

**EASY  
400  
PLUS**

EN



INNOVATION FOR WELDERS

## **EASY 400 PLUS TIG COLD WIRE SYSTEM**

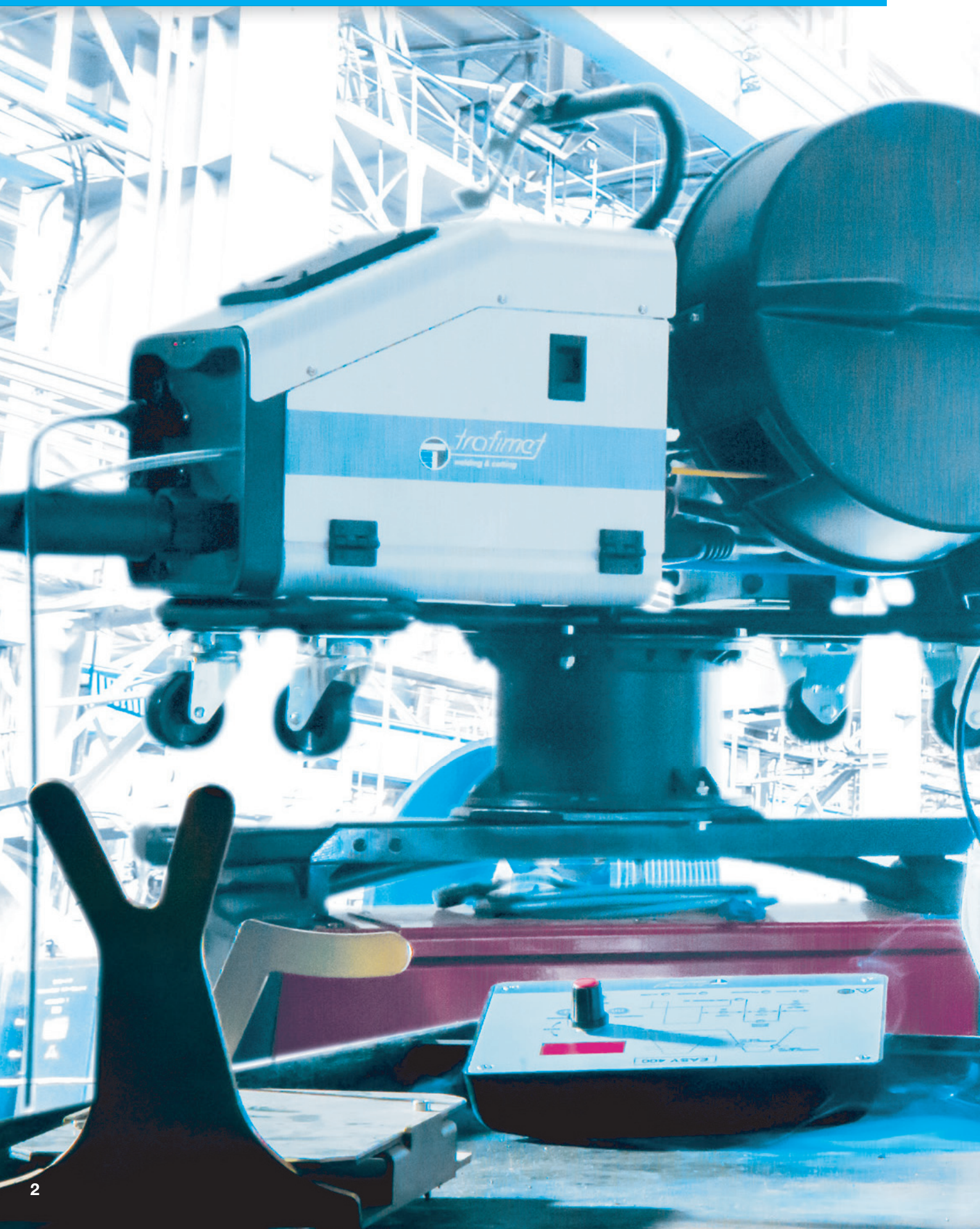
EASY 400 PLUS System is the latest and most innovative technology for TIG Cold wire feeders.





## EASY 400 PLUS

New technology TIG Cold wire feeder







**EASY 400 PLUS is the most innovative Tig cold wire feeder, developed and produced by Trafimet Group, in order to be combined with all the TIG generators and to be used both for manual welding and integrated with automation systems.**

The characteristic features of the EASY 400 PLUS make it ideal for applications in the most advanced sectors of industry, where quality in TIG welding and speed of performance are essential requirements.

Some sectors where EASY 400 PLUS expresses its full potential;

- Aerospace industry,
- Construction of chemical plants,
- Automation welding plants,
- Industrial plants & pipe lines,
- Automotive industry.





# EASY 400 PLUS

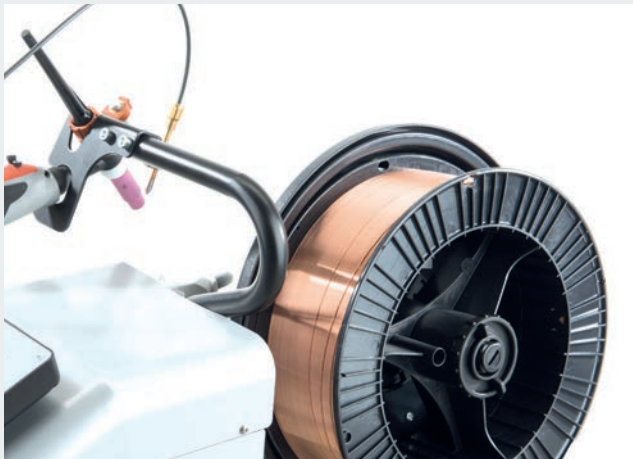
Easy, fast, reliable

## INNOVATIVE SYSTEM

Innovations of EASY 400 PLUS allow quality TIG welding, always easier and faster. The electronic control of the wire feed speed increases the deposit percentage and the welding speed, without wasting filler material.

The possibility of being able to carry out all the wire feed speed controls, directly from the torch and with one hand, reduces working times.

EASY 400 PLUS also offers the possibility of saving all the parameters set, so that they can be recalled for future applications, speeding up production changes and ensuring the repeatability of the processes.



## ECONOMICAL SAVING

Reduction of the overall welding costs; the filler material on spool is cheaper than the standard TIG rods. And the time loss of rod replacements are canceled.

## HEALTH FIRST OF ALL

EASY 400 PLUS allows an extreme reduction of fatigue for the welder, who uses and manages operations with only one hand.





## EASY 400 PLUS

The smart wire feeder makes the difference

### QUALITY WORK

The design of the EASY 400 PLUS has been studied in detail to allow the operator the best comfort.

The wire feeder is equipped with two practical housings, where you can wind the cable of the control panel and store the torch.

We are aware that carrying out the profession in an orderly manner is an important component of the quality of work.

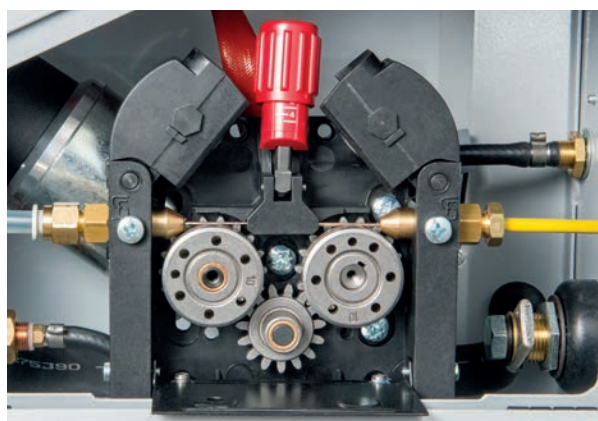




### SMALL AND VERSATILE

Extremely reduced size and weight make EASY 400 PLUS the ideal solution to follow the operator in any work environment

Wire feeder dimensions : 350x250x300 mm  
Wire feeder weight : 7,5 kgs



### EXTREME PRECISION AND REPRODUCIBILITY OF WELDING

Maximum precision of the wire output speed thanks to the 4 roller group and the wire feeding motor management with encoder.

The digital control of the wire output speed guarantees maximum precision and the exact reproducibility of the welding process.

### SINERGIC OR INDEPENDENT WIRE PULSATION

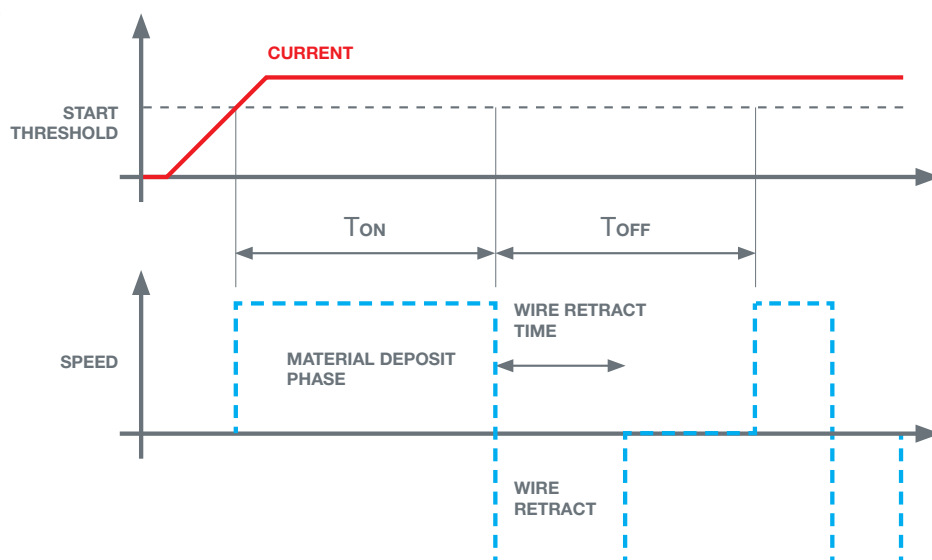
The wire pulsation can be synergic or independent.

#### SYNERGIC PULSE

Using the machine in pulsed arc, the wire will automatically stop and restart synergically with the welding current.

#### INDEPENDENT PULSE

Activating the pulsation using the machine with in continuous current, the wire will be intermittently fed, with the possibility to set the Time ON and Time OFF from 0,3 to 25 seconds.



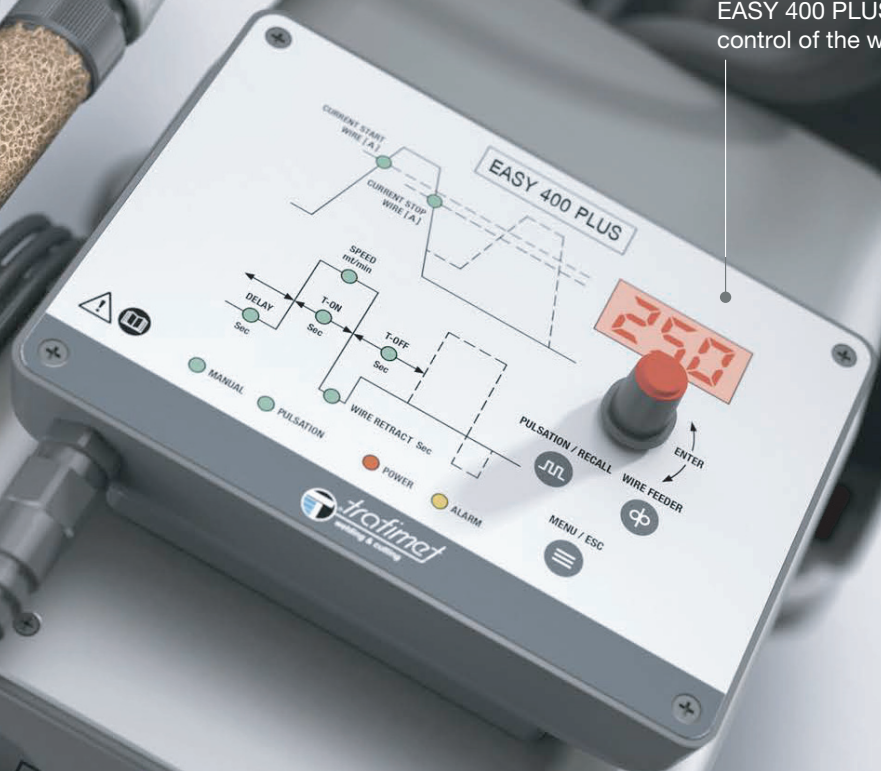


## EASY 400 PLUS

Total control of the welding process

### ALWAYS BY YOUR SIDE

The EASY 400 PLUS control panel is removable. This allows on the manual welding the operator to move the panel next to the welding area for a faster set-up of the parameters. For the welding automations, remote control panel is suitable to set the parameters far from the peripherals. EASY 400 PLUS gives a total control of the welding process.



### AUXILIARY CONTROL CONNECTOR

A connector is available on the front panel of EASY 400 PLUS for interfacing with the automation plants, through the possibility to manage the torch signals; START/STOP welding arc, FORWARD/BACKWARD, Wire speed UP/DOWN.

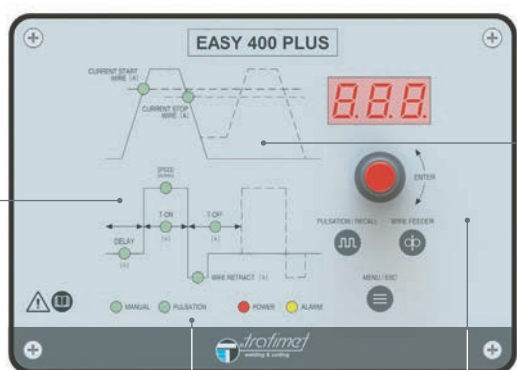
It is possible to use the same input to connect an auxiliary START/STOP WIRE command, released from the current thresholds; this allows you to control the wire output independently, for example by connecting to a control desk.





## USER FRIENDLY

With EASY 400 PLUS, the operator can save up to 16 welding jobs, to easily recall the previously used welding programs. The setting of the parameters is simple, fast and intuitive, thanks to the new digital graphic panel.



### CURRENT START WIRE

#### Wire start threshold from 15 to 460A.

The wire comes out only when the set START current threshold is exceeded (or via the auxiliary command). The wire starts to be fed with a soft start speed and with an acceleration ramp it gradually moves to the set nominal speed.

### CURRENT STOP WIRE

#### Wire stop threshold from 15 to 460A.

Under the STOP threshold the wire will stop and go into the wire retract phase.

### SPEED

Wire speed from 0 to 8 m/min.

### T-ON

Pulsation ON time, from 0,3 to 25 sec is the wire feeding time.

### T-OFF

Pulsation OFF time, from 0,3 to 25 sec is the time while the wire does not advance.

### DELAY

Wire output delay time from 0 to 25 sec. The wire will start feeding after this time. The time is counted from the moment the current has surpassed the START threshold.

### WIRE RETRACT

Wire retract time from 0 to 2,5 sec. After the current goes under the current STOP threshold the wire will retract for the set time at the maximum speed (8 m/sec) and then stop.

### MANUAL

OFF = automatic wire feeding.  
ON = manual wire feeding.

### PULSATION

ON = independent pulsation activated.

### POWER

ON = power presence.

### ALARM

ON = alarms presence.

### PULSATION / RECALL

**Pulsation activation:** activation of the asynchronous (independent) pulsations of the wire.

### WIRE FEEDER

**Wire loading/feeding** if pressed continuously.  
**Wire retraction** if pressed intermittently.

### MENU / ESC

**Access to user menu** where you can save/load the welding programs and set parameters.

### ENTER

#### Knob selector and data confirm.

Special settings:

- soft start speed, from 10% to 100% of the nominal speed,
- acceleration ramp, from OFF to 2 seconds.
- manual wire exit command,
- password setting,
- special settings for automation systems.



DISPLAY



## EASY 400 PLUS

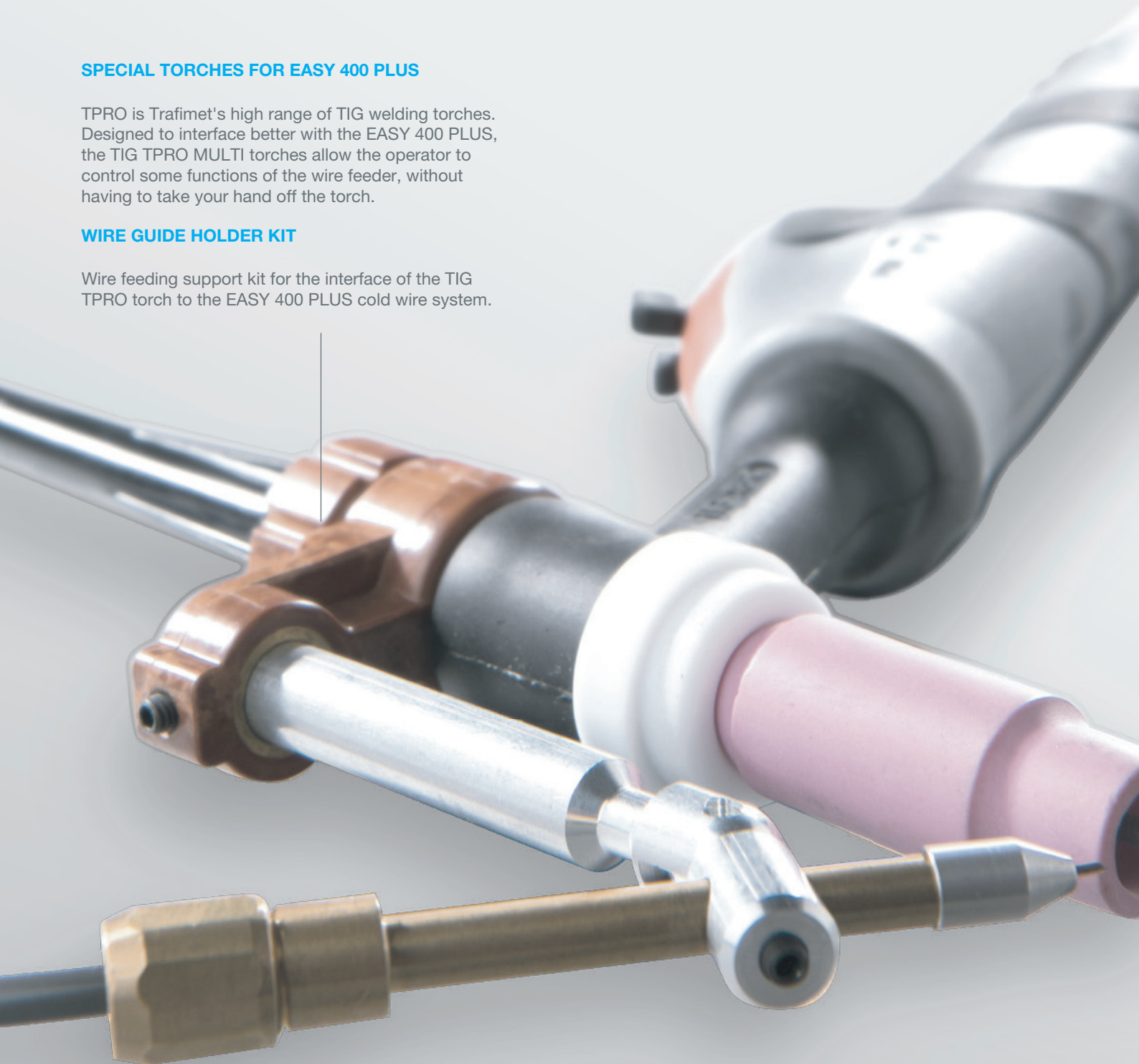
### Special multifunctional TIG torches

#### SPECIAL TORCHES FOR EASY 400 PLUS

TPRO is Trafimet's high range of TIG welding torches. Designed to interface better with the EASY 400 PLUS, the TIG TPRO MULTI torches allow the operator to control some functions of the wire feeder, without having to take your hand off the torch.

#### WIRE GUIDE HOLDER KIT

Wire feeding support kit for the interface of the TIG TPRO torch to the EASY 400 PLUS cold wire system.







### TORCH REMOTE CONTROL

The TPRO Multi torches allow the operator to adjust all the parameters, without interrupting the welding jobs.

**Lever 1 up**  
START/STOP welding arc.

**Lever 1 down**  
Wire stop/restart during welding.  
Wire feed loading/retract not welding.

**Lever 2 up**  
UP wire speed.

**Lever 2 down**  
DOWN wire speed.

### A TOP QUALITY AND DURABLE CABLE

Great flexibility and superior electrical performances. The cable is made of highly flexible materials and last meter leather, offering great resistance to wear caused by sliding, by atmospheric agents and by chemical substances.



### TWO KIND OF SPARE PARTS

To have everything you need

**STARTER KIT**  
Contains all the spares for a specific electrode diameter.

**MASTER KIT**  
Contains all the spares for welding with electrodes from 1,0 to 3,2 mm.



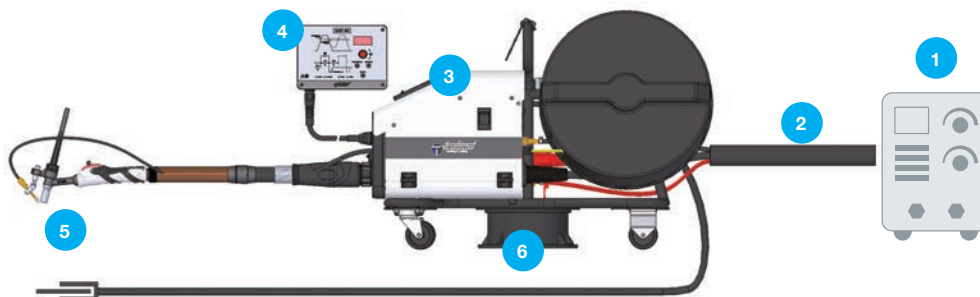
# EASY 400 PLUS

## Technical features

Input Voltage	120 Vac - 230 Vac - 50/60 Hz
Power	100 VA
Maximum welding current	350A (100% work cycle) 460A (30% work cycle)
Diameter of the wire usable for steel filler materials	0,8 mm ÷ 1,2 mm
Diameter of the wire usable for aluminium alloys filler materials	1,0 mm ÷ 1,6 mm
Wire spool size	Ø 200 mm ÷ Ø 300 mm
Level of protection	IP 2X
Dimensions	350 x 250 x 300 mm
Net weight (MU0633)	7,5 kg



### CONFIGURE YOUR EASY 400 PLUS



1

#### INFORMATION OF YOUR WELDING MACHINE

Producer

Brand / Model

2

#### CONNECTION CABLE ASSEMBLY

Wire feeder - power source

**TH0450-01-108** 1,5 m  
**TH0450-04-108** 4,0 m  
**TH0450-08-108** 8,0 m

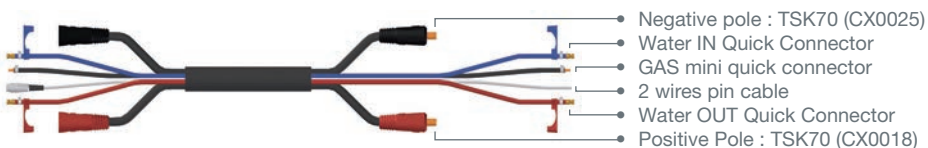
EASY 400 PLUS - Master Tig  
 Air-cooled

**TH0450-01-G081** 1,5 m  
**TH0450-04-G081** 4,0 m  
**TH0450-08-G081** 8,0 m

EASY 400 PLUS - Master Tig  
 Water-cooled

**TH0450-01-W081** 1,5 m  
**TH0450-04-W081** 4,0 m  
**TH0450-08-W081** 8,0 m  
**TH0450-14-W081** 14,0 m

Trafimet standard cable connections



If the cable is custom, the last 3 digits of the part number (108) correspond to the connection number > **Torches and spare parts catalogue.**



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### WIRE FEEDER

EASY 400 PLUS (with 2 steel rollers set 0,8 ÷ 1,0 mm included)

**MU0634**

4

### REMOTE CONTROL

4 m cable

**BX1374**

5

### TIG TORCH

> see the following page

6

### TROLLEY KIT FOR WELDING WIRE SPOOL

Ø Max 300 mm

**TT0174**



## EASY 400 PLUS ACCESSORIES

### For the use of EASY 400 PLUS with any torch

Wire feeding kit for TIG manual torches, complete of buttons for the wire speed adjustment, loading and retract.



Kit for manual torches - 4 m

**TT0177**

Wire feeding kit for TIG automatic torches, can be used in association with any automatic welding control equipment.



Kit for automatic torches - 4 m

**TT0178**

## EASY 400 PLUS ROLLER SETS

### 2 ROLLERS SET

For steel wire  
Ø 0,8 ÷ 1,0 mm  
(STANDARD)  
**FA0201**



For steel wire  
Ø 1,0 ÷ 1,2 mm  
**FA0202**



For aluminium wire  
Ø 1,0 ÷ 1,2 mm  
**FA0203**



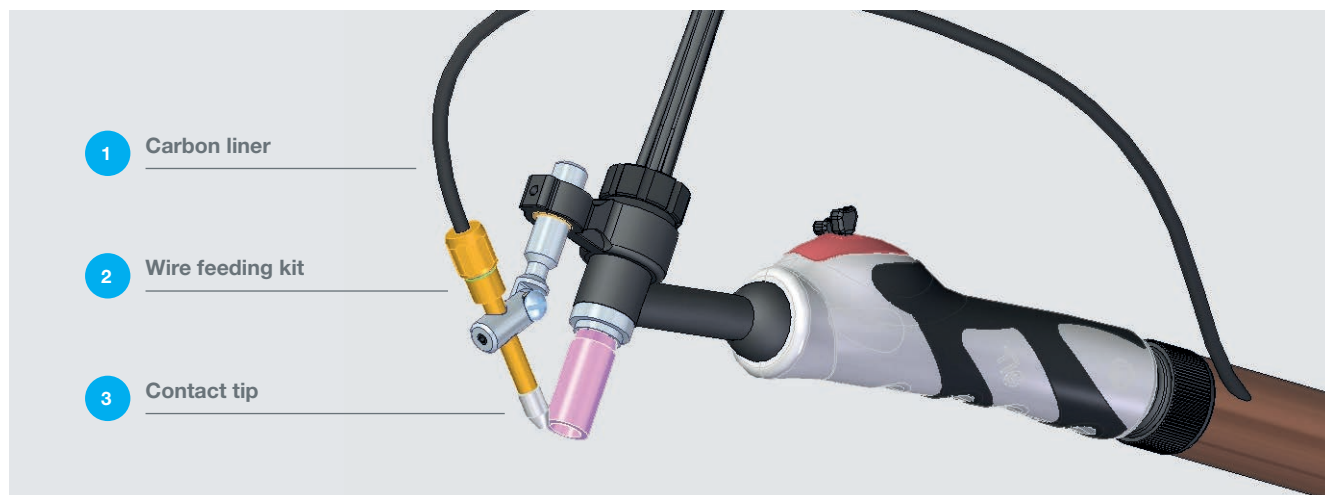
For aluminium wire  
Ø 1,2 ÷ 1,6 mm  
**FA0204**



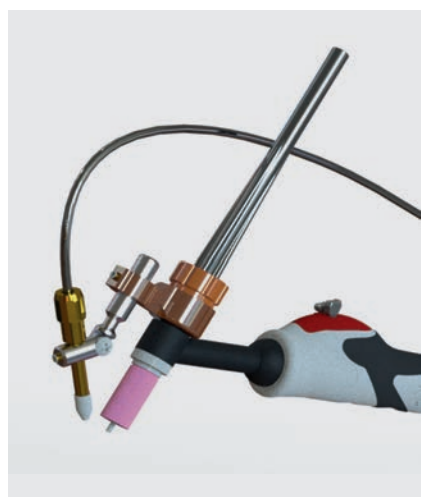


# EASY 400 PLUS

## TIG TPRO Multi and AUTOTIG torches



### TPRO Multi 20HC EASY 400 PLUS



	Water cooling
	4 m cable
<b>V Peak</b>	113
	Argon

$\varnothing$	0,5 ÷ 3,2 mm
<b>X 100%</b>	320A DC - 250A AC
	4 bar
	1,5 l/min

Code	Description	Pack
HB3804S-358-TG3	TPRO Multi 20HC 4m - EASY 400 PLUS	1
1 GM0956	Black Liner (Nylon +12% Graphite) 4m 1,0-1,2 mm	1
2 FE0169	TPRO Multi 20HC wire feeder kit (inclusive of TT0170 kit)	1
3 TT0170	3 contact tips kit $\varnothing$ 0,8 / 1,0 / 1,2 mm	1
3 MD0222-08	Contact tip for $\varnothing$ 0,8 mm wire	5
3 MD0222-10	Contact tip for $\varnothing$ 1,0 mm wire	5
3 MD0222-12	Contact tip for $\varnothing$ 1,2 mm wire	5

### TPRO Multi 18HC EASY 400 PLUS



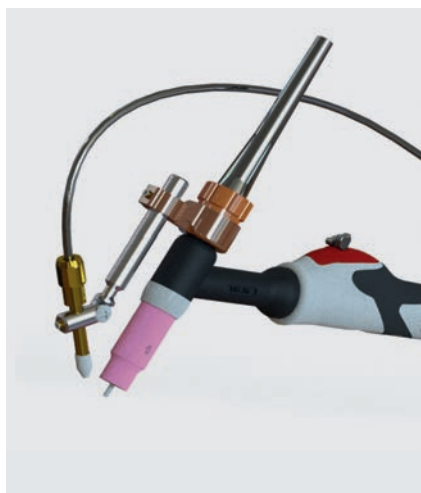
	Water cooling
	4 m cable
<b>V Peak</b>	113
	Argon

$\varnothing$	0,5 ÷ 4,0 mm
<b>X 100%</b>	400A DC - 300A AC
	4 bar
	1,5 l/min

Code	Description	Pack
HB3304S-358-TG3	TPRO Multi 18HC 4m - EASY 400 PLUS	1
1 GM0956	Black Liner (Nylon +12% Graphite) 4m 1,0-1,2 mm	1
2 FE0179	TPRO Multi 18HC wire feeder kit (inclusive of TT0170 kit)	1
3 TT0170	3 contact tips kit $\varnothing$ 0,8 / 1,0 / 1,2 mm	1
3 MD0222-08	Contact tip for $\varnothing$ 0,8 mm wire	5
3 MD0222-10	Contact tip for $\varnothing$ 1,0 mm wire	5
3 MD0222-12	Contact tip for $\varnothing$ 1,2 mm wire	5



## TPRO Multi 26 EASY 400 PLUS



	Air cooling
	4 m cable
<b>V Peak</b>	113

	Argon
	0,5 ÷ 4,0 mm
<b>X 35%</b>	180A DC - 150A AC

	Code	Description	Pack
	HA2604S-358-TG3	TPRO Multi 26 4m - EASY 400 PLUS	1
1	GM0956	Black Liner (Nylon +12% Graphite) 4m 1,0-1,2 mm	1
2	FE0179	TPRO Multi 26 wire feeder kit (inclusive of TT0170 kit)	1
3	TT0170	3 contact tips kit Ø 0,8 / 1,0 / 1,2 mm	1
3	MD0222-08	Contact tip for Ø 0,8 mm wire	5
3	MD0222-10	Contact tip for Ø 1,0 mm wire	5
3	MD0222-12	Contact tip for Ø 1,2 mm wire	5

## AUTOTIG 20 EASY 400 PLUS



	Water cooling
	4 m cable
<b>V Peak</b>	113
	Argon

	0,5 ÷ 3,2 mm
<b>X 100%</b>	250A DC - 220A AC
	4 bar
	1,5 l/min

	Code	Description	Pack
	HB2004P-358-TG3	AutoTIG 20 4m - EASY 400 PLUS	1
1	GM0956	Black Liner (Nylon +12% Graphite) 4m 1,0-1,2 mm	1
2	FE0189	AutoTIG 20 wire feeder kit (inclusive of TT0170 kit)	1
3	TT0170	3 contact tips kit Ø 0,8 / 1,0 / 1,2 mm	1
3	MD0222-08	Contact tip for Ø 0,8 mm wire	5
3	MD0222-10	Contact tip for Ø 1,0 mm wire	5
3	MD0222-12	Contact tip for Ø 1,2 mm wire	5

## AUTOTIG 18HC EASY 400 PLUS



	Water cooling
	4 m cable
<b>V Peak</b>	113
	Argon

	0,5 ÷ 4,0 mm
<b>X 100%</b>	320A DC - 270A AC
	4 bar
	1,5 l/min

	Code	Description	Pack
	HB3304P-358-TG3	AutoTIG 18HC 4m - EASY 400 PLUS	1
1	GM0956	Black Liner (Nylon +12% Graphite) 4m 1,0-1,2 mm	1
2	FE0189	AutoTIG 18HC wire feeder kit (inclusive of TT0170 kit)	1
3	TT0170	3 contact tips kit Ø 0,8 / 1,0 / 1,2 mm	1
3	MD0222-08	Contact tip for Ø 0,8 mm wire	5
3	MD0222-10	Contact tip for Ø 1,0 mm wire	5
3	MD0222-12	Contact tip for Ø 1,2 mm wire	5





## NEW GENERATION TIG COLD WIRE SYSTEM

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