



# iwave

Full freedom to unleash your welding potential.



### TIG system

190i / 230i / 300i /  
400i / 500i



### Multiprocess PRO system

300i / 400i / 500i



# Full freedom

## TIG welding quality without compromise

Maximum quality – on every weld, with every material. Thanks to targeted heat input and an improved ignition function, iWave offers you maximum control of your arc and significantly reduced ignition delays.

All the operating elements of the iWave series are designed for maximum control too. The result is intuitive handling, allowing you to fully focus on your welding challenge.

Got a wide range of welding challenges to master? Then the iWave multiprocess PRO is the perfect choice. In addition to all the TIG functions you can think of, you can also weld all MIG/MAG process variants.

iWave: Full freedom to unleash your welding potential.



## iWave – your benefits



### **Targeted heat input**

#### Maximum control of the weld pool

With CycleTIG, you control the arc and the heat input to the fullest extent. Short welding times let you reliably maintain control of the weld pool and weld even the thinnest material with ease.



### **Self-explanatory operation**

#### Graphical, dynamic menu navigation – in over 30 languages

Straightforward and self-explanatory. With our intuitive menu structure you can easily change settings and get right back to welding.



### **Multiprocess PRO**

#### One system for all processes (iWave 300i – 500i)

iWave and Multiprocess PRO – the new way to enjoy full freedom when welding. In addition to all the TIG functions, you can also weld all MIG/MAG process variants with a single system. Take advantage of the modular concept and expand your high-tech welding system platform to suit your own specific needs with the Welding Packages Standard, Pulse, PMC, LSC, or CMT.



### **Reproducible ignition**

#### Up to 71% less ignition delay

Fast and reproducible ignition, regardless of material condition and without any manual adjustment of the ignition parameters. All thanks to RPI auto – our intelligent ignition function.



### **Ready for Industry 4.0**

#### Contactless data transfer and authentication

Ready for Industry 4.0 and all that lies ahead: iWave supports the key connection standards, from WLAN to Bluetooth and NFC, for optimum use.

For further information, visit:  
[www.fronius.com/iwave](http://www.fronius.com/iwave)



# Be co



## Operation

### iWave 190i–230i

Graphical, dynamic  
operating concept

- Immediate graphical feedback when changing a range of welding parameters
- 4.3" color display with plain text display
- Over 30 languages available
- All work parameters in 1st menu level

# Better Control

## for better results

Inspired by welders, made for welders: all the operating elements of the iWave series are designed for your everyday work – from the robustness to the colors, legibility, and brightness.

This also applies to the settings:

all key welding parameters are located directly on the first menu level. With over 30 language choices available, the plain text display provides clarity. And operation with gloves has never been so easy.

- Can be used easily when wearing gloves
- Status bar: Additional functions that have been set and main settings at a glance
- 5 EasyJobs and 3 user-defined parameters in the 1st menu level
- Configurable favorites button



# Easy, clear, structured



If necessary:  
5 EasyJobs

USB interface  
for software updates,  
for example

Combined press-  
and-turn button



## iWave 300i–500i operation

Graphical, dynamic  
operating concept

- Immediate graphical feedback when changing a range of welding parameters
- 7" color display with plain text display and touchscreen
- Over 30 languages can be selected
- All work parameters in 1st menu level



Status bar  
 Navigation bar

Touchscreen  
 Full screen mode

Wire threading  
 Gas test

NFC field, e.g., for user management and for locking/unlocking the power source with the NFC card or fob

Go straight to the desired setting with the plain text display in over 30 languages

Intuitive and reliable: the system is operated using the combined press-and-turn button or the touchscreen. Graphical instructions and dynamic visualizations when you are changing parameters provide direct assistance.

- Status bar: Additional functions that have been set and main settings at a glance
- 5 EasyJobs
- Touchscreen can also be used when wearing gloves
- Full screen mode: Display is around 40% bigger
- Configurable 1st menu level

# Tota flex





# al ibility

Multiprocess PRO – One welding system  
for all processes and process variants.  
Equipped for the challenges of tomorrow.

Whether it is TIG, MIG/MAG, or MMA: the iWave 300i, 400i, or 500i and the Multiprocess PRO option give you complete freedom so you can ignite all your welding potential.

Unlike conventional Multiprocess systems, ours gives you access to all MIG/MAG process variants, as well as all high-tech TIG functions.

Choose exactly the functions you need from our modular Welding Packages: Standard, Pulse, PMC, LSC, and CMT. Even professional MMA welding is possible – with welding with Cel electrodes as a highlight.





# Multi proce PRO

## iWave 300i, 400i, 500i

Use MIG/MAG processes without limit:  
ignite your welding potential in just three  
steps with iWave:

### STEP 1



Order and integrate the hardware  
option OPT/i Multiprocess PRO.

### STEP 2



Expand your modular welding system  
with the required MIG/MAG hardware  
components such as external  
wirefeeder, welding torch, etc.

### STEP 3



Select your required MIG/MAG  
Welding Packages.

### That's it!



Your power source is ready for all  
welding processes.

# ESS

## Highlights

Little space  
needed

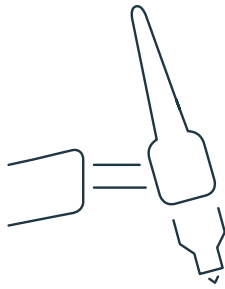
One power source for all  
welding processes.

No  
changeover

Change process at the touch of  
a button.

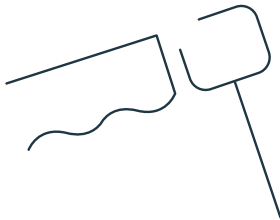
100%  
compatibility

With all available welding process variants  
from Fronius, in the field of TIG, MIG/MAG  
(Standard, Pulse, PMC, LSC and CMT), and  
manual metal arc welding.



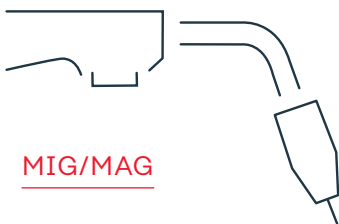
TIG DC / AC/DC

- Quality & appearance
- TIG DC or AC/DC from  
3 - 500A



MMA welding

- Independence
- MMA welding from  
10 - 500A



MIG/MAG

- Cost effectiveness and  
productivity
- MIG/MAG from 3 - 500A
- Welding Packages:  
Standard, Pulse, PMC,  
LSC, CMT



# Full Connectivity

Performance for Industry 4.0: iWave supports the key communication standards. You can quickly and wirelessly connect peripheral devices to the welding system via Bluetooth – from high-tech welding helmets such as the Vizor Connect to remote controls. You integrate the welding system directly into your network via WLAN so firmware updates can be carried out with ease.



## Bluetooth

For connecting wireless remote controls and Bluetooth-compatible welding helmets.



## NFC

For user management – and for easy locking and unlocking of the welding system.



## WLAN

For complete network capability – for updates & use of the Smart Manager function without Ethernet (data documentation).

## User management

Complete control: you can assign individual authorizations for each user via the integrated authorization system. The system immediately detects what the person may – and may not – do when they log in with a key card or key fob. If you want to assign and manage authorizations centrally for several welding systems, our Central User Management is the ideal solution.

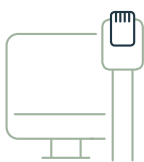
# Data management



## WeldCube Light

### Minimal local documentation

You can record mean values for each weld directly in the welding system as standard and for no additional cost and export them as a PDF.



## WeldCube Basic

### Enhanced decentralized documentation

### with configurable range of functions

If you require actual values, limit monitoring, and editing functions for set values, as well as mean values, we present the WeldCube Basic. This version also records the data directly in the welding system.



## WeldCube Premium

### Central data documentation

Less administration, better overview: WeldCube Premium makes documentation significantly easier by storing your welding data centrally in a database. Intelligent management, statistics, and analysis functions with graphical visualization help you with the controlling requirements of welding production.

For further information, visit: [www.fronius.com/weldcube](http://www.fronius.com/weldcube)

# Cycle Tig

## Outstanding weld appearance

Thanks to the Tacking function

## Targeted heat input

Ideal for welding thin sheet metals and repair welding, such as edge applications

## Simple weld pool control

No burn through – even on corner and butt welds

## Fewer temper colors

For sensitive locations

## Easier handling

Thanks to the precise setting options for current, time, and various parameter combinations.

## For targeted heat input

TIG welding made easier, thanks to the CycleTig function. This is based on the stitch welding principle and offers additional adjustment options and new parameter combinations for better welding results.

## A direct comparison of the advantages

Targeted heat input





Seam optics



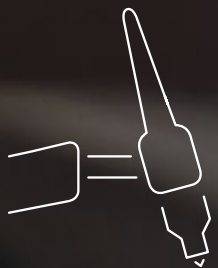
Skill level | Handling



# Ignition

Stable and reproducible.

Noticeably better: iWave takes the ignition behavior of TIG welding to a new level. The HF ignition process has been optimized. And the ignition behavior has been adapted to the different electrode diameters.



RPI auto\*\*

Up to 71%\* less  
ignition delay

Quicker, reproducible ignition – regardless of the condition of the material. With RPI auto, iWave has a solution that comes as standard. The new ignition mode is the intelligent evolution of the proven RPIon function. The welding system now automatically accepts the changes to the ignition settings – including when the ignition worsens and without the need for manual intervention.

Evaluation overview	RPI off	RPI on	RPI auto
Reproducible ignition	..	...	....
Lowest ignition delay	...	.	....
Lowest electrode load	...	.	..
Careful handling of the weld surface	....	..	...

\* Compared to RPI off | Test series under laboratory conditions: 200 A welding current / 0.5s welding time/ 1000 ignitions!

\*\* Only for iWave AC/DC



# TIG functions



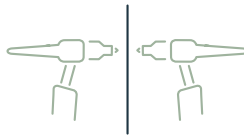
## Automatic cap-shaping in just 2 seconds

Save time: use the function to quickly form a cap based on the set electrode diameter.



## Tacking – time saving of up to 50% when tacking materials

The weld pool is made to oscillate by means of pulse currents. This makes it easier to tack components together and reduces tacking time, leaving hardly any or no temper colors on the tacking points.



## Synchronous welding like never before

Challenge mastered: our “Sync Mode” makes synchronous, double-sided TIG welding with alternating current easier than ever before. Our solution for this ultimate welding challenge is automatic harmonization of both arcs, allowing two welders to work in perfect sync.



## AC/DC waveforms – the right arc for every requirement

Weld your way: iWave offers you the option of selecting the wave shape during AC welding. These are typical of a range of weld properties that you prefer for the welding task in question. If required, you can also combine the waveforms.



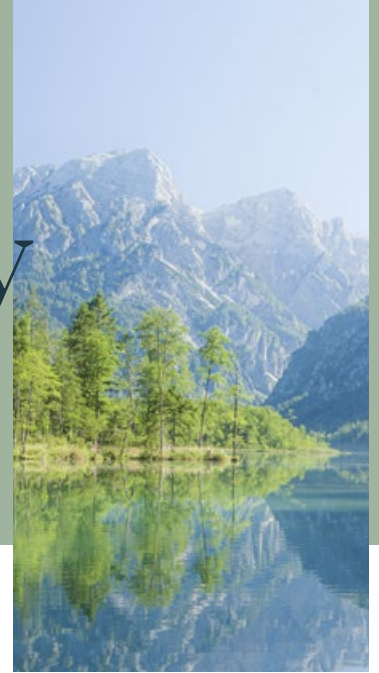
## Automatic gas post-flow – protecting the tungsten electrode

Welding without oxidation. The iWave ensures the gas shield for the tungsten electrode and weld. The gas post-flow is calculated automatically based on the set welding current and the electrode diameter.

# We take responsibility

## We believe in sustainability

Long service life, repairability, and recyclability: like all Fronius products, iWave is designed and produced with sustainability in mind. We use the latest technology to help protect people and the environment, and ensure a worthwhile future for coming generations.



## iWave AC/DC – technical data

	iWave 190i AC/DC EF	iWave 190i AC/DC MV/B	iWave 230i DC EF	iWave 230i AC/DC MV/B	iWave 300i AC/DC	iWave 300i AC/DC / MV/NC	iWave 400i AC/DC	iWave 400i AC/DC / MV/NC	iWave 500i AC/DC	iWave 500i AC/DC / MV/NC
Weight	17.0 kg (37.4 lb)	16.5 kg (36.3 lb)	17.0 kg (37.4 lb)	16.5 kg (36.3 lb)	65.5 kg (144.4 lb)	63.5 kg (139.9 lb)	67.0 kg (147.7 lb)	65.0 kg (143.3 lb)	68.5 kg (151.0 lb)	66.5 kg (146.6 lb)
Dimensions / width	210 mm / 8.26 in	210 mm / 8.26 in	210 mm / 8.26 in	210 mm / 8.26 in	300 mm / 11.8 in	300 mm / 11.8 in	300 mm / 11.8 in	300 mm / 11.8 in	300 mm / 11.8 in	300 mm / 11.8 in
Dimensions / height	369 mm / 14.5 in	369 mm / 14.5 in	369 mm / 14.5 in	369 mm / 14.5 in	740 mm / 29.1 in	740 mm / 29.1 in	740 mm / 29.1 in	740 mm / 29.1 in	740 mm / 29.1 in	740 mm / 29.1 in
Dimensions / length	558 mm / 21.9 in	558 mm / 21.9 in	558 mm / 21.9 in	558 mm / 21.9 in	706 mm / 27.8 in	706 mm / 27.8 in	706 mm / 27.8 in	706 mm / 27.8 in	706 mm / 27.8 in	706 mm / 27.8 in
Mains frequency	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz
Mains voltage	230 V	120 V / 230 V	230 V	120 V / 230 V	3 x 400 V	3x 200- 230 V / 3x 380- 575 V	3 x 400 V	3x 200- 230 V / 3x 380- 575 V	3 x 400 V	3x 200- 230 V / 3x 380- 575 V
Mains voltage tolerance	+/-15%	+/-15%	+/-15%	+/-15%	+/-15%	+/-10%	+/-15%	+/-10%	+/-15%	+/-10%
Welding current / duty cycle [10min/40°C]	190 A / 35%	190 A / 35% [230 V] 150 A / 35% [120 V]	230 A / 35%	230 A / 35% [230 V] 170 A / 35% [120 V]	300 A / 40%	300 A / 40%	400 A / 40%	400 A / 40%	500 A / 40%	500 A / 40%
Welding current / duty cycle [10min/40°C]	160 A / 60%	160 A / 60% [230 V] 120 A / 60% [120 V]	195 A / 60%	195 A / 60% [230 V] 140 A / 60% [120 V]	260 A / 60%	260 A / 60%	360 A / 60%	360 A / 60%	430 A / 60%	430 A / 60%
Welding current / duty cycle [10min/40°C]	140 A / 100%	140 A / 100% [230 V] 100 A / 100% [120 V]	165 A / 100%	165 A / 100% [230 V] 120 A / 100% [120 V]	240 A / 100%	240 A / 100%	320 A / 100%	320 A / 100%	360 A / 100%	360 A / 100%
Maximum welding current	190 A	190 A	230 A	230 A	300 A	300 A	400 A	400 A	500 A	500 A
Minimum welding current	3 A	3 A	3 A	3 A	3 A	3 A	3 A	3 A	3 A	3 A
Mark of conformity	CE, S, CCC	CE, CSA, S	CE, S, CCC	CE, CSA, S	CE, S	CE, CSA, S, CCC	CE, S	CE, CSA, S, CCC	CE, S	CE, CSA, S, CCC
Open circuit voltage	100 V	100 V	100 V	100 V	96 V	101 V	96 V	101 V	96 V	101 V
Working voltage range	10.1-17.6 V	10.1-17.6 V	10.1-19.2 V	10.1-19.2 V	10.1-22.0 V	10.1-22.0 V	10.1-26.0 V	10.1-26.0 V	10.1-30.0 V	10.1-30.0 V

## Reducing the mental and physical load



For us, sustainability also means protecting people from physical and mental stress.

The new iWave operating concept, technologies for noise reduction during welding, or ergonomic aspects such as the working height of the systems or the design of the welding torch, all help to make the welder's life easier.



## Environment and resources

During development of the new iWave series, we focused on bringing long-lasting and repairable systems into the market. A recyclable plastic housing and components that can be individually serviced and replaced help protect our environment. New technologies reduce power losses and gas consumption, thereby conserving resources.

## iWave DC – technical data

	iWave 230i DC EF	iWave 230i DC MV/B	iWave 300i DC	iWave 300i DC /MV/NC	iWave 400i DC	iWave 400i DC /MV/NC	iWave 500i DC	iWave 500i DC /MV/NC
Weight	16.4 kg (36.1 lb)	15.9 kg (35.0 lb)	40.0 kg (88.2 lb)	38.0 kg (83.7 lb)	41.0 kg (90.4 lb)	39.5 kg (87.1 lb)	43.0 kg (94.8 lb)	41.0 kg (90.4 lb)
Dimensions / width	210 mm / 8.26 in	210 mm / 8.26 in	300 mm / 11.8 in	300 mm / 11.8 in	300 mm / 11.8 in	300 mm / 11.8 in	300 mm / 11.8 in	300 mm / 11.8 in
Dimensions / height	369 mm / 14.5 in	369 mm / 14.5 in	510 mm / 20.0 in	510 mm / 20.0 in	510 mm / 20.0 in	510 mm / 20.0 in	510 mm / 20.0 in	510 mm / 20.0 in
Dimensions / length	558 mm / 21.9 in	558 mm / 21.9 in	706 mm / 27.8 in	706 mm / 27.8 in	706 mm / 27.8 in	706 mm / 27.8 in	706 mm / 27.8 in	706 mm / 27.8 in
Mains frequency	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz	50-60 Hz
Mains voltage	230 V	120 V / 230 V	3 x 400 V	3x 200- 230 V / 3x 380-575 V	3 x 400 V	3x 200- 230 V / 3x 380-575 V	3 x 400 V	3x 200- 230 V / 3x 380-575 V
Mains voltage tolerance	+/-15%	+/-15%	+/-15%	+/-10%	+/-15%	+/-10%	+/-15%	+/-10%
Welding current / duty cycle [10min/40°C]	230 A / 45%	230 A / 45% [230 V] 170 A / 45% [120 V]	300 A / 40%	300 A / 40%	400 A / 40%	400 A / 40%	500 A / 40%	500 A / 40%
Welding current / duty cycle [10min/40°C]	205 A / 60%	205 A / 60% [230 V] 155 A / 60% [120 V]	260 A / 60%	260 A / 60%	360 A / 60%	360 A / 60%	430 A / 60%	430 A / 60%
Welding current / duty cycle [10min/40°C]	170 A / 100%	170 A / 100% [230 V] 130 A / 100% [120 V]	240 A / 100%	240 A / 100%	320 A / 100%	320 A / 100%	360 A / 100%	360 A / 100%
Maximum welding current	230 A	230 A	300 A	300 A	400 A	400 A	500 A	500 A
Minimum welding current	3 A	3 A	3 A	3 A	3 A	3 A	3 A	3 A
Mark of conformity	CE, S, CCC	CE, CSA, S	CE, S	CE, CSA, S, CCC	CE, S	CE, CSA, S, CCC	CE, S	CE, CSA, S, CCC
Open circuit voltage	97 V	97 V	96 V	99 V	96 V	99 V	96 V	99 V
Working voltage range	10.1-19.2 V	10.1-19.2 V	10.1-22.0 V	10.1-22.0 V	10.1-26.0 V	10.1-26.0 V	10.1-30.0 V	10.1-30.0 V

# iWave – function overview

Functions	iWave 190i AC/DC	iWave 230i AC/DC	iWave 300i AC/DC	iWave 400i AC/DC	iWave 500i AC/DC	iWave 230i DC	iWave 300i DC	iWave 400i DC	iWave 500i DC
Pulse welding	✓	✓	✓	✓	✓	✓	✓	✓	✓
RPI on	✓	✓	✓	✓	✓				
RPI auto	✓	✓	✓	✓	✓				
SoftStart (touchdown ignition)	✓	✓	✓	✓	✓	✓	✓	✓	✓
HF ignition	✓	✓	✓	✓	✓	✓	✓	✓	✓
Touch HF ignition	✓	✓	✓	✓	✓	✓	✓	✓	✓
TIG Comfort Stop	✓	✓	✓	✓	✓	✓	✓	✓	✓
Arc break voltage	✓	✓	✓	✓	✓	✓	✓	✓	✓
Automatic cap-shaping	✓	✓	✓	✓	✓				
Waveform setting (AC/DC)	✓	✓	✓	✓	✓				
Tacking	✓	✓	✓	✓	✓	✓	✓	✓	✓
Synchronized welding	✓	✓	✓	✓	✓	✓	✓	✓	✓
Automatic gas post-flow	✓	✓	✓	✓	✓	✓	✓	✓	✓
CEL mode	✓	✓	✓	✓	✓	✓	✓	✓	✓
CycleTIG	✓	✓	✓	✓	✓	✓	✓	✓	✓
Multiprocess (TIG, MMA)	✓	✓	✓	✓	✓	✓	✓	✓	✓
Multiprocess PRO			✓	✓	✓		✓	✓	✓
Generator-compatible	✓	✓	✓	✓	✓	✓	✓	✓	✓
Multivoltage 120/230 V	✓	✓				✓			
Multivoltage 200-600 V			✓	✓	✓		✓	✓	✓
Cooling type	Gas-cooled	Gas or water-cooled	Gas or water-cooled	Gas or water-cooled	Gas or water-cooled	Gas or water-cooled	Gas or water-cooled	Gas or water-cooled	Gas or water-cooled
Connectivity (WLAN, NFC, Bluetooth)	✓	✓	✓	✓	✓	✓	✓	✓	✓
Ethernet and Speednet as standard	Ethernet optional	Ethernet optional	Ethernet and Speednet as standard	Ethernet and Speednet as standard	Ethernet and Speednet as standard	Ethernet and Speednet as standard	Ethernet and Speednet as standard	Ethernet and Speednet as standard	Ethernet and Speednet as standard

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