THE GYS MULTIPROCESS SYSTEM

EXAGON

ONE SOURCE. MORE WAYS TO WORK.

400 CC/CV & 400 FLEX CC/CV

MMA / MIG-MAG / DC TIG / GOUGING



BUILD THE SYSTEM AROUND THE JOB.

EXAGON combines constant-current and constant-voltage output for fabrication, construction, hire, offshore and naval work. Use the source for MMA and DC Lift TIG, or add the appropriate feeder, HF TIG unit and cooling equipment for the application.

400A CAPABILITY

Both sources deliver 400A at 60% duty cycle on the appropriate three-phase supply.

TWO SUPPLY CHOICES

400 CC/CV uses 400V three-phase. FLEX adds wide-voltage single- and three-phase operation.

SYSTEM FLEXIBILITY

Workshop and portable MIG feeders, HF TIG, cooling and remote-control options.

INSIDE / Model comparison 02 / Ordering 03 / Extended technical guide 04-10

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MODEL COMPARISON

MIG OUTPUT AND SUPPLY

Choose 400 CC/CV for a 400 V three-phase installation, or 400 FLEX for a site supply that needs single- and three-phase flexibility. Select the feeder by how it will be powered and where it will be used.

Robust CC/CV inverter sources for workshop and site work. Pair with a wire feeder for MIG, or configure the system for MMA, TIG and gouging applications.

MODEL	GYS ORDER CODE	SUPPLY / FUSE	RATED OUTPUT / DUTY	AT 60%	AT 100%
400 CC/CV	010925	400V 3-phase / 32A	400A at 60%	400 A	350 A
400 FLEX CC/CV	069718	208–525 V 1~/3~	300 A at 40% / 400 A at 60%	— / 400 A	220 / 350 A

GYS duty-cycle ratings at 40 °C to EN 60974-1. Compare sustained output for production work. See the technical guide for voltage bands and fuse type. FLEX ratings are shown for single-phase / three-phase. GYS specifies 63 A at 208–380 V and 32 A at 380–525 V.

Spool and machine size

MODEL	SPOOL DIAMETER	MACHINE WEIGHT
400 CC/CV	Via feeder	32 kg
400 FLEX CC/CV	Via feeder	40 kg

GYS manufacturer reference

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OPTIONS & ORDERING

EXAGON PACKAGE SETUP

Use the GYS order code to specify the machine and match accessories to the exact configuration.

What to order

PACKAGE / OPTION	SELECTION AND CONTENTS
EXAFEED 4L / 032408	Separate wire feeder for the 400 CC/CV. Specify connection cable and torch for the welding position and distance.
NOMADFEED 425-4 CC/CV / 036291	Voltage-sensing feeder for work away from the power source. Select the torch and wire drive components for the job.
EXATIG / 013780	HF TIG control module. Specify TIG torch, gas and cooling as applicable.
Supply for FLEX	Confirm phase and voltage before quoting. Maximum output differs between single- and three-phase supplies.

Wire and controls

CHECK	MANUFACTURER DETAILS
FLEX output	Single-phase: up to 270A. Three-phase: up to 400A. Fuse requirement: 63A at 208-380V or 32A at 380-525V.
MIG configuration	EXAFEED 4L or NOMADFEED 425-4 CC/CV provides wire feeding. Feeders and interconnections are separate options.
Other options	EXATIG HF control, EXACOOL cooling and trolley systems expand the available configurations.

GYS manufacturer reference







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A MULTIPROCESS SOURCE. A CONFIGURABLE SYSTEM.

CC = CONSTANT CURRENT / CV = CONSTANT VOLTAGE / ACCESSORIES ADD CAPABILITY





WHAT EACH CONFIGURATION DOES

Process	Configuration & application
MMA	Source operation with rutile, basic and cellulosic electrodes. The 400 CC/CV supports electrodes up to 6mm.
Pulsed MMA	Source function for vertical positions and improved control of the weld pool.
DC Lift TIG	Source capability for DC TIG with contact ignition and the appropriate torch equipment.
Arc gouging	Carbon-electrode gouging: up to 6.4mm on 400 CC/CV; up to 6.5mm on FLEX.
Workshop MIG-MAG	400 CC/CV + EXAFEED 4L for solid or cored wire with full feeder-front control.
Portable MIG-MAG	Source + NOMADFEED 425-4 CC/CV for work away from a fixed workshop position.
HF DC TIG	400 CC/CV + EXATIG adds non-contact ignition, gas control and enhanced TIG functions.

THE ACCESSORY DEFINES THE COMPLETE SYSTEM.

The source is supplied without welding accessories. MIG feeders, torches, interconnections, cooling and HF TIG equipment are selected separately. Pulsed operation is available for MMA and, with EXATIG connected to the 400 CC/CV, for DC TIG.

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CHOOSE THE SOURCE FOR YOUR SUPPLY.

EXAGON 400 CC/CV / REF. 010925 / EXAGON 400 FLEX CC/CV / REF. 069718



400 CC/CV



400 FLEX CC/CV

Specification	400 CC/CV	400 FLEX CC/CV
Supply	400V three-phase, +/-15%	Single- or three-phase; FLEX input envelope 190-600V
Rated supply bands	400V three-phase	208-380V or 380-525V
Fuse, rated bands	32A delayed / slow-blow	63A at 208-380V; 32A at 380-525V
MMA current range	20-400A	20-300A single-phase / 20-400A three-phase
DC TIG current range	10-400A	10-300A single-phase / 10-400A three-phase
MIG-MAG current range	15-400A	15-300A single-phase / 15-400A three-phase
Maximum-output duty cycle / 40°C	400A at 60%	300A at 40% single-phase; 400A at 60% three-phase
Current at 100% duty cycle / 40°C	350A	220A single-phase / 350A three-phase
Open-circuit voltage / VRD	84V / reduced to below 35V	85V / reduced to below 35V
Dimensions (L x W x H)	580 x 520 x 300mm	660 x 510 x 300mm
Source weight / protection	32kg / IP23	40kg / IP23
Generator recommendation	30kW / 36kVA	36kVA

FLEX output and protection depend on the connected phase and voltage. R H Davey can match the system to your available supply. Source weights exclude feeders, cooling units and accessories.

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DIRECT SETTINGS. CONTROLLED REPEATABILITY.

VISIBLE DISPLAYS / LARGE CONTROLS / PROGRAM MEMORY / INDUSTRIAL PROTECTION



TWO CONTROLS. THE SETTINGS YOU NEED.

Control	MMA / TIG	MIG-MAG / gouging
Primary adjustment	Welding current	Welding voltage
Secondary adjustment	ArcForce in MMA	Inductance in MIG-MAG

STORE REPEAT JOBS

Store up to 50 settings or programmes per process for recurring work.

OPERATOR ACCESS

Large knobs suit gloved hands. The display remains readable in bright working conditions.

PROTECT SETTINGS

Lockable controls help avoid unintended changes. Optional remote controls extend access at the work area.

DESIGNED FOR DEMANDING WORKING AREAS.

Reinforced metal panels, rubber protection and steel handles support regular movement. The 400 CC/CV uses a protected ventilation corridor; FLEX adds on-demand ventilation, PFC and broad supply compatibility. Both provide a VRD function that reduces open-circuit voltage.

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WORKSHOP MIG. FULL CONTROL AT THE FEEDER.

EXAFEED 4L / REF. 032408 / FOR EXAGON 400 CC/CV





EXAFEED 4L

A dedicated four-roll feeder for workshop MIG-MAG on the EXAGON 400 CC/CV. Front-panel voltage, wire-speed and inductance adjustment keep the main controls close to the welding position.

Specification / function	EXAFEED 4L
Duty cycle at 40°C	500A at 60% / 400A at 100%
Drive / wire speed	Four driven rolls, electronically regulated 100W motor / 1-22m/min
Wire range	Solid steel / stainless: 0.8-1.6mm; flux-cored: 0.9-2.4mm
Spools / supplied rollers	200mm and 300mm / 1.0-1.2mm rollers
Supply / torch compatibility	48V-2A and 24V-1A / air- or water-cooled; push-pull 24/42V
Trigger & spot modes	2T / 4T; SPOT and SPOT-DELAY
Advanced settings	Pre-gas, Hotstart, Creep speed, Burnback and Post-gas
Operator features	50 memories, current/voltage display, lockable keypad and internal LED light
Dimensions / weight / protection	675 x 300 x 230mm / 19kg / IP23

Optional interconnections up to 20m, remote adjustment, wheel kits, support pads and slinging support allow the feeder to be positioned for the application. Ratings of the complete welding system also depend on source, torch and cooling.

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PORTABLE MIG FOR LARGE WORK AREAS.

NOMADFEED 425-4 CC/CV / REF. 036291 / EXAGON & EXAGON FLEX





PUT THE FEEDER CLOSER TO THE JOINT.

NOMADFEED adds portable solid- and flux-cored-wire MIG-MAG capability to EXAGON and EXAGON FLEX, allowing the feeder to move closer to the weld on large structures and assemblies.

Component	Purpose / selection detail
NOMADFEED 425-4 CC/CV	Four-roll portable feeder for 10/15kg wire reels; weight 16kg.
EXAGON 400 CC/CV	400V three-phase source: 400A at 60%, 350A at 100%.
EXAGON 400 FLEX CC/CV	Single- or three-phase flexibility, PFC and FLEX technology. Output depends on phase and supply.
NOMADCABLE	10m power interconnection option, ref. 032446.
JOBSITE XL	Sack-truck option, ref. 039568, for moving the selected source configuration.

PLAN THE REACH

Choose the cable run and work-area layout for the structure or assembly.

MATCH THE POWER

A FLEX single-phase supply provides a different output and duty cycle from three-phase operation.

BUILD THE PACKAGE

Source, feeder, cable, MIG torch, gas equipment and return lead are selected together.

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ADD HF TIG. MANAGE THE COMPLETE CYCLE.

EXATIG / REF. 013780 / OPTIMISED FOR EXAGON 400 CC/CV





NON-CONTACT STARTING. CONTROLLED GAS FLOW.

EXATIG is a DC TIG HF unit powered from the welding source. With the EXAGON 400 CC/CV connection, it provides HF or Lift starting, gas synchronisation, torch management and DC pulse functionality.

Function / specification	EXATIG
TIG modes with EXAGON 400 CC/CV	DC continuous and DC pulse; HF non-contact or Lift contact ignition
Trigger / torch control	2T / 4T; automatic torch detection; potentiometer-torch remote current adjustment
Cycle adjustments	Pre/post-gas, rise time, welding current, hot/cold current, pulse frequency and fading time
Integrated flowmeter	Argon flow adjustment from 5 to 25L/min
Input / auxiliary supply	14-100V from source; no separate auxiliary power cable required
Duty cycle at 40°C	400A at 25%; 270A at 60%; 220A at 100%
Dimensions / weight	340 x 260 x 160mm / 6.5kg; transport-case dimensions 450 x 350 x 200mm / 8kg

CHECK THE COMPLETE TIG SYSTEM RATING.

EXATIG has its own duty-cycle limits. The power source's 400A at 60% rating does not make the EXATIG-based TIG system a 400A at 60% system.

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COMPLETE THE SYSTEM WITH R H DAVEY.

COOLING / INTERCONNECTIONS / TRANSPORT / REMOTE CONTROL



EXACOOL / 032422



TROLLEY / 077522



REMOTE OPTIONS

Component	Key details
EXACOOL cooling unit	1kW capacity; 5.5L reservoir; maximum pressure 4 bar. 400V supply, 5A delayed fuse. 680 x 300 x 230mm; 17kg empty; IP23.
Workshop transport	Trolley ref. 077522; JOBSITE XL sack truck ref. 039568. Select the transport equipment for the configured system.
Remote adjustment	FLEX: RC-HA1, 8m, ref. 045675; RC-FA1 foot control, 4m, ref. 045682. EXAFEED: 10m cabled control, ref. 047679.

EXAFEED INTERCONNECTION OPTIONS

Length / cable section	Air-cooled reference	Water-cooled reference
1.8m / 70mm²	-	037243
5m / 70mm²	047587	047617
10m / 70mm²	047594	047624
10m / 95mm²	047600	047631
15m / 95mm²	038349	038448
20m / 95mm²	038431	038455

LET'S BUILD YOUR EXAGON PACKAGE.

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Technical information and photography: supplied GYS Exagon brochure and model data sheets 010925, 069718, 013780 and 032408. Specifications and package contents may change. Accessories are optional unless specified.

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