The Invertec® V155-S offers much more than you would expect from a welder this size. Weighing in at just under 15 lbs. (6.8 kg) the Invertec® V155-S is no lightweight contender. It packs the full punch of a heavyweight professional that you can take to the most demanding job sites. It features 120/230V auto reconnect operation and can operate from a portable generator. It can also plug into a 200 ft. (61 m) 230V extension cord so you can weld just about anywhere.

**FEATURES**

- **Two stick modes**, SOFT and CRISP, provide the right arc characteristics for different types of electrodes.
- **Fan-As-Needed™ (F.A.N.)** reduces noise and dust inside the machine.
- **Auto-Adaptive Arc Force** minimizes electrode sticking in the puddle without compromising arc stability or increased spatter.
- **Automatic Hot Start** boosts the current during starting to make striking an arc easier.
- **Touch Start TIG® mode** – it’s like getting a TIG welder for free!

**APPLICATIONS**

- Light Duty Metal Fabrication
- Maintenance
- Autobody/Farm

**WHAT’S INCLUDED**

**K2605-1 Machine Only Includes:**

- Invertec® V155-S
- Stick electrode holder, cable and Twist Mate™ plug
- Work cable and clamp with Twist Mate™ plug
- Fully adjustable shoulder strap
- 120/230V input cord, 6.6 ft. (2 m) with a 120V 15 Amp plug
- Extra 120V 20 Amp plug

**INPUT**

- 120/230V

**OUTPUT**

- CC
- DC
- DC

**Output Range**

5-155 Amps DC
Max OCV: 75V

**Weight/Dimensions (H x W x D)**

14.7 lbs. (6.7 kg)
11.3 x 6.2 x 15.4 in.
(288 x 158 x 392 mm)
1. Stick/Touch Start TIG® Modes
2. Status Lights
3. Output Control
4. Twist Mate™ Connectors

**Two Stick Modes**

**Soft Mode**
Provides a lower arc force level to deliver a smooth arc with reduced spatter. It provides a clean flat fillet weld with excellent wetting and bead appearance. For stainless electrodes such as Red Baron® 308L (E308L-16), rutile electrodes such as Fleetweld® 37 (E6013), and low hydrogen electrodes such as Excalibur® 7018 MR.

**Crisp Mode**
Provides a more dynamic arc characteristic for welding in all positions. For cellulosic electrodes such as Fleetweld® 35 (E6011).

**Touch Start TIG® Mode**
Machine has a low open circuit voltage in TIG mode to reduce tungsten contamination. Simply touch the tungsten to the work piece and lift off. The machine will instantly ramp up the voltage and current to establish the arc without the use of high frequency.
TIG Ready-Pak® Welding Package
Order a TIG Ready-Pak® Package and get a complete welding package.

Each Package Contains:
- Invertec® V155-S
- Stick electrode holder and cable, 10 ft. (3.0 m) with Twist Mate™ plug
- Work clamp and cable, 10 ft. (3.0 m) with Twist Mate™ plug
- Fully adjustable shoulder strap
- 120/230V input cord, 6.6 ft. (2 m) with a 120V 15 Amp plug
- Extra 120V 20 Amp plug
- Gas Regulator
- PTA-17V TIG torch with Ultra-Flex™ cable and Twist Mate™ adapter
- PTA-17 TIG accessory kit (KP508)
- Easy-Store/Easy-Carry Suitcase

Order:
K2606-1 Invertec® V155-S TIG Ready-Pak® Package

A CLOSER LOOK

Invertec® V155-S — Auto Adaptive Arc Force™
Auto Adaptive Arc Force™ continuously measures the arc voltage to adapt the optimum value of Arc Force. This optimizes the arc stability without the risk of electrode sticking and minimizes spatter.

Competition — Standard Arc Force
With Standard Arc Force, the peak welding current that prevents the electrode from sticking in the weld pool is pre-set. The fixed peak may react aggressively, causing spatter and an unstable arc.

Stable Arc with Reduced Spatter

Fluctuating Arc with Some Spatter
GENERAL OPTIONS
Welding Cart
Full-featured cart is designed to store and transport a welder, 80 cubic foot gas cylinder, welding cables and accessories. Includes an angled top shelf for easy access to welder controls, a lower tray for added storage space, a sturdy handle also used as a convenient cable wrap hanger. Order K2275-1

Twist Mate™ Cable
Plug Kit
Twist Mate™ plug for connecting welding cable to output terminal. Contains one plug. Order K852-25

TIG OPTIONS
PTA-17FV Flex Head Gas Valve
TIG Torch with Ultra-Flex™ Cable (12.5 ft., 1 pc.)
150 amp air-cooled compact and durable flexible head TIG torch with integral gas valve for gas control at the torch. Gas nozzle not included.
Order K1782-13 (requires K960-2 Twist Mate™ Adapter)

1-Piece TIG Torch Adapter
For connection of PTA-9V or PTA-17V torches (1-piece cable) to power sources without gas passing through the Twist Mate™ connection.
Order K960-2

Cut Length
Consumables
TIG welding filler metals are available for welding stainless steel, mild steel, and copper alloys. Request Lincoln Publication C1.10 for more information.

Deluxe Adjustable Gas Regulator & Hose Kit
Accommodates CO₂, argon, or argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3 m) gas hose. Order K586-1

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details

PRODUCT SPECIFICATIONS

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Product Number</th>
<th>Input Power Voltage/Phase/Hz</th>
<th>Rated Output Current/Voltage/Duty Cycle</th>
<th>Input Current @ Rated Output(1)</th>
<th>Output Range</th>
<th>H x W x D inches (mm)</th>
<th>Net Weight lbs. (kg)</th>
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<tbody>
<tr>
<td>Invertec® V155-S</td>
<td>K2605-1</td>
<td>120V/1/50/60</td>
<td>75A/23.0V/100% Stick</td>
<td>24.0A</td>
<td>5-155 Amps DC Max ODV: 75V</td>
<td>11.3 x 6.2 x 15.4 (288 x 158 x 392)</td>
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<td></td>
<td>K2606-1 (Ready-Pak® Pkg.)</td>
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<td>100A/24.0V/30% Stick</td>
<td>33.8A</td>
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<td>105A/14.2V/100% TIG</td>
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(1) Input amps on 60 Hz input.

CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers’ particular purpose is specifically disclaimed.

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