



- Multiprocess inverter welding machine (MIG-MAG/FLUX/BRAZING/MMA/TIG DC-Lift and GOUGING) with external 4-roller wire feeder, 400A. 3ph 230/400V power supply.
- OneTouch synergic adjustment. 40 preset synergic curves.
- LCD display of the wire speed, welding voltage and current. 2/4 times, spot operating selection.
- MMA: direct and pulse current (MMA PULSE) operation. VRD device.
- Gouging process. TIG-DC Lift.
- Particular construction of the ventilation system which, following a dedicated tunnel, allows preservation of the electronic components from dirt and dust.
- Strong, resistant to impact and dust; reduced weight and size. High energy savings.

## TECHNICAL DATA

CODE	<b>816906</b>	CURRENT CONTROL RANGE 230V DC	<b>20 - 320 A</b>	FLUX CORED WELDING WIRE DIA.	<b>0,8 - 1,6 mm</b>
THREEPHASE MAINS VOLTAGE	<b>230 / 400 V</b>	CURRENT 60% DC 230V	<b>240 A</b>	BRAZING WIRE DIAM.	<b>0,8 - 1,2 mm</b>
MAINS TOLERANCE	<b>-25 / +15 %</b>	CURRENT 100% DC 230V	<b>200 A</b>	WIRE COIL DIMENSION A Min-Max	<b>200 - 300 mm</b>
MAINS FREQUENCY	<b>50 / 60 Hz</b>	MAX ABSORBED CURRENT 230V	<b>38 A</b>	FEED ROLLS	<b>2 + 2</b>
MAX CURRENT DC EN60974-1	<b>400 @ 40% A</b>	MAX DC NO LOAD VOLT. 230V	<b>106 V</b>	FEED ROLLS TYPE	<b>S</b>
CURRENT CONTROL RANGE DC	<b>20 - 400 A</b>	RANGE VOUT MIG 230V	<b>10 - 30 V</b>	FEED ROLLS Ø	<b>30 mm</b>
CURRENT 60% DC	<b>300 A</b>	MAX ABSORBED POWER 230V	<b>11 kW</b>	WIRE SPEED RANGE	<b>1,5 - 20 m/min</b>
CURRENT 100% DC	<b>250 A</b>	FUSE 230V	<b>32 A</b>	SUPPLY CABLE LENGTH	<b>2,5 m</b>
MAX ABSORBED CURRENT	<b>31 A</b>	ABSORBED POWER idle	<b>34 W</b>	ELECTROMAGN. COMPATIBLE CLASS	<b>A</b>
MAX DC NO LOAD VOLTAGE	<b>73 V</b>	EFFICIENCY	<b>89 %</b>	NORM	<b>EN 60974-1 /-5 /-10</b>
RANGE V OUT MIG	<b>10 - 34 V</b>	ELECTRODES Ø	<b>1,6 - 6 mm</b>	INSULATION CLASS	<b>F</b>
MAX ABSORBED POWER	<b>16 kW</b>	STEEL WELDING WIRE DIAMET.	<b>0,6 - 1,6 mm</b>	PROTECTION DEGREE	<b>IP23</b>
FUSE	<b>25 A</b>	INOX WELDING WIRE DIAMETER	<b>0,8 - 1,6 mm</b>	DIMENSIONS (LxWxH)	<b>54,6 x 27,4 x 86 cm</b>
MAX CURRENT DC EN60974-1 230V	<b>300 @ 40% A</b>	ALUM. WELDING WIRE DIAM.	<b>0,8 - 1,6 mm</b>	WEIGHT	<b>39 kg</b>

## OPTIONAL ACCESSORIES

### ELECTRODE HOLDERS WITH CABLE

804124 ELECTRODE HOLDER + CABLE 35MMQ 4M AX50

### GOUGING ACCESSORIES

802666 GOUGING KIT

### OTHER ACCESSORIES

804318 WHEELS KIT LINEAR i /SUPERMIG i

### GAS REGULATORS

722346 GAS REGULATOR 2 MANOMETERS 32 L/min

804208 QUICK GAS CONNECTOR

### MIG/MAG WELDING KITS

804397 ALUMINIUM WELDING KIT D. 1-1,6 MM

804398 FLUX CORED WIRE WELDING KIT D. 1-1,6 MM

### MIG TORCHES

742187 MT36 MIG TORCH 4M

742188 MT36 MIG TORCH 5M

### WIRE FEEDERS AND ACCESSORIES

802486 COIL ADAPTOR B-300

### MIG CONNECTION CABLES

802348 CONNECTING CABLE 70MMQ 4M 14 POLES

802349 CONNECTING CABLE 70MMQ 10M 14 POLES

### TIG TORCHES

742058 ST26V 4M AX50 TIG TORCH

### TROLLEYS AND ACCESSORIES

803091 TROLLEY - FEDERAL

## DESCRIPTION

MIG-MAG/FLUX/BRAZING/MMA and TIG DC-Lift multiprocess inverter welding machine, with 4-rolls, separate wire feeder. Flexibility of use with different materials (steel, stainless steel, high-strength steel, aluminium, etc.) and wide variety of fields of application (industry, metalwork, construction, etc.). Particularly resistant to dirt and dust thanks to the special construction of the ventilation system which, following a dedicated tunnel, preserves the electronic components, guaranteeing a longer life. The fast SYNERGIC adjustment of the welding parameters thanks to the "ONE TOUCH" technology, makes the product very easy to use. Just set the material thickness and start welding. The intelligent and automatic control of the arc, moment by moment, maintains high welding performance in all working conditions, with different materials and/or gases. The operator can also intervene manually along the arc length: this adjustment means the weld seam can be modified according to the welder's style. The graphic display allows a clear view of the main welding parameters and product settings. The ATC technology, Made in Telwin, allows excellent welds on thin surfaces to be obtained with great ease thanks to advanced arc control. The 4-roll- wire feeder with 4m long cables (direct connection), robust and transportable, allows for remote control of the power source. Electrode welding is possible in both direct and pulse current modes. The pulse mode (MMA Pulse) is recommended for basic electrodes and positional welding and guarantees less spatter and rework and higher weld quality. The GOUGING function is available with carbon electrodes. Light weight and compactness also ensure easy portability to all locations, both indoors and outdoors.

#### **Features:**

- robust, impact and dust resistant;
- reduced weight and dimensions;
- high energy saving;
- backlit LCD display

#### **MIG-MAG**

- operating modes: manual and synergic;
- 40 pre-set synergic curves;
- LCD display of wire speed, welding voltage and current;
- selection of 2/4 time operation, spot;
- adjustments: wire upslope, electronic reactance, wire burn back time, post gas;
- ATC
- adjustments from the wire feeder unit: manual wire feed, weld bead adjustment, wire feed speed (MAN mode) and welding power (SYN mode);
- possibility of connecting semi-automatic wire feeder units (CV).

#### **MMA**

- DC and pulse current operation mode (MMA PULSE);
- MMA adjustments: hot start, arc force;
- antistick protection;
- VRD device;
- visualization on LCD display of voltage and welding current.

#### **TIG**

- LIFT DC striking and visualization on LCD display of voltage and welding current.

## GOUGING

- Gouging function with visualization on LCD display of gouging voltage and current.

Protections: thermostat, overvoltage (+15%), undervoltage (-25%), overcurrent, motor-generator.

**Complete with MIG-MAG torch, work cable and clamp, wire feeder unit with connecting cables.**

## DOWNLOAD

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CATALOG IMAGE



INSTRUCTION MANUAL



SPARE PARTS LIST



BROCHURE



CERTIFICATE

## USEFUL LINKS

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VIDEO