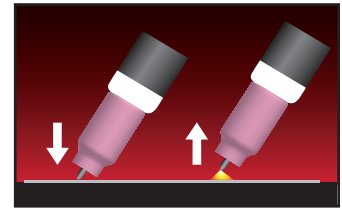
Key Controls

- 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.

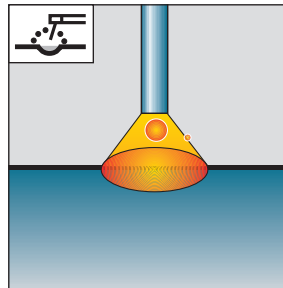


Two Stick Modes

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.

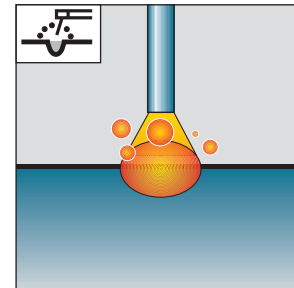
For stainless electrodes such as Red Baron® 308L (E308L-16), rutile electrodes such as Fleetweld® 37 (E6013), and low hydrogen electrodes such as Excalibur® 7018 MR.



Crisp Mode

Provides a more dynamic arc characteristic for welding in all positions.

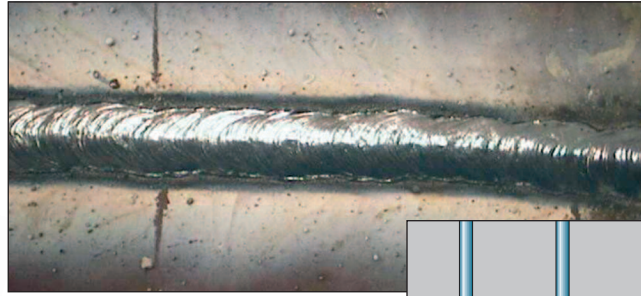
For cellulosic electrodes such as Fleetweld® 35 (E6011).



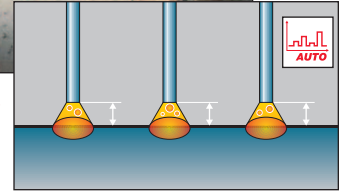
A CLOSER LOOK

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.

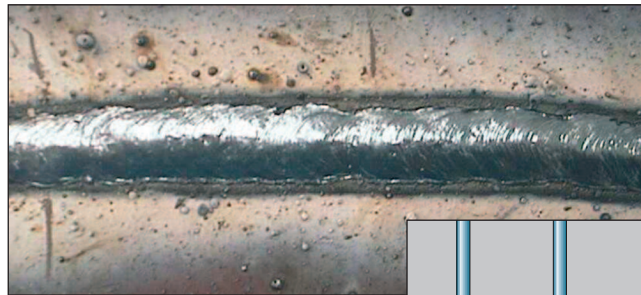


Stable Arc with Reduced Spatter

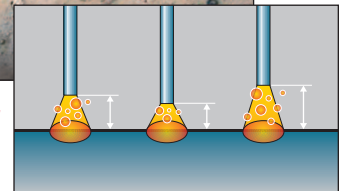


Competition — Standard Arc Force

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 OPTIONS

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 and 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)



PTA-9FV Flex Head Gas Valve TIG Torch (25 ft., 1 pc.)

125 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 K1781-7 (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

RECOMMENDED OPTIONS

TIG OPTIONS (CON'T.)



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

Request Lincoln Publication C9.10 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 KP507 for PTA-9 torches
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.)

TIG OPTIONS (CON'T.)



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



INVERTEC® V155-S ORDER FORM

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
Invertec® V155-S Base Unit with Stick Accessories	K2605-1		
Invertec® V155-S TIG Ready-Pak® Welding Package	K2606-1		
Recommended General Options			
Welding Cart	K2275-1		
Twist-Mate™ Cable Plug Kit	K852-25		
Recommended TIG Options			
PTA-17FV Flex Head Gas Valve Torch	K1782-13		
PTA-9FV Flex Head Gas Valve Torch	K1781-7		
1-Piece TIG Torch Adapter	K960-2		
Cut Length Consumables	See Publication C9.10		
TIG Torch Parts Kit:			
- PTA-9FV	KP507		
- PTA-17FV torch	KP508		
Deluxe Adjustable Gas Regulator & Hose Kit	K586-1		
TOTAL:			

CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company® is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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