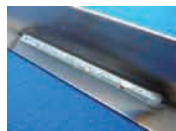


November 2017

Modes for Mild Steel, Stainless Steel, and Aluminum Are Standard.
Pulse Welding Machines with High Welding Performance and Various Functions.



“VP Pulse Control” for High Precision Pulse Period Control compensates arc length change and achieves beautiful bead and low spatter welding.



- Weld current: 300 A
- Base metal: Mild steel
- Joint: Fillet
- Gas: 80 % Ar + CO₂

- Weld speed: 80 cm/min
- Plate thickness: 3.2 mm
- Wire: YGW15 (1.2 mm)



- Weld current: 200 A
- Base metal: Stainless steel (SUS304)
- Joint: Fillet
- Gas: 98 % Ar + O₂

- Weld speed: 80 cm/min
- Plate thickness: 3.0 mm
- Wire: YS308 (1.2 mm)

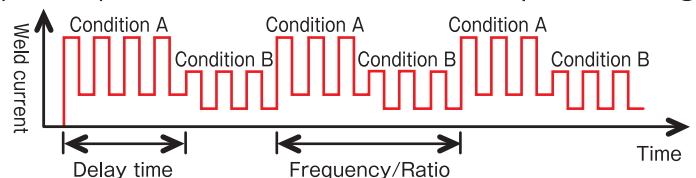


- Weld current: 170 A
- Base metal: Aluminum (A5052)
- Joint: Fillet
- Gas: 100 % Ar

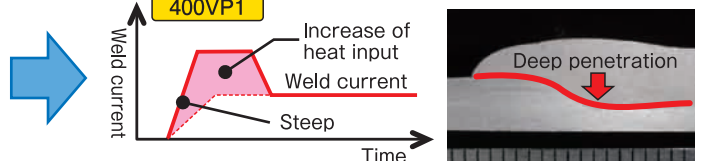
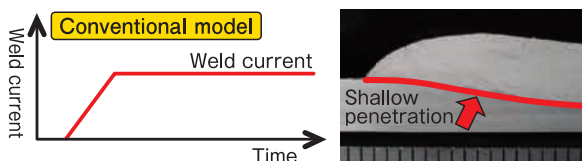
- Weld speed: 80 cm/min
- Plate thickness: 3.0 mm
- Wire: A5356-WY (1.2 mm)

High Quality Aluminum MIG Welding.

[Low-pulse function] Pulse output of 2 conditions (A and B) achieves beautiful bead and low spatter welding.



[Control for deeper penetration] Deep penetration at the start of aluminum welding achieves long effective weld length.



Easy to operate even for inexperienced operators

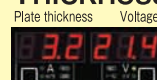
“Weld Navigation.” for weld parameters



You can set weld parameters by setting joint, plate thicknesses, and weld speed.

Standard

“Thickness settings” for easier welding



You can set weld parameters only by entering plate thickness.

Standard

Specifications

① Welding Power Source	YD-400VP1YAA	YD-400VP1YA1	YD-400VP1YU1
		Semi-automatic	Automatic or robotic (equipped with robot connection interface)
Rated input voltage (Allowable fluctuation range)	200 V to 220 V (180 V to 242 V)		380 V to 415 V (342 V to 456 V)
Number of phases	3-phase		
Rated frequency	50 Hz/60 Hz (Common)		
Rated input	19.7 kVA, 18.0 kW		
Maximum no-load voltage	82 V DC		
Rated output current	400 A		
Rated output voltage	38 V		
Rated duty cycle	60 %		
Output current adjustable range	30 A DC to 400 A DC		
Output voltage adjustable range	12 V DC to 38 V DC		
Power control process	IGBT inverter type		
Memory	100-channel reproducible storage		
Sequence	Main welding, Main welding-Crater, Initial welding-Main welding-Crater, Arc spot		
Waveform control process	Digital setting [-99 (low) to 0 (Standard) to 99 (high)]		
Applicable welding process	CO ₂ , MAG, MIG, Pulsed MAG, Pulsed MIG		
Applicable shielding gas	CO ₂ welding: 100 % CO ₂ MAG welding: Mixed gas of 80 % Ar and 20 % CO ₂ Stainless steel MIG welding: Mixed MIG gas of 98 % Ar and 2 % O ₂ Aluminum MIG welding: Ar 100 % (MIG gas) [CO ₂ : Carbon dioxide, Ar: Argon, O ₂ : Oxygen]		
Applicable wire size (diameter)	0.8 mm/0.9 mm/1.0 mm/1.2 mm/1.4 mm/1.6 mm		
Applicable wire type *1	Mild steel (MS) , Flux cored mild steel (MS_FCW) , Stainless steel (Solid) , Flux cored stainless steel (SUS_FCW) [FCW: Flux cored wire] , Hard aluminum, Soft aluminum		
Pre-flow time	0.0 s to 10.0 s (Increment of 0.1 s)		
Post-flow time	0.0 s to 10.0 s (Increment of 0.1 s)		
Arc spot time	0.3 s to 10.0 s (Increment of 0.1 s)		
Input terminal	Terminal block (for 3-phase, M6 bolting)		
Output terminal	Copper terminal with M8 bolting		
Dimensions *2 (Width × Depth × Height)	380 mm × 540 mm × 640 mm		380 mm × 540 mm × 660 mm
Mass (Weight)	54 kg	56 kg	63 kg

*1 For robot welding, only mild steel (MS) , flux cored mild steel (MS_FCW) , stainless steel (solid) , and flux cored stainless steel are applicable.

*2 Excluding the input terminal cover on the rear panel.

② Wire Feeder	Mild steel/Stainless steel (Air-cooled)	Aluminum (Air-cooled)	Aluminum (Water-cooled)	③ Controller	YD-00DCR1	YD-40GTR1
	Model number	YW-40DG2	YW-40DG2TAK		YW-40DGW2TAK	Type
Drive method	Two drive rolls	Four drive rolls	Four drive rolls	Cable length	2 m	2 m
Applicable wired dia. (mm)	0.9, 1.2	1.2, 1.6	1.2, 1.6			
Spool shaft	With brake	With brake	With brake			

To use a wire diameter other than the applicable one, an optional part (sold separately) is needed.

④ Welding Torches	Mild steel/Stainless steel (Air-cooled)	Aluminum (Air-cooled)	Aluminum (Water-cooled)
	Model number	YT-35CSG4	YT-30MD2
Rated current	350 A	300 A	500 A
Applicable wire type	Mild steel / (Stainless steel)	Aluminum / (Mild steel / Stainless steel)	Aluminum / (Mild steel / Stainless steel)
Applicable wire dia.	1.2 mm	1.2 mm	1.6 mm
Cable length	3 m	3 m	3 m
Cooling method	Air-cooled	Air-cooled	Water-cooled
Duty cycle	CO ₂	300 A: 60 % , 350 A: 45 %	(350 A: 45 %) (500 A: 100 %)
	MAG	350 A: 35 %	(280 A: 60 % , 300 A: 50 %) (450 A: 100 % , 500 A: 80 %)
	MIG	(350 A: 35 %)	280 A: 60 % , 300 A: 50 % (450 A: 100 % , 500 A: 80 %)
	Pulsed MAG	350 A: 20 %	(300 A: 30 %) (500 A: 60 %)
	Pulsed MIG	(350 A: 10 %)	300 A: 30 % (500 A: 60 %)

• To apply a welding process or wire type indicated in the parentheses (), an optional part (sold separately) is needed. If the optional part is not used, the torch wears significantly.

• To use a wire diameter other than the applicable one, an optional part (sold separately) is needed.

• Use of a wire other than the specified diameter or an elongated wire (over 3 m) can cause trouble in wire feed performance as a result, arc becomes unstable.

• To use a water-cooled torch, it is necessary to use an optional (separately sold) water coolant and water cooling hose unit.

Power supply facilities

Model	YD-400VP1YAA	YD-400VP1YA1	YD-400VP1YU1
Capacity	19.7 kVA or more		
Input protection	Fuse	60 A	30 A
	Breaker (Leakage breaker)	60 A	30 A
Input power cable	14 mm ² or more	5.5 mm ² or more	
Grounding cable	14 mm ² or more	5.5 mm ² or more	



Safety precautions

• Before attempting to use any welding product always read the manual to ensure correct use.

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• Specifications are subject to change without notice.

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