

ET 186i AC/DC

Portable AC/DC HF TIG/Stick Welding System



The ET 186i AC/DC is a complete, multi-process TIG and Stick welding system. Lightweight and reduced in size for versatility and portability. Fully featured professional performance capability with variable controls for ease of use in a variety applications. HF Arc Start provides non-contact arc starting that eliminates tungsten or material contamination.

- AC and DC output for aluminum and non-ferrous alloys, stainless, mild steel and chrome molys
- AC Frequency: adjustable frequency of the AC square wave when welding on aluminum for optimized set up (15 Hz - 150 Hz)
- Wave Balance: adjustable for optimized penetration or cleaning action when welding on aluminum
- HF Arc Start: provides non-contact arc starting that eliminates tungsten or material contamination
- Pulse: changes the weld current from high to low at a specified frequency, reduces heat input on thin material (0.5 Hz - 200 Hz)

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Industry

- Automotive
- Transportation
- Light Fabrication
- Repair and Maintenance



ET 186i AC/DC system complete package with foot control and basic utility cart (W1006304).

ET 186i AC/DC

Specifications	
Primary voltage	208/230 VAC
Supply voltage	187 - 253 VAC
Supply frequency	50/60 Hz
Number of phases	1 ph
Supply plug	NEMA 6-50P
Rated kVA @ 200 Amp	9.5 kVA
Lead cord length	3 m (10 ft.)
Maximum input current	35.6 A
Maximum output	200 A
TIG (GTAW) welding output 40°C (104°F)	200 A/18 V @ 20% duty cycle 116 A/14.6 V @ 60% duty cycle 90 A/13.6 V @ 100% duty cycle
Stick (SMAW) welding output 40°C (104°F)	170 A/26.8 V @ 15% duty cycle 100 A/24 V @ 60% duty cycle 80 A/23.2 V @ 100% duty cycle
Current range	TIG: 10 - 200 A Stick: 10 - 170 A
Nominal open circuit voltage	70.3 VDC/50 VAC
Approvals	IEC 60974-1, CSA E60974-1, UL 60974-1
Protection class	IP23S
Warranty period	3 years*
Dimensions, L x W x H	475 x 240 x 400 mm (18.7 x 9.5 x 15.8 in.)
Weight	22 kg (48.4 lbs.)

Ordering Information	
Description	Part Number
ET 186i AC/DC TIG/Stick System <i>Includes: ET 186i AC/DC inverter power supply, electrode holder with 4 m (13 ft.) lead, work clamp with 3 m (10 ft.) lead, 26 TIG torch 3.8 m (12.5 ft.) lead with integrated controls and accessories, input power cable/plug 2.75 m (9 ft.), Victor argon flowgauge regulator, 3.8 m (12.5 ft.) hose, electrode bonus, shoulder strap and operating manual/CD.</i>	W1006301
ET 186i AC/DC TIG/Stick System with Foot Control <i>Includes: all components from W1006301 plus foot control with 4.6 m (15 ft.) cable.</i>	W1006303
ET 186i AC/DC TIG/Stick System with Foot Control & Basic Utility Cart <i>Includes: all components from W1006301 plus foot control with 4.6 m (15 ft.) cable and basic utility cart.</i>	W1006304

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Options & Accessories	
Description	Part Number
TIG Torch and Accessories (required for TIG welding)	W4013600
Electrode Holder 200A and Lead Assembly, 4 m (13 ft.), 25 mm	9110-1177
Ground Clamp 200 A and Lead Assembly, 3 m (10 ft.), 25 mm	9255-1140
Victor Argon Flow Gauge Regulator GF-250-50-580	0781-9411
Gas Hose, 3.8 m (12.5 ft.), Male 5/8-18UNF	W4013900
Foot Control, 4.6 m (15 ft.) cable and 8-pin Male Plug	W4013200
Basic Utility Cart, max 177.8 mm (7 in.) diameter cylinder	W4014700





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COMPANY WITH
MANAGEMENT SYSTEM
CERTIFIED BY DNV
= ISO 9001 =
= ISO 14001 =
= OHSAS 18001 =