



WELDING AND CUTTING MACHINES



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Magmaweld is a manufacturer of Stick Electrodes, MIG/MAG & TIG Wires, Flux Cored Wires, Submerged-Arc Wires and Fluxes, Welding Machines, Welding Ancillary Products and Automation Systems in Turkey. Oerlikon Kaynak Elektrodları ve Sanayi A.Ş. was founded in 1957 in order to manufacture stick electrodes as a licensee of Oerlikon-Buehrle AG.



Welding Consumables Factory
Organize Sanayi Bölgesi 2. Kısım, Manisa, Turkey



Welding Machines and Automation Factory
Organize Sanayi Bölgesi 5. Kısım, Manisa, Turkey

In the year 1996, in order to reduce costs, to strengthen the leading position in Turkey and turn Magmaweld into a global brand, two old factories in Istanbul were moved to new, state of the art factory in Manisa, situated in the west of Turkey. In 2010 the second factory has been opened also in Manisa to produce high-tech welding equipment as well as to integrate robotic automation systems.

The MAGMAWELD brand came out as an analogy between the molten core of the earth, the MAGMA and the WELDPPOOL.

Magmaweld greatly values technical education and has been contributing to the training and education of thousands of welders through regular, free of charge courses since 1961. This service helps to increase consumer awareness and technical competence throughout the industry.

Magmaweld strives for customer satisfaction and process excellence. In order to satisfy customer needs, all questions and remarks about products, training, welding technologies, welding procedures, standards, work safety and automation are processed through the call center at +90 444WELD (4449353) or through live support from www.magmaweld.com where the relevant information is directed to Magmaweld's experts.

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Portable Stick Electrode (MMA) Welding Machines

proSTICK 200i

Inverter Technology for Professionals



Steels
Stainless Steels
Cast Irons
Aluminium Alloys
Copper Alloys
Nickel Alloys



- Operates with 1 Phase 230V-50/60 Hz mains voltage and generators over 10 kVA, tolerates voltage fluctuations up to 15%. Auto-Protection against low and high input voltages.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- Offers excellent welding performance with all types of electrodes, including cellulosic and aluminum.
- Advanced options; **Hot Start** for easy ignition, **Arc Force** for arc stability, **Anti Stick** to prevent electrode sticking and **Interval Timer** for Spot welding.
- **VRD** for hazardous environments such as mines.
- TIG welding on even thin metals due to its stable low currents with **Lift TIG** arc ignition.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- **Smart Fan** dynamically regulates the cooling performance in accordance with the heating of the appliance.
- **Smart Thermic Protection** continuously monitors the inner temperature and if necessary stops the machine before the thermic switch.
- Portable lightweight design but withstands tough working conditions.
- Designed also for outdoor use, protection class is IP 23.
- Standard accessories come with the machine.



EN 60974-1

EN 60974 -10

RoHS

proSTICK 200i	
Mains Voltage (1-phase)	230 V - 50/60Hz
Rated Power	9.7 kVA
Duty Cycle Rate (25°C)	%35
EN 60974 -1 (I/X%)	200/14
Welding Current Range	5 - 200 ADC
Rated Welding Current	200 ADC
Open Circuit Voltage	85 VDC
Stick Electrode Diameter Range	1.60 - 5.00 mm
Dimensions (l x w x h)	440 x 155 x 310 mm
Weight	12.5 kg
Protection Class	IP 23

Standard Accessories

Workpiece Clamp and Cable	7905201603 (16 mm ² - 3 m)
Electrode Clamp and Cable	7906201603 (16 mm ² - 3 m)

Optional Accessories

Lava TIG 20V (4 m) TIG Torch	7111020004
Lava TIG 20V (8 m) TIG Torch	7111020008

Portable Stick Electrode (MMA) Welding Machines

monoSTICK 165i, 200i

Inverter Technology for Workshops and Construction Sites



Steels
Stainless Steels



- Operates with 1 Phase 230V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- Excellent welding characteristics for rutile and basic electrodes.
- Current adjustment scale by electrode diameters, digital display on monoSTICK 200i for easy parameter selection.
- Scratch TIG welding with a valve-torch.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Designed also for outdoor use, protection class is IP 23.
- Portable lightweight design but withstands tough working conditions.
- Resists against tipping over scaffolds due to its wider base.
- Fan cooling and thermal protection against overheating.
- Standard accessories come with the machine.

	monoSTICK 165i	monoSTICK 200i
Mains Voltage (1-phase)	230 V - 50/60Hz	230 V - 50/60Hz
Rated Power	7.7 kVA	9.7 kVA
Duty Cycle Rate (25°C)	%35	%35
EN 60974 -1 (I/X%)	160/20	200/14
Welding Current Range	10 - 160 ADC	10 - 200 ADC
Rated Welding Current	160 ADC	200 ADC
Open Circuit Voltage	65 VDC	65 VDC
Stick Electrode Diameter Range	1.60 - 3.25 mm	1.60 - 4.00 mm
Dimensions (l x w x h)	467 x 160 x 312 mm	467 x 160 x 312 mm
Weight	7.5 kg	10.5 kg
Protection Class	IP 23	IP 23
Digital Display	-	√

Standard Accessories

Workpiece Clamp and Cable	7905201603 (16 mm ² - 3 m)
Electrode Clamp and Cable	7906201603 (16 mm ² - 3 m)



EN 60974-1

EN 60974 -10

RoHS

Portable Stick Electrode (MMA) Welding Machines

miniSTICK, megaSTICK

Inverter Technology for Small Workshops



Steels
Stainless Steels

- Operates with 1 Phase 230V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- Excellent welding characteristics for rutile and basic electrodes.
- Current adjustment scale by electrode diameters, digital display on megaSTICK for easy parameter selection.
- It has the **smallest size and weight** of its product family, it can easily be carried or hung by a shoulder strap.
- Scratch TIG welding with a valve-torch.
- Stable welding current without loss of performance due to electric line fluctuations or with longer welding and electrical cables.
- Designed also for outdoor use, protection class is IP 23.
- Fan cooling and thermal protection against overheating.
- Standard accessories come with the machine.



	miniSTICK	megaSTICK
Mains Voltage (1-phase)	230 V - 50/60Hz	230 V - 50/60Hz
Rated Power	6.83 kVA	9.7 kVA
Duty Cycle Rate (25°C)	%70	%30
EN 60974 - 1 (I/X%)	140/15	200/14
Welding Current Range	5 - 140 ADC	5 - 200 ADC
Rated Welding Current	140 ADC	200 ADC
Open Circuit Voltage	75 VDC	75 VDC
Stick Electrode Diameter Range	1.60 - 3.25 mm	1.60 - 4.00 mm
Dimensions (l x w x h)	360 x 120 x 200 mm	360 x 120 x 200 mm
Weight	4.25 kg	4.9 kg
Protection Class	IP 23	IP 23
Digital Display	-	√



Standard Accessories	Ministick Deluxe	Ministick	Megastick Deluxe	Megastick
Workpiece Clamp and Cable	7905101602 (16 mm ² - 2 m)	7905101602 (16 mm ² - 2 m)	7905102502 (25 mm ² - 2 m)	7905102502 (25 mm ² - 2 m)
Electrode Clamp and Cable	7906101602 (16 mm ² - 2 m)	7906101602 (16 mm ² - 2 m)	7906102502 (25 mm ² - 2 m)	7906102502 (25 mm ² - 2 m)
Wire Brush / Hammer	8369000175	-	8369000175	-
Hand Mask	8502301007	-	8502301007	-
Electrode	11101HAEM1	-	11101NAEM1	-
Product Code	501M1500MF	501M1400MF	501M2001MF	501M2000MF



EN 60974-1

EN 60974 -10

RoHS

Industrial Stick Electrode (MMA) Welding Machines

ID Series

Inverter Technology for Construction Sites



Steels
Stainless Steels
Cast Irons
Aluminium Alloys
Copper Alloys
Nickel Alloys



- Operates with 3 Phase 400V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- Excellent welding characteristics for Rutile, Basic and Cellulosic electrodes.
- Welding current is adjusted precisely by the potentiometer knob on the front panel or by the remote control unit. Preset values and welding current and voltage values are digitally monitored from the front panel.
- Advanced options; **Hot Start** for easy ignition, **Arc Force** for arc stability, **Anti Stick** to prevent electrode sticking
- Scratch TIG welding with a valve-torch.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Fan cooling and thermal protection against overheating.
- Suitable for mobile use with optional trolley or rack systems to group 4, 6 or 9 machines.
- Standard accessories come with the machine.



EN 60974-1

EN 60974 -10

RoHS

	ID 250E	ID 300E	ID 350E	ID 400E
Mains Voltage (3-phase)	400 V / 50 - 60 Hz	400 V / 50 - 60 Hz	400 V / 50 - 60 Hz	400 V / 50 - 60 Hz
Rated Power	13 kVA (%35)	16.1 kVA (%30)	19.6 kVA (%35)	22.9 kVA (%35)
Welding Current Range	5 - 250 ADC	5 - 300 ADC	5 - 350 ADC	5 - 400 ADC
Rated Welding Current	250 ADC (%35)	300 ADC (%30)	350 ADC (%35)	400 ADC (%35)
Open Circuit Voltage	85 VDC	85 VDC	86 VDC	86 VDC
Stick Electrode Diameter Range	1.60 - 5.00 mm	1.60 - 5.00 mm	1.60 - 5.00 mm	1.60 - 6.00 mm
Dimensions (l x w x h)	526 x 250 x 408 mm	526 x 250 x 408 mm	585 x 307 x 515 mm	585 x 307 x 515 mm
Weight	21 kg	21 kg	32 kg	32 kg
Protection Class	IP 21	IP 21	IP 21	IP 21

Standard Accessories

Workpiece Clamp and Cable	7905212503 (25 mm ² - 3 m)	7905212503 (25 mm ² - 3 m)	7905203503 (35 mm ² - 3 m)	7905203503 (35 mm ² - 3 m)
Electrode Clamp and Cable	7906202503 (25 mm ² - 3 m)	7906202503 (25 mm ² - 3 m)	7906203503 (35 mm ² - 3 m)	7906203503 (35 mm ² - 3 m)

Optional Accessories

Remote Control 10m	7900000210	7900000210	7900000210	7900000210
Remote Control 20m	7900000220	7900000220	7900000220	7900000220
Remote Control 30m	7900000230	7900000230	7900000230	7900000230
Remote Control 40m	7900000240	7900000240	7900000240	7900000240
Remote Control 50m	7900000250	7900000250	7900000250	7900000250
Transport Trolley	7900000600	7900000600	7900000600	7900000600
Rack (4, vertical)	7900000804	7900000804	7900000804	7900000804
Rack (6, vertical)	7900000807	7900000807	7900000807	7900000807
Rack (9, vertical)	7900000809	7900000809	7900000809	7900000809
Lava TIG 20V (4 m) TIG Torch	7111020004	7111020004	7111020004	7111020004
Lava TIG 20V (8 m) TIG Torch	7111020008	7111020008	7111020008	7111020008



Transport Trolley



Rack



Remote Control

Industrial Stick Electrode (MMA) Welding Machines

RD 500E, RD 650E

Thyristor Technology for Challenging Applications



Steels
Stainless Steels
Cast Irons
Aluminium Alloys
Copper Alloys
Nickel Alloys

- Operates with 3 Phase 400V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 10%.
- Excellent welding characteristics for Rutile, Basic, Cellulosic electrodes up to 6.0 mm. and high carbon gauging performance up to 13mm with RD 650E model.
- Welding current is adjusted by the potentiometer knob on the front panel or by the remote control box. Set values and Real values of current and voltage during welding are digitally monitored from the front panel.
- Advanced Stick Electrode options; **Hot Start** for easy ignition, **Arc Force** for arc stability, **Anti Stick** to prevent electrode sticking.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Due to its large wheels and telescopic arms, easy mobility on rough ground conditions.
- Fan cooling and thermal protection against overheating.
- Standard accessories come with the machine.



	RD 500E	RD 650E
Mains Voltage (3-phase)	400 V / 50 - 60 Hz	400 V / 50 - 60 Hz
Rated Power	42.9 kVA (25%)	47.1 kVA (40%)
Welding Current Range	10 - 500 ADC	10 - 650 ADC
Rated Welding Current	500 ADC (25%)	650 ADC (40%)
Open Circuit Voltage	85 VDC	78 VDC
Stick Electrode Diameter Range	2.00 - 6.00 mm	2.00 - 6.00 mm
Largest Carbon Electrode Diameter	8.00 mm	13.00 mm
Dimensions (l x w x h)	830 x 670 x 760 mm	830 x 670 x 760 mm
Weight	205 kg	215 kg
Protection Class	IP 21	IP 21

Standard Accessories

Workpiece Clamp and Cable	7905305003 (50 mm ² - 3 m)	7905307003 (70 mm ² - 3 m)
Electrode Clamp and Cable	7906305005 (50 mm ² - 5 m)	7906307005 (70 mm ² - 5 m)

Optional Accessories

Remote Control 10m	7900000210
Remote Control 20m	7900000220
Remote Control 30m	7900000230
Remote Control 40m	7900000240
Remote Control 50m	7900000250
Carbon Gouging Clamp	7908201000

Carbon Gouging Clamp



EN 60974-1

EN 60974 -10

RoHS

Industrial Stick Electrode (MMA) Welding Machines

TD 355, GL 451, GL 600

Magnetic Current Adjustment Technology
for Remote Construction Sites



Steels
Stainless Steels
Cast Irons
Aluminium Alloys
Copper Alloys
Nickel Alloys



- Operates with 3 Phase 400V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 10%.
- Excellent welding characteristics for Rutile, Basic and Cellulosic electrodes and high carbon gauging performance with GL models.
- Possible to work with long welding cables.
- Current adjustment by turning handles and adjusted value is monitored through mechanical scales.
- Contains no electronic component, servicing is easy.
- Due to its large wheels and telescopic arms, easy mobility on rough ground conditions.
- Fan cooling and thermal protection against overheating.
- Standard accessories come with the machine.

	TD 355	GL 451	GL 600
Mains Voltage (3-phase)	400 V / 50 - 60 Hz	400 V / 50 - 60 Hz	400 V / 50 - 60 Hz
Rated Power	20 kVA (%35)	27 kVA (%35)	35 kVA (%35)
Welding Current Range	60 - 350 ADC	60 - 450 ADC	90 - 600 ADC
Rated Welding Current	320 ADC (%35)	450 ADC (%35)	600 ADC (%35)
Open Circuit Voltage	54 - 64 VDC	73 VDC	72 VDC
Stick Electrode Diameter Range	2.00 - 5.00 mm	2.50 - 6.00 mm	3.25 - 6.00 mm
Largest Carbon Electrode Diameter	-	8.00 mm	10.00 mm
Dimensions (l x w x h)	950 x 660 x 650 mm	920 x 660 x 900 mm	920 x 660 x 900 mm
Weight	125 kg	228 kg	244 kg
Protection Class	IP 21	IP 21	IP 21

Standard Accessories

Workpiece Clamp and Cable	7905203503 (35 mm ² - 3 m)	7905305003 (50 mm ² - 3 m)	7905407003 (70 mm ² - 3 m)
Electrode Clamp and Cable	7906203505 (35 mm ² - 5 m)	7906305005 (50 mm ² - 5 m)	7906407005 (70 mm ² - 5 m)

Optional Accessories

Carbon Gouging Clamp	-	7908201000	7908201000
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Carbon Gouging Clamp



Diesel Welding Generators

MPM Series



Steels
Stainless Steels
Cast Irons
Aluminium Alloys
Copper Alloys
Nickel Alloys



- Water cooled diesel engine generator set designed for welding, whereas it can be used as a normal generator with standard outputs 400V/50 Hz (3~), 230V/50 Hz (1~). Optionally, a 48V/110V output is also available.
- In addition to Rutile, Basic and Cellulosic coated electrode welding, Carbon Cutting, TIG (Lift TIG) and MIG/MAG welding with optional wire feeding unit are also possible.
- Welding current can be adjusted through the potentiometer on the front panel and also with the wired remote control.
- Current, voltage, fuel level and operating time indicators are on the front panel.
- No loss of performance with long welding cables.
- Especially designed for outdoor use, protection class is IP23.
- Ignites with a 12V internal battery and switches to idle position automatically when there is no load.
- Warnings are; low fuel level, low oil pressure, battery charge failure and protections are; against current leakage and overheating.
- Standard accessories come with the machine.
- Trailer is Optional.



EN 60974-1

EN 60974 -10

RoHS

Motor	MPM 15/400 I-KA	MPM 500 P	MPM 20/500 P
Type	Kubota D1105-E	Perkins 404D - 22G	Perkins 1103 A-33G1
Power	28 HP (20.6 kVA)	32.4 HP (23.50 kVA)	40.8 HP (30kVA)
Total Cylinder Capacity	1123 cm ³	2216 cm ³	3300 cm ³
Number of Cylinders	3	4	3
Cooling Type	Water	Water	Water
Operation Type	Electricity	Electricity	Electricity
Fuel Type	Diesel	Diesel	Diesel
Fuel Consumption	4.9 lt / h (%75)	4 lt / h (75%)	5.4 lt / h (%75)
Fuel Tank Volume	38 lt	70 lt	74 lt
Dimensions (l x w x h)	1590 x 730 x 920 mm	1855 x 737 x 1119 mm	2000 x 900 x 1200 mm
Weight	450 kg	895 kg	1080 kg

Generator			
Type	GenSet Asynchronous Brushless	GenSet Asynchronous Brushless	GenSet Asynchronous Brushless
Maximum Power (1 Phase)	10 kVA - 230 V AC	10 kVA - 230 V AC	12 kVA - 230 V AC
Maximum Power (3 Phase)	15 kVA - 400 V AC	17 kVA - 400 V AC (Op.)	20 kVA - 400 V AC
Power Factor	0.80	0.80	0.80

Welding Circuit			
Rated Welding Current	400 A - 35 V DC (%30)	500 A - 30 V DC (%40)	500 A - 40 V DC (%60)
Welding Current Range	30 - 400 A DC	30 - 500 A DC	30 - 500 A DC
Maximum Open Circuit Voltage	70 V DC	70 V DC	70 V DC
Stick Electrode Diameter Range	2.00 - 6.00 mm	2.00 - 6.00 mm	2.00 - 6.00 mm
Largest Carbon Electrode Diameter	6 mm	8 mm	10 mm

Accessories			
Workpiece Clamp and Cable	7905305003 (50 mm ² - 3 m)	7905407003 (70 mm ² - 5m)	7905407003 (70 mm ² - 5m)
Electrode Clamp and Cable	7906305005 (50 mm ² - 5 m)	7906407005 (70 mm ² - 5m)	7906407005 (70 mm ² - 5m)
Remote Control (Standard)	7950000009 (20 m)	7950000009 (20 m)	7950000009 (20 m)
Terminal Replacement Kit (Optional)	7950000007	7950000007	7950000007
Trailer (Optional)	7950000005 (2 Wheel)	7950000006 (2 Wheel)	7950000004 (2 Wheel)

Product Codes



	Standard (With 230V Euro Type Mains Plug)	Without Mains Plug
miniSTICK	501M1400MF	-
miniSTICK Deluxe	501M1500MF	-
megaSTICK	501M2000MF	-
megaSTICK Deluxe	501M2001MF	-
monoSTICK 165i	501N1600MF	-
monoSTICK 200i	501N201DMF	-
proSTICK 200i	501P200DMF	-
ID 250E	-	5030250DM0
ID 300E	-	5030300DM0
ID 350E	-	5030350DM0
ID 400E	-	5030400DM0
RD 500E	-	502S500DM0
RD 650E	-	502S650DM0
TD 355	-	502M3500M0
GL 451	-	502M4500M0
GL 600	-	502M6000M0
MPM 15 - 400 IKA	-	550040W1G0
MPM 20 - 500 P	-	550050W3G0
MPM 500 P	-	550050W2G0

* Please contact for different plug types requests.

Stick Electrode (MMA) Welding Accessories



	Electrode Clamps	Grounding Pliers	Carbon Clamps	Remote Control	Transport Trolley	Rack
miniSTICK	7906101602 (16 mm ² - 2 m)	7905101602 (16 mm ² - 2 m)	-	-	-	-
megaSTICK	7906102502 (25 mm ² - 2 m)	7905102502 (25 mm ² - 2 m)	-	-	-	-
monoSTICK 165i	7906201603 (16 mm ² - 3 m)	7905201603 (16 mm ² - 3 m)	-	-	-	-
monoSTICK 200i	7906201603 (16 mm ² - 3 m)	7905201603 (16 mm ² - 3 m)	-	-	-	-
proSTICK 200i	7906201603 (16 mm ² - 3 m)	7905201603 (16 mm ² - 3 m)	-	-	-	-
ID 250E	7906202503 (25 mm ² - 3 m)	7905212503 (25 mm ² - 3 m)	-	7900000210 (10 m)	7900000600	7900000804 (4 items)
				7900000220 (20 m)		7900000806 (6 vertical)
				7900000230 (30 m)		7900000807 (6 horizontal)
				7900000240 (40 m)		7900000809 (9 items)
				7900000250 (50 m)		
ID 300E	7906202503 (25 mm ² - 3 m)	7905212503 (25 mm ² - 3 m)	-	7900000210 (10 m)	7900000600	7900000804 (4 items)
				7900000220 (20 m)		7900000806 (6 vertical)
				7900000230 (30 m)		7900000807 (6 horizontal)
				7900000240 (40 m)		7900000809 (9 items)
				7900000250 (50 m)		
ID 350E	7906203503 (35 mm ² - 3 m)	7905203503 (35 mm ² - 3 m)	-	7900000210 (10 m)	7900000600	7900000804 (4 items)
				7900000220 (20 m)		7900000806 (6 vertical)
				7900000230 (30 m)		7900000807 (6 horizontal)
				7900000240 (40 m)		7900000809 (9 items)
				7900000250 (50 m)		
ID 400E	7906203503 (35 mm ² - 3 m)	7905203503 (35 mm ² - 3 m)	-	7900000210 (10 m)	7900000600	7900000804 (4 items)
				7900000220 (20 m)		7900000806 (6 vertical)
				7900000230 (30 m)		7900000807 (6 horizontal)
				7900000240 (40 m)		7900000809 (9 items)
				7900000250 (50 m)		
RD 500E	7906305005 (50 mm ² - 5 m)	7905305003 (50 mm ² - 3 m)	7908201000	7900000210 (10 m)	-	-
				7900000220 (20 m)	-	-
				7900000230 (30 m)	-	-
				7900000240 (40 m)	-	-
				7900000250 (50 m)	-	-
RD 650E	7906307005 (70 mm ² - 5 m)	7905307003 (70 mm ² - 3 m)	7908201000	7900000210 (10 m)	-	-
				7900000220 (20 m)	-	-
				7900000230 (30 m)	-	-
				7900000240 (40 m)	-	-
				7900000250 (50 m)	-	-
TD 355	7906203505 (35 mm ² - 5 m)	7905203503 (35 mm ² - 3 m)	-	-	-	-
GL 451	7906305005 (50 mm ² - 5 m)	7905305003 (50 mm ² - 3 m)	7908201000	-	-	-
GL 600	7906407005 (70 mm ² - 5 m)	7905407003 (70 mm ² - 3 m)	7908201000	-	-	-

Portable TIG Welding Machines

monoTIG 220ip AC/DC

Inverter-Pulse Technology with Advanced Functions



Aluminium Alloys
Stainless Steels
Steels
Copper Alloys
Nickel Alloys



- Operates with 1 Phase 230V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Extra protection against extremely high or low supply voltages.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- TIG arc ignition by **HF** or **Lift TIG**.
- Excellent welding of thin metals due to very stable low current performance and pulse abilities.
- Balance adjustment of AC Current.
- Advanced TIG settings; **Pre-Gas, Slope-Up, Welding Current, Pulse Frequency and Width, Slope-Down, Post-Gas and Crater Filling.**
- Offers 100 JOB memory.
- Interval timer for spot welding.
- 2/4 Triggering and Current Adjustment via torch and foot pedal.
- Welding parameters are monitored on the digital display.
- Excellent welding characteristics for rutile and basic electrodes.
- Advanced Stick Electrode options; **Hot Start** for easy ignition, **Arc Force** for arc stability, **Anti Stick** to prevent electrode sticking.
- **VRD** for hazardous environments such as mines.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Portable design, withstands tough working conditions.
- Fan cooling and thermal protection against overheating.
- Standard accessories come with the machine.

NEW monoTIG 220ip AC/DC

Mains Voltage (1-phase)	230 V - 50/60Hz
Rated Power (MMA)	9.2 kVA (%15)
Rated Power (TIG)	8.05 kVA (%20)
Welding Current Range	3 - 220 ADC
Rated Welding Current	220 ADC (%20)
Open Circuit Voltage	87 VDC
Stick Electrode Diameter Range	2.00 - 5.00 mm
Tungsten Electrode Diameter Range	1.00 - 2.40 mm
Dimensions (l x w x h)	529 x 221 x 395 mm
Weight	16.5 kg
Protection Class	IP 21

Standard Accessories

Workpiece Clamp and Cable	7905201603 (16 mm ² - 3 m)
Gas Hose	790700002 (2 m)
Torch (Air Cooled 4 m)	7110018004

Optional Accessories

Electrode clamp and cable	7906201603 (16 mm ² - 3 m)
Gas Regulator	7020001004
Water Cooling Unit (CSP 40)	7910005200
Lava TIG 26 (8 m) Air Cooled TIG Torch	7110018008
Lava TIG 18W (4 m) Water Cooled TIG Torch	7110038004
Lava TIG 18W (8 m) Water Cooled TIG Torch	7110038008
TIG Accessory Set Air Cooled (Torch + Regulator)	7910000510
Water Cooled TIG Accessory Set (Torch + Regulator)	7910000530
Foot Pedal (On/Of)	7910000120
Foot Pedal (Current Adjustable)	7910000140
Transport Trolley	7910000100

**Trolley****Foot Pedal**

Portable TIG Welding Machines

monoTIG 160ip

Inverter Pulse Technology for Workshops

- Operates with 1 Phase 230V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- TIG arc ignition by **HF** or **Lift TIG**.
- Thin metal sheet welding due to its pulsing frequency up to 2 kHz.
- Advanced TIG settings; **Pre-Gas, Slope-Up, Welding Current, Pulse Frequency and Width, Slope-Down, Post-Gas and Crater Filling**.
- Offers 10 JOB memory.
- Triggering via torch as 2/4 or with foot pedal as On/Off.
- Welding parameters are monitored on the digital display.
- Excellent welding characteristics for rutile and basic electrodes.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Designed also for outdoor use, protection class is IP 23.
- Portable lightweight design but withstands tough working conditions.
- Fan cooling and thermal protection against overheating.
- Standard accessories come with the machine.



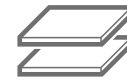
Stainless Steels
Steels



monoTIG 220ip

Inverter-Pulse Technology with Advanced Functions

- Operates with 1 Phase 230V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
Extra protection against extremely high or low supply voltages.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- TIG arc ignition by **HF** or **Lift TIG**.
- Excellent welding of thin metals due to very stable low current performance and pulse abilities.
- Advanced TIG settings; **Pre-Gas, Slope-Up, Welding Current, Pulse Frequency and Width, Slope-Down, Post-Gas and Crater Filling**.
- Offers 100 JOB memory.
- Interval timer for spot welding.
- 2/4 Triggering and Current Adjustment via torch and foot pedal.
- Welding parameters are monitored on the digital display.
- Excellent welding characteristics for rutile and basic electrodes.
- Advanced Stick Electrode options; **Hot Start** for easy ignition, **Arc Force** for arc stability, **Anti Stick** to prevent electrode sticking.
- **VRD** for hazardous environments such as mines.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Portable design, withstands tough working conditions.
- Fan cooling and thermal protection against overheating.
- Standard accessories come with the machine.



Stainless Steels
Steels
Copper Alloys
Nickel Alloys



EN 60974-1

EN 60974 -10

RoHS

	monoTIG 160ip	monoTIG 220ip
Mains Voltage (1-phase)	230 V - 50/60Hz	230 V - 50/60Hz
Rated Power (MMA)	7.6 kVA (%20)	9.2 kVA (%15)
Rated Power (TIG)	5.1 kVA (%30)	8.05 kVA (%20)
Welding Current Range	30 - 160 ADC	3 - 220 ADC
Rated Welding Current	160 ADC (%30)	220 ADC (%20)
Open Circuit Voltage	75 VDC	87 VDC
Stick Electrode Diameter Range	2.00 - 3.25 mm	2.00 - 5.00 mm
Tungsten Electrode Diameter Range	1.60 - 2.40 mm	1.00 - 2.40 mm
Dimensions (l x w x h)	515 x 160 x 312 mm	474 x 221 x 395 mm
Weight	10 kg	15.5 kg
Protection Class	IP 23	IP 21

Standard Accessories

Workpiece Clamp and Cable	7905201603 (16 mm ² - 3 m)	7905201603 (16 mm ² - 3 m)
Gas Hose	790700002 (2 m)	790700002 (2 m)
Torch (Air Cooled 4 m)	7110018004	7110018004

Optional Accessories

Electrode clamp and cable	7906201603 (16 mm ² - 3 m)	7906201603 (16 mm ² - 3 m)
Gas Regulator	7020001004	7020001004
Water Cooling Unit (CSP 40)	7910005200	7910005200
Lava TIG 26 (8 m) Air Cooled TIG Torch	7110018008	7110018008
Lava TIG 18W (4 m) Water Cooled TIG Torch	7110038004	7110038004
Lava TIG 18W (8 m) Water Cooled TIG Torch	7110038008	7110038008
TIG Accessory Set Air Cooled (Torch + Regulator)	7910000510	7910000510
Water Cooled TIG Accessory Set (Torch + Regulator)	7910000530	7910000530
Foot Pedal (On/Of)	7910000130	7910000120
Foot Pedal (Current Adjustable)	-	7910000140
Transport Trolley	7910000100	7910000100



Trolley



Foot Pedal

Portable TIG Welding Machines

monoTIG 160i monoTIG 200i

With HF Unit

- Operates with 1 Phase 230V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- TIG arc ignition by **HF** or **Lift TIG**.
- Thin metal sheet welding due to its stable low currents starting from 5 Ampere.
- Basic TIG settings; **Welding Current, Slope-Down, Post-Gas** and **Crater Filling**.
- Welding parameters are monitored on the digital display.
- Triggering via torch as 2/4 or with foot pedal as On/Off.
- Excellent welding characteristics for rutile and basic electrodes.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Designed also for outdoor use, protection class is IP 23.
- Portable lightweight design but withstands tough working conditions.
- Fan cooling and thermal protection against overheating.
- Standard accessories come with the machine.



Stainless Steels
Steels



monoTIG 160i Basic

Without HF Unit

- Operates with 1 Phase 230V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- Excellent welding characteristics for rutile and basic electrodes.
- TIG welding with **Lift TIG** arc ignition.
- TIG torch with trigger and foot pedal (On / Off) can be used.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Designed also for outdoor use, protection class is IP 23.
- Portable lightweight design but withstands tough working conditions.
- Fan cooling and thermal protection against overheating.
- Standard accessories come with the machine.



Stainless Steels
Steels



EN 60974-1

EN 60974 -10

RoHS

	monoTIG 160i Basic	monoTIG 160i	monoTIG 200i
Mains Voltage (1-phase)	230 V - 50/60Hz	230 V - 50/60Hz	230 V - 50/60Hz
Rated Power (MMA)	7.8 kVA (%20)	7.41 kVA (%30)	9.55 kVA (%25)
Rated Power (TIG)	5.2 kVA (%20)	5.01 kVA (%30)	6.69 kVA (%25)
Welding Current Range	10 - 160 ADC	5 - 160 ADC	5 - 200 ADC
Rated Welding Current	160 ADC (%20)	160 ADC (%30)	200 ADC (%25)
Open Circuit Voltage	20 - 65 VDC	65 VDC	65 VDC
Stick Electrode Diameter Range	1.60 - 3.25 mm	1.60 - 3.25 mm	2.00 - 4.00 mm
Tungsten Electrode Diameter Range	1.20 - 2.40 mm	1.20 - 2.40 mm	1.00 - 2.40 mm
Dimensions (l x w x h)	450 x 160 x 312 mm	520 x 160 x 312 mm	520 x 160 x 312 mm
Weight	9.5 kg	9.5 kg	10 kg
Protection Class	IP 23	IP 23	IP 23

Standard Accessories

Workpiece Clamp and Cable	7905201603 (16 mm ² - 3 m)	7905201603 (16 mm ² - 3 m)	7905201603 (16 mm ² - 3 m)
Electrode Clamp and Cable	7906201603 (16 mm ² - 3 m)	-	-
Gas Hose	790700002 (2 m)	790700002 (2 m)	790700002 (2 m)
Torch (Air Cooled 4 m)	7110018204	7110018004	7110018004

Optional Accessories

Water Cooling Unit (CSP 40)	7910005200	7910005200	7910005200
Gas Regulator	7020001004	7020001004	7020001004
Electrode clamps and cable	-	7906201603 (16 mm ² - 3 m)	7906201603 (16 mm ² - 3 m)
Lava TIG 26 (8 m) Air Cooled TIG Torch	-	7110018008	7110018008
Lava TIG 18W (4 m) Water Cooled TIG Torch	-	7110038004	7110038004
Lava TIG 18W (8 m) Water Cooled TIG Torch	-	7110038008	7110038008
TIG Accessory Set Air Cooled (Torch + Regulator)	-	7910000510	7910000510
Water Cooled TIG Accessory Set (Torch + Regulator)	-	7910000530	7910000530
Foot Pedal (On/Of)	7910000130	7910000130	7910000130
Trolley	7910000100	7910000100	7910000100



Trolley



Foot Pedal

Industrial TIG Welding Machines

ID Series

High Capacity Inverter-Pulse Technology
with Advanced Functions



Stainless Steels
Steels
Copper Alloys
Nickel Alloys



- Operates with 3 Phase 400V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- TIG arc ignition by **HF** or **Lift TIG**.
- Excellent welding of thin metals due to very stable low current performance and pulse abilities.
- Advanced TIG settings; **Pre-Gas, Slope-Up, Welding Current, Pulse Frequency and Width, Slope-Down, Post-Gas and Crater Filling**.
- Offers 10 JOB memory in 250 ampere and 300 ampere models, **100 JOB** memory in 500 ampere model.
- Interval timer for spot welding.
- 2/4 TrIGGERING and Current Adjustment via torch and foot pedal.
- Welding parameters are monitored on the digital display.
- Excellent welding characteristics for wide range of stick electrodes.
- Advanced Stick Electrode options; **Hot Start** for easy ignition, **Arc Force** for arc stability, **Anti Stick** to prevent electrode sticking.
- **VRD** for hazardous environments such as mines.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Optional gas cylinder platform with large wheels to ease mobility in workshops.
- Fan cooling and thermal protection against overheating.
- Standard accessories come with the machine.



EN 60974-1

EN 60974 -10

RoHS

Standard	ID 250 T DC	ID 300 T DC	
Pulsed	ID 250 T DC Pulse	ID 300 T DC Pulse	
Standard Water Cooled	ID 250 TW DC	ID 300 TW DC	
Pulsed Water Cooled	ID 250 TW DC Pulse	ID 300 TW DC Pulse	NEW ID 500 TW DC Pulse
Mains Voltage (3-phase)	400 V - 50/60 Hz	400 V - 50/60 Hz	400 V - 50/60 Hz
Rated Power (MMA)	13 kVA (%35)	16.1 kVA (%30)	25.88 kVA (%25)
Rated Power (TIG)	9.5 kVA (%35)	12.3 kVA (%30)	21.18 kVA (%30)
Welding Current Range	5 - 250 ADC	5 - 300 ADC	5 - 500 ADC
Rated Welding Current	250 ADC (%35)	300 ADC (%30)	500 ADC (%30)
Open Circuit Voltage	85 VDC	85 VDC	85 VDC
Stick Electrode Diameter Range	1.60 - 4.00 mm	1.60 - 5.00 mm	1.60 - 6.00 mm
Tungsten Electrode Diameter Range	1.00 - 2.40 mm	1.00 - 2.40 mm	1.00 - 4.00 mm
Dimensions (l x w x h)	598 x 252 x 661 mm	598 x 252 x 661 mm	514 x 290 x 629 mm
Weight (Power Source)	22.5 kg	22.5 kg	36.5 kg
Protection Class	IP 21	IP 21	IP 21

Cooling Unit

Cooling Capacity	2.07 kW	2.07 kW	2.07 kW
Power Absorbed from Mains	0.265 kVA	0.265 kVA	0.265 kVA
Current Absorbed from Mains	0.650 A	0.650 A	0.650 A
Dimensions	430 x 320 x 280 mm	430 x 320 x 280 mm	642 x 290 x 263 mm
Weight	23 kg	23 kg	22 kg

Standard Accessories

Workpiece Clamp and Cable	7905212503 (25 mm ² - 3 m)	7905203503 (35 mm ² - 3 m)	7905407003 (70 mm ² - 3 m)
Gas Hose	790700002 (2 m)	790700002 (2 m)	790700002 (2 m)
Lava TIG 26 (4 m) Air Cooled TIG Torch*	7110018004	7110018004	-
Lava TIG 18W (4 m) Water Cooled TIG Torch*	7110038004	7110038004	7110038004

* Torch selection is according to the cooling type of the machine.

Optional Accessories












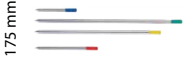
Electrode Clamp and Cable	7906202503 (25 mm ² - 3 m)	7906203503 (35 mm ² - 3 m)	7906207003 (70 mm ² - 3 m)
Lava TIG 26 (8 m) Air Cooled TIG Torch	7110018008	7110018008	-
Lava TIG 18W (8 m) Water Cooled TIG Torch	7110038008	7110038008	7110038008
Water Cooling Unit (CST 60i)	7910005250	7910005250	7910005250
Foot Pedal (On / Off)	7910000120	7910000120	7910000120
Foot Pedal (Current Adjustable)	7910000140	7910000140	7910000140
Torch Control Tools (2 Button / 4 Button)	7910000003/7910000004	7910000003/7910000004	7910000003/7910000004
Transport Trolley (4 Wheels)	7910000200	7910000200	7910000200
Gas Regulator (Argon)	7020001004	7020001004	7020001004
TIG Accessory Set Air Cooled (Torch + Regulator)	7910000510	7910000510	7910000510
Water Cooled TIG Accessory Set (Torch + Regulator)	7910000530	7910000530	7910000530

Product Codes



	Standard	Pulse
monoTIG 160i Basic	511016B2MF	-
monoTIG 160ip	-	511016P2MF
monoTIG 200	511020N2MF	-
monoTIG 220ip DC	-	511022P2LF
monoTIG 220ip AC/DC	-	515022P2MF
ID 250T DC	51302502M0	513025P2M0
ID 250TW DC	51322502M0	513225P2M0
ID 300T DC	51303002M0	513030P2M0
ID 300TW DC	51323002M0	513230P2M0
ID 500TW DC Pulse	-	513250P2M0

TIG Torches and Consumables

Control Options		100 - 200 A	200 - 350 A	
				
		Lava TIG 26	Lava TIG 18W	
Welding Capacity	DC	180 A	380 A	
	AC	150 A	270 A	
Duty Cycle		%35	%100	
Ordering Codes	4 m	7110018004	7110038004	
	8 m	7110018008	7110038008	
Cooling Type		Air	Water	
Consumables				
Nozzle		6.00 mm / No 4	7014000604	7014000604
		8.00 mm / No 5	7014000805	7014000805
		10.00 mm / No 6	7014001006	7014001006
		11.00 mm / No 7	7014001107	7014001107
		12.00 mm / No 8	7014001108	7014001108
		16.00 mm / No 10	7014001610	7014001610
Clamp Holder		1.00 mm	7013000110 / 7016000010	7013000110 / 7016000010
		1.60 mm	7013000116 / 7016000016	7013000116 / 7016000016
		2.00 mm	7013000120 / 7016000020	7013000120 / 7016000020
		2.40 mm	7013000124 / 7016000024	7013000124 / 7016000024
		3.20 mm	7013000132 / 7016000032	7013000132 / 7016000032
		4.00 mm	7013000140 / -	7013000140 / -
Insulation	Top		7017000102	7017000102
	Bottom		7017000101	7017000101
Electrode Clamp		1.00 mm	7012000010	7012000010
		1.60 mm	7012000016	7012000016
		2.00 mm	7012000020	7012000020
		2.40 mm	7012000024	7012000024
		3.20 mm	7012000032	7012000032
		4.00 mm	7012000040	7012000040
Pear Cover	Short		701500102	701500102
	Long		701500101	701500101
Tung. Electrode		1.60 mm		7018000116
		2.00 mm		7018000120
		2.40 mm		7018000124
		3.20 mm		7018000132
		4.00 mm		7018000140
				WT - 20 (Red)

Monophase MIG / MAG Welding Machines

monoMIG 200ik

Inverter Technology for Workshops



Steels
Stainless Steels
Aluminium Alloys



- Operates with 1 Phase 230V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- Excellent welding characteristics with all types of solid and flux cored wires with CO₂ or Mix gases. EN, EP Connectivity.
- **Welding Voltage, Wire Feeding Speed, Soft Start, Pre-Gas, Post-Gas, Burn-Back** timer settings and **2/4 Trigger** options are adjusted on the front panel.
- Large digital displays for easy monitoring of welding parameters.
- Manual wire feeding and gas valve buttons.
- ø300 mm, ø270 mm and ø200 mm spools, drums of any size and ø100 mm spool with a spool gun can be used with monoMIG 200ik.
- ø200 mm spools and ø100 mm spool with a spool gun can be used with megaMIG.
- 24V AC outlet for CO₂ gas heater in monoMIG 200ik.
- Built in gas cylinder platform with large wheels to ease mobility in workshops with monoMIG 200ik.
- Fan cooling and thermal protection against overheating.
- Standard accessories come with the machine.



EN 60974-1

EN 60974 -10

RoHS

	monoMIG 200ik	NEW megaMIG
Mains Voltage (1-phase)	230 V - 50/60Hz	230 V - 50/60Hz
Rated Power	8.6 kVA (%16)	8.21 kVA (%20)
Welding Current Range	30 - 200 ADC	30-200 ADC
Rated Welding Current	200 ADC (%16)	200 ADC (%20)
Open Circuit Voltage	52 VDC	75 VDC
Stick Electrode Diameter Range	-	1.60 - 4.00 mm
Dimensions (l x w x h)	888 x 455 x 870 mm	559 x 210 x 447 mm
Weight (Torch Excluded)	48 kg	19.5 kg
Protection Class	IP 21	IP 21

Wire Feed System

Wire Diameter Range	0.60 - 1.00 mm	0.60 - 1.00 mm
Standard Wire Rollers	0.80 - 1.00 mm	0.80 - 1.00 mm
Roller Diameter	2 x 37 mm	1 x 30 mm
Wire Feeding Speed	1 - 21.5 m/min.	1 - 18 m/min.
Trigger Control	2 / 4	2 / 4
Spool Capacity	max. 15 kg	max. 5 kg

Standard Accessories

Workpiece Clamp and Cable	7905201602 (16 mm ² - 2 m)
Gas Hose	790700002 (2 m)

Optional Accessories

Lava MIG 25 (3 m) Air Cooled MIG Torch	7120020003
Gas Regulator (CO ₂)	7020001005
Gas Regulator (Mix)	7020001004
CO ₂ Heater (24V)	7020009003
Spool Gun	7121018006
MIG / MAG CO ₂ Accessory Set* (Torch + Heater + Regulator)	7920000521
MIG/MAG Mix/Argon Accessory Set* (Torch + Regulator)	7920000525

* Should be verified during ordering.



Spool Gun



MIG/MAG Torch



Regulator



CO₂ Heater

Industrial Inverter MIG / MAG Welding Machines

ID 300M

Synergic Inverter Technology for Production



Steels
Stainless Steels
Aluminium Alloys
Copper Alloys
Nickel Alloys



- Operates with 3 Phase 400V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Excellent welding characteristics with all types of solid and flux cored wires with CO₂ or Mix gases.
- 3 Operating Modes; Synergic, Intelligent, Classic. With these options a welder can adapt from conventional to synergic welding easily.
- ONE LCD for ALL parameter selection; Trigger mode(2/4), Wire type, wire diameter, gas type and thickness of the base metal for Synergic Welding and Soft Start, Pre-Gas, Post-Gas, Burn-Back, Crater Filling timer settings as GENERAL SETTINGS.
- Industry 4.0 features such as; OEE, Arc-On Time reporting, WP setting/controlling/reporting, Barcode and RF Card reading. (Optional)
- 4 Wheel Drive system, offers very powerful feedability for longer torches and offers less deformation on soft wires such as aluminum and flux cored wires.
- The Separate wire feeder standard harness length is 5 m and can be extended up to 30 m upon request.
- Manual wire feeding & gas valve buttons are inside of the wire feeding cabinet.
- ø300 mm, ø270 mm and ø200 mm diameter spools and drums of any size can be used.
- 24V AC outlet for CO₂ gas heater.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Built in gas cylinder platform with large wheels to ease mobility in workshops.
- Fan cooling and thermal protection against overheating.
- Water cooling unit for water cooled torches provides powerful cooling even at very hot climates. (Water-cooled (W) models)
- Standard accessories come with the machine.



EN 60974-1

EN 60974 -10

RoHS

Standard	ID 300M
Mains Voltage (3-phase)	400 V - 50/60 Hz
Rated Power	15.1 kVA (%40)
Welding Current Range	50 - 300 ADC
Rated Welding Current	300 ADC (%40)
Maximum Open Circuit Voltage	62 VDC
Dimensions (l x w x h)	1075 x 531 x 1334 mm
Weight	93.5 kg
Protection Class	IP 21

Wire Feed System	
Wire Diameter Range	0.60 - 1.20 mm
Standard Wire Rollers	0.80 / 1.00 mm
Roller Diameter	4 x 37 mm
Wire Feeding Speed	1 - 21.5 m/min.
Trigger Control	2 / 4
Spool Capacity	max. 20 kg
Dimensions (l x w x h)	660 x 315 x 443 mm
Weight	21.5 kg

Standard Accessories	
Workpiece Clamp and Cable	7905212505 (25 mm ² - 5 m)
Gas Hose	790700002 (2 m)

Optional Accessories	
CO ₂ Heater (24 V)	7020009003
Gas Regulator (CO ₂)	7020001005
Gas Regulator (Mix)	7020001004
Lava MIG 35 (3 m) Air Cooled MIG Torch	7120035003
Lava MIG 40 (3 m) Air Cooled MIG Torch	7120040003
MIG / MAG CO ₂ Accessory Set* (Torch + Heater + Regulator)	7920000531
MIG/MAG Mix/Argon Accessory Set* (Torch + Regulator)	7920000535

* Should be verified during ordering.

Industrial Synergic Inverter-Pulse MIG / MAG Welding Machines

ID Series (CC / CV)

Synergic Inverter-Pulse Technology for Production



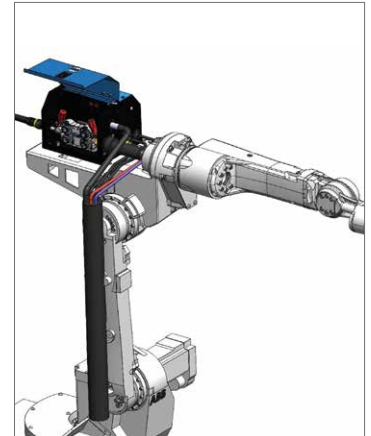
Steels
Stainless Steels
Aluminium Alloys
Copper Alloys
Nickel Alloys



ID 400MKW Pulse

ID 500MW Pulse Smart

ID 500MW Pulse Expert



Robotic Wire Feeder
compatible with
ID 500MWR

- Operates with 3 Phase 400V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Due to inverter technology, energy efficiency is higher than the conventional machines.
- Excellent welding characteristics with all types of solid and flux cored wires with CO₂ or Mix gases.
- Multi process welding; MIG/MAG, Stick Electrode, Carbon Gauging and TIG welding.
- No Spatter welding due to advanced electronically optimized inductance and pulsing functions. Excellent welding characteristics for all methods.
- **3 Operating Modes; Synergic, Intelligent, Classic.** With these options a welder can adapt from conventional to synergic welding easily.
- Wire type, wire diameter, gas type and thickness of the base metal for Synergic Welding and Soft Start, Pre-Gas, Post-Gas, Burn-Back, Crater Filling timer settings as general settings.
- **Smart model** is designed with a membrane button - led combination panel inside the wire-feeder cabinet for easy selection of synergic parameters such as; wire type, wire diameter, gas type and welding method.
- **Expert model** has advanced features such as **6 Trigger Mode, Double Pulse and LCD panel** to select all necessary parameters through the menus.
- 100 Different job in Expert series and 3 different job in Smart series
- Trigger mode selection from torch.
- Industry 4.0 features such as; OEE, Arc-On Time reporting, WP setting/controlling/reporting, Barcode and RF Card reading. (Optional)
- 4 Wheel Drive system, offers very powerful feedability for longer torches and offers less deformation on soft wires such as aluminum and flux cored wires.
- Robotic model is named as ID 500MWR. Mounting its special wirefeeder on any robot-arm is easy. It communicates with "ethernet and profi... etc." protocols with any robot, also analog communication feature makes it possible to connect to older robots.
- The Separate wire feeder standard harness length is 5 m and can be extended up to 30 m upon request.
- Manual wire feeding & gas valve buttons are inside of the wire feeding cabinet.
- ø300 mm, ø270 mm and ø200 mm diameter spools and drums of any size can be used.
- 24V AC outlet for CO₂ gas heater.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Built in gas cylinder platform with large wheels to ease mobility in workshops.
- Intelligent control of temperature reduces energy consumption and extends the fan and machine life. (SmartFan)
- Water cooling unit for water cooled torches provides powerful cooling even at very hot climates. (Water-cooled (W) models)
- Standard accessories come with the machine.



EN 60974-1

EN 60974-10

RoHS

Standard		NEW ID 500M Smart		
Pulsed	ID 400MK Pulse	ID 500M Pulse Smart	ID 500M Pulse Expert	
Standard Water Cooled		ID 500MW Smart		
Pulsed Water Cooled	ID 400MKW Pulse	ID 500MW Pulse Smart	ID 500MW / ID 500MWR Pulse Expert	
Mains Voltage (3-phase)	400 V - 50/60 Hz	400 V - 50/60 Hz	400 V - 50/60 Hz	
Rated Power	22.1 kVA (%40)	32.5 kVA (%40)	32.5 kVA (%40)	
Welding Current Range	50 - 400 A DC	50 - 500 A DC	50 - 500 ADC	
Rated Welding Current	400 ADC (%40)	500 ADC (%40)	500 ADC (%40)	
Maximum Open Circuit Voltage	82 VDC	82 VDC	82 VDC	
Dimensions (l x w x h)	702 x 293 x 722 mm	1075 x 531 x 1334 mm	1075 x 531 x 1334 mm	
Weight	Air-Cooled	94 kg	103.5 kg	103.5 kg
	Water Cooled	108 kg	113.5 kg	113.5 kg
Protection Class	IP 21	IP 21	IP 21	

Wire Feed System

Wire Diameter Range	0.80 - 1.60 mm	0.80 - 2.40 mm	0.80 - 2.40 mm
Standard Wire Rollers	1.00 / 1.20 mm	1.00 / 1.20 mm	1.00 / 1.20 mm
Roller Diameter	4 x 37 mm	4 x 37 mm	4 x 37 mm
Wire Feeding Speed	1 - 24 m/min.	1 - 24 m/min.	1 - 24 m/min.
Trigger Control	2 / 4 / 6 - 100 Job	2 / 4 - 3 Job	2 / 4 / 6 - 100 Job
Spool Capacity	max. 20kg	max. 20kg	max. 20kg
Dimensions (l x w x h)	-	660 x 315 x 443 mm	660 x 315 x 443 mm
Weight	-	23.7 kg	23.7 kg

Cooling System

Cooling Capacity	1.02 kW	1.02 kW	1.02 kW
Rated Power	0.266 kVA	0.266 kVA	0.266 kVA
Rated Current	0.650 A	0.650 A	0.650 A
Dimensions (l x w x h)	733 x 293 x 299 mm	430 x 320 x 280 mm	430 x 320 x 280 mm
Weight	23.5 kg	23 kg	23 kg

Standard Accessories

Workpiece Clamp and Cable	7905203505 (35 mm ² - 5 m)	7905407005 (70 mm ² - 5 m)	7905407005 (70 mm ² - 5 m)
Gas Hose	7907000002 (2 m)	7907000002 (2 m)	7907000002 (2 m)

Optional Accessories

CO ₂ Heater (24 V)	7020009003	7020009003	7020009003
Gas Regulator (CO ₂)	7020001005	7020001005	7020001005
Gas Regulator (Mix)	7020001004	7020001004	7020001004
Lava MIG 50W Water Cooled MIG Torch (3 m)	7120050003	7120050003	7120050003
Lava MIG 65W Water Cooled MIG Torch (3 m)	-	7120160003	7120160003
MIG / MAG CO ₂ Accessory Set* (Torch + Heater + Regulator)	7920000541/7920000551	7920000541/7920000551	7920000541/7920000551
MIG/MAG Mix/Argon Accessory Set* (Torch + Regulator)	7920000545 / 7920000555	7920000545 / 7920000555	7920000545 / 7920000555

* Should be verified during ordering.



Smart Step Controlled Industrial MIG/MAG Welding Machines

RS Pro Series

Step Transformer-Rectifier Technology
with Advanced Functions



Steels
Stainless Steels
Aluminium Alloys
Copper Alloys
Nickel Alloys



New
"Smart Mode"
Functions

- Operates with 3 Phase 400V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Excellent welding characteristics with all types of solid and flux cored wires with CO₂ or Mix gases.
- Intelligent control of temperature reduces energy consumption and extends the fan and machine life. (SmartFan)
- Sleep Mode to save energy if there is no activity in 7 minutes.
- Powerful Digital Displays are closer to the welder.
- 4 roll drive system provides good feedability especially with long torches and soft wires such as aluminum and flux cored wires are conveyed without any deformation.
- The Separate wire feeder standard harness length is 5 m and can be extended up to 30 m upon request.
- Optimum welding parameters can be obtained from the printed table inside of the wire feed cover.
- Wire feed speed adjustment, 2/4 trigger selection, **Soft Start**, **Pre-Gas**, **Post-Gas**, **Burn-Back** timer adjustments are through the red knob and membrane switch (M) on the wire feeding panel. During welding, voltage and current are monitored on digital displays.
- Welding voltage is adjusted from the course and fine switches; increments are optimized to obtain welding parameters with lowest spatter levels.
- Manual wire feeding & gas valve buttons are in the wire feeding cabinet.
- Ø300 mm, Ø270 mm and Ø200 mm spools and drums of any size can be used.
- 24V AC outlet for CO₂ gas heater.
- Multiple workpiece connections (Inductance outlets) enables optimum parameter adjustment for low spatter welding.
- Built in gas cylinder platform with large wheels to ease mobility in workshops.
- Water cooling unit for water cooled torches provides powerful cooling even at very hot climates. (Water-cooled (W) models)
- Standard accessories come with the machine.



EN 60974-1

EN 60974 -10

RoHS

Compact Separate Wire Feeder Water Cooled		RS 350MK Pro RS 350M Pro RS 350MW Pro	RS 450M Pro RS 450MW Pro	RS 550M Pro RS 550MW Pro
Mains Voltage (3-phase)		400 V - 50/60 Hz	400 V - 50/60 Hz	400 V - 50/60 Hz
Rated Power		15.8 kVA (%40)	22.6 kVA (%50)	31.7 kVA (%50)
Welding Current Range		60 - 350 ADC	85 - 450 ADC	95 - 550 ADC
Rated Welding Current		350 ADC (%40)	450 ADC (%50)	550 ADC (%50)
Maximum Open Circuit Voltage		20 - 52 VDC	20 - 57 VDC	21 - 58 VDC
Voltage Adjustment and Number of Levels		3 x 7	3 x 10	3 x 10
Dimensions (l x w x h)	Compact	876 x 505 x 939 mm	-	-
	Separate Wire Feeder	1008 x 592 x 1220 mm	1008 x 592 x 1220 mm	1008 x 592 x 1220 mm
	Water Cooled	1008 x 592 x 1443 mm	1008 x 592 x 1443 mm	1008 x 592 x 1443 mm
Weight	Compact	123 kg	-	-
	Separate Wire Feeder	145.5 kg	225 kg	252.5 kg
	Water Cooled	177 kg	256.5 kg	284 kg
Protection Class		IP 21	IP 21	IP 21

Wire Feed System

Wire Diameter Range	0.60 - 1.20 mm	0.80 - 2.00 mm	0.80 - 2.40 mm
Standard Wire Rollers	1.00 / 1.20 mm	1.00 / 1.20 mm	1.00 / 1.20 mm
Roller Diameter	4 x 37 mm	4 x 37 mm	4 x 37 mm
Wire Feeding Speed	1 - 21.5 m/min.	1 - 21.5 m/min.	1 - 21.5 m/min.
Trigger Control	2 / 4	2 / 4	2 / 4
Spool Capacity	max. 20 kg	max. 20 kg	max. 20 kg
Dimensions (l x w x h)	660 x 315 x 443 mm	660 x 315 x 443 mm	660 x 315 x 443 mm
Weight	21 kg	23.5 kg	26.5 kg

Cooling System

Cooling Capacity	2.11 kW	2.11 kW	2.11 kW
Rated Power	0.22 kVA	0.22 kVA	0.22 kVA
Rated Current	0.96 A	0.96 A	0.96 A
Dimensions (l x w x h)	770 x 490 x 280 mm	770 x 490 x 280 mm	770 x 490 x 280 mm
Weight	33.5 kg	33.5 kg	33.5 kg

Standard Accessories

Workpiece Clamp and Cable	Compact	7905203503 (35 mm ² - 3 m)	7905407003 (70 mm ² - 3 m)	7905407003 (70 mm ² - 3 m)
	Separate Wire Feeder	7905203505 (35 mm ² - 5 m)	7905407005 (70 mm ² - 5 m)	7905407005 (70 mm ² - 5 m)
Gas Hose		790700002 (2 m)	790700002 (2 m)	790700002 (2 m)

Optional Accessories

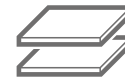
CO ₂ Heater (24V)	7020009003	7020009003	7020009003
Gas Regulator (CO ₂)	7020001005	7020001005	7020001005
Gas Regulator (Mix)	7020001004	7020001004	7020001004
Lava MIG 35 (3 m) Air Cooled MIG Torch	7120035003	7120035003	-
Lava MIG 40 (3 m) Air Cooled MIG Torch	7120040003	7120040003	7120040003
Lava MIG 50W (3 m) Water Cooled MIG Torch	7120050003	7120050003	7120050003
MIG / MAG CO ₂ Accessory Set* (Torch + Heater + Regulator)	7920000531/7920000551	7920000541/ 7920000551	7920000541/7920000551
MIG/MAG Mix/Argon Accessory Set* (Torch + Regulator)	7920000555	7920000555	7920000555

* Should be verified during ordering.

Classical Step Controlled Industrial MIG / MAG Welding Machines

RS Series

Step Transformer - Rectifier Technology



Steels
Stainless Steels
Aluminium Alloys
Copper Alloys
Nickel Alloys



Optional Open Case



Optional 5 kg Spool Case

- Operates with 3 Phase 400V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Excellent welding characteristics with all types of solid and flux cored wires with CO₂ or Mix gases.
- 4 roll drive system provides good feedability especially with long torches and soft wires such as aluminum and flux cored wires are conveyed without any deformation.
- The Separate wire feeder standard harness length is 5 m and can be extended up to 30 m upon request.
- Optimum welding parameters can be obtained from the printed table inside of the wire feed cover.
- Wire feed speed and 2/4 trigger adjustments are on the front panel, **Soft Start, Pre-Gas, Post-Gas, Burn-Back** timer settings, manual wire feeding & gas valve buttons are inside of the wire feeding cabinet.
- Welding voltage is adjusted from the course and fine switches; increments are optimized to obtain welding parameters with lowest spatter levels.
- Digital displays on the power source for adjusting and monitoring of welding parameters.
- Multiple workpiece connections (Inductance outlets) enables optimum parameter adjustment for low spatter welding.
- Ø300 mm, Ø270 mm and Ø200 mm spools and drums of any size can be used.
- 220V AC outlet for CO₂ gas heater.
- Built in gas cylinder platform with large wheels to ease mobility in workshops.
- Fan cooling and thermal protection against overheating.
- Water cooling unit for water cooled torches provides powerful cooling even at very hot climates. (Water-cooled (W) models)
- Standard accessories come with the machine.



EN 60974-1

EN 60974 -10

RoHS

Compact Separate Wire Feeder		RS 200MK	RS 250MK RS 250M
Mains Voltage (3-phase)		400 V - 50/60 Hz (3 Ph.)	400 V - 50/60 Hz
Rated Power		7.9 kVA (%23)	10 kVA (%40)
Welding Current Range		40 - 240 ADC	57 - 250 ADC
Rated Welding Current		240 ADC (%33)	250 ADC (%40)
Maximum Open Circuit Voltage		17 - 36 VDC	19.7 - 51 VDC
Voltage Adjustment and Number of Levels		2 x 7	3 x 7
Dimensions	Compact	890 x 460 x 950 mm	890 x 460 x 950 mm
	(l x w x h)	-	865 x 510 x 780 mm
Weight	Compact	101 kg	105 kg
	Separate Wire Feeder	-	101 kg
Protection Class		IP 21	IP 21

Wire Feed System			
Wire Diameter Range		0.60 - 1.00 mm	0.60 - 1.20 mm
Standard Wire Rollers		0.80 / 1.00 mm	0.80 / 1.00 mm
Roller Diameter		4 x 37 mm	4 x 37 mm
Wire Feeding Speed		1 - 21.5 m/min.	1 - 21.5 m/min.
Trigger Control		2 / 4	2 / 4
Spool Capacity		max. 15 kg	max. 20 kg
Dimensions (l x w x h)		-	560 x 225 x 450 mm
Weight		-	23 kg

Standard Accessories			
Workpiece Clamp and Cable	Compact	7905201603 (16 mm ² - 3 m)	7905212503 (25 mm ² - 3 m)
	Separate Wire Feeder	-	7905212505 (25 mm ² - 5 m)
Gas Hose		790700002 (2 m)	790700002 (2 m)

Optional Accessories			
CO ₂ Heater (220V)		7020009002	7020009002
Gas Regulator (CO ₂)			7020001005
Gas Regulator (Mix)			7020001004
Lava MIG 25 (3 m) Air Cooled MIG Torch		7120025003	7120025003
Lava MIG 35 (3 m) Air Cooled MIG Torch		-	7120035003
MIG / MAG CO ₂ Accessory Set* (Torch + Heater + Regulator)		7920000520	7920000520
MIG/MAG Mix/Argon Accessory Set* (Torch + Regulator)		7920000525	7920000525

* Should be verified during ordering.

Compact Separate Wire Feeder Water Cooled		RS 300MK RS 300M	RS 350MK RS 350M RS 350MW
Mains Voltage (3-phase)		400 V - 50/60 Hz	400 V - 50/60 Hz
Rated Power		13.8 kVA (%40)	15.6 kVA (%40)
Welding Current Range		40 - 300 ADC	60 - 350 ADC
Rated Welding Current		300 ADC (%40)	350 ADC (%40)
Maximum Open Circuit Voltage		19 - 44 VDC	20 - 52 VDC
Voltage Adjustment and Number of Levels		3 x 7	3 x 7
Dimensions (l x w x h)	Compact	890 x 460 x 950 mm	876 x 505 x 939 mm
	Separate Wire Feeder	865 x 510 x 780 mm	1008 x 592 x 1220 mm
	Water Cooled	-	1008 x 592 x 1443 mm
Weight	Compact	112 kg	123 kg
	Separate Wire Feeder	101 kg	145.5 kg
	Water Cooled	-	177 kg
Protection Class		IP 21	IP 21

Wire Feed System

Wire Diameter Range	0.60 - 1.20 mm	0.60 - 1.20 mm
Standard Wire Rollers	0.80 / 1.00 mm	1.00 / 1.20 mm
Roller Diameter	4 x 37 mm	4 x 37 mm
Wire Feeding Speed	1 - 21.5 m/min.	1 - 21.5 m/min.
Trigger Control	2 / 4	2 / 4
Spool Capacity	max. 20 kg	max. 20 kg
Dimensions (l x w x h)	560 x 225 x 450 mm	560 x 225 x 450 mm
Weight	23 kg	23 kg

Cooling System

Cooling Capacity	-	2.11 kW
Rated Power	-	0.22 kVA
Rated Current	-	0.96 A
Dimensions (l x w x h)	-	770 x 490 x 280 mm
Weight	-	33.5 kg

Standard Accessories

Workpiece Clamp and Cable	Compact	7905212503 (25 mm ² - 3 m)	7905203503 (35 mm ² - 3 m)
	Separate Wire Feeder	7905212505 (25 mm ² - 5 m)	7905203505 (35 mm ² - 5 m)
Gas Hose		790700002 (2 m)	790700002 (2 m)

Optional Accessories

CO ₂ Heater (220V)	7020009002	7020009002
Gas Regulator (CO ₂)		7020001005
Gas Regulator (Mix)		7020001004
Lava MIG 25 (3 m) Air Cooled MIG Torch	-	-
Lava MIG 35 (3 m) Air Cooled MIG Torch	7120035003	7120035003
Lava MIG 40 (3 m) Air Cooled MIG Torch	-	7120040003
Lava MIG 50W (3 m) Water Cooled MIG Torch	-	7120050003
MIG / MAG CO ₂ Accessory Set* (Torch + Heater + Regulator)	7920000520	7920000530 / 7920000550
MIG/MAG Mix/Argon Accessory Set* (Torch + Regulator)	7920000525	7920000535 / 7920000555

* Should be verified during ordering.

Compact Separate Wire Feeder Water Cooled		RS 400MK RS 400M RS 400MW	RS 500M RS 500MW
Mains Voltage (3-phase)		400 V - 50/60 Hz	400 V - 50/60 Hz
Rated Power		19.1 kVA (%50)	29.5 kVA (%40)
Welding Current Range		45 - 400 ADC	45 - 500 ADC
Rated Welding Current		400 ADC (%50)	500 ADC (%40)
Maximum Open Circuit Voltage		20 - 48 VDC	19 - 53 VDC
Voltage Adjustment and Number of Levels		4 x 7	3 x 10
Dimensions (l x w x h)	Compact	890 x 460 x 950 mm	-
	Separate Wire Feeder	1020 x 590 x 1290mm	1020 x 590 x 1290mm
	Water Cooled	1020 x 590 x 1515 mm	1020 x 590 x 1515 mm
Weight	Compact	121 kg	-
	Separate Wire Feeder	134 kg	195 kg
	Water Cooled	155 kg	215 kg
Protection Class		IP 21	IP 21

Wire Feed System

Wire Diameter Range	0.80 - 1.60 mm	0.80 - 2.40 mm
Standard Wire Rollers	1.00 / 1.20 mm	1.00 / 1.20 mm
Roller Diameter	4 x 37 mm	4 x 37 mm
Wire Feeding Speed	1 - 21.5 m/min.	1 - 21.5 m/min.
Trigger Control	2 / 4	2 / 4
Spool Capacity	max. 20 kg	max. 20 kg
Dimensions (l x w x h)	560 x 225 x 450 mm	560 x 225 x 450 mm
Weight	25 kg	25 kg

Cooling System

Cooling Capacity	2.11 kW	2.11 kW
Rated Power	0.22 kVA	0.22 kVA
Rated Current	0.96 A	0.96 A
Dimensions (l x w x h)	770 x 490 x 280 mm	770 x 490 x 280 mm
Weight	33.5 kg	33.5 kg

Standard Accessories

Workpiece Clamp and Cable	Compact	7905203503 (35 mm ² - 3 m)	7905407003 (70 mm ² - 3 m)
	Separate Wire Feeder	7905203505 (35 mm ² - 5 m)	7905407005 (70 mm ² - 5 m)
Gas Hose		790700002 (2 m)	790700002 (2 m)

Optional Accessories

CO ₂ Heater (220V)	7020009002	7020009002
Gas Regulator (CO ₂)		7020001005
Gas Regulator (Mix)		7020001004
Lava MIG 25 (3 m) Air Cooled MIG Torch	-	-
Lava MIG 35 (3 m) Air Cooled MIG Torch	7120035003	-
Lava MIG 40 (3 m) Air Cooled MIG Torch	7120040003	7120040003
Lava MIG 50W (3 m) Water Cooled MIG Torch	7120050003	7120050003
MIG / MAG CO ₂ Accessory Set* (Torch + Heater + Regulator)	7920000540 / 7920000550	7920000540 / 7920000550
MIG/MAG Mix/Argon Accessory Set* (Torch + Regulator)	7920000545 / 7920000555	7920000545 / 7920000555

* Should be verified during ordering.

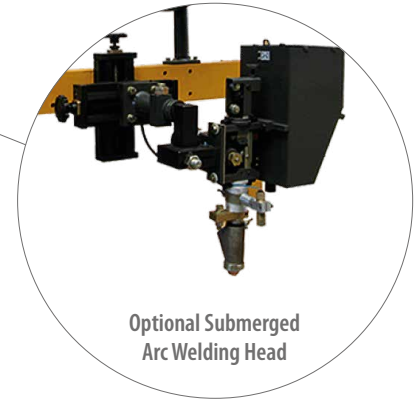
Industrial Thyristor Controlled MIG / MAG Welding Machines

RD 650MW

Thyristor Technology for Heavy Industries



Steels
Stainless Steels
Aluminium Alloys
Copper Alloys
Nickel Alloys



Optional Submerged
Arc Welding Head

- Operates with 3 Phase 400V-50/60 Hz mains voltage and generators, tolerates voltage fluctuations up to 15%.
- Excellent welding characteristics with all types of solid and flux cored wires with CO₂ or Mix gases.
- Up to 2.8 mm wire diameter can be used with Flux Cored and Subarc welding processes.
- The Separate wire feeder standard harness length is 5 m and can be extended up to 30 m upon request.
- 4 roll drive system provides good feedability especially with long torches and soft wires such as aluminum and flux cored wires are conveyed without any deformation.
- Welding Voltage, Wire Speed, **Soft Start**, **Pre-Gas**, **Post-Gas**, **Burn-Back** timers and **2/4 trigger** are set on the front panel of the wire feeder.
- Optimum welding parameters can be obtained from the printed table inside of the wire feed cover.
- Digital displays on the wire feeder for adjusting and monitoring welding parameters.
- Manual wire feeding & gas valve buttons are inside of the wire feeding cabinet.
- Multiple workpiece connections (Inductance outlets) enables optimum parameter adjustment for low spatter welding.
- Ø300 mm, Ø270 mm and Ø200 mm spools and drums of any size can be used.
- 220V AC outlet for CO₂ gas heater.
- Multiple workpiece connections (Inductance outlets) enables optimum parameter adjustment for low spatter welding.
- Stable welding current without loss of performance due to electric line fluctuations or with long welding and electrical cables.
- Built in gas cylinder platform with large wheels to ease mobility in workshops.
- Fan cooling and thermal protection against overheating.
- Water cooling unit for water cooled torches provides powerful cooling even at very hot climates.
- Submerged arc welding head can be coupled easily. (Option)
- Standard accessories come with the machine.



EN 60974-1

EN 60974 -10

RoHS

RD 650MW	
Mains Voltage (3-phase)	400 V - 50/60 Hz
Rated Power	48.5 kVA (%40)
Welding Current Range	60 - 650 ADC
Rated Welding Current	650 ADC (%40)
Maximum Open Circuit Voltage	20 VDC
Dimensions (l x w x h)	1152 x 645 x 1795 mm
Weight	235 kg
Protection Class	IP 21

Wire Feed System	
Wire Diameter Range	1.00 - 2.80 mm
Standard Wire Rollers	1.20 / 1.60 mm
Roller Diameter	4 x 37 mm
Wire Feeding Speed	1 - 21.5 m/min.
Trigger Control	2 / 4
Spool Capacity	max. 20 kg
Dimensions (l x w x h)	574 x 230 x 500 mm
Weight	27 kg

Cooling System	
Cooling Capacity	14330 Btu (4.2 kW)
Rated Power	0.22 kVA
Rated Current	0.96 A
Dimensions (l x w x h)	770 x 490 x 280 mm
Weight	33.5 kg

Standard Accessories	
Workpiece Clamp and Cable	7905509505 (95 mm ² - 5 m)
Gas Hose	790700002 (2 m)

Optional Accessories	
CO ₂ Heater (220V)	7020009002
Gas Regulator (CO ₂)	7020001005
Gas Regulator (Mix)	7020001004
Lava MIG 50W (3 m) Water Cooled MIG Torch	7120050003
Lava MIG 65W (3 m) Water Cooled MIG Torch	7120160003
Submerged Arc Welding Head	-
MIG / MAG CO ₂ Accessory Set* (Torch + Heater + Regulator)	7920000550
MIG/MAG Mix/Argon Accessory Set* (Torch + Regulator)	7920000555

* Should be verified during ordering.

Product Codes



	Compact	Separate Wire Feeding Unit (5 m)	Separate Wire Feeding Unit (10 m)	Separate Wire Feeding Unit (15 m)	Separate Wire Feeding Unit (20 m)	Wire Feeding Unit Type
monoMIG 200	521K2000M0	-	-	-	-	-
RS 200	522020AK00	522020A110	522020A120	522020A130	522020A140	Close
RS 250	522025AK00	522025A110	522025A120	522025A130	522025A140	Close
RS 300	522030AK00	522030A110	522030A120	522030A130	522030A140	Close
RS 350	522035AK00	522035A110	522035A120	522035A130	522035A140	Close
RS 350 Water Cooled	522035WK00	522035W110	522035W120	522035W130	522035W140	Close
RS 350 Pro	522P35AK00	522P35A210	522P35A220	522P35A230	522P35A240	Open
RS 350 Pro Water Cooled	522P35WK00	522P35W210	522P35W220	522P35W230	522P35W240	Open
RS 400	522040AK00	522040A110	522040A120	522040A130	522040A140	Close
RS 400 Water Cooled	-	522040W110	522040W120	522040W130	522040W140	Close
RS 450 Pro	-	522P45A210	522P45A220	522P45A230	522P45A240	Open
RS 450 Pro Water Cooled	-	522P45W210	522P45W220	522P45W230	522P45W240	Open
RS 500	-	522050A110	522050A120	522050A130	522050A140	Close
RS 500 Water Cooled	-	522050W110	522050W120	522050W130	522050W140	Close
RS 550 Pro	-	522P55A210	522P55A220	522P55A230	522P55A240	Open
RS 550 Pro Water Cooled	-	522P55W210	522P55W220	522P55W230	522P55W240	Open
RD 650 Water Cooled	-	522T50W110	522T50W120	522T50W130	522T50W140	Close
ID 300	523030AK00	523030A210	523030A220	523030A230	523030A240	Open
ID 500 Smart	-	523150A210	523150A220	523150A230	523150A240	Open
ID 500 Pulse Smart	-	523B50A210	523B50A220	523B50A230	523B50A240	Open
ID 500 Smart Water Cooled	-	523150W210	523150W220	523150W230	523150W240	Open
ID 500 Pulse Smart Water Cooled	-	523B50W210	523B50W220	523B50W230	523B50W240	Open
ID 500 Pulse Expert	-	523P50A210	523P50A220	523P50A230	523P50A240	Open
ID 500 Pulse Expert Water Cooled	-	523P50W210	523P50W220	523P50W230	523P50W240	Open

* Please contact for optional wire feeder requests.

MIG/MAG Torches and Consumables

50W Control Options		100 - 200 A	250 - 400 A	500 A				
		Lava MIG 15	Lava MIG 25	Lava MIG 35	Lava MIG 40	Lava MIG 50W	Lava MIG 65W	
Welding Capacity	CO ₂	150 A (%60)	230 A (%60)	320 A (%60)	400 A (%60)	500 A (%100)	600 A (%100)	
Order Codes	3 m	7120015003	7120020003	7120035003	7120040003	7120050003	7120160003	
	4 m	7120015004	7120020004	7120035004	7120040004	712050004	7120160004	
	5 m	7120015005	7120020005	7120035005	7120040005	712050005	7120160005	
Cooling Type		Air	Air	Air	Air	Water	Double Water	
Consumables								
Nozzle		12 mm	7022001253	7022011253	-	-	-	
		15 mm	-	7022001554	-	7022101575	-	
		16 mm	-	-	7022001684	-	7022001675	-
		17 mm	-	-	-	-	-	7022101777
		Adapter	-	-	-	-	-	7022302821
Contact Nozzle		Standard	0.60 mm	7023062506 (M6xL25)	7023062806 (M6xL28)	-	-	
			0.80 mm	7023062508 (M6xL25)	7023062808 (M6xL28)	7023083008 (M8xL30)	-	
			1.00 mm	7023062510 (M6xL25)	7023062810 (M6xL28)	7023083010 (M8xL30)	-	
			1.20 mm	7023062512 (M6xL25)	7023062812 (M6xL28)	7023083012 (M8xL30)	7023213512 (M10xL30 CuCrZr)	
			1.40 mm	-	-	7023083014 (M8xL30)	-	
			1.60 mm	-	7023062816 (M6xL28)	7023083016 (M8xL30)	7023213526 (M10xL35 CuCrZr)	
			2.00 mm	-	-	7023083520 (M8xL30)	7023213520 (M10xL35 CuCrZr)	
			2.40 mm	-	-	7023083524 (M10xL30)	7023213524 (M10xL35 CuCrZr)	
		Aluminum	1.00 mm	-	7023162810 (M6xL28)	7023183010 (M8xL30)	-	
			1.20 mm	-	7023162812 (M6xL28)	7023183012 (M8xL30)	-	
KTM Holder		M6	7026000156	7026000256	7026000356	-	-	
		M8	-	-	7026000358	7026000408	7026000508	-
		M10	-	-	-	-	-	7026000608
Gas Distributor		Ceramic	-	7024100024	7024100035	7024100050	7024100050	7024100065
		Copper	-	7026000246	-	-	-	-
Steel Spiral		0.60 mm 0.90 mm	3 m	-	-	7025030609	-	
			4 m	-	-	7025040609	-	
			5 m	-	-	-	-	
		1.00 mm 1.20 mm	3 m	-	-	7025031012	-	
			4 m	-	-	7025041012	-	
			5 m	-	-	7025051012	-	
		1.20 mm 1.60 mm	3 m	-	-	7025031012	-	
			4 m	-	-	7025041216	-	
			5 m	-	-	7025051216	-	
		1.60 mm 2.40 mm	3 m	-	-	7025031624	-	
			-	-	-	-	-	
		Teflon Spiral		0.60 mm 0.90 mm	3 m	-	-	7025530610
-	-				-	-	-	
1.00 mm 1.20 mm	3 m			-	-	7025531012	-	
	-			-	-	-	-	
1.60 mm	3 m			-	-	7025531216	-	
	-			-	-	-	-	
Wire Feed Rollers*		RS /ID		-	-	-	-	
		0.6-0.8 mm	-	-	7027000608 / 7027400608	-		
		0.8-1.0 mm	-	-	7027000810 / 7027400810	-		
		1.0-1.2 mm	-	-	7027001012 / 7027401012	-		
		1.2-1.6 mm	-	-	7027001216 / 7027401216	-		

* Used in Magmaweld machines in 2012 models and later. Please contact for previous production and Lorch equipment.

Industrial Submerged Arc Welding Machines

MZ-1000BF
MZ-1000BB



Steels
Stainless Steels
Copper Alloys

Thyristor Technology for Heavy Industries



Power Supply ZD5-1000



Tractor MZC-1250F19



Welding Head MZ9-1250B11*

- Designed to be used 24 hours a day, 7 days a week under heavy working conditions such as steel construction sites, shipyards, pressure tube, longitudinal or spiral pipe manufacturing.
- Tractor or Welding Head models.
- Stable welding current without loss of performance due to electric line fluctuations, ambient temperature changes or long welding and electrical cables.
- Welding Voltage, Wire Feed Speed, Tractor Speed are controlled and monitored through digital displays on the control box. Optionally positioners, rollers, linear benches can be controlled and monitored as well.
- Crater current, crater voltage, flashback time adjustments.
- Tractor supports wire spools up to 435 mm diameter and 25 kg weight and 8 Lt flux hopper.
- In addition to **Subarc Welding (SAW)** process, **Electroslag Welding (ESW)** **Carbon Gauging (CAC)**, **Stick Electrode Welding (SMAW)** processes can also be performed.
- The power supply is fan-cooled and has thermal protection against overheating.
- Flux recovery unit is optional.
- Standard accessories come with the machine.

Power Source	ZD5-1000
Mains Voltage (3-phase)	380 V / 50 Hz
Rated Power	68 kVA
Recommended Mains Fuse	125 A Kompakt Şalter
Open Circuit Voltage	71 V
Welding Current Range	200 - 1000 A
Operating Cycle	%100
Dimensions (l x w x h)	980 x 670 x 1000 mm
Weight	480 kg
Protection Class	IP 21
Product Code	502S100DK0

Tractor / Welding Head	MZC-1250F19	MZ9-1250B11
Dimensions (l x w x h)	900 x 520 x 850 mm	-
Weight	68 kg	45 kg
Wire Diameter	3.20 - 4.00 - 4.80 mm	3.20 - 4.00 - 4.80 mm
Welding Speed	15 - 125 cm/min.	-
Wire Feed Speed	33 - 330 cm/min.	27 - 270 cm/min.
Welding Head Adjustment Range	100 x 120 (Lengthwise x Widthwise)	150 x 150 (Lengthwise x Widthwise)
Rotation Angle Between Welding Head & Tractor	360°	360°
Welding Head Rotation Angle (Right - Left)	45°	45°
Welding Head Rotation Angle (Forward - Backward)	45°	45°
Flux Capacity	8 lt	8 lt
Wire Bearing Capacity	25 kg	25 kg
Standard Rail Length	1.80 m (2 pieces)	-
Communication Cable	15 m (1 piece)	15 m (1 piece)
Protection Class	IP 21	IP 21
Product Code	530T1001K0	530T10002K0

Standart Accessories	
Welding Cable (70 mm ² x 15 m) 2 pieces	K301400615
Workpiece Cable (70 mm ² x 5 m) 2 pieces	K301500605
Communication Cable (15 m) 1 piece	Y533000013
Rail (1.8 m) 2 pieces	7930002001

Optional Accessories	
Flux Recovery Unit (Compressor Connection)	7930001002 -
Rail (1.8 m)	7930002001 -
Carbon Gauging Clamp	7908201000

Consumables		
Nozzle	7032001000	7032001000
Contact Tip Holder	Y532000074	Y532000072
Contact Tip (2.40 mm)	7033000024	7033000024
Contact Tip (3.20 mm)	7033000032	7033000032
Contact Tip (4.00 mm)	7033000040	7033000040
Contact Tip (5.00 mm)	7033000050	7033000050
Torch Head	Y532000003	Y532000003
Flow Pipe	Y532000008	Y532000008
Flux Recovery Unit Filter (Ø 180 x 500 Double Layer)	A257100003	A257100003



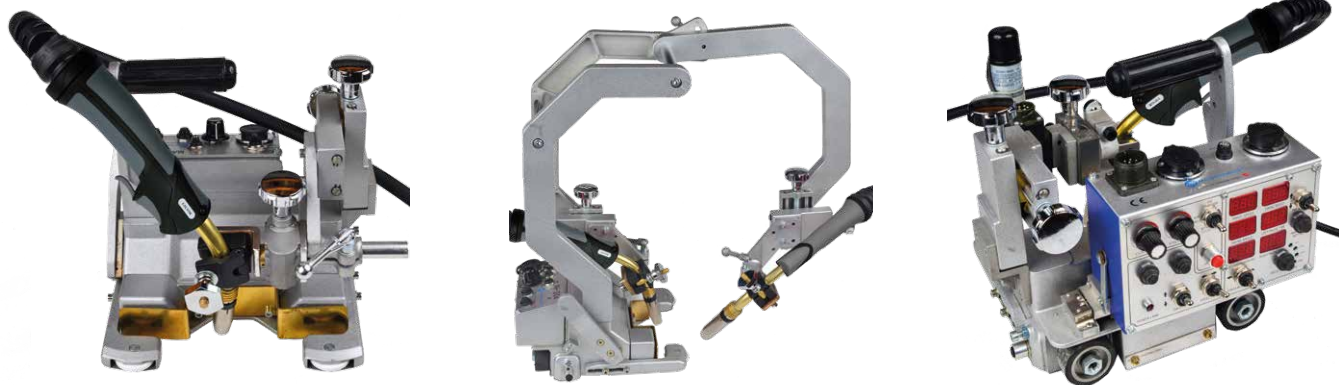
Rail



Carbon Gauging Clamp

Welding and Cutting Carriages

HK6 I Single Torch HK6 II Double Torch HK6 W Oscillation



- Welding tractor for mainly fillet weldings such as Dutch profiles in shipbuilding.
- Twin torch attachment for welding both sides of the "I" profile at the same time.
- Portable but sturdy structure with well balanced center of gravity against tipping over, easy installation and provides smooth travelling.
- Travels also vertical up with the help of the powerful magnet under the tractor.
- Automatic stop function stops the tractor at any desired place.
- 42V operating voltage for operational safety.
- Communicates with any MIG/MAG welding machine and any MIG/MAG hand torch can be installed.

HK6 W Oscillation model:

- Advanced digital control box.
- The oscillation angle and frequency are adjusted separately
- Intermittent welding function

Technical Specifications	HK6 I Single Torch	HK6 II Double Torch	HK6 W Oscillation
Operating voltage	42 V / 50Hz	42 V / 50Hz	42 V / 50Hz
Horizontal Torch Angle	40° - 55°	40° - 55°	45° - 55°
Up/Down Setting	45 mm	45 mm	40 mm
Front/Rear Adjustment	45 mm	45 mm	40 mm
Traction Force	16 kg	30 kg	-
Tractor Speed	150 - 1500 mm/min.	100 - 1500 mm/min.	50 - 1900 mm/min.
Monitoring System	Guide Wheel	Guide Wheel	Guide Wheel
Drive System	Four-Wheel Drive	Four-Wheel Drive	Four-Wheel Drive
Standard Tracking Height	45 mm	45 mm	45 mm
Dimensions (l x w x h)	260 x 260 x 264 mm	500 x 280 x 520 mm	430 x 280 x 290 mm
Weight (Aba Body)	6.9 kg	12.6 kg	12 kg
Product Code	560M0000M0	560M0010M0	560M0001M0
Oscillation Right/Left Timing	-	-	0 - 2,5 sec.
Oscillation Deviation	-	-	0 - ±8°
Oscillation Speed	-	-	0 - 100°
Oscillation Angle	-	-	±15°
Oscillation Modes	-	-	

Standard Accessories

Step Down Transformer	220-42 V	220-42 V	220-42 V
Twin Torch Parts	-	796000001	-

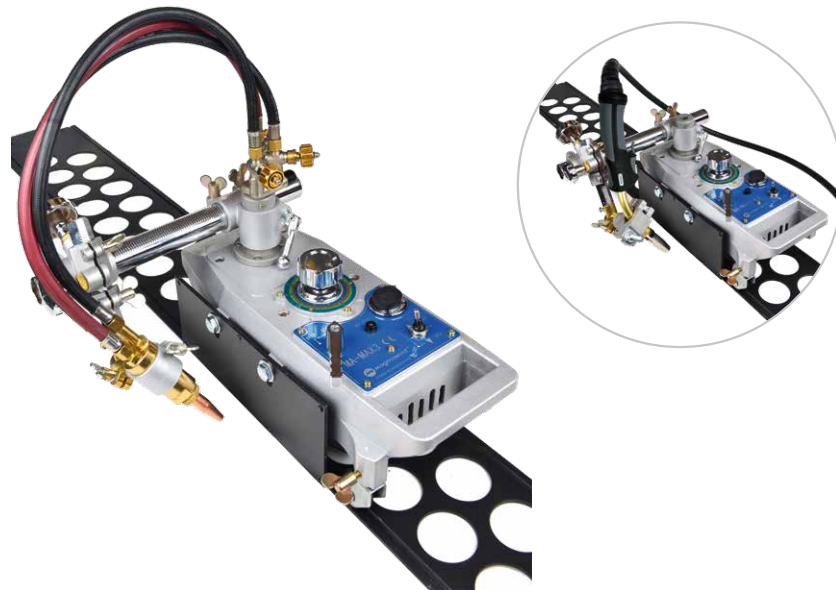
Optional Accessories

Twin Torch Parts	796000001	-	-
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Welding and Cutting Carriages

HK12 Max 3

Oxygen and Plasma Cutting Tractor



- Automatic welding and cutting with MIG/MAG or OXY-FUEL or PLASMA torches.
- Unique guiding system and special cutting nozzles provides clean and precise cuttings.
- For Straight lines 2 x 1.8 m long rails are standard; they can be joined one after the other infinitely.
- Adjustable circular rail option for circular cutting.
- "X" welding edge can be opened with special torches and cutting is performed up to 600 mm. thickness.
- Suitable for linear, circular welding and for grooving welding ends. (With optional circular rail)
- Double conical reduction gear system for speed adjustments.
- Directions: Forward - Stop - Reverse, clutch lever and speed control knob.
- Robust and lightweight structure due to its reinforced aluminum body.
- Allows working under high temperature conditions.
- Fan cooling and thermal protection against overheating.

Technical Specifications	HK12 Max 3
Operating voltage	220V / 50Hz
Cutting Thickness S-Type	40 - 45 mm (Standard)
Cutting Speed	80 - 800 mm/min. (50 Hz)
Weight	30 kg
Tractor Speed	100-1500 mm/min.
Product Code	560R0000M0

Standard Accessories	
Straight Cutting Rail (1.8 m)	7960000015
Plasma Cutting Torch Connection Set	7960000003
Welding Torch Connection Set	7960000004

Welding Fume Extraction and Filtration Systems

DFS MP

DFS 1M, DFS 2M

DFS 1MK, DFS 2MK

Mobile Models



Compakt Model
DFS MP

- Operates with 1 Phase 220V/50Hz
- 2 m Acrobat arm
- Provides high performance and low energy consumption rate.
- 99% efficient cleaning of welding fume with F8 Filter.
- Carbon Filter can be attached for advanced applications.
- Aluminium mesh filter for prefiltering and spark arresting.
- Filter change indicator for filter efficiency.
- Operation control lamp.
- Optional HEPA filter can be attached.



One Arm Model
DFS 1M

Two Arm Model
DFS 2M

- Operates with 3 Phase 380V/50-60Hz .
- 99% efficient cleaning of welding fume with F8 Filter.
- Aluminium mesh filter for prefiltering and spark arresting.
- Filter change indicator for filter efficiency.
- Reversed phase control lamp.
- 3 m supply cable is provided as standart.
- Acrobat arms can be selected as 2 m, 3 m and 4 m.
- Optional lighting can be attached.
- Carbon filter can be selected for advanced applications.



DFS 1M

DFS 2M

DFS 1MK

DFS 2MK

	DFS 1M	DFS 2M	
	DFS 1MK	DFS 2MK	DFS MP
Supply Voltage	380 V - 50 / 60 Hz	380 V - 50 / 60 Hz	230 V - 50 / 60Hz
Filtering Efficiency	> 99%	> 99%	> 99%
Motor Power	1,1 kW / 1,5 kW (K model)	1,5 kW	0,35 kW
Suction Capacity	3000 m ³ / h	2800 m ³ / h	850 m ³ / h
Suction Capacity (For K Models)	2800 m ³ / h	2600 m ³ / h	-
Noise Level	72 dB (A)	72 dB (A)	65 dB (A)
Dimensions (l x w x h)	650 x 750 x 1050 mm	650 x 750 x 1050 mm	480 x 480 x 820 mm
Dimensions (for K Models) (l x w x h)	650 x 750 x 1200 mm	650 x 750 x 1200 mm	-
Weight	96 kg	108 kg	49 kg
Weight (for K Models)	115 kg	115 kg	-

Product Codes

DFS MP	-	-	8411325M12
DFS 1M / DFS 2M (with 2 m arm)	8411145M12	8411445M12	-
DFS 1M / DFS 2M (with 3 m arm)	8411145M13	8411445M13	-
DFS 1M / DFS 2M (with 4 m arm)	8411145M14	8411445M14	-
DFS 1MK / DFS 2MK (with 2 m arm)	8411245M12	8411545M12	-
DFS 1MK / DFS 2MK (with 3 m arm)	8411245M13	8411545M13	-
DFS 1MK / DFS 2MK (with 4 m arm)	8411245M14	8411545M14	-

Consumables and Optional Accessories

Pre Filter	8490000301	8490000301	-
Main Filter	8490000603	8490000603	-
Carbon Filter (For K Models)	8490000200	8490000200	-
Lighting 3 m (Optional)	8421000103	8421000103	-

Welding Fume Extraction and Filtration Systems

DFS 1S, DFS 2S DFS 1SK, DFS 2SK

Fixed Models



**One Arm Model
DFS 1S**

**Two Arm Model
DFS 2S**

- Operates with 3 Phase 380V/50-60Hz .
- 99% efficient cleaning of welding fume with F8 Filter.
- Aluminium mesh filter for prefiltering and spark arresting.
- Filter change indicator for filter efficiency.
- Reversed phase control lamp.
- 3 m supply cable is provided as standart.
- Acrobat arms can be selected as 2 m, 3 m and 4 m.
- Optional lighting can be attached.
- Carbon filter can be selected for advanced applications.



	DFS 1S DFS 1SK	DFS 2S DFS 2SK
Supply Voltage	380 V - 50 / 60 Hz	380 V - 50 / 60 Hz
Filtering Efficiency	> 99%	> 99%
Motor Power	1,1 kW / 1,5 kW (Modèle K)	1,5 kW
Suction Capacity	3000 m ³ / h	2800 m ³ / h
Suction Capacity (For K Models)	2800 m ³ / h	2600 m ³ / h
Noise Level	72 dB (A)	72 dB (A)
Dimensions (l x w x h)	655 x 755 x 935 mm	655 x 755 x 935 mm
Dimensions (for K Models) (l x w x h)	655 x 755 x 1085 mm	655 x 755 x 1085 mm
Weight	90 kg	90 kg
Weight (for K Models)	110 kg	110 kg

Product Codes

DFS 1S / DFS 2S (with 2 m arm)	8412145M12	8412445M12
DFS 1S / DFS 2S (with 3 m arm)	8412145M13	8412445M13
DFS 1S / DFS 2S (with 4 m arm)	8412145M14	8412445M14
DFS 1SK / DFS 2SK (with 2 m arm)	8412245M12	8412545M12
DFS 1SK / DFS 2SK (with 3 m arm)	8412245M13	8412545M13
DFS 1SK / DFS 2SK (with 4 m arm)	8412245M14	8412545M14

Consumables and Optional Accessories

Pre Filter	8490000301	8490000301
Main Filter	8490000603	8490000603
Carbon Filter (For K Models)	8490000200	8490000200
Lighting 3 m (Optional)	8421000303	8421000303

Welding Fume Extraction and Filtration Systems

DES MS

Mobile Fan System



DES SS

Fixed Fan System

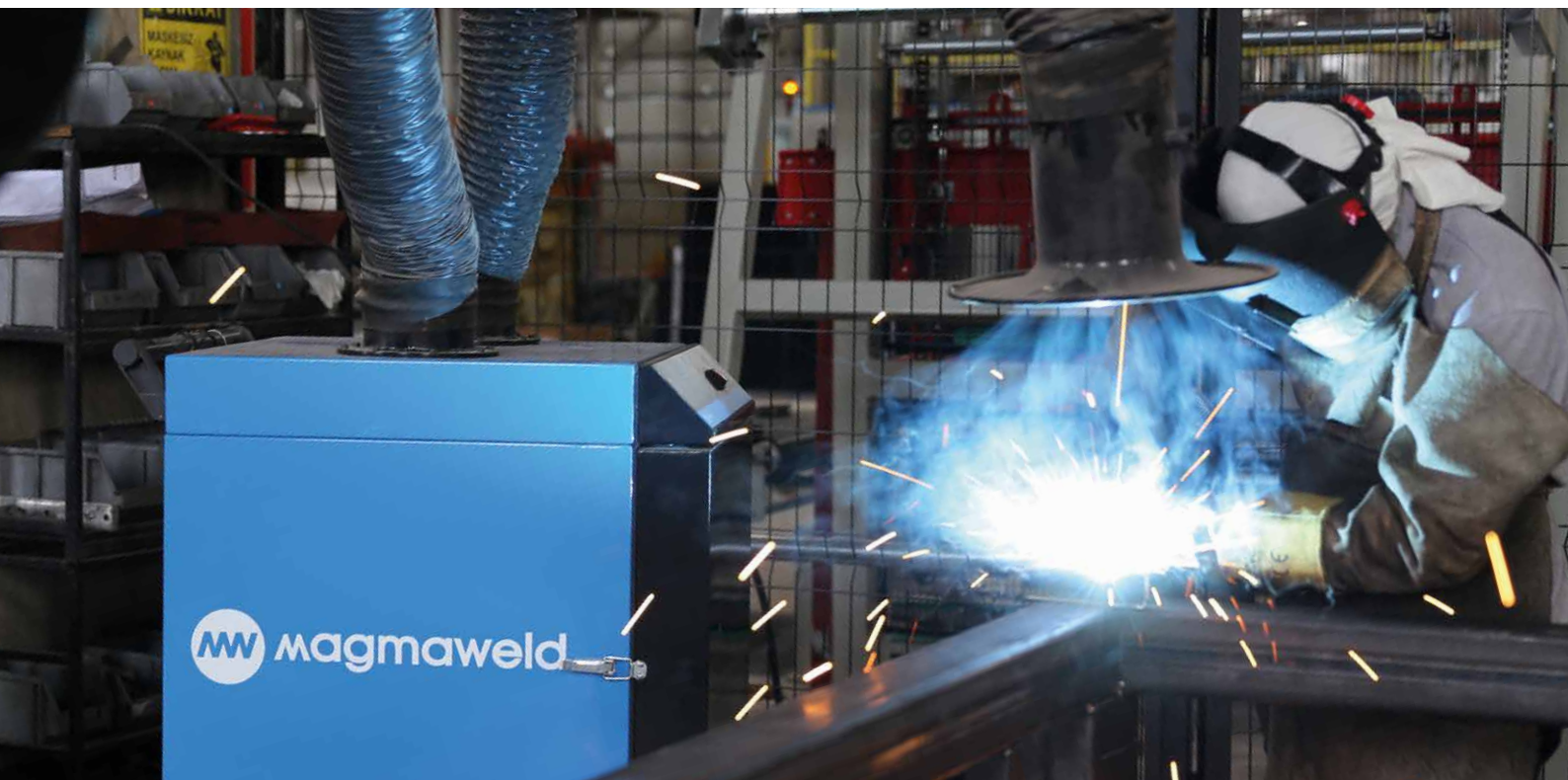


- Operates with 3 Phase 380V/50-60Hz
- Mobile Fan Systems are especially used in arrow and enclosed environments. 5 m suction hose provided as standart. Outlet hose can be selected up to 15 m. Magnet support allows hood to fix anywhere requested.
- Fixed Fan Systems especially used in multiple welding cabins. Fixed fans are generally attached to local wentilation systems. Acrobat arms can be selected as 2 m, 3 m and 4 m.
- Optional lighting can be attached (DES SS models)

	DES MS	DES SS
Besleme Gerilimi	380 V - 50 / 60 Hz	380 V - 50 / 60 Hz
Motor Gücü	1,1 kW	1,1 kW / 1,5 kW
Emiş Kapasitesi	3000 m ³ / h	3000 m ³ / h
Gürültü Seviyesi	69 dB (A)	69 dB (A)
Boyut (u x g x y)	650 x 500 x 250 mm	650 x 500 x 250 mm
Ağırlık	40 kg	37 kg
Product Code (DES MS)	Main Unit	8413145M00
	5 m Outlet Hose	8413145M45
	10 m Outlet Hose	8413145M46
	15 m Outlet Hose	8413145M47
Product Code (DES SS)	1.1 kW (2 m)	-
	1.1 kW (3 m)	-
	1.1 kW (4 m)	-
	1.5 kW (2 m)	-
	1.5 kW (3 m)	-
1.5 kW (4 m)	-	

Optional Accessories

Lighting (2 m)	-	8421000502
Lighting (3 m)	-	8421000503
Lighting (4 m)	-	8421000504



magNET

Tracking of all welding parameters;

- Arc-on Time
- Wire deposition (Speed and Amount)
- Welding current and voltage
- Wire speed and consumption
- Gas flow rate
- Gas consumption saving
- Welding speed (Linear, Rotation or Robot Arm)
- Wire & Gas Cost
- Maintenance plan of welding machine and equipment

» Data Collection and Processing from any brand/model welding machine

» Welding application experience in many sectors from steel construction to automotive

» Easy installation without stopping production

» WPS compliance report and graphics

» EN1090 Archive and WPS Development Tools





From the magNET operator screen;

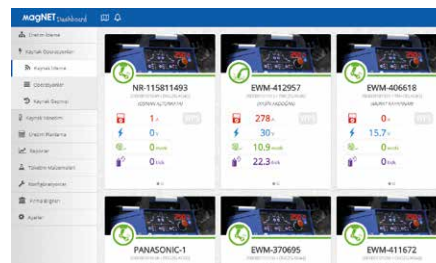
- Welder identification
- Work order, product code and WPS number entries
- Downtime entries
- Welding gas & wire entries

On the computer;

- User-friendly Interface
- Detailed reporting for all collected data
- Machine and welder performance monitoring
- Possibility to create Magmaweld WPS / p-WPS library
- Web-based software
- Application of critical parameters with limits and alarms



Production and Downtime Entries



User Friendly Interface



Gas or Welding Wire Input



Detailed Reporting for All Collected Data

Non-Stop Welding Since 1957

Magmaweld is a developer & manufacturer of Stick Electrodes, MIG/MAG & TIG Wires, Flux Cored Wires, Submerged-Arc Wires and Fluxes, Welding Machines, Fume Extractors, Welding Ancillary Products and Robotic Automation Systems since 1957 in Turkey. 95% of its sales program is manufactured by the two factories in Manisa/Turkey.



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