**Buddy™ Arc 400i / 400i XC**
Compact and Powerful Inverter MMA Welder

**Robust and Powerful**
The Buddy™ Arc 400i and 400i XC are heavy duty, fan cooled, IGBT based inverter controlled power sources meant for MMA / TIG (scratch-start) welding.

**MMA Welding**
A wide current range and powerful welding performance make the Buddy™ Arc machines suitable for a wide range of applications and electrode types such as:

- General purpose
- Low-hydrogen
- Stainless steel
- Cellulosis

The Buddy™ Arc 400i XC model has controlled welding dynamics that provides excellent weld properties for welding pipe root passes.

**TIG Welding**
The Buddy™ Arc machines are capable of performing TIG welding with precise current control. All you need is an optional TIG-torch with a gas valve, a gas regulator and a cylinder of gas. You can weld mild steel or stainless steel material with or without filler material.

**Voltage Reduction Device – VRD**
In some areas a voltage reduction device, or VRD, is required. VRD is a safety function that limits the open circuit voltage from the machine to less than 35V. The Buddy™ Arc are prepared for VRD and the function can easily be activated inside the power source.

**Easy Settings**
The simple control panel of the Buddy™ Arc makes it easy to optimise settings, reducing the time taken for achieving the best weld characteristics. These units are equipped with hot start and arc force with the possibility to adjust parameters during welding. Hot start helps to avoid starting problems while arc force sets the intensity of the arc for improved weld quality.

As an option the Buddy™ Arc can be equipped with a remote control unit.

**Applications**
- General fabrication
- Railways
- Shipbuilding
- Civil construction
- Pipe workshops

**Energy Efficient**
The Buddy™ Arc machines are constructed to maintain a high power factor and efficiency, thus keeping the energy cost to a minimum without affecting the weld quality.

**Safety and Reliability**
The Buddy™ Arc machines conform to the International Standards that ensure the reliability and safe use of these machines.

These units are equipped with overheating and mains over/under voltage protection that will temporarily switch off the machines automatically to prevent any potential damage that the components might sustain.

- Inverter controlled - more efficient power usage
- Light weight - improved mobility
- Easy-to-use control panel - quick setup
- Adjustable hot start - easy to strike the electrode, helps you to avoid starting problems.
- Adjustable arc force - sets the intensity of the arc for improved weld quality.
- Wide mains voltage tolerance - stable welding controls
**Technical Data**

Buddy™ Arc 400i  
Buddy™ Arc 400i XC

- **Mains voltage, V/Ph Hz**: 400V ± 15%, 3ph, 50Hz
- **Effective input current, A**: 21.4A
- **Fuse (slow), A**: 32
- **Mains cable, Ø mm²**: 4C x 4
- **Permitted load at (MMA)**
  - 60% duty cycle, A/K: 400 / 36
  - 100% duty cycle, A/K: 310 / 32.4
- **Permitted load at (TIG)**
  - 60% duty cycle, A/K: 400 / 26
  - 100% duty cycle, A/K: 310 / 22.4
- **Power factor at maximum current**: 0.93
- **Efficiency at maximum current, %**: 85
- **Setting range (TIG/MMA), A**: 20 - 400
- **Open circuit voltage (OCV), V**: 68 (400i)  
  78 (400i XC)
- **Reduced OCV (VRD), V**: <35
- **Dimensions lxwxh, mm**: 540 x 280 x 510
- **Weight, kg**: 29 (400i)  
  31 (400i XC)
- **Operating temperature**: -10 till 40°C
- **Application class**: S
- **Standards**: IEC 60974-1  
  IEC 60974-10

**Ordering Information**

Buddy™ Arc 400i  
46F0226400

Buddy™ Arc 400i XC  
46F0227400

Remote Control 5m  
46F1004001

Remote Control 10m  
46F1005001

Delivery Content: 3m mains cable, 2 nos. male quick connectors for Buddy Arc 400i / 400i XC.

**Optional Accessories**

- **TXH 200V – 4m TIG Torch (for Scratch TIG)**: 1620607292
- **TXH 200V – 8m TIG Torch (for Scratch TIG)**: 1620607293
- **Welding Cable Cu 50 sq mm (100m Roll)**: 4600600162
- **Welding Cable Cu 70 sq mm (100m Roll)**: 4600600163
- **Holder Handicool HC 600**: 2002001001
- **Holder Comfort 600**: 2002001002
- **Heavy Duty Earth Clamp 600**: 2002002001
- **Hand Shield Armour (83 x 108mm)**: 2001001004
- **Eco Arc Helmet (83 x 108mm)**: 2001001003
- **Welding Hand Gloves**: 2001005001

**Unrivalled Service And Support**

Our commitment and ability to deliver the expected service and support starts immediately after the order is confirmed. We endeavour to offer our customers an After Sales service, which is second to none. A strong and skilful service organisation is prepared to offer service and maintenance, calibration, validation and upgrading of equipment and software. The service organisation will offer standardised solutions for the reconditioning or modification of existing products.

**Quality Accessories For Quality Welding**

ESAB offers a wide range of accessories. The complete range, along with product information, is available at www.esabindia.com or contact your local ESAB dealer.