EWM AG
WE ARE WELDING

Catalogue 2017

Welding machines and accessories

A new dimension of welding

MULTIMATRIX®

/// Perfection is the principle

The EN 1090 WPQR Package is now free of charge!

3 Years 5 Years transformer and rectifier
ewm-warranty*
24 hours / 7 days
*For details visit www.ewm-group.com

Valid from 2017-01-01

/// simply more

The new dimension in welding

MULTIMATRIX®

/// Perfection is the principle

MULTIMATRIX® is the devised solution for all your current and future welding tasks.
ewm further develops welding processes, material and power source characteristics, networking and individual operation on a continuous basis.
MULTIMATRIX® technology makes it possible to adapt to such new developments or welding tasks quickly using data exchange via a USB flash memory or LAN/WiFi network.

Simply...

… better welding
Continually optimised welding properties in all MIG/MAG processes

… greater sustainability
Less power consumed due to highly efficient welding procedures and inverter technology with standby function

… better quality
The ewm Xnet software is suitable for recording, analysing and optimising all welding data, with optionally either LAN or WiFi interface – ideal prerequisites for Industrie 4.0

… better overview
Convenient, intuitive operation – Expert 2.0 control with plain-text display on large screen

… greater process reliability
Precise wire feeding with the drive 4X wire feeder

… greater convenience
Reduced welder fatigue with optimum freedom of movement – MT function torches with X technology – no additional control cable

… greater security of investment
Permanent further development of MULTIMATRIX technology to achieve best possible efficiency and quality

EWM AG – Simply more!

EWM has a fully coordinated system in which all components are systematically geared towards delivering consistently high welding quality, conserving resources and reducing the workload. The advantages for our customers are obvious – the complete product portfolio means that they only have one contact. EWM provides you with advice and service. We also guarantee the quickest availability and delivery times for all of our products. In doing so, we take technological responsibility for the entire welding process.
This catalogue contains the complete EWM product range from welding machines.

■ Advice + service

Have you got any questions which are not answered in this catalogue? Our global EWM branches and sales partners are happy to help and advise you at any time. You will find your local partner online at www.ewm-group.com. Alternatively, please contact the EWM works team at any time on +49 2680 181-0 or info@ewm-group.com.

■ Validity

See title page. All catalogues with earlier dates are hereby void.

■ Financing

Do you only require a machine temporarily or you would like to finance it? We will naturally be happy to provide you with an attractive leasing or rental quotation. Contact us or your dealer.

■ Up to five-year warranty

Our welding machines combine future-oriented, state-of-the-art technology of the highest quality in all their high-tech components. We take full responsibility for this! Each of our products is carefully checked. We have every faith in our products and therefore provide you with a five or three-year warranty on our welding machines, also for 3-shift operation, in accordance with the current version of the warranty conditions.

■ Returns

If you do need to return a product for some reason, please discuss this with the seller in advance. Your return can only be accepted and processed to your satisfaction as quickly as possible in accordance with our return conditions if previously agreed upon and if the goods are in their original packaging. Custom-made products cannot be exchanged.

■ T&Cs + technical data

All products are supplied in accordance with the Terms and Conditions of the applicable EWM sales company. The information in our documents is non-binding. We retain the right to make changes on the grounds of technical developments or errors.

Contact EWM

■ Internet www.ewm-group.com

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You can contact us by phone Monday to Friday from 7.30 am to 5 pm 02680-181-0

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■ Marketing marketing@ewm-group.com

■ Technical documentation documentation@ewm-group.com

■ Quality management qm@ewm-group.com

■ Automation automatisierung@ewm-group.com

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Taurus 355 Synergic S HP MM TKW 139
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Tetrix 230 Comfort 2.0 puls TM 208
Tetrix 300 Smart ● Classic ● Comfort TM 210
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MULTIMATRIX (MM)

Multiprocess MIG/MAG pulse welding machines

	alpha Q 330	alpha Q 351 puls	alpha Q 551 puls	alpha Q 551 puls D	alpha Q 551 puls 2DV
Pulse					
Standard					
forceArc®/forceArc puls					
coldArc®/coldArc puls					
rootArc®/rootArc puls					
pipeSolution®					
Page	**68**	**71**	**71**	**75**	**77**
DC	330 A / 40 %	–	–	–	–
	270 A / 60 %	–	550 A / 60 %	550 A / 60 %	550 A / 60 %
	210 A / 100 %	350 A / 100 %	420 A / 100 %	420 A / 100 %	420 A / 100 %
Control systems					
alpha Q Progress	G W	W	W	W	W
alpha Q Expert 2.0		W	W		W

MULTIMATRIX (MM)

Multiprocess* MIG/MAG pulse welding machines

	Phoenix 401 puls	Phoenix 501 puls	Phoenix 351 puls	Phoenix 401 puls	Phoenix 451 puls	Phoenix 551 puls
Pulse						
Standard						
forceArc®/forceArc puls						
rootArc®/rootArc puls						
Page	**104**	**105**	**107**	**107**	**108**	**108**
DC	–	–	–	–	–	–
	–	500 A / 60 %	–	–	450 A / 80 %	550 A / 60 %
	400 A / 100 %	430 A / 100 %	350 A / 100 %	400 A / 100 %	**420 A / 100 %**	**420 A / 100 %**
Control systems						
Picomig puls						
Phoenix Progress	W	W	W	W	W	W
Phoenix Expert 2.0	–	–	W	W	W	W

MULTIMATRIX (MM)

Multiprocess* MIG/MAG standard welding machines

	Taurus 355	Taurus 355	Taurus 405	Taurus 505	Gouging up to 1,000 A – Taurus	Gouging Taurus 505 Basic
Standard						
forceArc® *						
rootArc® *						
Page	**134**	**140**	**141**	**141**	**150**	**141**
DC	350 A / 40 %	–	–	–	–	–
	300 A / 60 %	350 A / 60 %	–	500 A / 60 %	**1000 A / 60 %**	**500 A / 60 %**
	270 A / 100 %	300 A / 100 %	400 A / 100 %	430 A / 100 %	**860 A / 100 %**	**430 A / 100 %**
Control systems						
Taurus Basic	G W	G W	G W	G W	G	G
Taurus Synergic S*	G W	G W	G W	G W	–	–

*** Multiprocess = MIG/MAG, TIG, MMA and gouging**

** Taurus Synergic S: with MULTIMATRIX technology, forceArc and rootArc

G Gas-cooled W Water-cooled

	Picomig 180 puls	Picomig 185 puls	Picomig 305 puls	Phoenix 355 puls	Phoenix 355 puls	Phoenix 405 puls	Phoenix 505 puls
Pulse							
Standard							
forceArc®/forceArc puls *							
rootArc®/rootArc puls *							
Page	**83**	**84**	**85**	**92**	**97**	**97**	**98**
DC	180 A / 25 %	180 A / 25 %	350 A / 40 %	350 A / 40 %	–	–	–
	120 A / 60 %	120 A / 60 %	300 A / 60 %	300 A / 60 %	350 A / 60 %	–	500 A / 60 %
	100 A / 100 %	100 A / 100 %	270 A / 100 %	270 A / 100 %	300 A / 100 %	400 A / 100 %	430 A / 100 %
Control systems							
Picomig	G	G	G	–	–	–	–
Phoenix Progress	–	–	–	G W	W	W	W
Phoenix Expert 2.0	–	–	–	G W	W	W	W

Multiprocess* MIG/MAG standard welding machines

	Phoenix 551 puls D	Phoenix 551 puls 2DV	Picomig 180 Synergic	Picomig 185 Synergic	Picomig 305 Synergic	Taurus 400 Basic
Standard						
forceArc® *						
rootArc® *						
Page	**113**	**116**	**123**	**124**	**125**	**133**
DC	–	–	180 A / 25 %	180 A / 25 %	350 A / 40 %	400 A / 30 %
	550 A / 60 %	550 A / 60 %	120 A / 60 %	120 A / 60 %	300 A / 60 %	280 A / 60 %
	420 A / 100 %	**420 A / 100 %**	100 A / 100 %	100 A / 100 %	270 A / 100 %	230 A / 100 %
Picomig Synergic			G	G	G	
Taurus Basic	W	W	–	–	–	G
	–	W	–	–	–	

* Picomig 305 only

	Taurus 351	Taurus 401	Taurus 501	Taurus 351	Taurus 401	Taurus 451	Taurus 551
	152	**152**	**158**	**164**	**164**	**164**	**165**
	–	–	–	–	–	–	–
	–	–	500 A / 60 %	–	–	450 A / 80 %	**550 A / 60 %**
	350 A / 100 %	400 A / 100 %	430 A / 100 %	350 A / 100 %	400 A / 100 %	420 A / 100 %	**420 A / 100 %**
	G W	G W	W	G W	G W	G W	G W
	G W	G W	W	G W	G W	G W	G W

Contents

Standard MIG/MAG welding machines, step switch controlled

	Mira 151	Mira 221	Mira 251	Mira 301	Saturn 301	Saturn 351
Standard						
Page	180	180	180	181	183	183
DC	150 A / 15 %	220 A / 15 %	250 A / 20 %	300 A / 20 %	300 A / 40 %	350 A / 40 %
	–	–	–	–	190 A / 60 %	250 A / 60 %
	55 A / 100 %	85 A / 100 %	125 A / 100 %	150 A / 100 %	160 A / 100 %	220 A / 100 %
Control systems						
M 1.02	G	G	G	G	G	G
M 2.20	–	–	–	G	G	G
M 2.40	–	–	–	G	G	G

G Gas-cooled W Water-cooled

Accessories

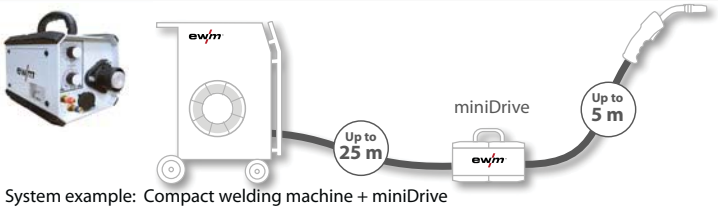
Wire feeders | Intermediate hose packages | Welding torches/function torches | Remote controls | Cooling units | Transport carts

283 * 314 / 316 / 311 / 311 * 320 / 333 / 339 / 339 360 370 131

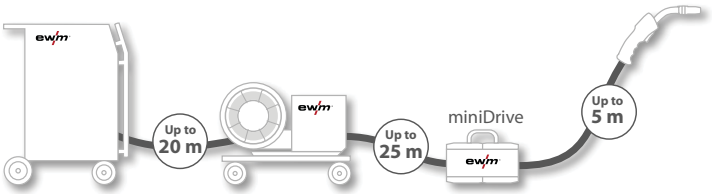
* Left to right: alpha Q/Phoenix/Taurus/Mira, Saturn, Wega

Saturn 351	Wega 401	Wega 401	Wega 501	Wega 601
187	188	192	195	195
350 A / 40 % 250 A / 60 % 220 A / 100 %	– 400 A / 60 % 300 A / 100 %	– 400 A / 60 % 300 A / 100 %	– 500 A / 60 % 400 A / 100 %	600 A / 45 % – 450 A / 100 %
G	G W	G W	W	W
G	G W	G W	W	W
G	G W	G W	W	W

Intermediate drive – miniDrive



System example: Compact welding machine + miniDrive



System example: Decompact welding machine + wire feeder + miniDrive

Intermediate hose packages for aluminium welding are only available up to a length of 15 m.

294

EWM EN 1090 WPQR Package

Certification to EN 1090 made easy:

- **EWM welding procedure specifications – extendible as required**
- **Can also be used for machines already purchased from the alpha Q, Phoenix, Taurus Synergic and Picomig series**
- **Tested and qualified welding consumables**

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Contents

TIG DC welding machines

	Picotig 200	Picotig 200 MV	Tetrix 200 puls	Tetrix 200 MV	Tetrix 230 puls	Tetrix 300	Tetrix 300 puls
TIG DC							
activArc®							
spotArc®							
MMA							
Page	**204**	**205**	**206**	**207**	**209**	**210**	**213**
DC	200 A / 25 %	–	200 A / 25 %	–	230 A / 40 %	–	**300 A / 35 %**
	150 A / 60 %	120 A / 60 %	150 A / 60 %	120 A / 60 %	200 A / 60 %	300 A / 60 %	260 A / 60 %
	120 A / 100 %	100 A / 100 %	120 A / 100 %	100 A / 100 %	170 A / 100 %	250 A / 100 %	210 A / 100 %
Control systems							
Picotic	G	G	–	–	–	–	–
Smart	–	–	G	–	–	G W	–
Classic	–	–	–	–	–	G W	–
Comfort 2.0	–	–	–	–	G W	–	G W
Comfort	–	–	G	G	–	G W	–
Synergic	–	–	–	–	–	–	–
activArc/spotArc	– / –	– / –	• / •	• / •	• / •	• / •	• / •

AC/DC TIG welding machines

	Picotig 200 AC/DC	Tetrix 230 AC/DC puls	Tetrix 300 AC/DC puls
TIG DC/TIG AC			
activArc®			
spotArc®			
MMA			
Page	**222**	**224**	**226**
DC	200 A / 35 %	230 A / 40 %	300 A / 35 %
	150 A / 60 %	200 A / 60 %	260 A / 60 %
	120 A / 100 %	170 A / 100 %	210 A / 100 %
Control systems			
Picotic AC	G	–	–
Smart AC	–		–
Classic AC	–	–	–
Comfort 2.0 AC	–	G W	W
Comfort AC	–	–	-
Synergic AC	–	–	
activArc/spotArc	– / –	• / •	• / •

G Gas-cooled W Water-cooled

Accessories

Hot wire power source	Wire feeder for filler wire	Remote controls	Cooling units	Transport carts
246	**288**	**360**	**131**	**370**

Tetrix 351	Tetrix 401	Tetrix 451	Tetrix 551	Tetrix 551 AW cold wire / hot wire
215	215	215	215	231 231
–	–	–	–	–
–	–	450 A / 80 %	550 A / 60 %	550 A / 60 %
350 A / 100 %	400 A / 100 %	420 A / 100 %	420 A / 100 %	420 A / 100 %
–	–	–	–	–
W	W	W	W	–
W	W	W	W	–
–	–	–	–	–
W	W	W	W	–
W	W	W	W	W [1] W [2]
• / •	• / •	• / •	• / •	• / •

[1] Cold/ [2] hot wire

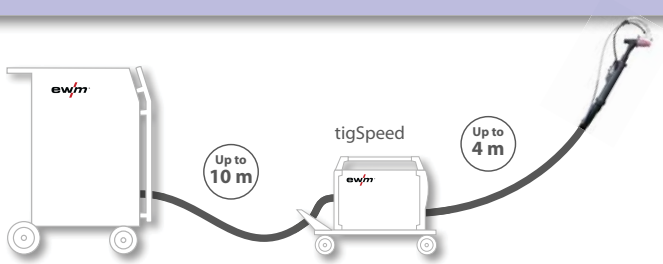
Tetrix 351 AC/DC	Tetrix 451 AC/DC	Tetrix 551 AC/DC	Tetrix 551 AC/DC AW cold wire / hot wire
228	228	228	235 235
–	–	–	–
350 A / 60 %	450 A / 80 %	550 A / 60 %	550 A / 60 %
300 A / 100 %	420 A / 100 %	420 A / 100 %	420 A / 100 %
–	–	–	–
W	W	W	–
W	W	W	–
–	–	–	–
W	W	W	–
W	W	W	W [1] W [2]
• / •	• / •	• / •	• / •

[1] Cold/ [2] hot wire

tigSpeed

Wire feeders for hot and cold wire
With superimposed forward/backward wire motion

245



System example: TIG welding machine + tigSpeed + welding torch

Contents

DC plasma welding machines

microplasma 20 | microplasma 50 | microplasma 120 | Tetrix 150 Plasma

Plasma
TIG DC/TIG AC
activArc®
spotArc®
MMA

Page	248	248	249	251
DC	–	–	120 A / 35 %	–
	–	–	–	–
	20 A / 100 %	50 A / 100 %	70 A / 100 %	150 A / 100 %
Control systems				
microplasma	G	G	G	–
Classic DC	–	–	–	W
Comfort DC	–	–	–	W
Synergic DC	–	–	–	W
Synergic AC/DC	–	–	–	–
activArc/spotArc	– / –	– / –	– / –	• / •
TIG DC/TIG AC	– / –	– / –	– / –	• / –

You will find more plasma welding machines with gas control in our automated welding price list.

MMA DC welding machines

Pico 160 cel puls | Pico 162 | Pico 162 MV | Pico 180 | Pico 220 cel puls | Pico 300 cel

MMA
TIG DC
Gouging

Page	254	255	278	256	257	258
DC	150 A / 30 %	150 A / 35 %	110 A / 35 %	180 A / 25 %	220 A / 30 %	300 A / 25 %
	120 A / 60 %	120 A / 60 %	90 A / 60 %	130 A / 60 %	160 A / 60 %	220 A / 60 %
	110 A / 100 %	100 A / 100 %	80 A / 100 %	120 A / 100 %	140 A / 100 %	170 A / 100 %
Control systems						
Pico 160	G					
Pico 162 (MV)		G,	G	–	–	–
Pico 180		–	–	G	–	–
Pico 220 cel puls		–	–	–	G	–
Pico 300 cel (pws)		–	–	–	–	G
Pico 350 cel (pws)		–	–	–	–	–
TIG/gouging		• / –	• / –	• / –	• / –	• / –

G Gas-cooled W Water-cooled

General accessories

Wire feed rollers | Software | Welding Trainer | Repetition test | Spare parts sets | Calibration device Load simulation device

300	433	434	429	428	430

Accessories for plasma welding machines

Remote controls | Cooling units | Recooling units | Transport carts | Gas metering units

359

364

365

372

385

Accessories for MMA welding machines

Gouging | Remote controls | Transport carts | Electrode holders | Wire feeders

373

353

369

379

288

Pico 300 cel pws	Pico 350 cel puls	Pico 350 cel puls pws	Pico 350 cel puls pws dgs	Pico 350 cel puls Pico 350 cel puls pws	+ Pico drive 4L
258	259	259	261	131	
300 A / 25 % 220 A / 60 % 170 A / 100 %	350 A / 35 % 280 A / 60 % 230 A / 100 %	350 A / 35 % 280 A / 60 % 230 A / 100 %	350 A / 35 % 280 A / 60 % 230 A / 100 %	350 A / 35 % 280 A / 60 % 230 A / 100 %	
–	–	–	–	–	
–	–	–	–	–	
–	–	–	–	–	
G	–	–	–	–	
–	G	G	G	G	
• / –	– / –	– / –	– / –	– / –	

Degauss 600 | Services | Overview of multivolt machines

58

438

279

all in – All characteristics and welding procedures are included in the machine price

EWM machines are always equipped with all device-specific welding procedures for steel, CrNi and aluminium – that is EWM's "All-in" philosophy.

- **forceArc puls**
  Fast, spatter-free and cost-effective pulse welding for the entire performance range
- **forceArc**
  Powerful arc for the higher performance range
- **coldArc/coldArc puls**
  Heat-reduced short arc with significantly less distortion; suitable for thin metal sheeting and root welding; coldArc puls for the higher performance range
- **pipeSolution**
  Safe welding in every position, with or without a gap
- **rootArc/rootArc puls**
  Short arc for effortless gap bridging; rootArc puls for the higher performance range
- **superPuls**
  Quick and easy welding of vertical-up welds without using the "Christmas tree technique"
- **MIG/MAG pulse arc**
- **MIG/MAG standard arc**
- **TIG and MMA welding, gouging, MIG brazing and much more**

EN 1090 WPQR Package

Now free download in PDF format!

Save time and money on qualification of welding processes: The ewm EN 1090 WPQR package provides you with WPQR certificates and welding procedure specifications for almost 90% of all standard welding positions and joints, usable with many ewm welding machines[1] and easily extended.

With welding consumables tested for suitability, the same WPQR certificates can even be used for welding machines by any manufacturer using the appropriate corresponding welding consumable.

You will now receive the EN 1090 WPQR package as a free PDF download whenever you purchase a new welding machine from the alpha Q, Phoenix, Taurus Synergic S or Picomig machine series!

This is how it works:

1. You acquire a new ewm welding machine from the alpha Q, Phoenix, Taurus Synergic S or Picomig machine series.
2. Register it with the machine serial number at www.ewm-group.com/en/registration

   Registration ensures that you are informed about all updates, add-ons and changes!
3. Once registration is successfully completed, you can then simply download the EN 1090 WPQR package. The download link is sent to you together with your certificate.

Alternatively, you can also purchase the EN 1090 WPQR package:

- **EN 1090 WPQR package folder**
  A folder in paper format at cost price.
  The package can also be downloaded in PDF format.
- **EN 1090 WPQR CD ROM**
  We will also gladly send you a CD at an extra cost.

Type	Description	Item no.	PG	Price
EN 1090 WPQR package folder	EN 1090 WPQR package in a folder	090-008803-00000	D1	125.00 €*
EN 1090 WPQR package CD ROM	EN 1090 WPQR package on CD ROM	090-008804-00000	D1	16.00 €*
EN 1090 WPQR package download	EN 1090 WPQR-package as a download	KOS-V00055-00000	N1	0.00 €*

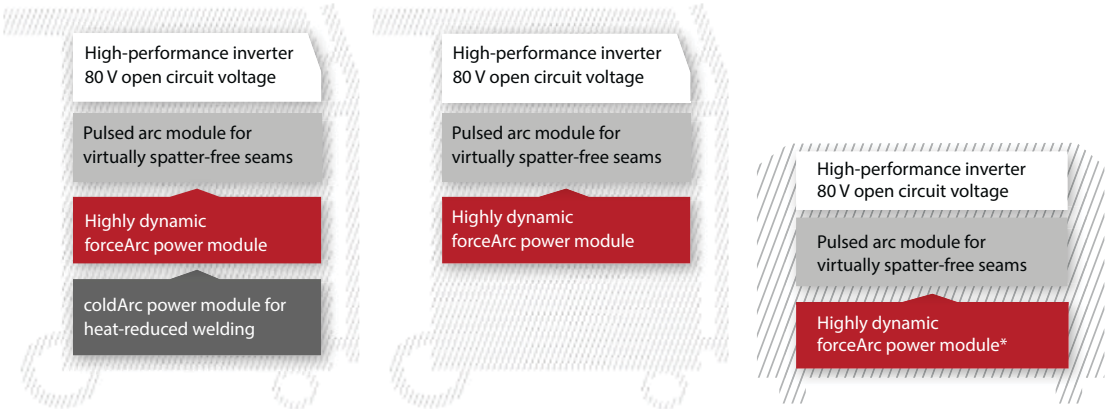
*If no new welding machine is purchased, the EN 1090 WPQR package costs 295,00 € in a folder / 210,00 € as a CD ROM / 169,00 € as a download! If a new welding machine from the alpha Q, Phoenix, Taurus Synergic S or Picomig series is purchased downloading the package is free!

Would you like to know what is included in the package?
If so, just ask for the free demo version at
www.ewm-en1090.com

[1]This qualification may also be used retrospectively for all previously purchased inverter machines mentioned above (manufactured in 2010 or later).

Inverter welding machines and welding procedures

Compact or decompact with the latest MULTIMATRIX® technology, ewm welding machines are well-conceived in every way. For simple operation and reliability in use.

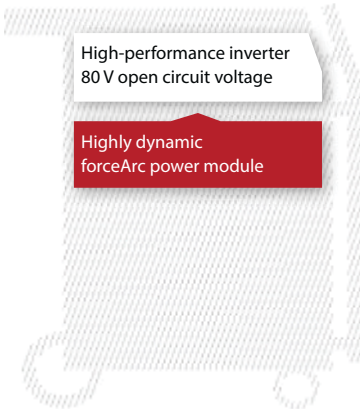


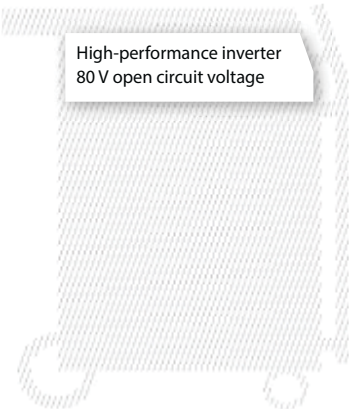
		alpha Q puls	Phoenix puls	Picomig puls
MULTIMATRIX technology		✓	✓	-
Multiprocess	forceArc / forceArc puls	✓ / ✓	✓ / ✓	✓* / ✓*
	coldArc / coldArc puls	✓ / ✓	- / -	- / -
	rootArc / rootArc puls	✓ / ✓	✓ / ✓	✓* / ✓*
	pipeSolution	✓	-	-
	superPuls	✓	✓	✓
	Pulsed arc	✓	✓	✓
	Standard short arc	✓	✓	✓
	Standard spray arc	✓	✓	✓*
	MMA	✓	✓	✓
	TIG (lift arc)	✓	✓	✓
	Gouging	✓	✓	-
	Xnet-compatible	✓	✓	-

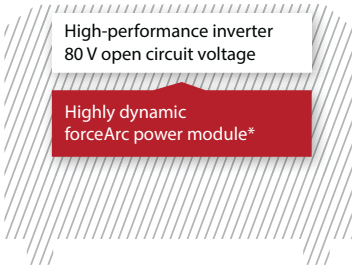
* Picomig 305 puls / Picomig 305 Synergic

Your benefits

- Robust, highly dynamic inverter technology
- Energy savings thanks to efficient welding procedures, optimum efficiency and automatic standby mode
- High open circuit voltage for excellent ignition characteristics
- High voltage reserves for long hose packages up to 70 m
- High duty cycle
- Wide mains voltage tolerance (-25% to +20%)
- For all climate zones, from the desert to Antarctica
- Rugged, dust-protected electronics
- Certified in accordance with EN 1090





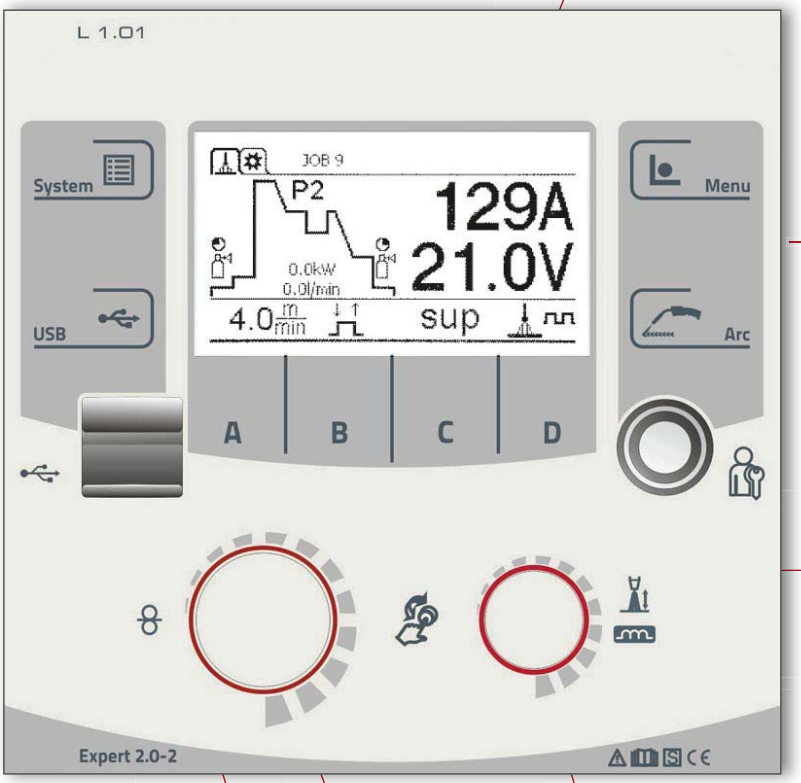


Taurus Synergic S	Taurus Basic	Picomig Synergic
✓	-	-
✓ / -	- / -	✓* / -
- / -	- / -	- / -
✓ / -	- / -	✓* / -
-	-	-
✓	-	-
-	-	-
✓	✓	✓
✓	✓	✓*
✓	✓	✓
✓	-	✓
✓	✓	-
✓	-	-

* Picomig 305 puls / Picomig 305 Synergic

All information at a glance,
quickly accessed

Direct access to expert knowledge. Numerous welding tasks can now be set up and read more easily. This means that all information displays can be individually adapted to the requirements of the user; operating errors are thus drastically reduced. Thanks to the new full-text menu, you also have the entire welding process and all important parameters available at a glance.



Clearly arranged LCD screen

- Plain text display for welding parameters and functions
- You have a perfect overview of everything, even through a welding helmet
- Anti-glare surface, easily readable even with reflected light

Practice-based control

- Clearly arranged, self-explanatory key buttons and LCD screen
- Membrane keyboard – resistant against dust, dirt and moisture
- Matrix operation – quicker to change between levels

Xbutton

- Scaled access authorisation
- Individual menu adaptation

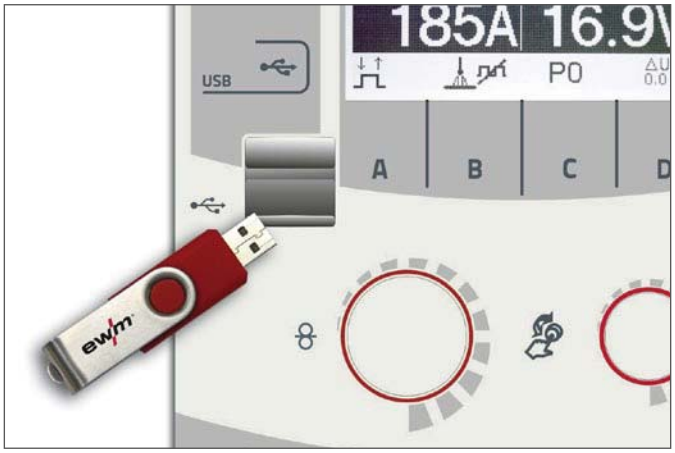
Click wheel

- Easy and intuitive to operate

USB connection

- Offline data transfer

Easy data exchange using USB flash memory



Access authorisation using Xbutton

LAN/Wi-Fi networking of power sources

Your benefits

Invest in the future!

- ewm is further developing welding processes, material characteristics, networking and individual operation on a continuous basis.
- MULTIMATRIX technology makes it possible to adapt to these new developments or welding tasks quickly using data exchange via a USB flash memory or LAN/Wi-Fi networks.

Individual user rights

- Administration of access rights for different control operating levels
- Identification of the welder
- Provision of individual welding parameters for each welder
- The ewm Xnet quality management software provides precise final costing thanks to data recording on an individual basis for each machine and application
- Extremely robust and considerably more durable than RFID chip cards, for example
- Incredibly easy to use even when wearing gloves
- Practical as it can be carried on a key ring, for example

Networking of any number of power sources

- LAN/Wi-Fi networking via built-in Expert 2.0 control or an external LAN/Wi-Fi gateway

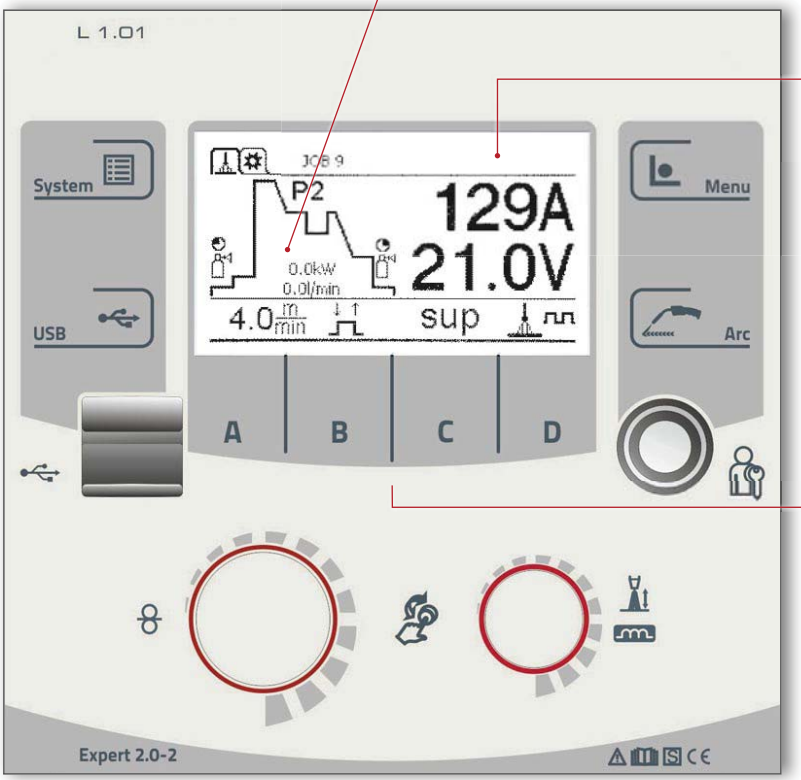
You will find detailed information on networking ewm welding machines on pages 30 and 31 or in the ewm Xnet quality management software brochure

Easier to operate

Control with Expert 2.0 LC display – functions

Everything at a glance, with quick access

Expert 2.0 features different practical user menus which ensure safe operation of the welding machine



Display of the effective arc power

- For easy calculation of the energy per unit length

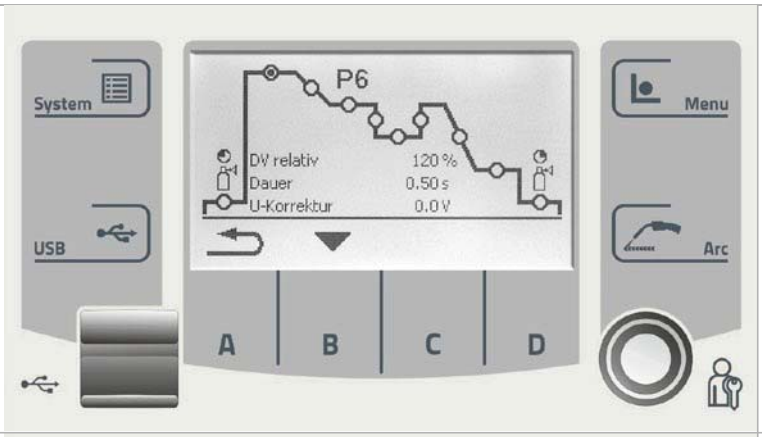
Robust protective screen for the display

- Scratch-proof protective screen for the display made of acrylic glass with hard coating
- Always clearly legible – no signs of wear, unlike touchscreens, for example
- 3 mm thick acrylic glass protective screen protects the LC display against damage

Reliable selection of welding parameters

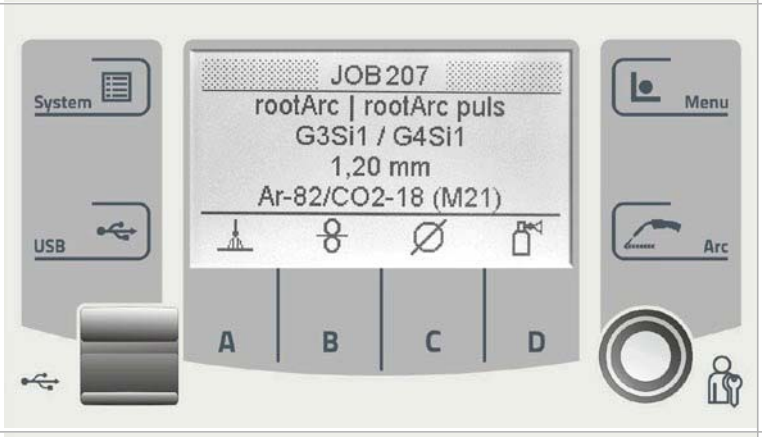
- Selected using durable hardware keys
- No signs of mechanical wear on the LCD display, unlike touchscreens, thanks to hardware keys

Your benefits



Display and change of welding program sequence

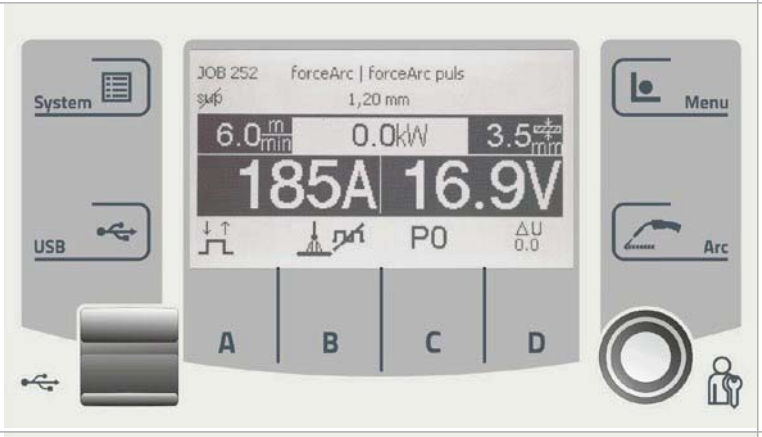
/ You can set all parameters in the program sequence



Start window for the JOB (welding task) selection

/ Practice-based control

/ JOB (welding task) easy to select using click wheel
- welding process
- material type
- gas type
- wire diameter



Screen showing welding parameters

/ Displays the effective arc power for a simple calculation of energy per unit length

/ Nominal, actual and hold values

/ Operating modes

/ Status messages

Language selection menu

/ The user interface is available in 13 languages

Phoenix puls

alpha Q puls

forceArc puls

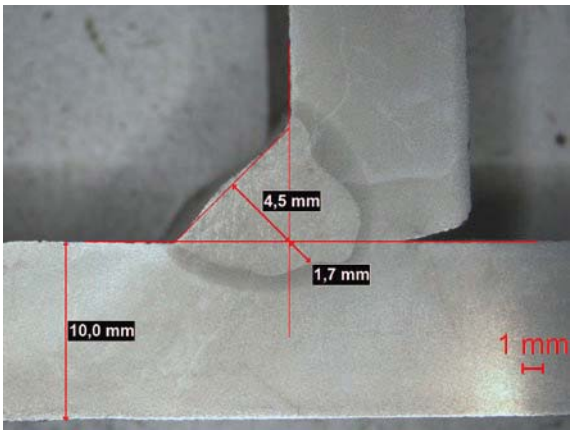
Fast, spatter-free, cost-saving pulse welding

Heat-reduced, easily managed pulse arc for the entire power range

For welding non-, low- and high-alloy materials

- Handling easy to learn, no familiarisation periods
- Can be used for forehand and backhand welding
- Excellent gap bridging
- Highly suitable for multi-pass welds
- Suitable for root welding on backing bar with up to 4 mm air gap
- Less distortion thanks to heat-reduced arc
- Excellent side wall wetting
- Rapid welding without undercuts
- Safe welding of scaled or badly rusted sheets
- Quiet arc, low strain on the welder, reduced welding fumes
- Changes to stick-out lengths are very rapidly stabilised
- Manual and automated application

Simple, safe, easy-to-learn handling of forceArc puls

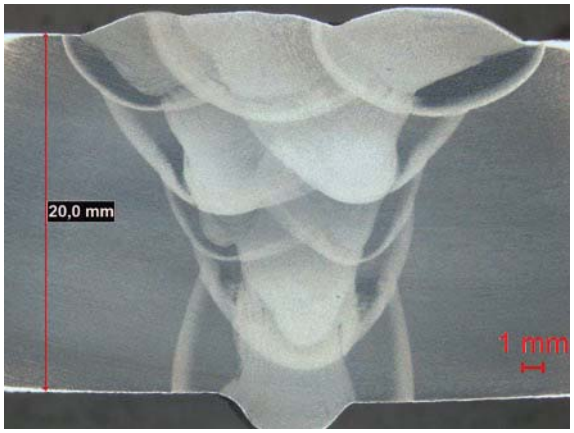


S355, t = 10 mm, T-joint, fillet weld without weld preparation
Welding current = 316 A, welding voltage = 28.8 V, WF = 10.5 m/min., Vs = 50 cm/min.

- Pulse welding – simple, safe, easy-to-learn handling for manual welding
- Fast, spatter-free welding without rework
- Symmetric fillet weld formation– maximum possible throat thickness can be achieved
- Controlled welding for changeable air gap up to 4 mm
- Good side wall wetting, no undercuts
- Eminently suitable for sheets with scaled or badly rusted surface
- For forehand and backhand torch operation

The EWM EN 1090 WPQR package saves time and money

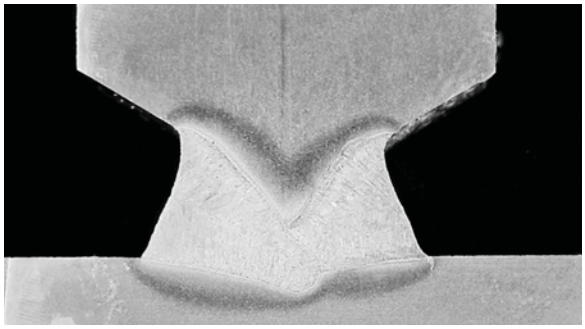
forceArc puls for multi-pass welds



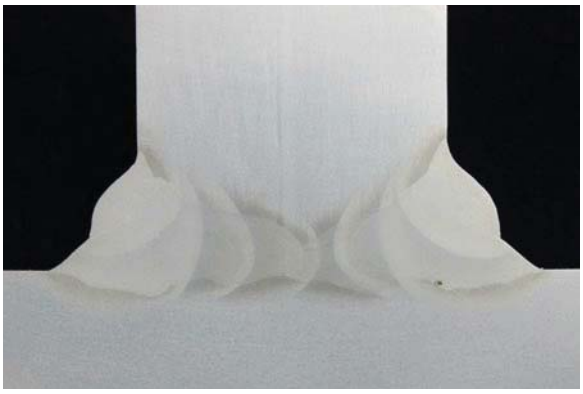
S355, t = 20 mm, butt joint, single-V butt weld with 30° included angle, on ceramic backing bar

- Eminently suitable for multi-pass welds
- Heat-reduced compared with standard pulse welding
- Several weld beads can be welded before the maximum intermediate pass temperature is reached
- Less distortion of the component thanks to heat reduction

forceArc puls for full penetration



Soft martensitic steel, high-alloy steel (1.4317), t = 50 mm, single-J butt weld, welded without air gap on both sides, without gouging or grinding on the root concavity side



S355, t = 30 mm, double bevel seam with 35° included angle, welded without air gap on both sides, without gouging or grinding on the root concavity side

- Root passes with backing bar, filler and final passes with butt joint
- Welded full penetrations on both sides
- Without gouging or grinding on the root concavity side, with or without air gap, on butt and T-joints

Your benefits

- Fast, spatter-free, cost-saving pulse welding
- Handling easy to learn, no familiarisation periods
- Quiet arc, low strain on the welder, reduced welding fumes
- Less distortion thanks to heat-reduced arc
- Excellent side wall wetting
- Can be used for forehand and backhand welding
- Suitable for root welding on backing bar with up to 4 mm air gap
- Excellent gap bridging
- Highly suitable for multi-pass welds

MULTIMATRIX®
/// Perfection is the principle

Taurus Synergic S

Phoenix puls

alpha Q puls

forceArc

Efficient and cost-effective welding

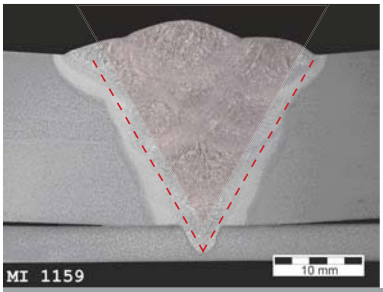
Heat-reduced, directionally stable and powerful arc with deep penetration for the upper power range.
Non-alloyed, low-alloy and high-alloy steels and high-tensile fine-grained steels

- Smaller included angle due to deep penetration and directionally stable arc
- Fewer passes
- Less distortion thanks to heat-reduced, concentrated arc
- Excellent root and sidewall fusion
- Perfect welding, even with very long stick-outs
- Reduced undercuts
- Virtually spatter-free
- Particularly beneficial for fillet welds, dynamically loaded components such as load-bearing parts for bridges, wagon and steel construction and other applications
- Non-alloyed, low-alloy and high-alloy steels, as well as high-tensile fine-grained steels
- Manual and automated applications

Process comparison of forceArc®/standard spray arc through TWI

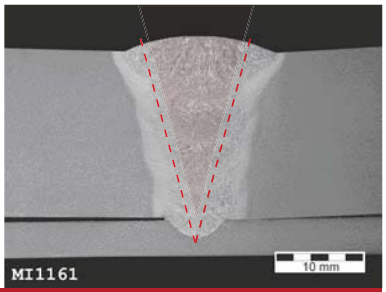
- Butt welds which are welded with the forceArc process and have tight opening angles of 30 ° and 40 ° comply with the requirements of EN ISO 15614-1:2004
- Due to the lower weld volume, the welding times are reduced compared to the standard spray arc process with an opening angle of 60° by up to 50%
- Fillet welds created with forceArc provide a mitred profile without undercut which also satisfies the requirements of EN ISO 15614-1:2004
- Fillet welds created with forceArc have a greater penetration depth

standard spray arc



11 passes

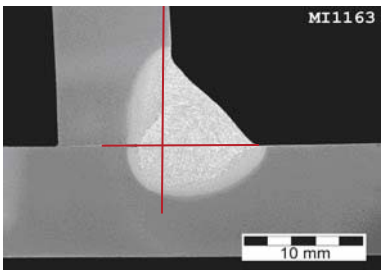
forceArc



5 passes

50% shorter welding time

Unchanged mechanical/technological properties!

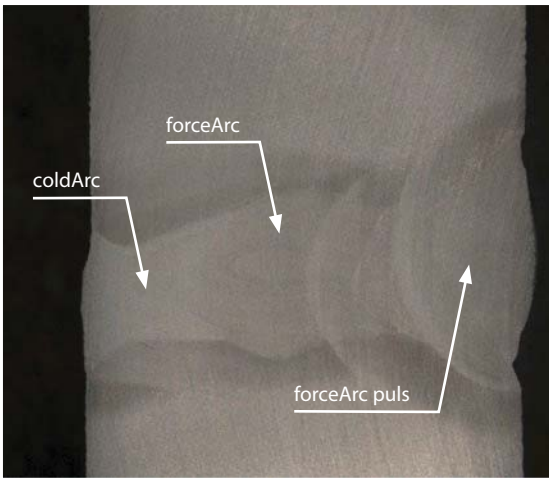


- Deeper penetration and therefore possible reduction of the effective throat thickness or seam cross-section
- Changes to stick-out lengths are rapidly stabilised
- Particularly advantageous for very narrow joints and fillet welds, for example

The ewm EN 1090 WPQR Package saves time and money

forceArc forceArc puls

- Combination of forceArc puls, forceArc and coldArc
- Root pass with coldArc, intermediate passes with forceArc and final pass with forceArc puls
- Saves a welding pass with a smaller included angle
- Perfect ignition and crater fill time with forceArc puls, welding with forceArc
- Less material distortion due to reduced heat input
- Lower intermediate pass temperature and minimised joint modification
- Particularly advantageous when, for example, welding fine-grained steels
- Angular shrinkage reduced in fillet welds



Sheet metal: S 235; 20 mm
Gas: M21-ArC-18
Wire: 1.2 mm G4Si1
Passes: 4
Position: PC
Included angle: 10°
Welded on one side, without weld pool backing

Combination of coldArc, forceArc and forceArc puls

Efficient and cost-effective welding

- Overall cost savings of up to 60%
- Minimal seam preparation
- Fewer passes
- Less welding consumables and shielding gas consumption
- Faster welding time
- Particularly advantageous with dynamically loaded components

Sheet metal: S 355; 30 mm
Gas: M21-ArC-18
Wire: 1.2 mm G4Si1
Passes: 11
Position: PB/PA
Included angle: 25°
Welded on one side, without weld pool backing with forceArc

Your benefits

forceArc

/ Up to 60% overall cost savings when comparing forceArc vs. standard spray arc welding.

/ Up to 35% electricity cost savings with the same deposition rate when compared to conventional spray arc welding

/ Up to 50% less harmful emissions through reduced welding fumes

/ Cost savings thanks to fewer passes

/ Less spatter means less finishing work

/ Less distortion thanks to heat-reduced, concentrated arc

/ Highly dynamic current control produces a directionally stable arc with great force and great penetration depth with fewer undercuts

MULTIMATRIX®
/// Perfection is the principle

alpha Q puls

coldArc
coldArc puls
Perfect welding and brazing

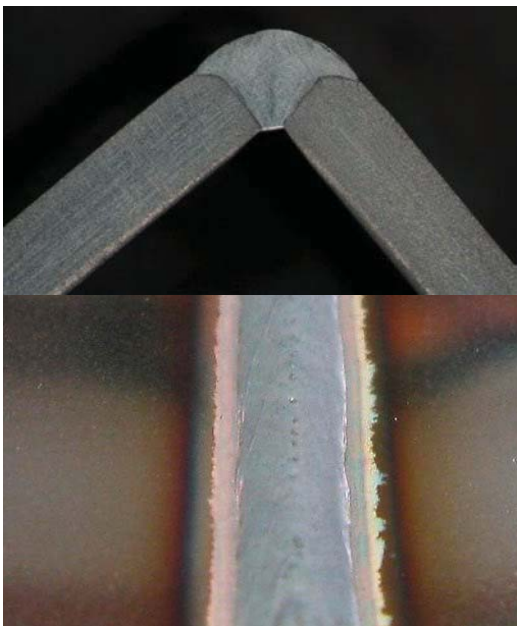
coldArc: Heat-reduced, low-spatter short arc for high dimensional stability welding and brazing, plus root welding with excellent gap bridging capabilities.

coldArc puls: The optimum enhancement for the higher performance range, with focused heat input – there where the heat is required.

- Less distortion and reduced discolouration thanks to minimised heat input
- Considerably reduced spatter thanks to virtually power-free material transfer
- Impressive process stability even with long hose packages without additional sensor leads
- Commercial torch systems, as the material is transferred without drive in the torch, causing no wear and tear
- Easy welding of the root passes in all sheet thicknesses and in all positions
- Perfect gap bridging even with inconsistent gap widths
- Excellent wetting of surfaces when brazing thin metal sheets
- Minimal finishing work, also optimum for visible seams
  thanks to low-spatter process
- Unalloyed, low-alloy and high-alloy steels and also dissimilar joints of even the thinnest metal sheets
- Brazing of CrNi sheets with CuAl8/AlBz8
- Brazing and welding of coated metal sheets, e.g. with CuSi, AlSi and Zn
- Root welding of non-alloyed and low-alloy steels and high-tensile fine-grained steels
- Visible CrNi seams within the thin metal sheet range

Minimised heat input -99% less spatter

- Outstanding for butt welds, lap welds and edge welds
- Perfect for visible seams – no post weld work necessary
- Ideally suited for high-alloy steels and coated metal sheets
- Less discolouration and scaling
- Reduced heat-affected zone
- Excellent control for positional welding

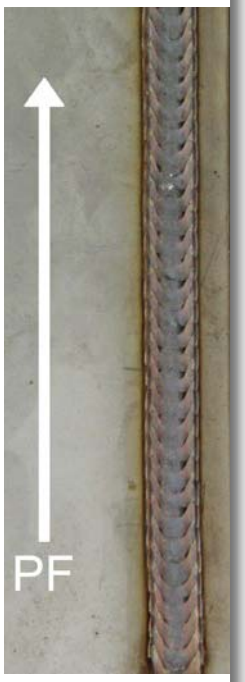


CrNi edge weld of 1 mm sheet metal, with coldArc

The ewm EN 1090 WPQR Package saves time and money

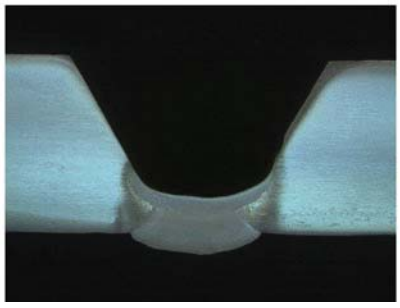
coldArc coldArc puls

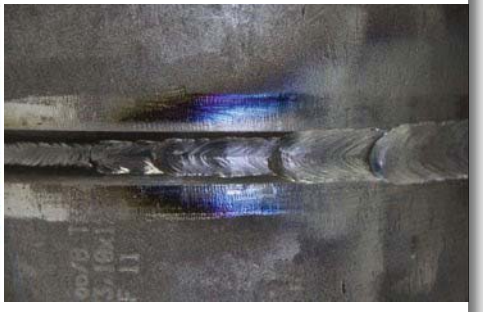
- Heat, where it is required with coldArc puls
- Root welding with coldArc: full control of the droplet transfer, minimised risk of bonding faults
- Pass build-up and final passes with coldArc puls
- Performance enhancement for thicker metal sheets with coldArc puls
- Perfect welding in transitional areas with coldArc puls
- Switching between coldArc and coldArc puls by pressing the torch trigger for secure overlaying of tack points.
- Simple modelling of the molten metal through automatic changing between coldArc and coldArc puls by switching on superPuls.
- Excellent and easy welding from a standing position through changing between coldArc and coldArc puls by switching on superPuls, without using the "Christmas tree technique".



Unique gap bridging for root passes

- Perfect gap bridging, even with alternating gap widths, thanks to coldArc
- No sagging of the molten metal
- Secure sidewall fusion, even with misaligned edges
- Complete elimination of "wire stab"
- Root passes for all panel thicknesses in all positions
- Pass build-up and final passes with coldArc puls





Your benefits

coldArc coldArc puls

- Root welding with TIG quality and MAG speed – up to 400% quicker than manual TIG and MMA welding
- Thin metal welding of plain steel and stainless steel, with much less distortion
- Reduced-energy short arc with unique gap bridging
- Digitally controlled, nearly power-free material transfer
- Perfect for sheet metal from 0.5 mm onward
- Up to 99% less spatter
- Outstanding for butt welds, lap welds and edge welds
- Ideal for CO_2 and mixed gas
- Heat-reduced brazing with innovative, zinc-based solders with low melting point
- Up to 75% less welding fume emissions when compared with coldArc/coldArc puls vs. standard short arc

MULTIMATRIX®
/// Perfection is the principle

Taurus Synergic S

Phoenix puls

alpha Q puls

rootArc
rootArc puls

The arc with optimum control of the weld pool

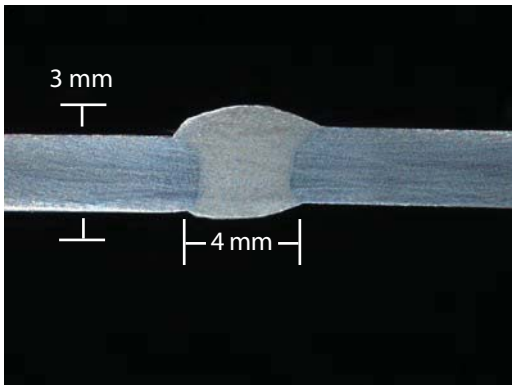
rootArc: Short arc with perfect weld modelling capabilities for effortless gap bridging and positional welding

rootArc puls: The perfect enhancement for focused heat input for the higher performance range

- Optimum reduction of spatter compared to standard short arc
- Perfect for sheet metal from 1 mm onward
- Optimal for positional and overhead welding
- Reduced-energy short arc
- rootArc puls for welding in transitional areas and for initial and final passes
- Excellent, heat-reduced welding in vertical-up positions (PF) through rootArc superPuls
- Superb root formation and secure sidewall fusion
- Vertical-up welds without weaving
- Un-alloyed and low-alloy steels
- Manual and automated applications

Effortless gap bridging in the vertical-down weld

- Stable, firm vertical-down weld
- Very good gap bridging
- Heat-reduced, low-spatter arc
- Superb root formation and secure sidewall fusion



Front

Back

Sheet metal:	3 mm
Gap:	4 mm
Gas:	M21-ArC-18
Wire:	1.0 mm SG3

The ewm EN 1090 WPQR Package saves time and money

rootArc rootArc puls

- Heat input, if necessary, with rootArc puls
- Root welding with rootArc: Effortless controlling of the weld pool
- Pass build-up and final passes with rootArc puls
- Performance enhancement for thick metal sheets with rootArc puls
- Switching between rootArc and rootArc puls by pressing the torch trigger for secure overlaying of tack points
- Effortless mastery of the weld pool by changing between rootArc and rootArc puls through switching on superPuls
- Quick and easy welding of vertical-up welds by changing between rootArc and rootArc puls through switching on superPuls

Vertical-up welds in the PF position

- Excellent welding in vertical-up weld positions (PF) with rootArc-superPuls
- Secure formation of the root base
- No more weaving required
- Smooth "herring bone" effect results in aesthetically pleasing weld seams

The "Christmas tree technique", normally reserved for true experts, can be avoided, which is advantageous for less experienced welders.

Your benefits

rootArc rootArc puls

- / Reliable short arc welding in all positions
- / Ideally suited for vertical-up welds (PF) without using the laborious "Christmas tree technique"
- / Quick and reliable root welding in TIG quality
- / Effortless welding of vertical-up/down welds and overhead welds
- / Ideal for CO_2 and mixed gas
- / Reduced-energy short arc for effortless mastery of gaps
- / Low-spatter, digitally-controlled material transfer
- / Perfect for sheet metal from 1 mm onward
- / Excellent for butt welds and lap welds

MULTIMATRIX®
/// Perfection is the principle

Taurus Synergic S

Phoenix puls

alpha Q puls

Pulsed arc
Standard arc

The arc with optimum control of the weld pool

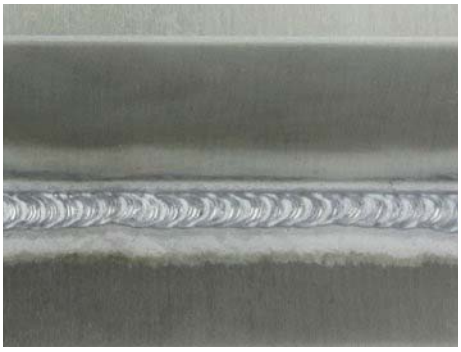
Pulsed arc: Controlled, short circuit-proof pulsed arc for all positions

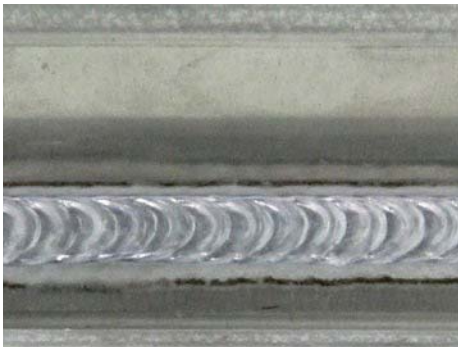
Standard arc: Controlled short arc far into the transitional area

- Welding of aluminium and aluminium alloys
- Welding of high-alloy steels and nickel alloys
- Even droplet transfer also for materials with high nickel content
- Stable arc in the wide transitional area between short and spray arc
- Copper welding
- Positional welding
- Controlled heat input via 1-droplet-per-pulse-transfer
- Standard short arc range extended far into the transitional area
- Fine-droplet material transfer in the extended short arc range when welding low-alloy steels

Aluminium welding with pulsed arc

- Perfect pulse welding of aluminium and aluminium alloys, for sheet metal thicknesses from 1 mm onward
- Stable arc in all positions, even when welding the thinnest aluminium sheets
- Almost spatter-free welding
- Spatter-free ignition by reversing the wire feeding
- Simple modelling of the molten metal through superPuls


Fillet weld, 1 mm sheet metal, AlMg, argon
1.2 mm wire electrode


Fillet weld, 8 mm sheet metal, AlMg, argon
1.2 mm wire electrode
Perfect ripples, thanks to superPuls

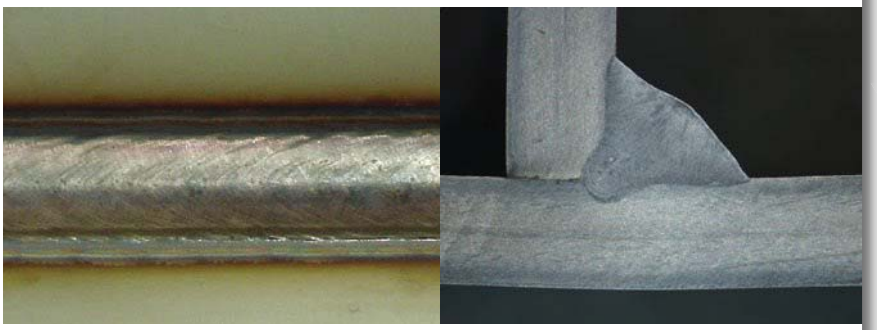
The ewm EN 1090 WPQR Package saves time and money

Pulsed arc Standard arc

- Extended standard short arc range of up to 11 m/min wire, with 1 mm wire diameter G4Si1 under mixed gas
- Less spatter and better arc stability through controlled short arc – to far beyond the transitional area
- High short-circuit frequency, steady weld pool, fine-droplet material transfer
- Higher welding speeds
- Simple modelling of the molten metal through automatic changing between pulse and standard arc by switching on superPuls
- Excellent welding in the vertical up position through automatic changing between pulse and standard arc by switching on superPuls

CrNi welding with pulsed arc

- Perfect pulse welding of high-alloy steels and nickel alloys, also for thin sheet metal from 1 mm onward
- Reliable arc welding in all positions
- Very low-spatter process (fewer corrosion attack points)
- Reduced pore susceptibility
- Flat, smooth and notch-free weld seams



Sheet metal:	3 mm
Materials:	CrNi 1.4301
Gas:	97.5% Ar/2.5% CO2
Wire:	1.2 mm 1.4316
Position:	PB

Your benefits

Pulsed arc Standard arc

/ Perfect welding of aluminium and aluminium alloys, high-alloy steels and nickel alloys, from 1 mm metal sheet thickness onward

/ Even droplet transfer also for materials with high nickel content

/ Copper welding

/ Extreme low-spatter pulsed arc, also in positional welding

/ Quick and reliable changes to stick-out lengths

/ Spatter-free ignition through reversible wire feeding

/ Extended standard short arc range, to far into the transitional area

/ Fine droplet material transfer in the extended short arc range when welding low-alloy steels

MULTIMATRIX®
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Your benefits

pipeSolution
pipeTruck – MAG orbital system

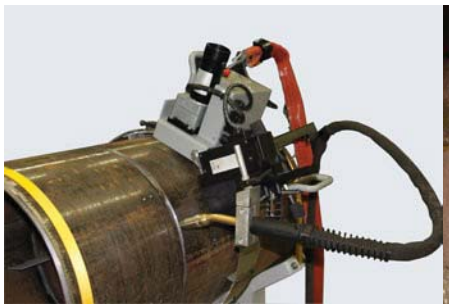
- pipeSolution/pipeTruck – up to 400% quicker than manual TIG and MMA welding
- Low and high-alloy solid wires (e.g. for the parent metal alloy 625)
- Rutile and basic flux-cored wires (e.g. for the parent metal high heat-resistant steel P91)
- Performance is significantly enhanced for root welding: Automated pipeSolution® achieves 150 to 500 mm per minute
- root welding in one operation without backing run
- MAG welding with pipeSolution® process on pipes with 3,400 mm diameter – wall thicknesses up to 30 mm
- Flawless welding result – high quality: certified by TÜV Hesse in welding procedure test according to AD 2000 regulations
- Root welding in one operation: Especially efficient, without a backing run, without weld pool backing
- The entire pipeTruck MAG orbital system from a single source:

  Welding tractor with control unit
  alpha Q puls power source
  Welding consumables
  Welding torch
  Wear parts
  Welding accessories
  Training and consultancy

pipeSolution
pipeTruck – MAG orbital system
Welding at MAG speed with TIG reliability.

Powerful short arc for rapid, safe welding,
with and without gaps, in all positions.

- Root welding for metal sheets and pipes in all positions
- Hot pass/intermediate pass with pulsed arc
- Intermediate/final pass with flux cored wire
- Safe overhead welding thanks to optimum viscosity of the weld pool
- Reduction or elimination of preparation work, e.g. weld pool backing
- Virtually power-free material transfer
- Impressive process stability, even with long hose packages without additional sensor leads
- Unalloyed, low-alloy and high-alloy steels and high-tensile fine-grained steels



pipeTruck MAG orbital system

- Considerable reduction in set-up time – the 19-kg tractor is placed effortlessly on the track system and can be clamped in quickly
- High precision of the orbiting speed, linear pendular motion with adjustable frequency and holding times
- Seam can be accessed at any time thanks to the arrangement of the welding system on the tractor side
- Pipe welding in any position
- Pipe diameters of DN300 and up
- Pipes can be welded automatically and in high quality in all wall thicknesses

superPuls

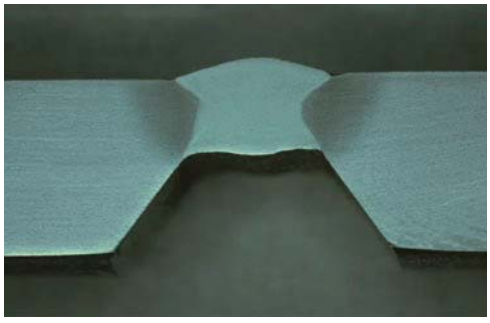
The superPuls combination of ewm welding processes offers a multitude of possibilities.

- Reliable fusion of the root base
- Effective filling with pulse
- No more weaving required
- Smooth bead ripples result in aesthetically pleasing weld seams
- Controlled reduced heat input
- Reduced spatter formation
- Easy modelling of the molten metal
- Quick and reliable welding of vertical-up welds without using the "Christmas tree technique"

The "Christmas tree technique", an application normally reserved for true experts, can be avoided, which is advantageous for less experienced welders.

Aluminium superPuls
PF position

CrNi superPuls
PF position



Steel superPuls
PF position

Your benefits

superPuls

/ Quick and easy welding of vertical-up welds without using the "Christmas tree technique"

/ Effortless mastery of the weld pool

/ Performance increase by pressing on the torch trigger for secure overlaying of tack points

/ Extreme low-spatter pulsed arc, also in positional welding

MULTIMATRIX®
/// Perfection is the principle

forceArc
forceArc puls

Heat-reduced, directionally stable and powerful arc with deep penetration for the upper power range.

Non-alloyed, low-alloy and high-alloy steels and high-tensile fine-grained steels

Pulsed arc
Standard arc

Pulsed arc: Controlled, short circuit-proof pulsed arc for all positions

Standard arc: Controlled short arc far into the transitional area

	forceArc	forceArc puls	Standard arc	Pulsed arc
Cost savings thanks to reduced weld volume	★★★★★	★★★★★	★★	★★★
Reduced energy costs	★★★★★	★★★★★	★★	★★★★
Penetration depth	★★★★★	★★★★★	★★	★★★★
Reduced heat input	★★★★★	★★★★	★★	★★★
Arc force	★★★★★	★★★★★	★★	★★★★
Directionally stable arc	★★★★★	★★★★★	★★	★★★★
Minimised spatter formation	★★★★★	★★★★★	★★★	★★★★★
Reduced undercuts	★★★★★	★★★★	★★★	★★★★
Highly dynamic current control	★★★★★	★★★★★	★★★	★★★★★
Reduced emissions/ less welding fumes	★★★★★	★★★★★	★★	★★★★

Applications				
Unalloyed and low-alloy steels	Yes	Yes	Yes	Yes
High-alloy steels	Yes	Yes	No	Yes
High-tensile fine-grained steels	Yes	Yes	No	Yes
Aluminium	Yes	Yes	No	Yes
Copper	No	Yes	No	Yes

★ Good ➡ ★★★★★ Excellent

coldArc
coldArc puls

coldArc: Heat-reduced, low-spatter short arc for high dimensional stability welding and brazing, plus root welding with excellent gap bridging capabilities.

coldArc puls: The optimum enhancement for the higher performance range, with focused heat input – there where the heat is required.

rootArc
rootArc puls

rootArc: Short arc with perfect weld modelling capabilities for effortless gap bridging and positional welding

rootArc puls: The perfect enhancement for focused heat input for the higher performance range

pipeSolution

Powerful arc for rapid, secure welding with and without gap in all positions.

	coldArc	coldArc puls	rootArc	rootArc puls	pipeSolution
Reduced heat input/ less distortion	★★★★★	★★★	★★★★	★★★	★★★
Reduced energy costs	★★★★★	★★★★	★★★★	★★★★	★★★★
Minimised spatter formation/ less finishing work	★★★★★	★★★★★	★★★	★★★★★	★★★★
Gap bridging	★★★★★	★★★	★★★★★	★★★	★★★★★
Reduced harmful emissions/ less welding fumes	★★★★★	★★★★★	★★★	★★★★★	★★★★
Arc force	★★★	★★★★	★★★★	★★★★	★★★★
Good root formation	★★★★★	★★	★★★★★	★★	★★★★★
Root welding in any position	★★★★★	★	★★★★★	★	★★★★★
Thin panel welding	★★★★★	★★★★	★★★★	★★★★	★★★

Applications					
Unalloyed and low-alloy steels	Yes	Yes	Yes	Yes	Yes
High-alloy steels	Yes	Yes	Yes	Yes	Yes
High-tensile fine-grained steels	Yes	Yes	Yes	Yes	Yes
Brazing (CuSi, CuAl)	Yes	Yes	No	Yes	No
Brazing (zinc wire ZnAl)	Yes	No	No	No	No
Dissimilar joint, aluminium with galvanised steel panel (braze welding)	Yes	Yes	No	Yes	No

★ Good → ★★★★★ Excellent

drive 4X wire feeder

Whether used on construction sites, in production halls, confined spaces or across long distances, drive 4X delivers impressive set-up times and easy handling. Dual ball-bearing drive axles and four individually driven wire feed rollers make the wire feed mechanism highly precise and robust with a long service life.

Your benefits

- Low weight, manhole-ready dimensions and a balanced carrying handle make transport easy.
- Standardised drive rolls, accessories and options
- Robust electronics in dust-free space
- Protected arrangement of connections for intermediate hose packages and control cables
- Interior lighting

ewm's own innovative wire feed mechanism eFeed

- 4-roll drive
- Fully-automated wire inching until wire comes into contact with the workpiece
- Permanently secured roller fastener cannot be lost
- Tool-free roll changes
- Drive roll sets each with four wire feed rollers, colour coded for various wire diameters and groove shapes
- Conversion kits no longer needed
- Exchange rollers in just three steps – instantly, without tools and with non-detachable parts
- Adjustable contact pressure

Four models to choose from

Basic

for Taurus Basic

LP

HP

Expert 2.0

for alpha Q, Phoenix and Taurus Synergic S

Variety of extension options

Options

Torch holder

/ For greater safety when working
/ Extends torch service life
/ Keeps work area organised

see page 414

Wheel set

/ For greater mobility

Rubber feet

/ Replace sliding rails

see page 414

Electronic gas flow control

/ Gas flow setting directly at the work area
/ Reduced gas consumption thanks to optimally specified values in JOB
/ Constant gas flow rate thanks to electronic adjustment
/ Nominal and actual value display of gas flow rate in l/min

see page 415

Crane suspension

/ For safe and easy transportation
/ Guarantees maximum mobility

Heavy duty kit (protective plate plus crane suspension)

/ For optimised protection under rough conditions
/ For standing, vertical and suspension operation
/ Temperature- and impact-resistant sliding protective plate

see page 415

Protective cap made of transparent plastic

/ Reliable protection for the entire control

Protective cover made of acrylic glass

/ Resistant cover firmly screwed into position
/ Machine still fully operable thanks to recesses

see page 416

Connection for drum feed

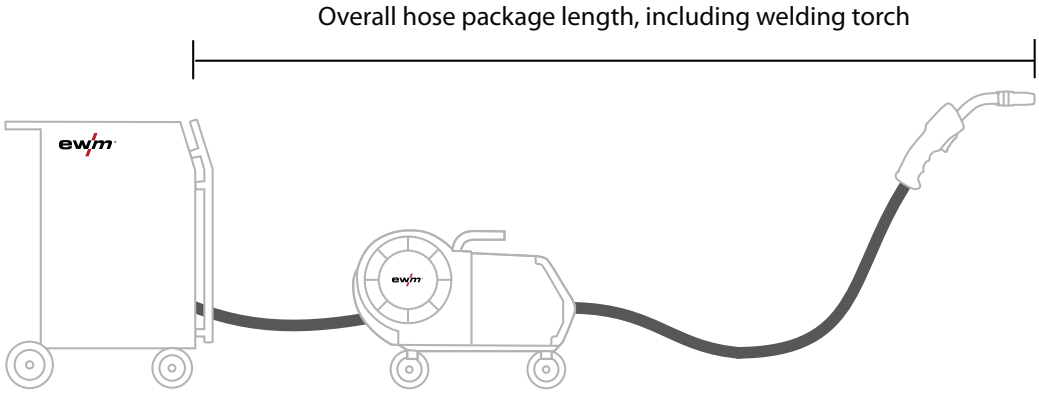
/ Less need to change wire spools saves time
/ Reduced order costs thanks to low price per kilo

see page 417

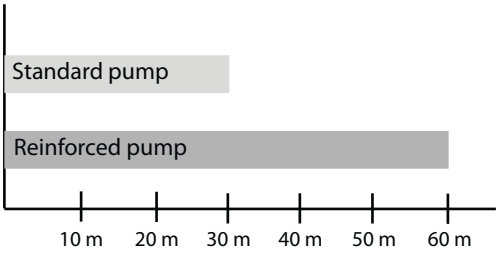
Front-side load socket (option ex works)

/ Connection capability for gouging torch or electrode holder
/ Even greater flexibility on the job

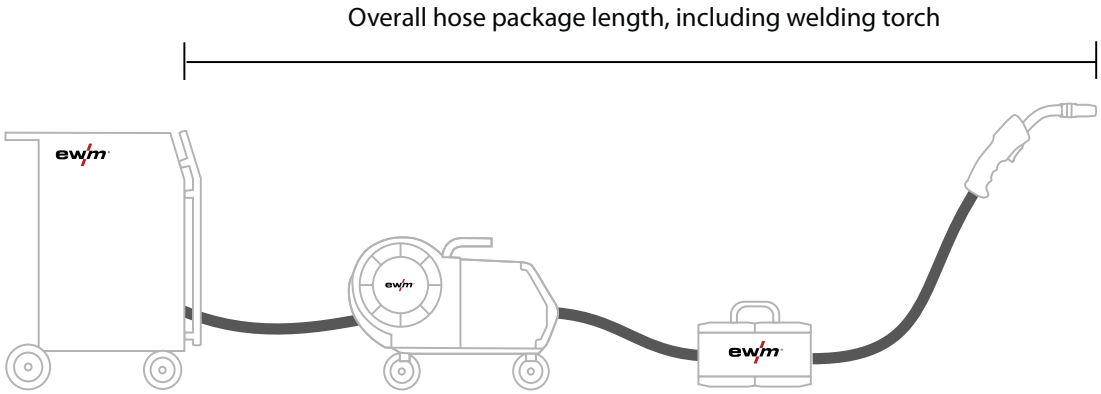
1) Welding machines with separate wire feeder



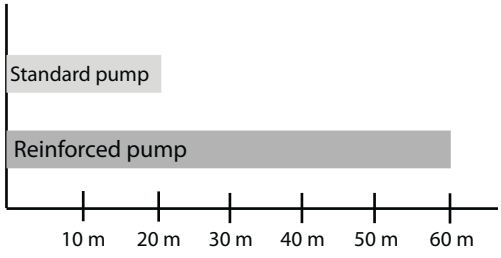
Standard pump: up to 30 m overall hose package length, including welding torch
Reinforced pump: up to 60 m overall hose package length, including welding torch



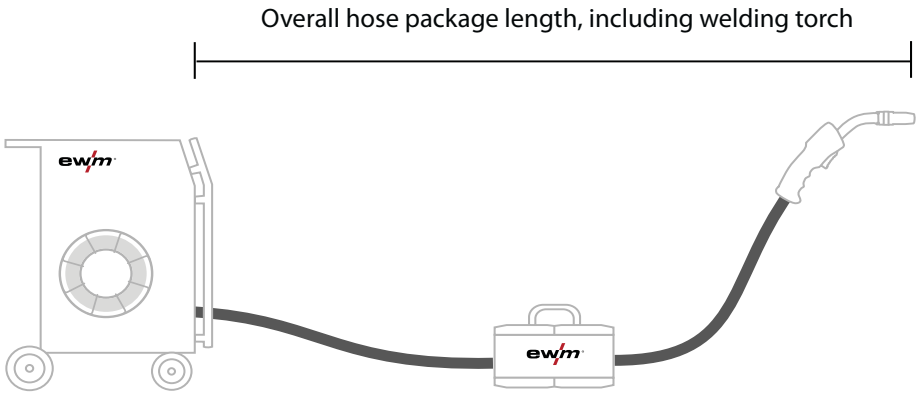
2) Welding machines with separate wire feeder and additional miniDrive



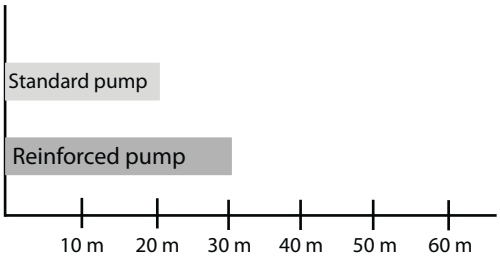
Standard pump: up to 20 m overall hose package length, including welding torch
Reinforced pump: up to 60 m overall hose package length, including welding torch



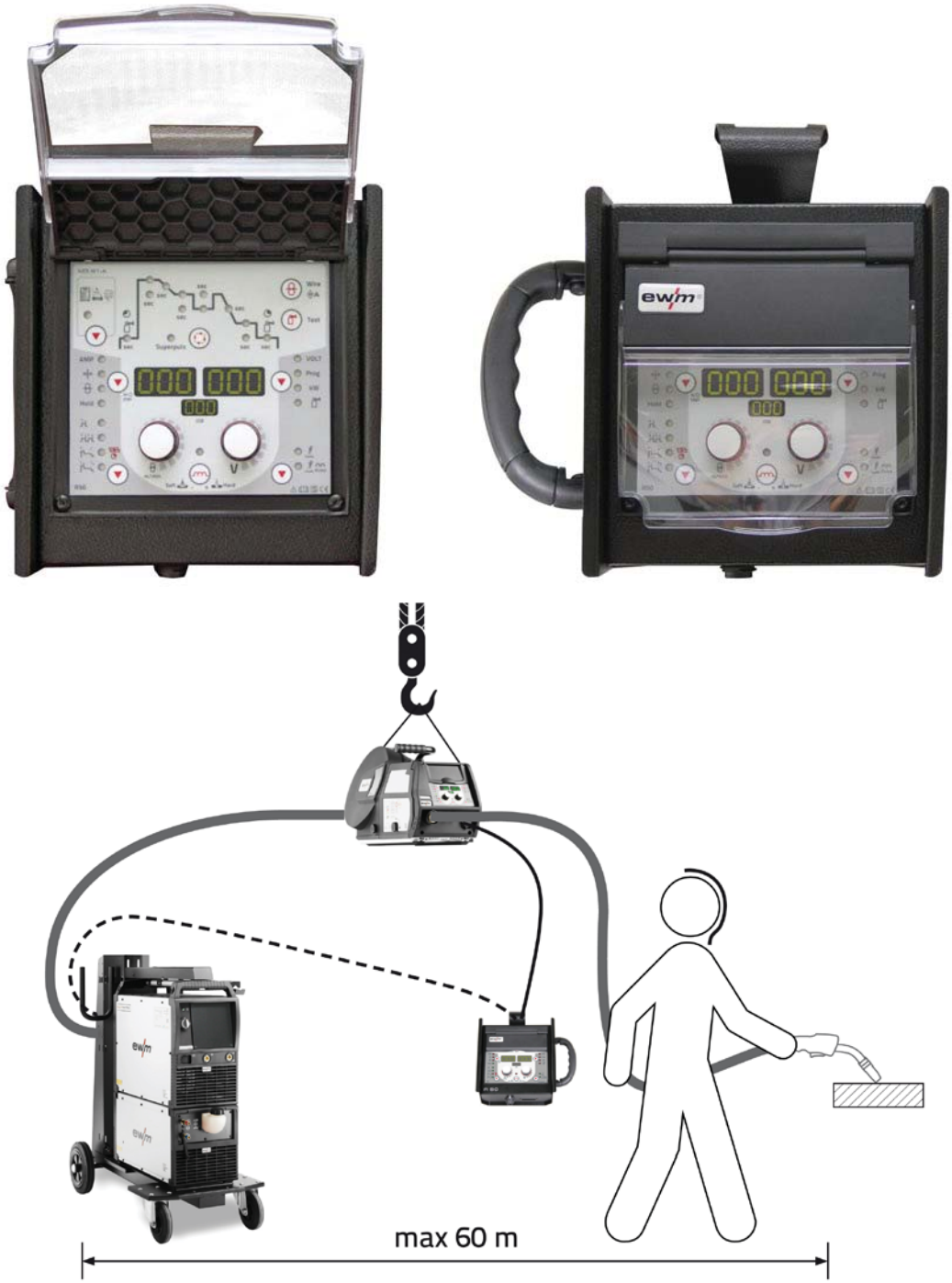
3) Compact welding machines with additional miniDrive



Standard pump: up to 20 m overall hose package length, including welding torch
Reinforced pump: up to 30 m overall hose package length, including welding torch

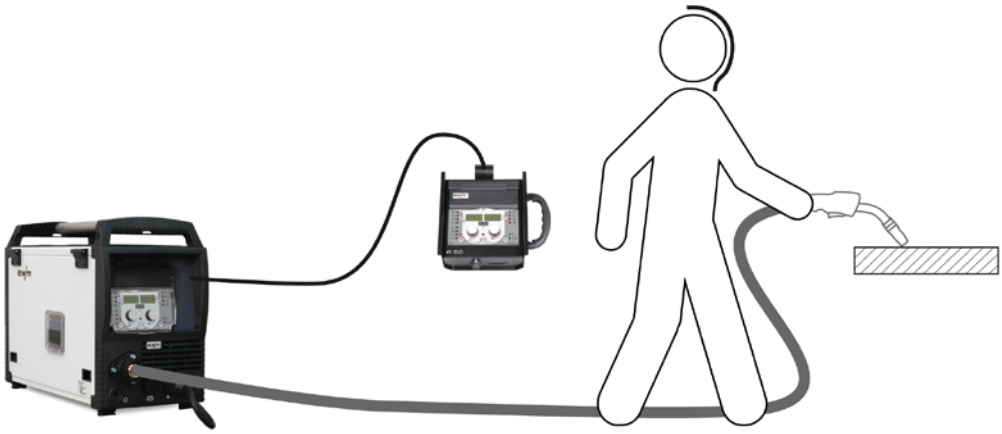


- Remote control **R50 7POL** enables all Taurus Synergic S, Phoenix and alpha Q machines to be equipped with a second remote control.
- All functions and parameters available on the wire feeder can be adjusted remotely using the **R50 7POL** within a distance of up to **60 m**.
- The **R50 7POL** can be connected to any 7-pole system bus interface on the welding machine or the wire feeder.
- The **R50 7POL** control can also be attached to the power source for welding machines with a separate wire feeder (decompact machines) as a second control without needing any tools.



R50 7POL as a second remote control directly on the workstation

R50 7POL plugged into the welding machine as a second control



R50 7POL as a second remote control with compact welding machine

R50 7POL as a second remote control with compact welding machine and miniDrive

Symbols

1-phase connection

2-phase connection

3-phase connection

3-phase connection „TNS net“

5-pole torch connection

7-pole remote control connection

8-pole torch connection

12-pole torch connection

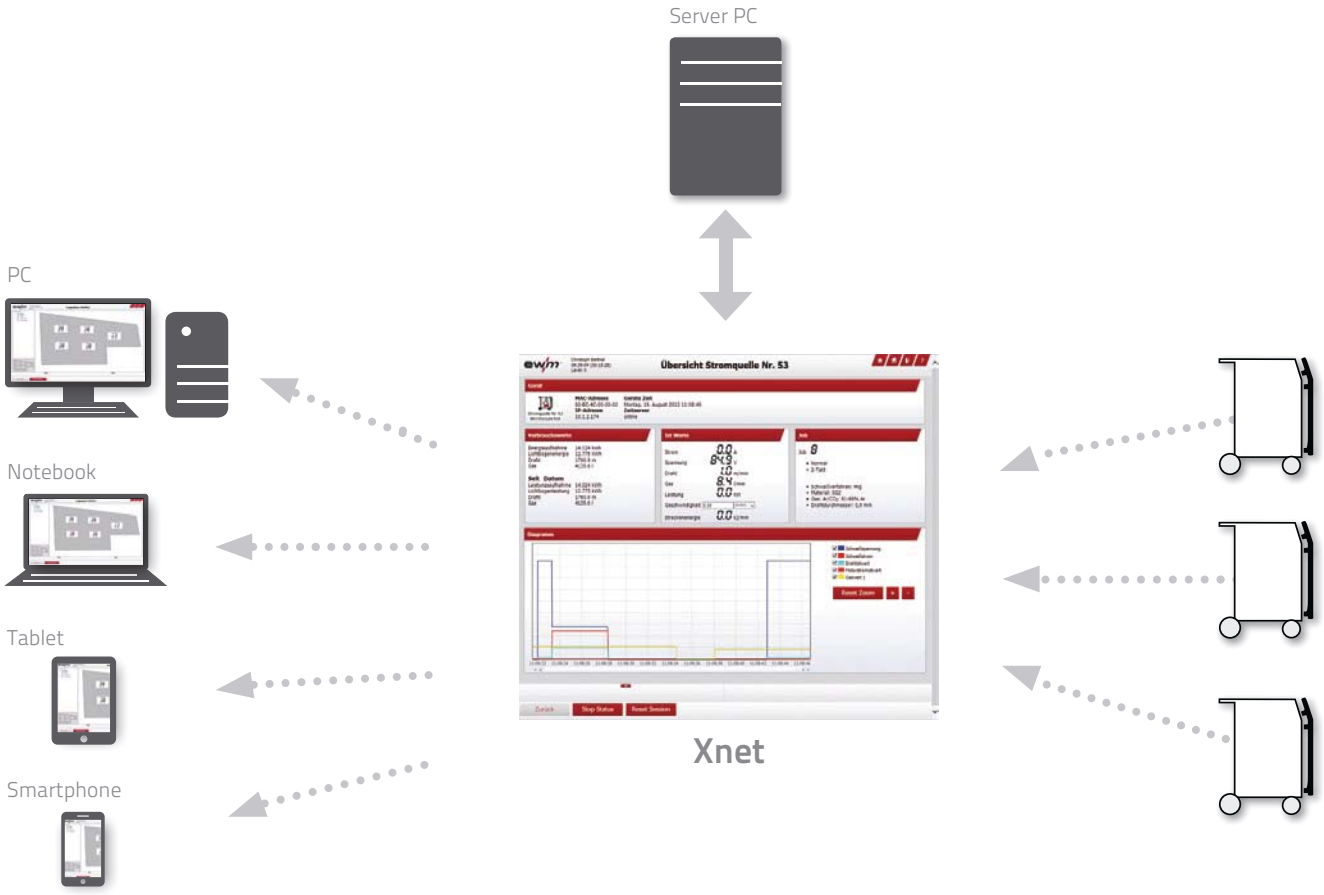
14-pole remote control connection

19-pole torch connection

28-pole connection

Abbreviations

2DV	Two wire feed units
2T	Double push button
2U/D	2x Up/Down
4R	4 rollers
5P	5-pole connection socket
8P	8-pole connection socket
ADAP	Adapter
ASM	Connection capability
AW	Connection capability filler wire
cel	Cellulose electrodes
CW	Cold wire
D	Double wire feed unit
D2	Wire spool D200
D3	Wire spool D300
DG	Decompact, gas cooled
DW	Decompact, water cooled
EZA	Euro torch connection
FDG	Mobile, decompact, gas cooled
FDW	Mobile, decompact, water cooled
FWD	Mobile, water cooled, decentral
GD	Gas cooled, decentral
GD UD	Gas cooled, decentral, Up/Down
GDV	Rotary gas valve
HFL	Highly flexible hose package
HW	Hotwire
KGE	Compact, gas cooled, Euro torch connection
MM	Multimatrix
MV	Multivolt
PC1	Powercontrol 1
PC2	Powercontrol 2
pws	Polarity reversing switch
TDG	Portable, decompact, gas cooled
TDM	Portable, decompact, modular
TGD	Portable, gas cooled, decentral
TGE	Portable, gas cooled, euro torch connection
TKM	Portable, compact, modular
TMD	Portable, modular, decentral
U/D	Up/Down
WD	Water cooled, decentral
WD UD	Water cooled, decentral, Up/Down
WE	Water cooled, Euro torch connection



- QM software for analysing of welding processes
- Record, view and analyse welding data
- Fast identification of disruptive factors thanks to realtime monitoring
- Suitable for manual, automated and robot -controlled applications
- Network can be expanded to any number of welding machines and computers
- Customisable user and machine management
- Ethernet networking, Wi-Fi also possible

For more information on Xnet see the Xnet brochure and on our website at www.ewm-group.com/xnet

ewm Xnet quality management software

Recording, analysing, optimising, benefiting

Can be used with:

alpha Q puls

Phoenix puls

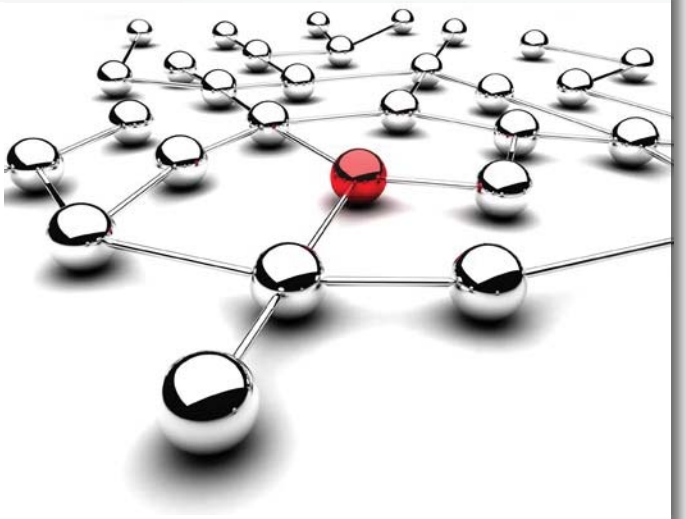
Taurus Synergic S

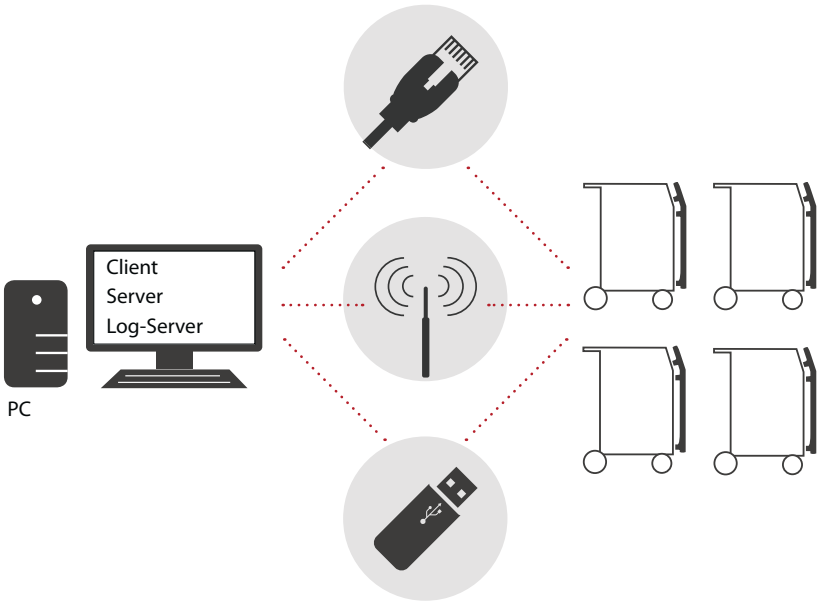
Tetrix

Document every weld seam, identify savings potentials and manufacture efficiently – these three requirements could not be any more different. The modular quality management software ewm Xnet helps to combine these three tasks in a single solution which both small welding firms and major, globally active companies can use.

LAN/Wi-Fi networking of power sources – alpha Q puls, Phoenix puls, Taurus Synergic S

1 LAN/Wi-Fi networking using built-in Expert 2.0 control
2 Networking via LAN/Wi-Fi gateway (Progress, Synergic S) (Progress, Synergic S)
3 Networking via external LAN/Wi-Fi gateway (compact machines, Progress, Expert 2.0, automated power sources)





Network solutions

The compact solution

- Occasional recording, reviewing and analysing of welding data as well as monitoring of networked machines
- The computer used does not need to be switched on permanently
- Ideal for smaller single-shift operations and smaller to medium-sized companies with up to about 15 networked machines

The standard solution

- Continuous recording, reviewing and analysing of welding data as well as monitoring of networked machines
- The computer used should be permanently switched on to reduce network loads
- The standard solution for medium-sized and large companies with up to about 60 networked machines

The high-performance solution

- Continuous recording, reviewing and analysing of welding data of a large number of machines as well as monitoring of networked machines
- The server PCs must be permanently switched on
- A high-performance solution for larger companies with more than 60 networked machines

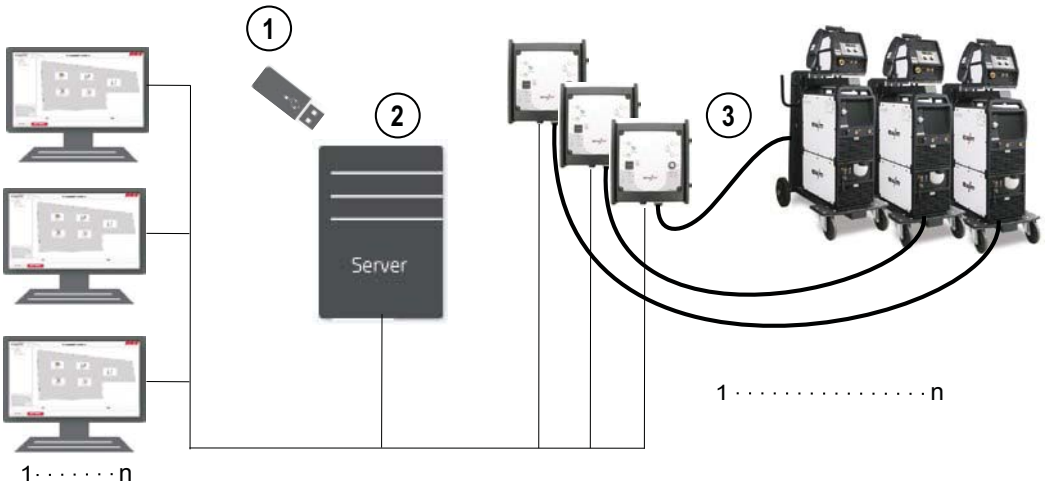
Xnet Your benefits:

- Recording of welding data
- Save, review and analyse at a central point
- Online monitoring – control and monitor the welding process for any number of welding machines from any number of PC workstations
- JOB (welding tasks) management – creation, administration and archiving of welding JOBs, both online and offline
- Option of transferring to all welding machines in the network
- Online analysis, evaluation, reporting and documentation of logged welding parameters for each networked welding machine using different documentation and analysis tools
- Convenient, easy-to-create graphic display layout showing equipment in the network, based on work facility floor plan; can be enlarged by zooming, navigation window and much more

MULTIMATRIX®

/// Perfection is the principle

LAN external gateway ● retrofit set ■ Extern LAN



Networking through external LAN gateway for machines with 7-pole digital interface

- Can be retrofitted
- Network can be expanded to any number of welding machines and computers

Item	Type	Designation	Item no.
1	ewm Xnet Starter-Set	Set: QM software, a dongle (contains the installation files and software licence)	091-008788-00001
3	ewm Xnet Extended-Set 1 LAN	Set: One machine licence, a LAN gateway, a network cable (10 m), one 7-pole connection cable (5 m)	091-008789-00001
3	ewm Xnet Extended-Set 3 LAN	Set: Three machine licences, three LAN gateways, three network cables (10 m), three 7-pole connection cables (5 m)	091-008789-00003
3	ewm Xnet Extended-Set 5 LAN	Set: Five machine licences, five LAN gateways, five network cables (10 m), five 7-pole connection cables (5 m)	091-008789-00005

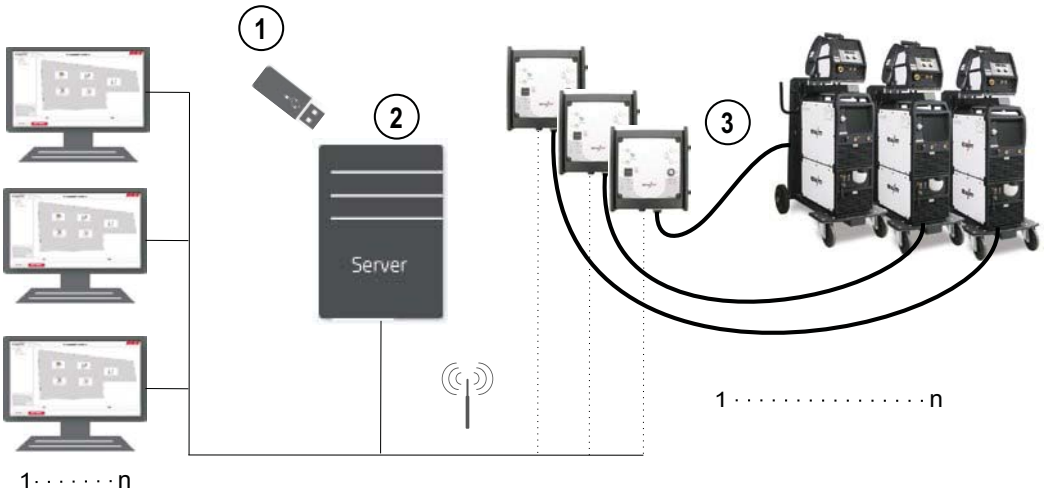
Optional

Item	Type	Designation	Item no.
2	ewm Tower Server	Tower server incl. Xnet QM software and 1 dongle	092-002813-xxxxx
3	ewm Xnet Extended-Set 1 LAN	Set: One machine licence, a LAN gateway, a network cable (10 m), one 7-pole connection cable (5 m)	091-008789-00001
3	ewm Xnet Extended-Set 3 LAN	Set: Three machine licences, three LAN gateways, three network cables (10 m), three 7-pole connection cables (5 m)	091-008789-00003
3	ewm Xnet Extended-Set 5 LAN	Set: Five machine licences, five LAN gateways, five network cables (10 m), five 7-pole connection cables (5 m)	091-008789-00005

▶ Specification on request

▶ System requirements of customer server: Pentium-compatible PC or higher (min. DualCore) with min. 2 GHz, Microsoft Windows 7, 8, Server 2008, installed .Net Framework 4.0 (will be installed at the same time if required), 2 GB RAM (4 GB recommended), 1 TB hard disk space, LAN 100/1000, CD-ROM drive, USB 1.1 connection or higher, minimum resolution 800x600, 256 colours

WiFi external gateway ● retrofit set ■ Extern WLAN



Networking via external WiFi gateway for machines with 7-pole digital interface

- Can be retrofitted
- Network can be expanded to any number of welding machines and computers

Item	Type	Designation	Item no.
1	ewm Xnet Starter-Set	Set: QM software, a dongle (contains the installation files and software licence)	091-008788-00001
3	ewm Xnet Extended-Set 1 WiFi	Set: One machine licence, one Wi-Fi gateway, one 7-pole connection cable (5 m)	091-008790-00001
3	ewm Xnet Extended-Set 3 WiFi	Set: Three machine licences, three Wi-Fi gateways, three 7-pole connection cables (5 m)	091-008790-00003
3	ewm Xnet Extended-Set 5 WiFi	Set: Five machine licences, five Wi-Fi gateways, five 7-pole connection cables (5 m)	091-008790-00005

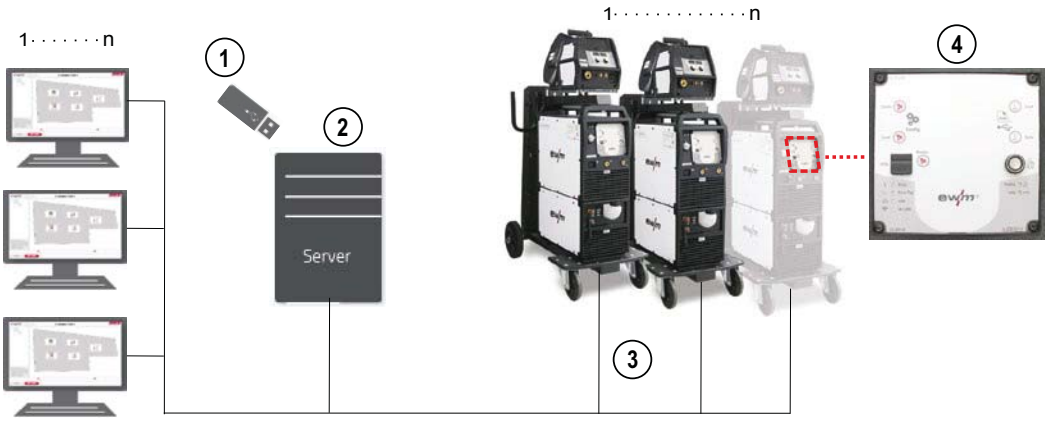
Optional

Item	Type	Designation	Item no.
2	ewm Tower Server	Tower server incl. Xnet QM software and 1 dongle	092-002813-xxxxx
3	ewm Xnet Extended-Set 1 WiFi	Set: One machine licence, one Wi-Fi gateway, one 7-pole connection cable (5 m)	091-008790-00001
3	ewm Xnet Extended-Set 3 WiFi	Set: Three machine licences, three Wi-Fi gateways, three 7-pole connection cables (5 m)	091-008790-00003
3	ewm Xnet Extended-Set 5 WiFi	Set: Five machine licences, five Wi-Fi gateways, five 7-pole connection cables (5 m)	091-008790-00005

▶ Specification on request

▶ System requirements of customer server: Pentium-compatible PC or higher (min. DualCore) with min. 2 GHz, Microsoft Windows 7, 8, Server 2008, installed .Net Framework 4.0 (will be installed at the same time if required), 2 GB RAM (4 GB recommended), 1 TB hard disk space, LAN 100/1000, CD-ROM drive, USB 1.1 connection or higher, minimum resolution 800x600, 256 colours

Built-in LAN gateway ● factory-fit option ■ Intern LAN



Networking with built-in LAN or WiFi gateway

- For alpha Q Progress puls MM, Phoenix Progress puls MM, Taurus Synergic S MM machine series
- Option ex works, retrofitting not possible
- Network can be expanded to any number of welding machines and computers

Item	Type	Designation	Item no.
1	ewm Xnet Starter-Set	Set: QM software, a dongle (contains the installation files and software licence)	091-008788-00001
3	LAN CABLE 10m	Network cable	094-020672-00000
4	OW LG 1.0	Built-in LAN gateway (ex works only)	092-003645-00001
5	ewm Xnet LC1	Xnet machine licence	090-008787-LIZ01

▶ Each machine requires a licence (5, not pictured), a gateway (4) and a corresponding cable (3)!

Optional

Item	Type	Designation	Item no.
2	ewm Tower Server	Tower server incl. Xnet QM software and 1 dongle	092-002813-xxxxx
3	LAN CABLE 10m	Network cable	094-020672-00000
4	OW LG 1.0	Built-in LAN gateway (ex works only)	092-003645-00001
5	ewm Xnet LC1	Xnet machine licence	090-008787-LIZ01

▶ Specification on request

▶ System requirements of customer server: Pentium-compatible PC or higher (min. DualCore) with min. 2 GHz, Microsoft Windows 7, 8, Server 2008, installed .Net Framework 4.0 (will be installed at the same time if required), 2 GB RAM (4 GB recommended), 1 TB hard disk space, LAN 100/1000, CD-ROM drive, USB 1.1 connection or higher, minimum resolution 800x600, 256 colours

Built-in WiFi gateway ● factory-fit option ■ Intern WLAN

Networking through built-in WiFi gateway

- For alpha Q Progress puls MM, Phoenix Progress puls MM, Taurus Synergic S MM machine series
- Factory-fit option, retrofitting not possible
- Network can be expanded to any number of welding machines and computers

Item	Type	Designation	Item no.
1	ewm Xnet Starter-Set	Set: QM software, a dongle (contains the installation files and software licence)	091-008788-00001
3	OW WLG 1.0	Built-in WiFi gateway (ex works only)	092-003646-00001
5	ewm Xnet LC1	Xnet machine licence	090-008787-LIZ01

▶ Each machine requires a licence (5, not pictured) and a gateway (3)!

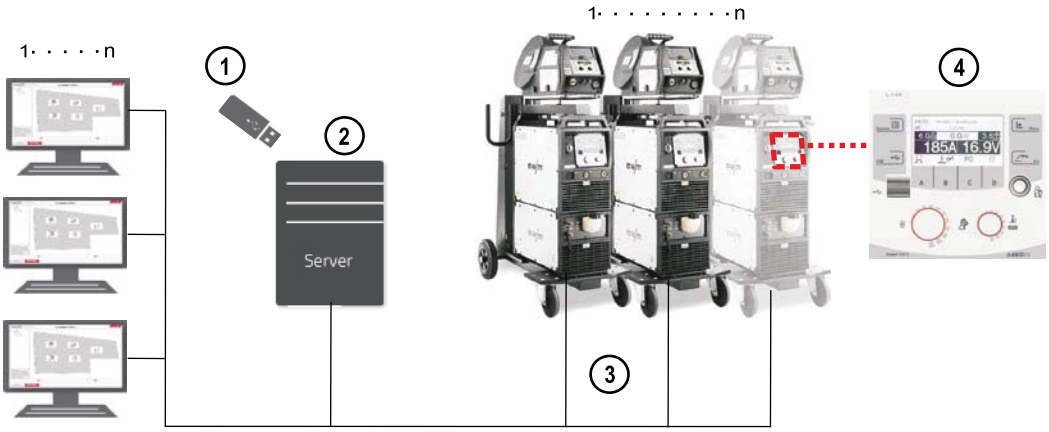
Optional

Item	Type	Designation	Item no.
2	ewm Tower Server	Tower server incl. Xnet QM software and 1 dongle	092-002813-xxxxx
3	OW WLG 1.0	Built-in WiFi gateway (ex works only)	092-003646-00001
5	ewm Xnet LC1	Xnet machine licence	090-008787-LIZ01

▶ Specification on request

▶ System requirements of customer server: Pentium-compatible PC or higher (min. DualCore) with min. 2 GHz, Microsoft Windows 7, 8, Server 2008, installed .Net Framework 4.0 (will be installed at the same time if required), 2 GB RAM (4 GB recommended), 1 TB hard disk space, LAN 100/1000, CD-ROM drive, USB 1.1 connection or higher, minimum resolution 800x600, 256 colours

LAN gateway ● built-in Expert 2.0 control system ● factory-fit option ■ Expert 2 LAN



Networking through built-in Expert 2.0 control system with LAN connection

- For alpha Q Expert puls MM and Phoenix Expert puls MM series
- Factory-fit option, retrofitting not possible
- Network can be expanded to any number of welding machines and computers

Item	Type	Designation	Item no.
1	ewm Xnet Starter-Set	Set: QM software, a dongle (contains the installation files and software licence)	091-008788-00001
3	LAN CABLE 10m	Network cable	094-020672-00000
4	OW EXPERT 2.0 LG	Expert 2.0 LAN gateway (ex works only)	092-003648-00001
5	ewm Xnet LC1	Xnet machine licence	090-008787-LIZ01

▶ Each machine requires a licence (5, not pictured), a gateway (4) and a corresponding cable (3)!

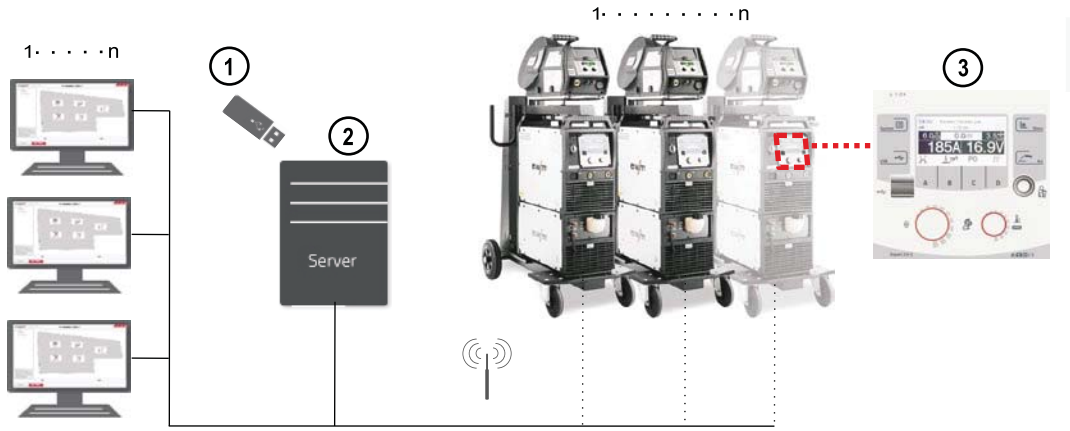
Optional

Item	Type	Designation	Item no.
2	ewm Tower Server	Tower server incl. Xnet QM software and 1 dongle	092-002813-xxxxx
3	LAN CABLE 10m	Network cable	094-020672-00000
4	OW EXPERT 2.0 LG	Expert 2.0 LAN gateway (ex works only)	092-003648-00001
5	ewm Xnet LC1	Xnet machine licence	090-008787-LIZ01

▶ Specification on request

▶ System requirements of customer server: Pentium-compatible PC or higher (min. DualCore) with min. 2 GHz, Microsoft Windows 7, 8, Server 2008, installed .Net Framework 4.0 (will be installed at the same time if required), 2 GB RAM (4 GB recommended), 1 TB hard disk space, LAN 100/1000, CD-ROM drive, USB 1.1 connection or higher, minimum resolution 800x600, 256 colours

WiFi gateway ● built-in Expert 2.0 control system ● factory-fit option ■ Expert 2 WLAN



Networking through built-in Expert 2.0 control system with Wi-Fi connection

- For alpha Q Expert puls MM and Phoenix Expert puls MM series
- Factory-fit option, retrofitting not possible
- Network can be expanded to any number of welding machines and computers

Item	Type	Designation	Item no.
1	ewm Xnet Starter-Set	Set: QM software, a dongle (contains the installation files and software licence)	091-008788-00001
3	OW EXPERT 2.0 WLG	Expert 2.0 WiFi gateway (ex works only)	092-003649-00001
5	ewm Xnet LC1	Xnet machine licence	090-008787-LIZ01

▶ Each machine requires a licence (5, not pictured) and a gateway (3)!

Optional

Item	Type	Designation	Item no.
2	ewm Tower Server	Tower server incl. Xnet QM software and 1 dongle	092-002813-xxxxx
3	OW EXPERT 2.0 WLG	Expert 2.0 WiFi gateway (ex works only)	092-003649-00001
5	ewm Xnet LC1	Xnet machine licence	090-008787-LIZ01

▶ Specification on request

▶ System requirements of customer server: Pentium-compatible PC or higher (min. DualCore) with min. 2 GHz, Microsoft Windows 7, 8, Server 2008, installed .Net Framework 4.0 (will be installed at the same time if required), 2 GB RAM (4 GB recommended), 1 TB hard disk space, LAN 100/1000, CD-ROM drive, USB 1.1 connection or higher, minimum resolution 800x600, 256 colours

Services

Type	Designation	Item no.
KOSV51	One-day training (with certificate of sale for Xnet)	KOS-V00051-00000
KOSV52	Hourly rate for IT specialist	KOS-V00052-00000
KOSV53	Software maintenance contract, includes debugging, updating and customer support regarding software utilisation (costs per month)	KOS-V00053-00000
KOS28	Hourly rate for installation of Xnet QM software on customer server	KOS-V00028-00000

Software ■ Xbutton

Xbutton

- Authentication key
- Controls access to welding machines with Expert 2.0 control
- Individual assignment of rights
- Simple Xbutton programming
- List of all users as well as all active/inactive Xbutton
- Clear allocation of Xbuttons
- Administration of any number of users

Type	Designation	PU Units	PE	Item no.
Xbutton Starter-Set	Authentication set: Programming box incl. cable, software key, dongle, 10 Xbuttons	1	per unit	092-002911-00000
1x Xbutton black	Authentication key			092-002912-00000
5x Xbutton black	Authentication key 5+1 (6 for the price of 5)	6	per PU	092-002912-00005
10x Xbutton black	Authentication key 10+3 (13 for the price of 10)	13		092-002912-00010
1x Xbutton red	Authentication key	1	per unit	092-002913-00000
5x Xbutton red	Authentication key 5+1 (6 for the price of 5)	6	per PU	092-002913-00005
10x Xbutton red	Authentication key 10+3 (13 for the price of 10)	13		092-002913-00010
1x Xbutton green	Authentication key	1	per unit	092-002914-00000
5x Xbutton green	Authentication key 5+1 (6 for the price of 5)	6	per PU	092-002914-00005
10x Xbutton green	Authentication key 10+3 (13 for the price of 10)	13		092-002914-00010
1x Xbutton yellow	Authentication key	1	per unit	092-002915-00000
5x Xbutton yellow	Authentication key 5+1 (6 for the price of 5)	6	per PU	092-002915-00005
10x Xbutton yellow	Authentication key 10+3 (13 for the price of 10)	13		092-002915-00010
1x Xbutton blue	Authentication key	1	per unit	092-002916-00000
5x Xbutton blue	Authentication key 5+1 (6 for the price of 5)	6	per PU	092-002916-00005
10x Xbutton blue	Authentication key 10+3 (13 for the price of 10)	13		092-002916-00010

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110

Type	Item no.	Page
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111

Overview

Degaussing

Max. welding current	Product name	Page
A		
600	Degauss 600	58

Degaussing prior to welding

Degauss 600

Magnetism is not desired where steel is welded. Undesired residual magnetism in steel parts results in an unstable and deflected arc. The effect may be so great that welding is impossible.

When using the Degauss 600, you can degauss your materials and workpieces. Following the easy installation of the components at the workpiece, the continuous degaussing process will automatically be completed within the shortest possible time.

The effect of the degaussing will show immediately in the subsequent welding process. Your welding results speak for themselves: The arc is stable and no longer deflected, there are no unnecessary arc striking spots, sidewalls are fused without lack of fusion, perfect results without rework or scrap are achieved.

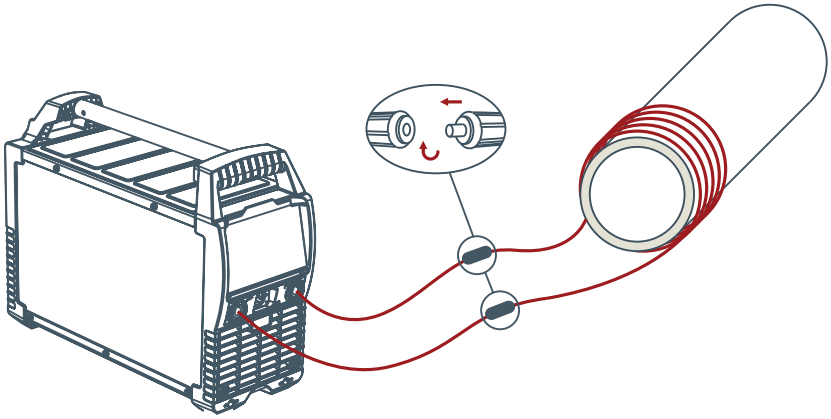
Your benefits

- Degaussing of magnetic materials and workpieces
- Single button operation – automatic degaussing
- Stable welding process without magnetic deflection – perfect welding result without finishing work

Your benefits

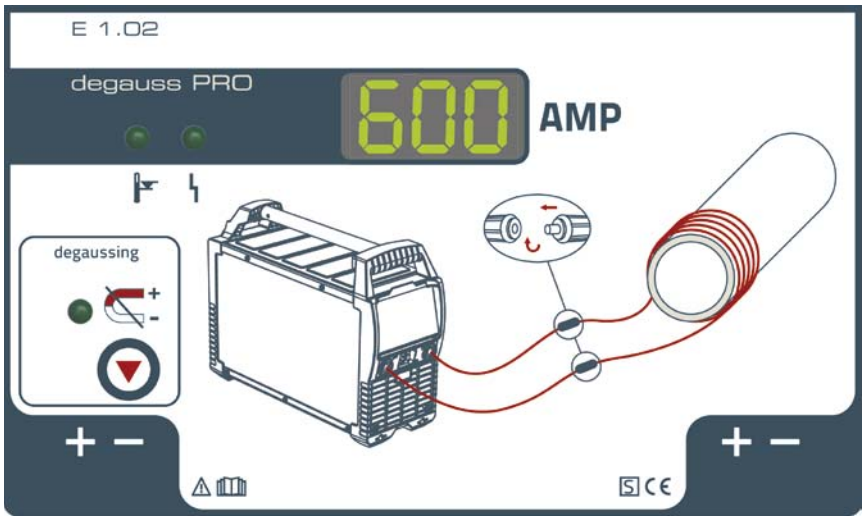
User's advantages

- / No deflection of the arc by residual magnetism in the workpiece
- / Avoidance of lack of fusion due to insufficient side-wall fusion
- / Minimisation of finishing work
- / Cost-efficient and high-quality results
- / Degaussing of pipes and metal sheets



Very straightforward handling

- / The set includes all components required for degaussing
- / Quick connection at the pipe by means of three load cables
- / Single button operation
- / Automatic degaussing process
- / Use at -25 °C to +40 °C with mains voltage tolerances of +/-20%
- / Portable and robust



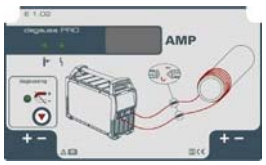
Degauss 600

- / Compact degaussing power source suitable for use at the construction site
- / Single button operation
- / Automatic degaussing process

Degauss 600

- Degaussing of pipes and metal sheets
- Automatic degaussing
- Dependable degaussing for better welding results through stable welding process without magnetic deflection, minimisation of finishing work
- Portable and robust
- Quick connection at the pipe by means of three load cables
- Use at -25 °C to +40 °C with mains voltage tolerances of +/- 20%
  - **Advantages of degaussing:**
  - No deflection of the arc by residual magnetism in the workpiece
  - Prevention of lack of fusion due to insufficient sidewall fusion
  - Minimisation of finishing work
  - Cost-efficient and high-quality results

E1.02



Options/accessories **Page** **280**

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Degaussing current	600 A
cos φ	0.99
Efficiency	90 %
External dimensions, compl.	600 x 205 x 415
Weight	23.5 kg

Type	Designation	Item no.
Set Degauss 600	Set: Degauss 600 degaussing machine, two 5-metre, 35 mm² load cables, one 20-metre, 35 mm² load cable, RT DGS1 remote control and 5-m connection cable	091-002065-00502

RT DGS1

- Remote control with a polarity reversing switch and start/stop function for Degauss 600
- Remote control activates additional function – generation of an opposing magnetic field during the welding process
- Infinitely adjustable current (0% to 100%) to produce the required opposing magnetic field directly at the welding site

Type	Designation	Item no.
RT DGS1	Degauss remote control	090-008806-00000
RA5 19POL 5m	Connection cables	092-001470-00005

FIM1-4 Set

- Magnetic field meter for measuring magnetic direct and alternating fields
- Three possible measuring ranges: 20 mT, 200 mT and 2000 mT
- Hand-held unit for operation with mains, battery or power-pack
- LCD digital display
- Measuring accuracy: ±2% of measured value ±1 digit using internal calibration voltage, better than ±1% of measured value ±1 digit using calibrated comparison magnet
- Resolution: 0.01 mT
- Output: ±199.9 mV analogue output corresponding to 1,999 digits, connection for analogue display, X-Y plotter and A-D converter
- Operating time: about 100 hours with dry-cell battery, about 50 hours with power-pack charge (power pack not included)

External dimensions, compl.	145 x 80 x 38
Weight	0.8 kg

Type	Designation	Item no.
FIM1-4 Set	Set: magnetic field meter, including Hall effect sensor	092-002937-00000

Overview

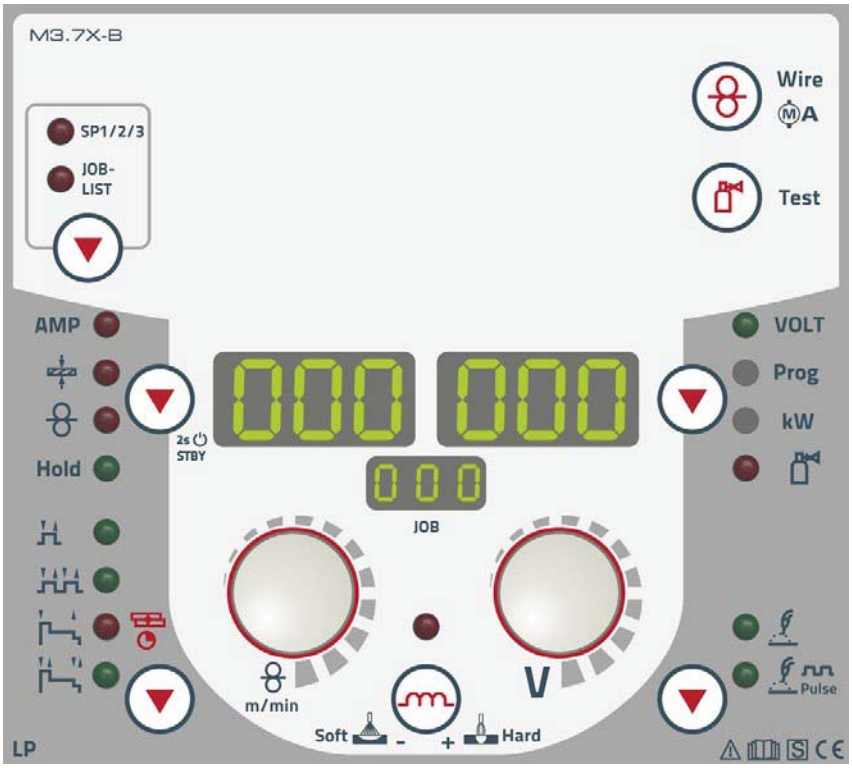
Multiprocess MIG/MAG pulse welding machines, Portable

Design	Max. welding current	Product name	Cooling		Page
	A		optional cooling unit	Water-cooled	
Compact	330	alpha Q 330 Progress puls LP MM TKM	•	•	66
		alpha Q 330 Progress puls HP MM TKM	•	•	68

Multiprocess MIG/MAG pulse welding machines, Mobile

Design	Max. welding current	Product name	Cooling		Page
	A		optional cooling unit	Water-cooled	
Decompact	350 - 550	alpha Q 351 • 551 Progress puls MM FDW		•	70
		alpha Q 351 Expert 2.0 puls MM FDW		•	72
		alpha Q 351 • 551 Progress puls MM D FDW		•	74
		alpha Q 351 • 551 Progress puls MM 2DVX FDW		•	76
		alpha Q 351 • 551 Expert 2.0 puls MM 2DVX FDW		•	78

Control LP



Synergic one-knob operation

/ Synergic operating point adjustment with just a single knob
/ Simple JOB selection (material, gas, wire Ø)
/ Equipped with EN 1090-certified Synergic characteristics for EWM coldArc, coldArc puls, pipeSolution, forceArc, forceArc puls, rootArc and rootArc puls at no extra charge
/ Equipped with EN 1090-certified Synergic characteristics for GMAW welding of steel/CrNi/aluminium at no extra charge
/ Suitable for MMA welding, TIG welding and gouging at no extra charge

Adjustable welding parameters and functions

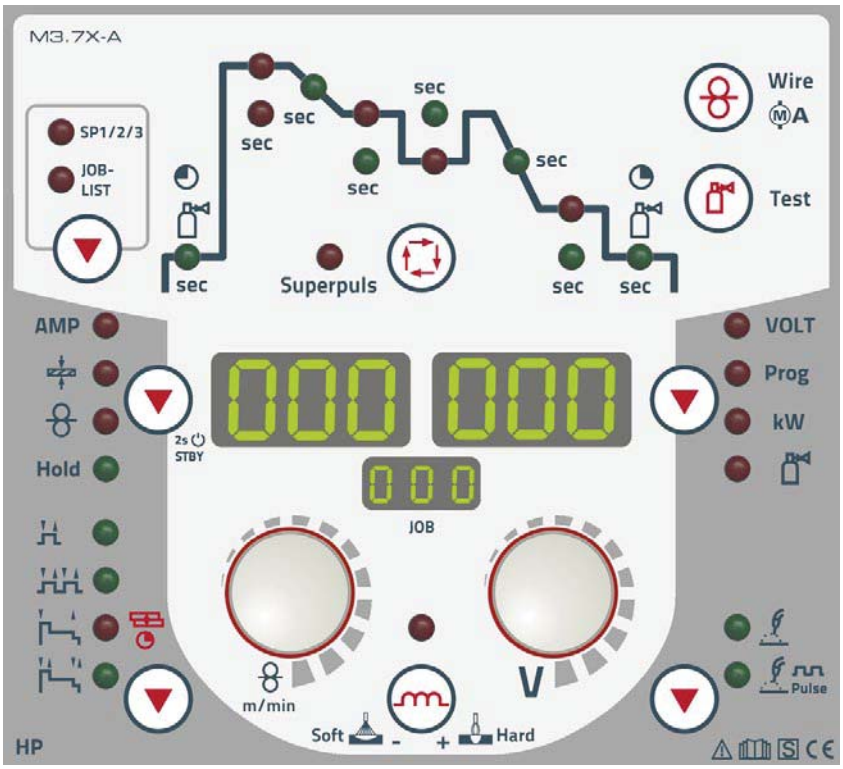
/ Very simple operation, direct access to the most important parameters
/ Wire feed speed 1 m/min to 24 m/min
/ Arc length correction
/ Arc dynamics (choke effect) from soft to hard
/ Operating modes: non-latched, latched
/ Special non-latched and special latched with pre-set, optimised start and end crater program (settings can be changed using R50 remote control or PC 300 software)
/ Spot welding/tack function
/ 16 welding programs per JOB
/ Standby function (save energy at the press of a button)
/ Electronic gas setting with control and monitoring of gas quantity (option)

Digital welding data display with hold function

/ JOB no.: current welding task visible at all times
/ Welding current, welding voltage
/ Armature current display
/ Kilowatt display for calculating the energy per unit length
/ Wire feed speed
/ Default plate thickness
/ Effective arc power for calculating the energy per unit length
/ Program number
/ Motor current (wire feed mechanism), indicates any wire feeding errors
/ Electronically controlled gas quantity

Synergic welding characteristics certified to EN 1090
Option to network via LAN or WiFi thanks to Multimatrix technology
HP control can be easily replaced by LP control at any time

Control HP



Synergic one-knob operation

/ Synergic operating point adjustment with just a single knob
/ Simple JOB selection (material, gas, wire Ø)
/ Equipped with EN 1090-certified Synergic characteristics for EWM coldArc, coldArc puls, pipeSolution, forceArc, forceArc puls, rootArc, rootArc puls and superPuls at no extra charge
/ Equipped with EN 1090-certified Synergic characteristics for GMAW welding of steel/CrNi/aluminium at no extra charge
/ Suitable for MMA welding, TIG welding and gouging at no extra charge

Adjustable welding parameters and functions

/ Wire feed speed 1 m/min to 24 m/min
/ Arc length correction
/ Arc dynamics (choke effect) from soft to hard
/ Operating modes: non-latched, latched
/ Special non-latched and special latched with pre-set, optimised start and end crater program (settings can be changed using R50 remote control or PC 300 software)
/ Spot welding/tack function
/ 16 welding programs per JOB
/ Standby function (save energy at the press of a button)
/ Electronic gas setting with control and monitoring of gas quantity (option)

Digital welding data display with hold function

/ JOB no.: current welding task visible at all times
/ Welding current, welding voltage
/ Armature current display
/ Kilowatt display for calculating the energy per unit length
/ Wire feed speed
/ Default plate thickness
/ Effective arc power for calculating the energy per unit length
/ Program number
/ Motor current (wire feed mechanism), indicates any wire feeding errors
/ Electronically controlled gas quantity

Welding procedure parameters set with LED user guidance

/ Gas pre- and post-flow time
/ Start program, welding program (16 programs per JOB), reduced welding program, end crater program with suitable slope times

Synergic welding characteristics certified to EN 1090
Option to network via LAN or WiFi thanks to Multimatrix technology
HP control can be easily replaced by LP control at any time

Control Expert 2.0

Operation

/ Welding current (amp), arc correction (volt) and arc dynamics (soft/hard) directly adjustable using two rotary knobs
/ Easy switching of welding process at the press of a button, e.g. from forceArc/forceArc puls to rootArc/rootArc puls or coldArc/coldArc puls or standard/pulse
/ Simple JOB selection (welding procedure, material, gas, wire Ø) using click wheel
/ Equipped with EN 1090-certified Synergic characteristics for EWM coldArc, coldArc puls, pipeSolution, forceArc, forceArc puls, rootArc, rootArc puls and superPuls at no extra charge
/ Equipped with EN 1090-certified Synergic characteristics for GMAW welding of steel/CrNi/aluminium at no extra charge
/ Suitable for MMA welding, TIG welding and gouging at no extra charge

Adjustable welding parameters and functions

/ Plain text display for all welding parameters and functions
/ Administration of access rights for different control operating levels using the Xbutton
/ Setting of all parameters in program sequence
/ Operating modes: non-latched, latched
/ Special non-latched and special latched with adjustable start and end crater program
/ Spot welding/tack function
/ 16 welding programs per JOB
/ Standby function (save energy at the press of a button)
/ Electronic gas setting with control and monitoring of gas quantity (option)

LCD display with different user menus

/ Display and change of welding program sequence
/ Information on selected welding task such as JOB number and procedure
/ Welding current, welding voltage
/ Wire feed speed
/ Default plate thickness
/ Effective arc power for calculating the energy per unit length
/ Nominal, actual and hold values
/ Operating modes
/ Status messages
/ Program number
/ Motor current (wire feed mechanism), indicates any wire feeding errors
/ Electronically controlled gas quantity
/ Pre-configured languages for the user menu: German, English, French, Italian, Dutch, Polish, Danish, Latvian, Russian, Spanish, Czech, Swedish, Brazilian Portuguese, Turkish, Hungarian, Romanian

Synergic welding characteristics certified to EN 1090
Option to network via LAN or WiFi thanks to Multimatrix technology
Easy offline data transfer via USB port

alpha Q 330 Progress puls LP MM TKM

MULTIMATRIX

/forceArc® /forceArc®puls
/rootArc® /rootArc®puls
/coldArc® /coldArc®puls
/pipeSolution®
/Pulse
/superPuls

LP

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Wire feed rolls	**Page**	**296**
Function torch	**Page**	**318**
Options/accessories	**Page**	**280**

- Compact inverter welding machine with one-knob Synergic LP control and integrated wire feed mechanism
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge Synergic characteristics for EWM coldArc, EWM coldArc puls, EWM pipeSolution, EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Gas-cooled or optionally water-cooled with cool71 U43 cooling unit
- Excellent torch cooling and therefore cost saving on consumables due to high-performance centrifugal pump and 7 litre water tank (cool71 U43 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Trolly 75-2 trolley and cool71 U43 cooling unit available for delivery
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 330 A
Duty cycle 40 °C	330 A / 40 %
	270 A / 60 %
	210 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	685 x 335 x 750
Weight	64 kg
Dimensions cooling unit in mm	685 x 335 x 255
Weight, cooling unit	34 kg
Trolley dimensions L x W x H in mm	980 x 505 x 990
Trolley weight	34 kg

Type	Designation	Item no.
alpha Q 330 Progress puls LP MM TKM	MIG/MAG multiprocess pulse welding machine, MULTIMATRIX technology, portable, modular	090-005501-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

alpha Q 330 Progress puls LP MM TKM	MIG/MAG multiprocess pulse welding machine, MULTIMATRIX technology, portable, modular	090-005501-00502
cool71 U43	Cooling unit with centrifugal pump	090-008220-00502
MT301W M7 3m	MIG/MAG welding torch, water-cooled	094-500058-00000
MT301W M7 4m		094-500058-00004
MT301W M7 5m		094-500058-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 75-2	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, dismounted	090-008176-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

alpha Q 330 Progress puls HP MM TKM

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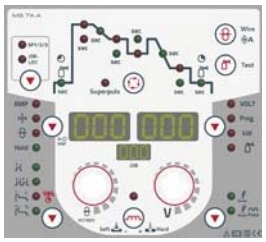
Progress



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- Compact inverter welding machine with one-knob Synergic control and integrated wire feed mechanism
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge Synergic characteristics for EWM coldArc, EWM coldArc puls, EWM pipeSolution, EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Gas-cooled or optionally water-cooled with cool71 U43 cooling unit
- Excellent torch cooling and therefore cost saving on consumables due to high-performance centrifugal pump and 7 litre water tank (cool71 U43 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Trolly 75-2 trolley and cool71 U43 cooling unit available for delivery
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 330 A
Duty cycle 40 °C	330 A / 40 %
	270 A / 60 %
	210 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	685 x 335 x 750
Weight	64 kg
Dimensions cooling unit in mm	685 x 335 x 255
Weight, cooling unit	34 kg
Trolley dimensions L x W x H in mm	980 x 505 x 990
Trolley weight	34 kg

Type	Designation	Item no.
alpha Q 330 Progress puls HP MM TKM	MIG/MAG multiprocess pulse welding machine, MULTIMATRIX technology, portable, modular	090-005402-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

alpha Q 330 Progress puls HP MM TKM	MIG/MAG multiprocess pulse welding machine, MULTIMATRIX technology, portable, modular	090-005402-00502
cool71 U43	Cooling unit with centrifugal pump	090-008220-00502
MT301W M7 3m	MIG/MAG welding torch, water-cooled	094-500058-00000
MT301W M7 4m		094-500058-00004
MT301W M7 5m		094-500058-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 75-2	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, dismounted	090-008176-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

alpha Q 351 ● 551 Progress puls MM FDW

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- Water-cooled MIG/MAG inverter welding machine, pulse, with separate wire feeder
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge Synergic characteristics for EWM coldArc, EWM coldArc puls, EWM pipeSolution, EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

alpha Q	351	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A
Open circuit voltage	93 V	
Setting range for welding current	5 A - 350 A	5 A - 550 A
Duty cycle 40 °C	–	550 A / 60 %
	350 A / 100 %	420 A / 100 %
cos φ	0.99	
Efficiency	88 %	
Dimensions LxWxH in mm	1100 x 455 x 1000	
Weight	135 kg	138.5 kg
Wire feeder, LxWxH in mm	660 x 280 x 380	
Weight, wire feeder	13 kg	

drive HP

drive LP

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Type	Designation	Item no.
alpha Q 351 Progress puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, mobile, water-cooled	090-005333-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
alpha Q 551 Progress puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, mobile, water-cooled	090-005334-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

alpha Q 351 Expert 2.0 puls MM FDW

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/pipeSolution®
/Pulse
/superPuls

- Water-cooled MIG/MAG inverter welding machine, pulse, with separate wire feeder
- Expert 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- Pre-configured languages for control menu: English, German, French, Italian, Dutch, Polish, Danish, Latvian, Russian, Spanish, Czech, Brazilian Portuguese, Swedish, Turkish, Hungarian, Romanian
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge Synergic characteristics for EWM coldArc, EWM coldArc puls, EWM pipeSolution, EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

alpha Q	351	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A
Open circuit voltage	93 V	
Setting range for welding current	5 A - 350 A	5 A - 550 A
Duty cycle 40 °C	–	550 A / 60 %
	350 A / 100 %	420 A / 100 %
cos φ	0.99	
Efficiency	88 %	
Dimensions LxWxH in mm	1100 x 455 x 1000	
Weight	135 kg	138.5 kg
Wire feeder, LxWxH in mm	660 x 280 x 380	
Weight, wire feeder	13 kg	

Expert 2.0

drive HP

drive LP

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Type	Designation	Item no.
alpha Q 351 Expert 2.0 puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, mobile, water-cooled	090-005359-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
alpha Q 551 Expert 2.0 puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, mobile, water-cooled	090-005360-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

alpha Q 351 ● 551 Progress puls MM D FDW

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/pipeSolution®
/Pulse
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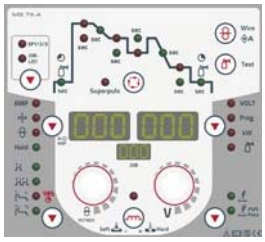
Progress



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- Water-cooled inverter welding machine, pulse, with double wire feeder with one-knob Synergic control
- Two welding tasks with just one power source for alternating welding of root and final passes, solid and/or flux cored wire, or a variety of materials and wire thicknesses
- No wire spool changing or torch conversion necessary, no non-productive times
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge Synergic characteristics for EWM coldArc, EWM coldArc puls, EWM pipeSolution, EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

alpha Q	351	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A
Open circuit voltage	93 V	
Setting range for welding current	5 A - 350 A	5 A - 550 A
Duty cycle 40 °C	–	550 A / 60 %
	350 A / 100 %	420 A / 100 %
cos φ	0.99	
Efficiency	88 %	
Dimensions LxWxH in mm	1100 x 680 x 1000	
Weight	149.5 kg	157 kg

Type	Designation	Item no.
alpha Q 351 Progress puls MM D FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005333-10502
drive 4X D HP	Double wire feeder	090-005459-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
alpha Q 551 Progress puls MM D FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005334-10502
drive 4X D HP	Double wire feeder	090-005459-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
		094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

alpha Q 351 ● 551 Progress puls MM 2DVX FDW

MULTIMATRIX

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/coldArc® /coldArc®puls
/pipeSolution®
/Pulse
/superPuls

drive HP

drive LP

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Options/accessories	Page	280

- Water-cooled inverter welding machine, pulse, with two individual wire feeders for large action radius
- Two welding tasks with just one power source for alternating welding of root and final passes, solid and/or flux cored wire, or a variety of materials and wire thicknesses
- No wire spool changing or torch conversion necessary, no non-productive times
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge Synergic characteristics for EWM coldArc, EWM coldArc puls, EWM pipeSolution, EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables thanks to cooling system with reinforced centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

alpha Q	351	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A
Open circuit voltage	93 V	
Setting range for welding current	5 A - 350 A	5 A - 550 A
Duty cycle 40 °C	–	550 A / 60 %
	350 A / 100 %	420 A / 100 %
cos φ	0.99	
Efficiency	88 %	
Dimensions LxWxH in mm	1100 x 680 x 1000	
Weight	158 kg	
Wire feeder, LxWxH in mm	660 x 280 x 380	
Weight, wire feeder	13 kg	

Type	Designation	Item no.
alpha Q 351 Progress puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005333-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
		094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
alpha Q 551 Progress puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005334-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
		094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

alpha Q 351 ● 551 Expert 2.0 puls MM 2DVX FDW

MULTIMATRIX

/forceArc® /forceArc®puls
/rootArc® /rootArc®puls
/coldArc® /coldArc®puls
/pipeSolution®
/Pulse
/superPuls

- Water-cooled inverter welding machine, pulse, with two individual wire feeders for large action radius
- Expert 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- Two welding tasks with just one power source for alternating welding of root and final passes, solid and/or flux cored wire, or a variety of materials and wire thicknesses
- Pre-configured languages for control menu: English, German, French, Italian, Dutch, Polish, Danish, Latvian, Russian, Spanish, Czech, Brazilian Portuguese, Swedish, Turkish, Hungarian, Romanian
- No wire spool changing or torch conversion necessary, no non-productive times
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge Synergic characteristics for EWM coldArc, EWM coldArc puls, EWM pipeSolution, EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables thanks to cooling system with reinforced centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

alpha Q	351	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A
Open circuit voltage	93 V	
Setting range for welding current	5 A - 350 A	5 A - 550 A
Duty cycle 40 °C	–	550 A / 60 %
	350 A / 100 %	420 A / 100 %
cos φ	0.99	
Efficiency	88 %	
Dimensions LxWxH in mm	1100 x 680 x 1000	
Weight	158 kg	
Wire feeder, LxWxH in mm	660 x 280 x 380	
Weight, wire feeder	13 kg	

Expert 2.0

drive HP

drive LP

Control	Page	63
Wire feed rolls	Page	296
Function torch	Page	318
Options/accessories	Page	280

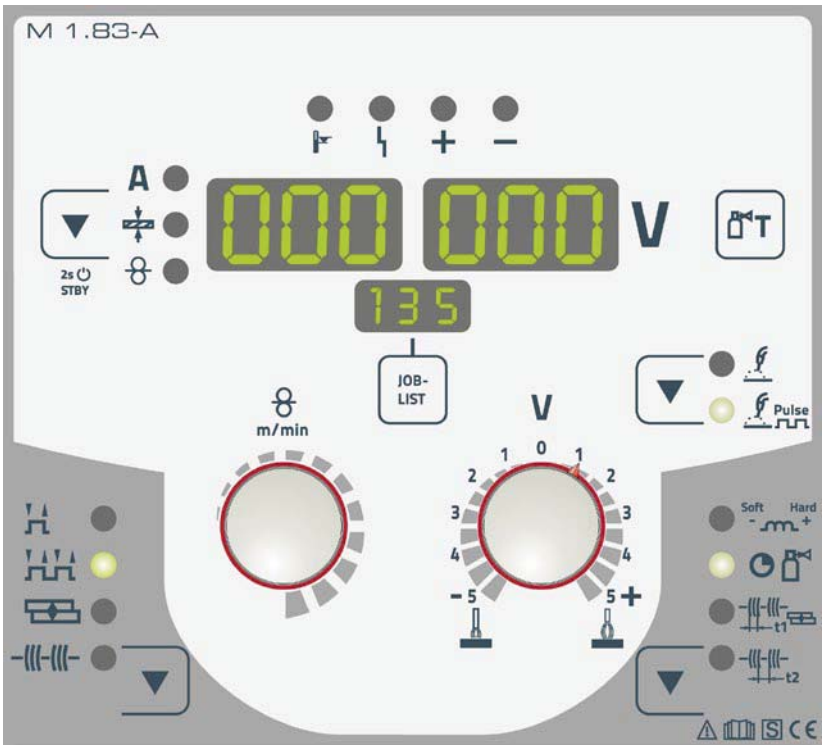
Type	Designation	Item no.
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005359-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
		094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005360-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
		094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Overview

Multiprocess MIG/MAG pulse welding machines, Portable

Design	Max. welding current	Product name	Page
	A		
Compact	180	Picomig 180 puls TKG	83
		Picomig 185 puls TKG	84
	350	Picomig 355 puls TKG	85

Control M1.83-A (Picomig)



Synergic one-knob operation:

/ Synergic operating point adjustment with just a single knob
/ Simple JOB preselection (material, gas, wire diameter)
/ EWM forceArc, forceArc puls, rootArc and rootArc puls (Picomig 355 only)
/ Synergic characteristics for steel/CrNi/aluminium
/ Pulsed GMAW welding, GMAW standard welding, MMA welding and TIG welding

Adjustable welding parameters and functions

/ Wire feed speed 1 m/min to 24 m/min
/ Arc length correction
/ Arc dynamics (choke effect) from soft to hard
/ Operating modes: non-latched, latched, spot, interval
/ Spot welding/tack function
/ Arcforce
/ Hot start
/ Antistick
/ Standby function (save energy at the press of a button)

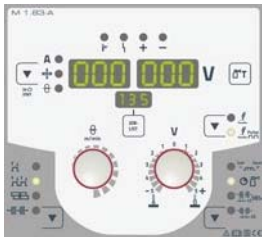
Digital welding data display with hold function

/ JOB no.: Current welding task visible at all times
/ Welding current, welding voltage
/ Wire feed speed
/ Default panel thickness
/ Program number
/ Motor current (wire feed mechanism), indicates any wire feeding errors

Picomig 180 puls TKG

/Pulse

M1.83-A



Control	**Page**	
Wire feed rolls	**Page**	**300**
Options/accessories	**Page**	**280**

- Multiprocess inverter welding machine, pulse, with easy Synergic one-knob operation and integrated wire feeder
- GMAW pulsed welding
- GMAW standard welding
- Synergic or manual welding operation
- Synergic characteristics for steel, CrNi and aluminium
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Perfect for welding self-shielding flux cored wires
- Infinitely adjustable arc dynamics (choke effect)
- MMA welding
- Non-latched/latched operation
- Interval welding
- Adjustable gas pre-flows/post-flows
- Saves power through highly efficient performance
- TIG lift arc welding
- Robust casing suitable for construction site use
- 4-roll drive. Equipped for 0.8 mm + 1.0 mm steel wires
- Easy, tool-free change of welding polarity
- IP23 spray water protected
- Wire spool diameter up to 200 mm/D200
- Portable, compact
- 3.5 m mains supply lead with 16 A shock-proof plug
- Mains connection 230 V/16 A
- High mains voltage tolerance +15%/-40% and therefore fully generator-compatible
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

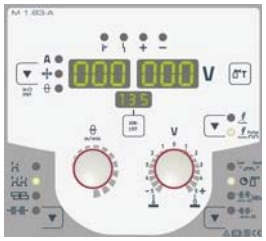
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 180 A
Duty cycle 40 °C	180 A / 25 %
	120 A / 60 %
	100 A / 100 %
cos φ	0.99
Efficiency	86 %
Dimensions LxWxH in mm	685 x 280 x 360
Weight	15 kg
Spool diameter	200 mm

Type	Designation	Item no.
Picomig 180 puls TKG	Multiprocess MIG/MAG pulse welding machine, compact, portable, Euro torch connector	090-005545-00502
MT221G M7 3m	MIG/MAG welding torch, gas-cooled	094-500050-00000
MT221G M7 4m		094-500050-00004
MT221G M7 5m		094-500050-00005
WK25mm² 230A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000016-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Picomig 180 puls TKG Set	Set for Picomig 180 puls (single machine): MIG welding torch, workpiece lead, 3 m gas hose, D200 flux cored wire 0.9 mm (2 kg), D200 steel wire 0.8 mm (2 kg), pressure regulator, flux cored nozzle	091-005545-00502
Packing unit		
6x Picomig 180 puls	Packing unit: 6 x Picomig 180 puls	092-015321-00502

Picomig 185 puls TKG

/Pulse

M1.83-A



Control	**Page**	
Wire feed rolls	**Page**	**296**
Options/accessories	**Page**	**280**

- Multiprocess inverter welding machine, pulse, with easy Synergic one-knob operation and integrated wire feeder
- GMAW pulsed welding
- GMAW standard welding
- Synergic or manual welding operation
- Synergic characteristics for steel, CrNi and aluminium
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Perfect for welding self-shielding flux cored wires
- Infinitely adjustable arc dynamics (choke effect)
- MMA welding
- Non-latched/latched operation
- Interval welding
- Adjustable gas pre-flows/post-flows
- Saves power through highly efficient performance
- TIG lift arc welding
- Robust casing suitable for construction site use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.0 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- IP23 spray water protected
- Portable, compact
- 3.5 m mains supply lead with 16 A shock-proof plug
- Mains connection 230 V/16 A
- High mains voltage tolerance +15%/-40% and therefore fully generator-compatible
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 180 A
Duty cycle 40 °C	180 A / 25 %
	120 A / 60 %
	100 A / 100 %
cos φ	0.99
Efficiency	86 %
Dimensions LxWxH in mm	636 x 298 x 482
Weight	21.4 kg
Spool diameter	300 mm

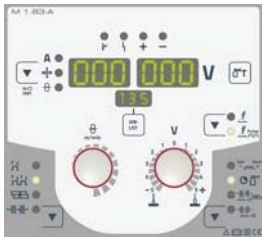
Type	Designation	Item no.
Picomig 185 puls TKG	Multiprocess MIG/MAG pulse welding machine, compact, portable, Euro torch connector	090-005547-00502
MT221G M7 3m	MIG/MAG welding torch, gas-cooled	094-500050-00000
MT221G M7 4m		094-500050-00004
MT221G M7 5m		094-500050-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Packing unit		
6x Picomig 185 puls	Packing unit: 6 x Picomig 185 puls	092-015324-00502

Picomig 355 puls TKG

/forceArc®/forceArc®puls
/rootArc®/rootArc®puls
/Pulse

M1.83-A



Control	**Page**	
Wire feed rolls	**Page**	**296**
Function torch	**Page**	**318**
Options/accessories	**Page**	**280**

- Multiprocess inverter welding machine, pulse, with easy Synergic one-knob operation and integrated wire feeder
- GMAW pulsed welding
- GMAW standard welding
- Synergic or manual welding operation
- EWM forceArc – welding
- EWM forceArc puls – pulsed welding
- EWM rootArc – welding
- EWM rootArc puls – pulsed welding
- Synergic characteristics for steel, CrNi and aluminium
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Perfect for welding self-shielding flux cored wires
- Infinitely adjustable arc dynamics (choke effect)
- MMA welding
- Non-latched/latched operation
- Interval welding
- Adjustable gas pre-flows/post-flows
- Saves power through highly efficient performance
- TIG lift arc welding
- Robust casing suitable for construction site use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.0 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- IP23 spray water protected
- Portable, compact
- Mains connection 3 x 400 V/16 A
- Connection capability for remote control and function torch
- 5 m mains supply lead

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	79 V
Setting range for welding current	5 A - 350 A
Duty cycle 40 °C	350 A / 40 %
	300 A / 60 %
	270 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	636 x 298 x 482
Weight	34 kg
Spool diameter	300 mm

Type	Designation	Item no.
Picomig 355 puls TKG	Multiprocess MIG/MAG pulse welding machine, compact, portable, Euro torch connector	090-005542-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Packing unit		
6x Picomig 355 puls TKG	Packing unit: 6 x Picomig 355 puls	092-015327-00502

Overview

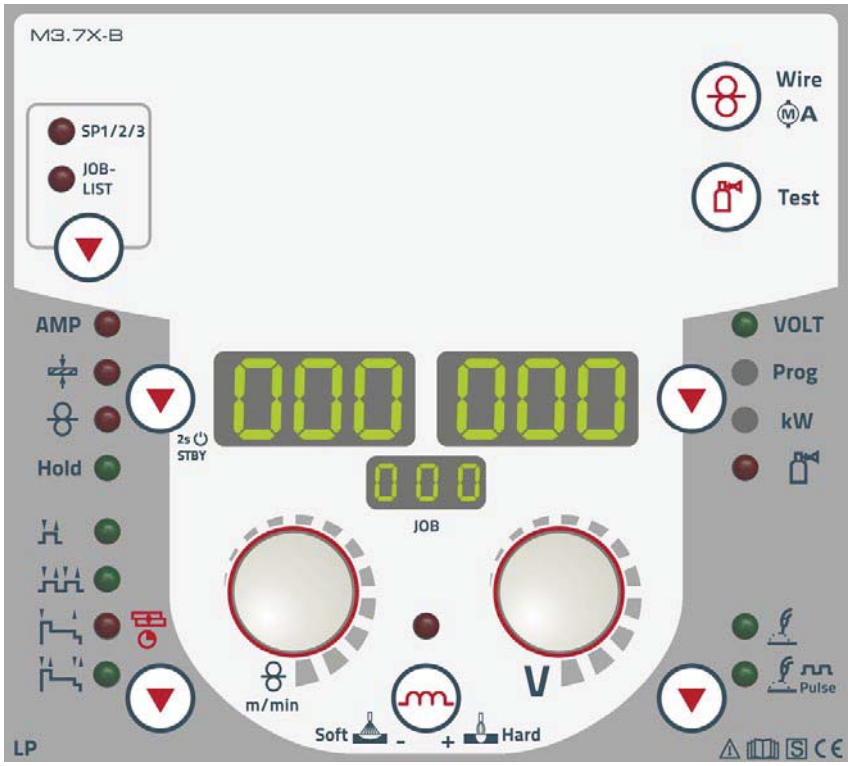
Multiprocess MIG/MAG pulse welding machines, Portable

Design	Max. welding current	Product name	Cooling		Page
	A		optional cooling unit	Water-cooled	
Compact	350	Phoenix 355 Progress puls LP MM TKM	•	•	90
		Phoenix 355 Progress puls HP MM TKM	•	•	92
		Phoenix 355 Expert 2.0 puls MM TKM	•		94
Decompact	350 - 500	Phoenix 355 • 405 • 505 Progress puls MM TDM	•	•	96
		Phoenix 355 • 405 • 505 Expert 2.0 puls MM TDM	•	•	99

Multiprocess MIG/MAG pulse welding machines, Mobile

Design	Max. welding current	Product name	Cooling		Page
	A		optional cooling unit	Water-cooled	
Compact	400 - 500	Phoenix 401 • 501 Progress puls LP MM FKW		•	102
		Phoenix 401 • 501 Progress puls HP MM FKW		•	104
Decompact	350 - 550	Phoenix 351 • 401 • 451 • 551 Progress puls MM FDW		•	106
		Phoenix 351 • 401 • 451 • 551 Expert 2.0 puls MM FDW		•	109
		Phoenix 351 • 401 • 451 • 551 Progress puls MM D FDW		•	112
		Phoenix 351 • 401 • 451 • 551 Progress puls MM 2DVX FDW		•	115
		Phoenix 351 • 401 • 451 • 551 Expert 2.0 puls MM 2DVX FDW		•	118

Control LP



Synergic one-knob operation

/ Synergic operating point adjustment with just a single knob
/ Simple JOB selection (material, gas, wire Ø)
/ Equipped with EN 1090-certified Synergic characteristics for EWM forceArc, forceArc puls, rootArc and rootArc puls at no extra charge
/ Equipped with EN 1090-certified Synergic characteristics for GMAW welding of steel/CrNi/aluminium at no extra charge
/ Suitable for MMA welding, TIG welding and gouging at no extra charge

Adjustable welding parameters and functions

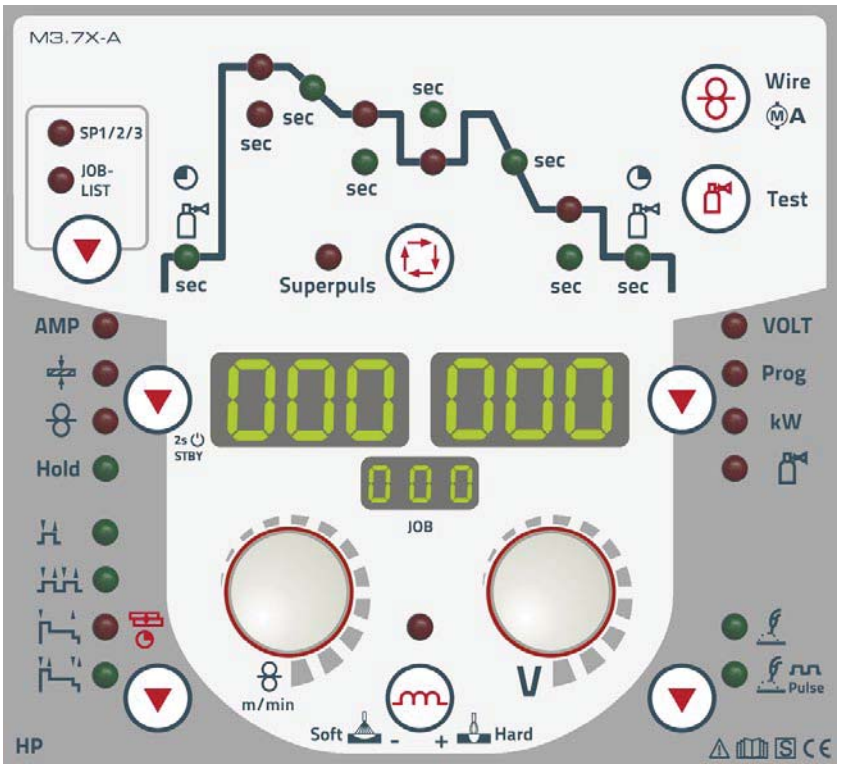
/ Very simple operation, direct access to the most important parameters
/ Wire feed speed 1 m/min to 24 m/min
/ Arc length correction
/ Arc dynamics (choke effect) from soft to hard
/ Operating modes: non-latched, latched
/ Special non-latched and special latched with pre-set, optimised start and end crater program (settings can be changed using R50 remote control or PC 300 software)
/ Spot welding/tack function
/ 16 welding programs per JOB
/ Standby function (save energy at the press of a button)
/ Electronic gas setting with control and monitoring of gas quantity (option)

Digital welding data display with hold function

/ JOB no.: current welding task visible at all times
/ Welding current, welding voltage
/ Armature current display
/ Kilowatt display for calculating the energy per unit length
/ Wire feed speed
/ Default plate thickness
/ Effective arc power for calculating the energy per unit length
/ Program number
/ Motor current (wire feed mechanism), indicates any wire feeding errors
/ Electronically controlled gas quantity

Synergic welding characteristics certified to EN 1090
Option to network via LAN or WiFi thanks to Multimatrix technology
HP control can be easily replaced by LP control at any time

Control HP



Synergic one-knob operation

/ Synergic operating point adjustment with just a single knob
/ Simple JOB selection (material, gas, wire Ø)
/ Equipped with EN 1090-certified Synergic characteristics for EWM forceArc, forceArc puls, rootArc, rootArc puls and superPuls at no extra charge
/ Equipped with EN 1090-certified Synergic characteristics for GMAW welding of steel/CrNi/aluminium at no extra charge
/ Suitable for MMA welding, TIG welding and gouging at no extra charge

Adjustable welding parameters and functions

/ Wire feed speed 1 m/min to 24 m/min
/ Arc length correction
/ Arc dynamics (choke effect) from soft to hard
/ Operating modes: non-latched, latched
/ Special non-latched and special latched with pre-set, optimised start and end crater program (settings can be changed using R50 remote control or PC 300 software)
/ Spot welding/tack function
/ 16 welding programs per JOB
/ Standby function (save energy at the press of a button)
/ Electronic gas setting with control and monitoring of gas quantity (option)

Digital welding data display with hold function

/ JOB no.: current welding task visible at all times
/ Welding current, welding voltage
/ Armature current display
/ Kilowatt display for calculating the energy per unit length
/ Wire feed speed
/ Default plate thickness
/ Effective arc power for calculating the energy per unit length
/ Program number
/ Motor current (wire feed mechanism), indicates any wire feeding errors
/ Electronically controlled gas quantity

Welding procedure parameters set with LED user guidance

/ Gas pre- and post-flow time
/ Start program, welding program (16 programs per JOB), reduced welding program, end crater program with suitable slope times
/ superPuls: Controlled reduced heat input for fast and safe welding of vertical-up welds without ‚Christmas tree technique'

Synergic welding characteristics certified to EN 1090
Option to network via LAN or WiFi thanks to Multimatrix technology
HP control can be easily replaced by LP control at any time

Machine control Expert 2.0 – decompact machines

Operation

/ Welding current (amp), arc correction (volt) and arc dynamics (soft/hard) directly adjustable using two rotary knobs
/ Easy switching of welding process at the press of a button, e.g. from forceArc/forceArc puls to rootArc/rootArc puls or coldArc/coldArc puls or standard/pulse
/ Simple JOB selection (welding procedure, material, gas, wire Ø) using click wheel
/ Equipped with EN 1090-certified Synergic characteristics for EWM forceArc, forceArc puls, rootArc, rootArc puls and superPuls at no extra charge
/ Equipped with EN 1090-certified Synergic characteristics for GMAW welding of steel/CrNi/aluminium at no extra charge
/ Suitable for MMA welding, TIG welding and gouging at no extra charge

Adjustable welding parameters and functions

/ Plain text display for all welding parameters and functions
/ Administration of access rights for different control operating levels using the Xbutton
/ Setting of all parameters in program sequence
/ Operating modes: non-latched, latched
/ Special non-latched and special latched with adjustable start and end crater program
/ Spot welding/tack function
/ 16 welding programs per JOB
/ Standby function (save energy at the press of a button)
/ Electronic gas setting with control and monitoring of gas quantity (option)

LCD display with different user menus

/ Display and change of welding program sequence
/ Information on selected welding task such as JOB number and procedure
/ Welding current, welding voltage
/ Wire feed speed
/ Default plate thickness
/ Effective arc power for calculating the energy per unit length
/ Nominal, actual and hold values
/ Operating modes
/ Status messages
/ Program number
/ Motor current (wire feed mechanism), indicates any wire feeding errors
/ Electronically controlled gas quantity
/ Pre-configured languages for the user menu: German, English, French, Italian, Dutch, Polish, Danish, Latvian, Russian, Spanish, Czech, Swedish, Brazilian Portuguese, Turkish, Hungarian, Romanian

Synergic welding characteristics certified to EN 1090
Option to network via LAN or WiFi thanks to Multimatrix technology
Easy offline data transfer via USB port

Phoenix 355 Progress puls LP MM TKM

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/Pulse
/superPuls

LP

Control	**Page**	**87**
Wire feed rolls	**Page**	**296**
Function torch	**Page**	**318**
Options/accessories	**Page**	**280**

- Compact inverter welding machine with one-knob Synergic LP control and integrated wire feed mechanism
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Gas-cooled or optionally water-cooled with cool 50 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- Trolly 55-5 trolley and cool50 cooling unit available

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 350 A
Duty cycle 40 °C	350 A / 40 %
	300 A / 60 %
	270 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	625 x 300 x 480
Weight	33 kg
Dimensions cooling unit in mm	610 x 300 x 330
Weight, cooling unit	16.5 kg
Trolley dimensions L x W x H in mm	1015 x 505 x 1105
Trolley weight	35 kg

Type	Designation	Item no.
Phoenix 355 Progress puls LP MM TKM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, portable, modular, Euro torch connector	090-005502-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 355 Progress puls LP MM TKM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, portable, modular, Euro torch connector	090-005502-00502
cool50 U40	Cooling unit with centrifugal pump	090-008598-00502
MT301W M7 3m	MIG/MAG welding torch, water-cooled	094-500058-00000
MT301W M7 4m		094-500058-00004
MT301W M7 5m		094-500058-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 355 Progress puls HP MM TKM

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/Pulse
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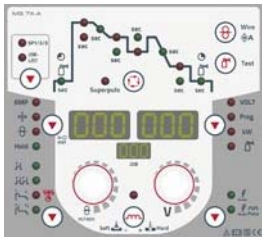
Progress



Control	**Page**	**87**
Wire feed rolls	**Page**	**296**
Function torch	**Page**	**318**
Options/accessories	**Page**	**280**

- Compact inverter welding machine with one-knob Synergic control and integrated wire feed mechanism
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Gas-cooled or optionally water-cooled with cool 50 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- Trolly 55-5 trolley and cool50 cooling unit available

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 350 A
Duty cycle 40 °C	350 A / 40 %
	300 A / 60 %
	270 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	625 x 300 x 480
Weight	33 kg
Dimensions cooling unit in mm	610 x 300 x 330
Weight, cooling unit	16.5 kg
Trolley dimensions L x W x H in mm	1015 x 505 x 1105
Trolley weight	35 kg

Type	Designation	Item no.
Phoenix 355 Progress puls HP MM TKM	–	090-005403-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 355 Progress puls HP MM TKM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, portable, modular, Euro torch connector	090-005403-00502
cool50 U40	Cooling unit with centrifugal pump	090-008598-00502
MT301W M7 3m	MIG/MAG welding torch, water-cooled	094-500058-00000
MT301W M7 4m		094-500058-00004
MT301W M7 5m		094-500058-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 355 Expert 2.0 puls MM TKM

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Expert 2.0

Control	**Page**	**87**
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- Compact inverter welding machine with integrated wire feed mechanism
- Expert 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- Pre-configured languages for control menu: English, German, French, Italian, Dutch, Polish, Danish, Latvian, Russian, Spanish, Czech, Brazilian Portuguese, Swedish, Turkish, Hungarian, Romanian
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Modular (gas- or water-cooled)
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Connection capability for remote control and function torch
- Trolly 55-5 trolley and cool50 cooling unit available

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 350 A
Duty cycle 40 °C	350 A / 40 %
	300 A / 60 %
	270 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	625 x 300 x 480
Weight	33 kg
Dimensions cooling unit in mm	610 x 300 x 330
Weight, cooling unit	16.5 kg
Trolley dimensions L x W x H in mm	1015 x 505 x 1105
Trolley weight	35 kg

Type	Designation	Item no.
Phoenix 355 Expert 2.0 puls MM TKM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, portable, modular, Euro torch connector	090-005445-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 355 Expert 2.0 puls MM TKM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, compact, portable, modular, Euro torch connector	090-005445-00502
cool50 U40	Cooling unit with centrifugal pump	090-008598-00502
MT301W M7 3m	MIG/MAG welding torch, water-cooled	094-500058-00000
MT301W M7 4m		094-500058-00004
MT301W M7 5m		094-500058-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 355 ● 405 ● 505 Progress puls MM TDM

MULTIMATRIX

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/rootArc® /rootArc® puls
/Pulse
/superPuls

- Modular MIG/MAG inverter welding machine, pulse, with separate wire feeder
- Synergic one-knob operation
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- Trolly 55-5 trolley and cool50 cooling unit available
- Protective earth monitoring (PE)

drive HP

drive LP

Control	Page	87
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Phoenix	355	405	505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	80 V		
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C	350 A / 60 %	–	500 A / 60 %
	300 A / 100 %	400 A / 100 %	430 A / 100 %
cos φ	0.99		
Efficiency	90 %		
Dimensions LxWxH in mm	625 x 300 x 535		
Weight	41 kg		45 kg
Wire feeder, LxWxH in mm	660 x 280 x 380		
Weight, wire feeder	13 kg		
Dimensions cooling unit in mm	610 x 300 x 330		
Weight, cooling unit	16.5 kg		
Trolley dimensions L x W x H in mm	1015 x 505 x 1105		
Trolley weight	35 kg		

Type	Designation	Item no.
Phoenix 355 Progress puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	090-005320-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
cool50-2 U40	Cooling unit with centrifugal pump	090-008603-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Phoenix 405 Progress puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	090-005321-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
cool50-2 U40	Cooling unit with centrifugal pump	090-008603-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 505 Progress puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	090-005322-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
cool50-2 U40	Cooling unit with centrifugal pump	090-008603-00502
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 355 ● 405 ● 505 Expert 2.0 puls MM TDM

MULTIMATRIX

/forceArc® /forceArc® puls
/rootArc® /rootArc® puls
/Pulse
/superPuls

- Modular MIG/MAG inverter welding machine, pulse, with separate wire feeder
- Expert 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- Pre-configured languages for control menu: English, German, French, Italian, Dutch, Polish, Danish, Latvian, Russian, Spanish, Czech, Brazilian Portuguese, Swedish, Turkish, Hungarian, Romanian
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- Trolly 55-5 trolley and cool50 cooling unit available

drive HP

Expert 2.0

drive LP

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Phoenix	355	405	505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	80 V		
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C	350 A / 60 %	–	500 A / 60 %
	300 A / 100 %	400 A / 100 %	430 A / 100 %
cos φ	0.99		
Efficiency	90 %		
Dimensions LxWxH in mm	625 x 300 x 535		
Weight	41 kg		45 kg
Wire feeder, LxWxH in mm	660 x 280 x 380		
Weight, wire feeder	13 kg		
Dimensions cooling unit in mm	610 x 300 x 330		
Weight, cooling unit	16.5 kg		
Trolley dimensions L x W x H in mm	1015 x 505 x 1105		
Trolley weight	35 kg		

Type	Designation	Item no.
Phoenix 355 Expert 2.0 puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	090-005352-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
cool50-2 U40	Cooling unit with centrifugal pump	090-008603-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Phoenix 405 Expert 2.0 puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	090-005353-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
cool50-2 U40	Cooling unit with centrifugal pump	090-008603-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 505 Expert 2.0 puls MM TDM	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, decompact, portable, modular	090-005354-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
cool50-2 U40	Cooling unit with centrifugal pump	090-008603-00502
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 401 • 501 Progress puls LP MM FKW

MULTIMATRIX

/forceArc® /forceArc® puls
/rootArc® /rootArc® puls
/Pulse
/superPuls

- Water-cooled, compact pulse welding machine with single-knob Synergic LP control and integrated wire feeder
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

LP

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Phoenix	401	501
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 32 A	
Open circuit voltage	80 V	
Setting range for welding current	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C	–	500 A / 60 %
	400 A / 100 %	430 A / 100 %
cos φ	0.99	
Efficiency	90 %	
Dimensions LxWxH in mm	1100 x 455 x 1000	
Weight	119.5 kg	

Type	Designation	Item no.
Phoenix 401 Progress puls LP MM FKW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, compact, mobile, water-cooled	090-005503-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 501 Progress puls LP MM FKW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, compact, mobile, water-cooled	090-005504-00502
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

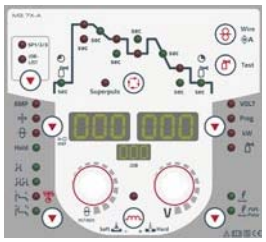
Phoenix 401 • 501 Progress puls HP MM FKW

MULTIMATRIX

/forceArc® /forceArc® puls
/rootArc® /rootArc® puls
/Pulse
/superPuls

- Water-cooled, compact pulse welding machine with one-knob Synergic control and integrated wire feeder
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

Progress



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Phoenix	401	501
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 32 A	
Open circuit voltage	80 V	
Setting range for welding current	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C	–	500 A / 60 %
	400 A / 100 %	430 A / 100 %
cos φ	0.99	
Efficiency	90 %	
Dimensions LxWxH in mm	1100 x 455 x 1000	
Weight	119.5 kg	

Type	Designation	Item no.
Phoenix 401 Progress puls HP MM FKW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, compact, mobile, water-cooled	090-005404-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 501 Progress puls HP MM FKW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, compact, mobile, water-cooled	090-005405-00502
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 351 ● 401 ● 451 ● 551 Progress puls MM FDW

MULTIMATRIX

/forceArc® /forceArc® puls
/rootArc® /rootArc® puls
/Pulse
/superPuls

- Water-cooled MIG/MAG inverter welding machine, pulse, with separate wire feeder
- Synergic one-knob operation
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

drive HP

drive LP

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Phoenix	351	401	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
Open circuit voltage	80 V			
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–		450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	
cos φ	0.99			
Efficiency	90 %			
Dimensions LxWxH in mm	1100 x 455 x 1000			
Weight	118 kg		129 kg	
Wire feeder, LxWxH in mm	660 x 280 x 380			
Weight, wire feeder	13 kg			

Type	Designation	Item no.
Phoenix 351 Progress puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005325-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Phoenix 401 Progress puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005326-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 451 Progress puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005327-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 551 Progress puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005328-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 351 ● 401 ● 451 ● 551 Expert 2.0 puls MM FDW

MULTIMATRIX

/forceArc® /forceArc® puls
/rootArc® /rootArc® puls
/Pulse
/superPuls

- Water-cooled MIG/MAG inverter welding machine, pulse, with separate wire feeder
- Expert 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- Pre-configured languages for control menu: English, German, French, Italian, Dutch, Polish, Danish, Latvian, Russian, Spanish, Czech, Brazilian Portuguese, Swedish, Turkish, Hungarian, Romanian
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

Expert 2.0

drive HP

drive LP

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Phoenix	351	401	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
Open circuit voltage	80 V			
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–		450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	
cos φ	0.99			
Efficiency	90 %			
Dimensions LxWxH in mm	1100 x 455 x 1000			
Weight	118 kg		129 kg	
Wire feeder, LxWxH in mm	660 x 280 x 380			
Weight, wire feeder	13 kg			

Type	Designation	Item no.
Phoenix 351 Expert 2.0 puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005329-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Phoenix 401 Expert 2.0 puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005330-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 451 Expert 2.0 puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005331-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

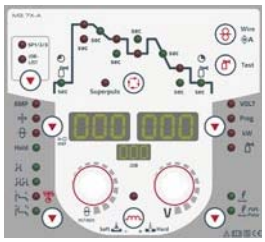
Phoenix 551 Expert 2.0 puls MM FDW	MIG/MAG multiprocess pulse welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005332-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 351 ● 401 ● 451 ● 551 Progress puls MM D FDW

MULTIMATRIX

/forceArc® /forceArc®puls
/rootArc® /rootArc®puls
/Pulse
/superPuls

Progress



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- Water-cooled inverter welding machine, pulse, with double wire feeder with one-knob Synergic control
- Two welding tasks with just one power source for alternating welding of root and final passes, solid and/or flux cored wire, or a variety of materials and wire thicknesses
- No wire spool changing or torch conversion necessary, no non-productive times
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

Phoenix	351	401	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
Open circuit voltage	80 V			
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–		450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	
cos φ	0.99			
Efficiency	90 %			
Dimensions LxWxH in mm	1100 x 680 x 1000			
Weight	147 kg		158 kg	

Type	Designation	Item no.
Phoenix 351 Progress puls MM D FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005325-10502
drive 4X D HP	Double wire feeder	090-005459-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Phoenix 401 Progress puls MM D FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, reinforced pump, wheel spacer, holding plate drive 4D	090-005326-10502
drive 4X D HP	Double wire feeder	090-005459-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 451 Progress puls MM D FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005327-10502
drive 4X D HP	Double wire feeder	090-005459-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 551 Progress puls MM D FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005328-10502
drive 4X D HP	Double wire feeder	090-005459-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

▶ Taurus machines available on request

Phoenix 351 ● 401 ● 451 ● 551 Progress puls MM 2DVX FDW

MULTIMATRIX

/forceArc® /forceArc®puls
/rootArc® /rootArc®puls
/Pulse
/superPuls

drive HP

drive LP

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- Water-cooled inverter welding machine, pulse, with two individual wire feeders for large action radius
- Two welding tasks with just one power source for alternating welding of root and final passes, solid and/or flux cored wire, or a variety of materials and wire thicknesses
- No wire spool changing or torch conversion necessary, no non-productive times
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables thanks to cooling system with reinforced centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

Phoenix	351	401	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
Open circuit voltage	80 V			
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–		450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	
cos φ	0.99			
Efficiency	90 %			
Dimensions LxWxH in mm	1100 x 680 x 1000			
Weight	147 kg		158 kg	
Wire feeder, LxWxH in mm	660 x 280 x 380			
Weight, wire feeder	13 kg			

Type	Designation	Item no.
Phoenix 351 Progress puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005325-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
		094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Phoenix 401 Progress puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005326-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
		094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 451 Progress puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, reinforced pump, wheel spacer, holding plate for two drive 4X	090-005327-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
		094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 551 Progress puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, reinforced pump, wheel spacer, holding plate for two drive 4X	090-005328-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
		094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

▶ Taurus machines available on request

Phoenix 351 ● 401 ● 451 ● 551 Expert 2.0 puls MM 2DVX FDW

MULTIMATRIX

/forceArc® /forceArc®puls
/rootArc® /rootArc®puls
/Pulse
/superPuls

- Water-cooled inverter welding machine, pulse, with two individual wire feeders for large action radius
- Expert 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- Two welding tasks with just one power source for alternating welding of root and final passes, solid and/or flux cored wire, or a variety of materials and wire thicknesses
- Pre-configured languages for control menu: English, German, French, Italian, Dutch, Polish, Danish, Latvian, Russian, Spanish, Czech, Brazilian Portuguese, Swedish, Turkish, Hungarian, Romanian
- No wire spool changing or torch conversion necessary, no non-productive times
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for EWM forceArc, EWM forceArc puls, EWM rootArc, EWM rootArc puls and superPuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables thanks to cooling system with reinforced centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible

Expert 2.0

drive HP

drive LP

Control	**Page**	**87**
Wire feed rolls	**Page**	**296**
Function torch	**Page**	**318**
Options/accessories	**Page**	**280**

Phoenix	351	401	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
Open circuit voltage	80 V			
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–		450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	
cos φ	0.99			
Efficiency	90 %			
Dimensions LxWxH in mm	1100 x 680 x 1000			
Weight	147 kg		158 kg	
Wire feeder, LxWxH in mm	660 x 280 x 380			
Weight, wire feeder	13 kg			

Type	Designation	Item no.
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005329-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
		094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005330-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
		094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 451 Expert 2.0 puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005331-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
		094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Phoenix 551 Expert 2.0 puls MM 2DVX FDW	Multiprocess MIG/MAG pulse welding machine with MULTIMATRIX technology, boosted pump	090-005332-54502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
		090-005392-00502
drive 4X LP		090-005412-00502
		090-005412-00502
drive 4X EX		090-005511-00502
		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
		094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
		394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

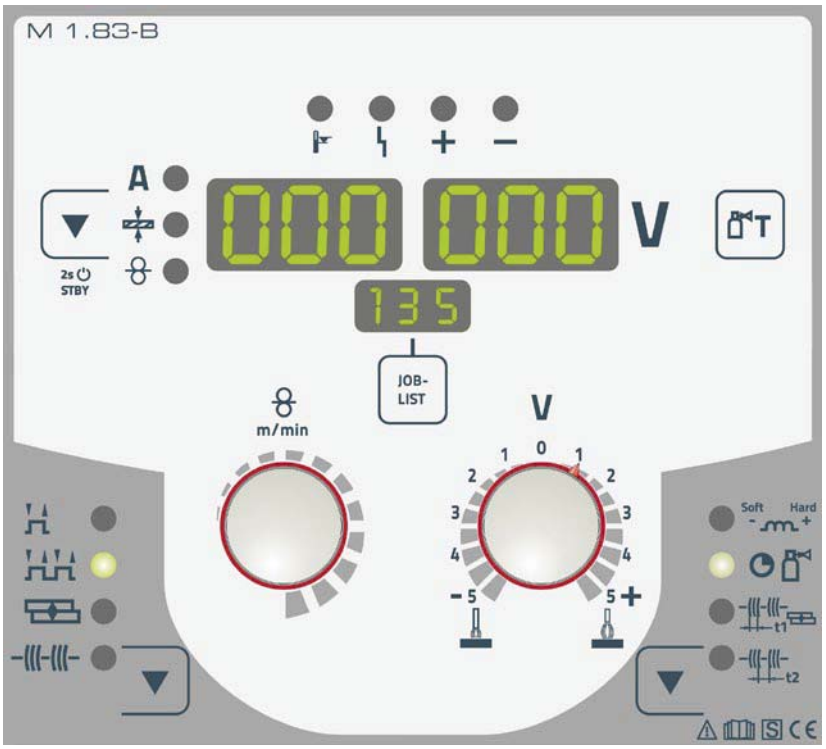
▶ Taurus machines available on request

Overview

Multiprocess MIG/MAG standard welding machines, Portable

Design	Max. welding current	Product name	Page
	A		
Compact	180	Picomig 180 Synergic TKG	123
		Picomig 185 Synergic TKG	124
	350	Picomig 355 Synergic TKG	125

Control M1.83-B (Picomig)



Synergic one-knob operation:

/ Synergic operating point adjustment with just a single knob
/ Simple JOB preselection (material, gas, wire diameter)
/ EWM forceArc and rootArc (Picomig 355 only)
/ Synergic characteristics for steel/CrNi/aluminium
/ GMAW standard welding, MMA welding and TIG welding

Adjustable welding parameters and functions

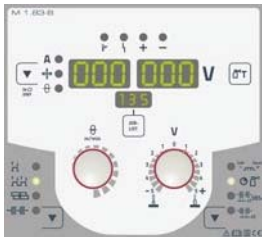
/ Wire feed speed 1 m/min to 24 m/min
/ Arc length correction
/ Arc dynamics (choke effect) from soft to hard
/ Operating modes: non-latched, latched, spot, interval
/ Spot welding/tack function
/ Arcforce
/ Hot start
/ Antistick
/ Standby function (save energy at the press of a button)

Digital welding data display with hold function

/ JOB no.: Current welding task visible at all times
/ Welding current, welding voltage
/ Wire feed speed
/ Default panel thickness
/ Program number
/ Motor current (wire feed mechanism), indicates any wire feeding errors

Picomig 180 Synergic TKG

M1.83-B



Control	Page	
Wire feed rolls	Page	300
Options/accessories	Page	280

- Multiprocess inverter welding machine with easy Synergic one-knob operation and integrated wire feed mechanism
- GMAW standard welding
- Synergic characteristics for steel, CrNi and aluminium
- Perfect for welding self-shielding flux cored wires
- Infinitely adjustable arc dynamics (choke effect)
- MMA welding
- Non-latched/latched operation
- Interval welding
- Adjustable gas pre-flows/post-flows
- Saves power through highly efficient performance
- TIG lift arc welding
- Robust casing suitable for construction site use
- 4-roll drive. Equipped for 0.8 mm + 1.0 mm steel wires
- Easy, tool-free change of welding polarity
- IP23 spray water protected
- Wire spool diameter up to 200 mm/D200
- Portable, compact
- 3.5 m mains supply lead with 16 A shock-proof plug
- Mains connection 230 V/16 A
- High mains voltage tolerance +15%/-40% and therefore fully generator-compatible
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

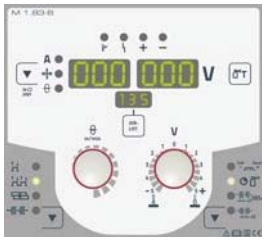
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 180 A
Duty cycle 40 °C	180 A / 25 %
	120 A / 60 %
	100 A / 100 %
cos φ	0.99
Efficiency	86 %
Dimensions LxWxH in mm	685 x 280 x 360
Weight	15 kg
Spool diameter	200 mm

Type	Designation	Item no.
Picomig 180 Synergic TKG	Multiprocess MIG/MAG welding machine, compact, portable, Euro torch connector	090-005546-00502
MT221G M7 3m	MIG/MAG welding torch, gas-cooled	094-500050-00000
MT221G M7 4m		094-500050-00004
MT221G M7 5m		094-500050-00005
WK25mm² 230A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000016-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Picomig 180 Synergic Set	Set for Picomig 180 Synergic (single machine): MIG welding torch, workpiece lead, 3 m gas hose, D200 flux cored wire 0.9 mm (2 kg), D200 steel wire 0.8 mm (2 kg), pressure regulator, flux cored nozzle	091-005546-00502
Packing unit		
6x Picomig 180 Synergic	Packing unit: 6 x Picomig 180 Synergic	092-015323-00502

Picomig 185 Synergic TKG

- Multiprocess inverter welding machine with easy Synergic one-knob operation and integrated wire feed mechanism
- GMAW standard welding
- Synergic characteristics for steel, CrNi and aluminium
- Perfect for welding self-shielding flux cored wires
- Infinitely adjustable arc dynamics (choke effect)
- MMA welding
- Non-latched/latched operation
- Interval welding
- Adjustable gas pre-flows/post-flows
- Saves power through highly efficient performance
- TIG lift arc welding
- Robust casing suitable for construction site use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.0 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- IP23 spray water protected
- Portable, compact
- 3.5 m mains supply lead with 16 A shock-proof plug
- Mains connection 230 V/16 A
- High mains voltage tolerance +15%/-40% and therefore fully generator-compatible

M1.83-B



Control	**Page**	
Wire feed rolls	**Page**	**296**
Options/accessories	**Page**	**280**

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 180 A
Duty cycle 40 °C	180 A / 25 %
	120 A / 60 %
	100 A / 100 %
cos φ	0.99
Efficiency	86 %
Dimensions LxWxH in mm	636 x 298 x 482
Weight	21.4 kg
Spool diameter	300 mm

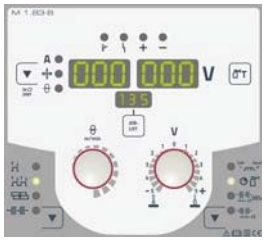
Type	Designation	Item no.
Picomig 185 Synergic TKG	Multiprocess MIG/MAG welding machine, compact, portable, Euro torch connector	090-005548-00502
MT221G M7 3m	MIG/MAG welding torch, gas-cooled	094-500050-00000
MT221G M7 4m		094-500050-00004
MT221G M7 5m		094-500050-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Packing unit		
6x Picomig 185 Synergic	Packing unit: 6 x Picomig 185 Synergic	092-015325-00502

Picomig 355 Synergic TKG

/forceArc®
/rootArc®

M1.83-B



Control	**Page**	
Wire feed rolls	**Page**	**296**
Function torch	**Page**	**318**
Options/accessories	**Page**	**280**

- Multiprocess inverter welding machine with easy Synergic one-knob operation and integrated wire feed mechanism
- GMAW standard welding
- EWM forceArc – welding
- EWM rootArc – welding
- Synergic characteristics for steel, CrNi and aluminium
- Perfect for welding self-shielding flux cored wires
- Infinitely adjustable arc dynamics (choke effect)
- MMA welding
- Non-latched/latched operation
- Interval welding
- Adjustable gas pre-flows/post-flows
- Saves power through highly efficient performance
- TIG lift arc welding
- Robust casing suitable for construction site use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.0 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Portable, compact
- Mains connection 3 x 400 V/16 A
- Connection capability for remote control and function torch
- 5 m mains supply lead

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	79 V
Setting range for welding current	5 A - 350 A
Duty cycle 40 °C	350 A / 40 %
	300 A / 60 %
	270 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	636 x 298 x 482
Weight	34 kg
Spool diameter	300 mm

Type	Designation	Item no.
Picomig 355 Synergic TKG	Multiprocess MIG/MAG welding machine, compact, portable, Euro torch connector	090-005512-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Packing unit		
6x Picomig 355 Synergic TKG	Packing unit: 6 x Picomig 355 Synergic	092-015326-00502

Overview

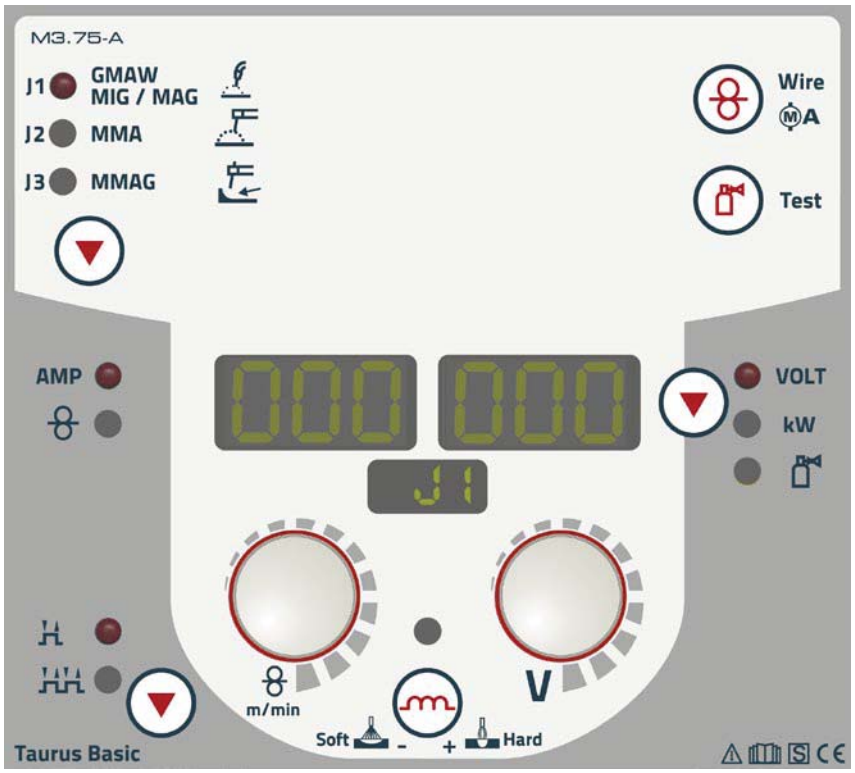
Multiprocess MIG/MAG standard welding machines, Portable

Design	Max. welding current	Product name	Cooling		Page
	A		optional cooling unit	Water-cooled	
	350	Pico 350 cel puls • Pico 350 cel puls pws			131
Compact	350	Taurus 355 Basic TKM	•		134
		Taurus 355 Synergic S LP MM TKM	•		135
		Taurus 355 Synergic S HP MM TKM	•		136
		Taurus 355 Basic TKW		•	137
		Taurus 355 Synergic S LP MM TKW		•	138
		Taurus 355 Synergic S HP MM TKW		•	139
Decompact	1000	Set Taurus 505 Basic Duo Gouging			150
	350 - 500	Taurus 355 • 405 • 505 Basic TDM G	•	•	140
		Taurus 355 • 405 • 505 Synergic S HP/LP MM TDM G	•	•	142
		Taurus 355 • 405 • 505 Basic TDW		•	144
		Taurus 355 • 405 • 505 Synergic S HP/LP MM TDW		•	147
	400	Taurus 400 Basic			133
	500	Taurus 505 Basic for gouging	•		151

Multiprocess MIG/MAG standard welding machines, Mobile

Design	Max. welding current	Product name	Cooling		Page
	A		optional cooling unit	Water-cooled	
Compact	350 - 400	Taurus 351 • 401 Basic FKG			152
		Taurus 351 • 401 Synergic S LP MM FKG			153
		Taurus 351 • 401 Synergic S HP MM FKG			155
	350 - 500	Taurus 351 • 401 • 501 Basic FKW		•	157
		Taurus 351 • 401 • 501 Synergic S LP MM FKW		•	159
		Taurus 351 • 401 • 501 Synergic S HP MM FKW		•	161
Decompact	350 - 550	Taurus 351 • 401 • 451 • 551 Basic FDG			163
		Taurus 351 • 401 • 451 • 551 Synergic S HP/LP MM FDG			166
		Taurus 351 • 401 • 451 • 551 Basic FDW		•	169
		Taurus 351 • 401 • 451 • 551 Synergic S HP/LP MM FDW		•	172

Basic control



Twin-knob operation:

/ Operating point adjustment using wire feed speed and welding voltage
/ Suitable for GMAW welding of steel, CrNi and aluminium at no extra charge
/ Suitable for MMA welding and gouging at no extra charge

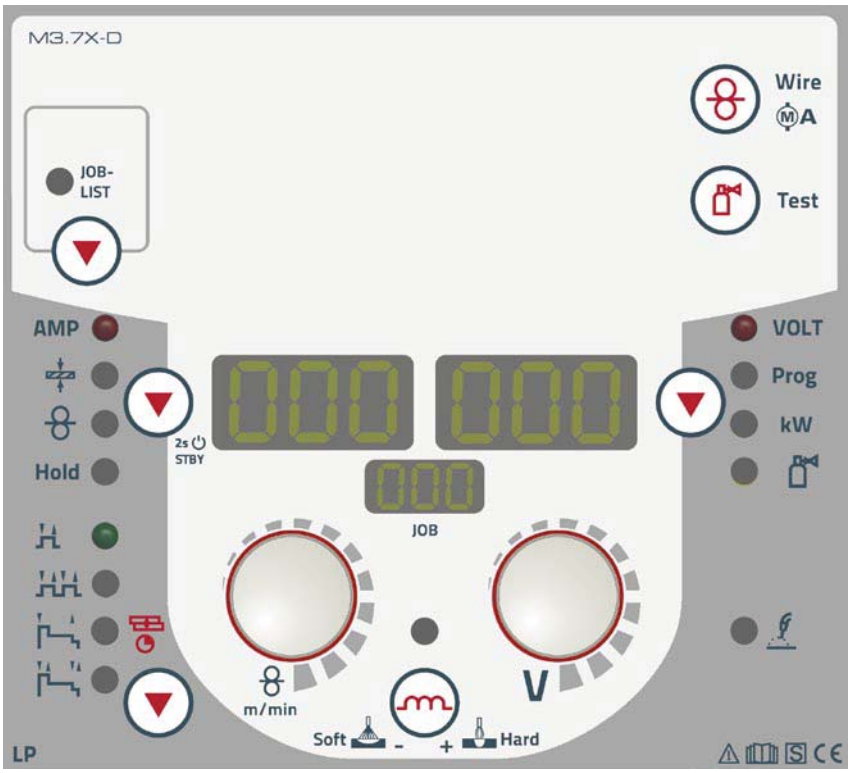
Adjustable welding parameters and functions

/ Wire feed speed 1 m/min. to 24 m/min.
/ Welding voltage
/ Adjustable arc dynamics (choke effect) from soft to hard
/ Operating modes: Non-latched, latched

Digital welding data display with hold function

/ Welding current
/ Welding voltage
/ Wire feed speed
/ Effective arc power for calculating energy per unit length
/ Motor current (wire feed mechanism), indicates any wire feeding errors

Synergic S LP control



Synergic one-knob operation

/ Synergic operating point adjustment with just a single knob
/ Easy JOB selection (material, gas, wire Ø) ready to start welding
/ Equipped with EN 1090-certified Synergic characteristics for EWM forceArc and rootArc at no extra charge
/ Equipped with EN 1090-certified Synergic characteristics for GMAW welding of steel, CrNi and aluminium at no extra charge
/ Suitable for MMA welding, TIG welding and gouging at no extra charge

Adjustable welding parameters and functions

/ Wire feed speed 1 m/min. to 24 m/min.
/ Arc length correction
/ Arc dynamics (choke effect) from soft to hard
/ Operating modes: Non-latched, latched
/ Special non-latched and special latched with pre-set, optimised start and end crater program (settings can be changed using R50 remote control or PC 300 software)
/ Spot welding/tack function
/ 16 welding programs per JOB
/ Standby function (save energy at the press of a button)
/ Electronic gas setting with control and monitoring of gas quantity (option)

Digital welding data display with hold function

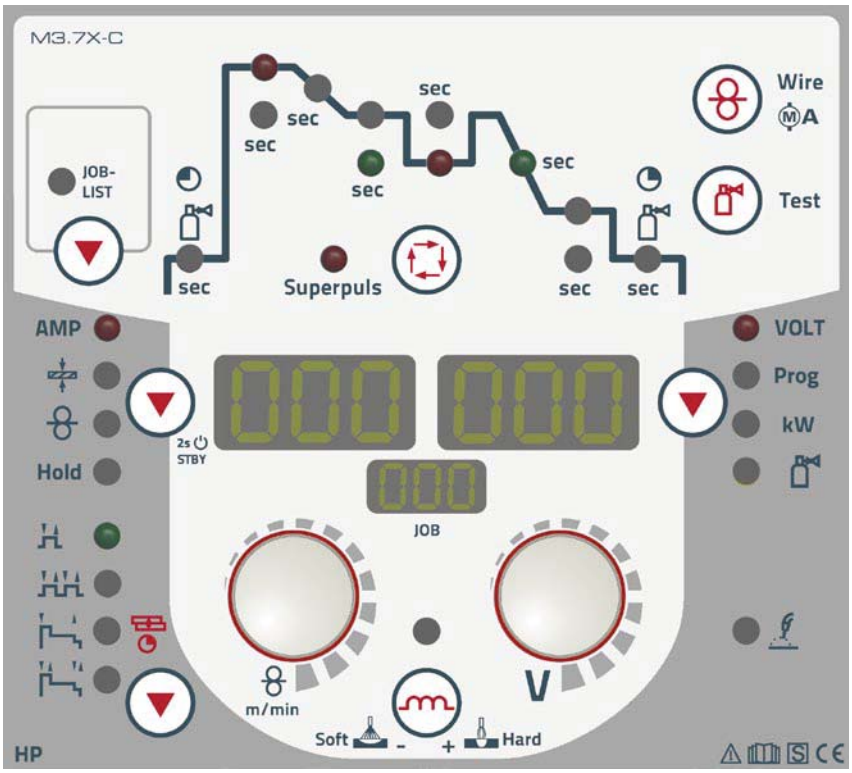
/ JOB no.: Current welding task visible at all times
/ Welding current, welding voltage
/ Wire feed speed
/ Default plate thickness
/ Effective arc power for calculating energy per unit length
/ Program number
/ Motor current (wire feed mechanism), indicates any wire feeding errors
/ Electronically controlled gas quantity

Synergic welding characteristics certified to EN 1090

Can be optionally networked with LAN or WiFi thanks to Multimatrix technology

LP control can be easily replaced by HP control at any time

Synergic S HP control



Synergic one-knob operation

/ Synergic operating point adjustment with just a single knob
/ Easy JOB selection (material, gas, wire Ø) ready to start welding
/ Equipped with EN 1090-certified Synergic characteristics for EWM forceArc, rootArc and superPuls at no extra charge
/ Equipped with EN 1090-certified Synergic characteristics for GMAW welding of steel, CrNi and aluminium at no extra charge
/ Suitable for MMA welding, TIG welding and gouging at no extra charge

Adjustable welding parameters and functions

/ Wire feed speed 1 m/min. to 24 m/min.
/ Arc length correction
/ Arc dynamics (choke effect) from soft to hard
/ Operating modes: Non-latched, latched
/ Special non-latched and special latched with adjustable start and end crater program
/ Spot welding/tack function
/ 16 welding programs per JOB
/ Standby function (save energy at the press of a button)
/ Electronic gas setting with control and monitoring of gas quantity (option)

Digital welding data display with hold function

/ JOB no.: Current welding task visible at all times
/ Welding current, welding voltage
/ Wire feed speed
/ Default plate thickness
/ Effective arc power for calculating energy per unit length
/ Program number
/ Motor current (wire feed mechanism), indicates any wire feeding errors
/ Electronically controlled gas quantity

Welding parameters set with LED user guidance

/ Gas pre- and post-flow time
/ Start program, welding program (16 programs per JOB), reduced welding program, end crater program with suitable slope times
/ superPuls: Controlled reduced heat input for fast and safe welding of vertical-up welds without 'Christmas tree technique'

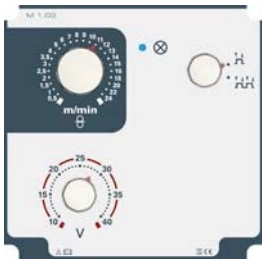
Synergic welding characteristics certified to EN 1090

Can be optionally networked with LAN or WiFi thanks to Multimatrix technology

LP control can be easily replaced by HP control at any time

Pico 350 cel puls • Pico 350 cel puls pws

M1.03



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Wire feed rolls	**Page**	**300**
Function torch	**Page**	**318**
Options/accessories	**Page**	**280**

- Multiprocess welding machine with separate wire feeder
- GMAW welding with Pico drive 4L or Pico drive 200C wire feeder
- Suitable for flux cored wire welding
- CC/CV characteristic
- Stick electrode/MMA for all electrode types
- Stick electrode/MMA cellulose electrodes: 100% safe for vertical-down welding
- MMA/MMA pulse welding:
  - Particularly suitable for root welding
  - Very suitable for difficult electrodes
  - Outstanding gap bridging with no sagging of the root side
  - Less distortion due to controlled heat input
  - Less finishing work due to less spatter
  - Fine-flaked weld surface similar to a TIG look for final passes
- Welding polarity can be reversed by pressing a button (polarity reversing switch)
- Perfect vertical-up welding through PF pulse function
- Portable, shoulder strap
- Antistick function
- TIG lift arc welding
- Adjustable hot start current and hot start time
- Robust design suitable for construction site use
- Impact-resistant casing
- Inspected protection against splash water (IP-34s)
- Adjustable Arcforce
- Available with open circuit voltage reduction, VRD (to AS 1674.2-2003; IEC/DIN EN 60974-1 and ГОСТ 12.2 007.8)
- Energy-saving thanks to high efficiency and standby function
- Mains connection 3 x 400 V/16 A

Pico	350 cel puls	350 cel puls pws
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A	3 x 16 A
Open circuit voltage	95 V	
Setting range for welding current	10 A - 350 A	10 A - 350 A
Duty cycle 40 °C	350 A / 35 % 280 A / 60 % 230 A / 100 %	350 A / 35 % 280 A / 60 % 230 A / 100 %
cos φ	0.99	0.99
Efficiency	88 %	88 %
Dimensions LxWxH in mm	600 x 205 x 415	600 x 205 x 415
Weight	23.5 kg	25 kg
Wire feeder, LxWxH in mm	690 x 300 x 410	690 x 300 x 410
Weight, wire feeder	13 kg	13 kg

Type	Designation	Item no.
Pico 350 cel puls	MMA inverter welding machine	090-002060-00502
Pico drive 4L	Wire feeder	090-002121-00502
MIG G 19POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m		094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		094-011063-00004
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000

Pico 350 cel puls pws	MMA inverter welding machine, pole reversing switch	090-002061-00502
Pico drive 4L	Wire feeder	090-002121-00502
MIG G 19POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m		094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		094-011063-00004
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000

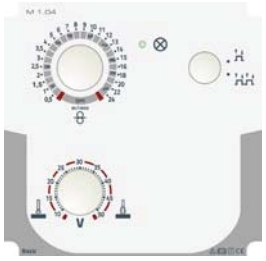
Pico 350 cel puls vrd (AUS)	MMA inverter welding machine with open circuit voltage reduction to AS 1674.2-2003	090-002060-28503
Pico 350 cel puls vrd (RU)	MMA inverter welding machine with open circuit voltage reduction as per IEC/EN 60974-1 and ГОСТ 12.2	090-002060-28504
Pico drive 4L	Wire feeder	090-002121-00502
MIG G 19POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m		094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		094-011063-00004
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000

Pico 350 cel puls pws vrd (AUS)	MMA inverter welding machine with pole reversing switch and open circuit voltage reduction to AS 1674.2-2003	090-002061-28503
Pico 350 cel puls pws vrd (RU)	MMA inverter welding machine with pole reversal and open circuit voltage reduction as per IEC/DIN EN	090-002061-28504
Pico drive 4L	Wire feeder	090-002121-00502
MIG G 19POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m		094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		094-011063-00004
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000

Taurus 400 Basic

E1.07

M1.04



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- MIG/MAG welding machine with separate Taurus drive 4L Basic wire feeder
- Most simple operation and selection of the welding tasks CV (MAG)/CC (MMA)
- Welding with solid wire and flux cored wire
- Adjusted parameters for welding with mixed gas or 100% CO2 at the push of a button
- Suitable for MMA welding and gouging at no extra charge
- Stick electrodes up to 6 mm diameter
- Infinitely adjustable arc dynamics (choke effect)
- Hot start and Arcforce adjustable
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- Robust design suitable for construction site use
- Impact-resistant casing
- Inspected protection against splash water (IP-34s)
- Energy-saving thanks to high efficiency and standby function
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Mains connection 3 x 400 V/16 A
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	10 A - 400 A
Duty cycle 40 °C	400 A / 30 % 280 A / 60 % 230 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	600 x 205 x 415
Weight	23.5 kg
Wire feeder, LxWxH in mm	690 x 300 x 410
Weight, wire feeder	13 kg

Type	Designation	Item no.
Taurus 400 Basic TDG	MIG/MAG inverter welding machine, portable	090-005446-00502
Taurus drive 4L Basic	Wire feeder	090-005447-00502
MIG G 19POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m		094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		094-011063-00004
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000

Taurus 355 Basic TKM

Basic

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- Compact inverter welding machine with Basic control and integrated wire feed mechanism
- Manual twin-knob operation (welding voltage and wire feeding)
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- Suitable for MMA welding and gouging at no extra charge
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Gas-cooled or optionally water-cooled with cool 50 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Connection capability for remote control and function torch
- Trolly 55-5 trolley and cool50 cooling unit available

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 350 A
Duty cycle 40 °C	350 A / 40 %
	300 A / 60 %
	270 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	625 x 300 x 480
Weight	33 kg

Type	Designation	Item no.
Taurus 355 Basic TKM	Multiprocess MIG/MAG welding machine, compact with eFeed drive, portable, Euro torch connector	090-005406-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 355 Synergic S LP MM TKM

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LP

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- Equipped at no extra charge with Synergic characteristics for EWM forceArc and rootArc
- Compact inverter welding machine with one-knob Synergic LP control and integrated wire feed mechanism
- Excellent Multimatrix welding characteristics
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Gas-cooled or optionally water-cooled with cool 50 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- LP control can be easily changed for HP control at any time
- Trolly 55-5 trolley and cool50 cooling unit available

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 350 A
Duty cycle 40 °C	350 A / 40 %
	300 A / 60 %
	270 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	625 x 300 x 480
Weight	33 kg

Type	Designation	Item no.
Taurus 355 Synergic S LP MM TKM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, portable, Euro torch connector	090-005421-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 355 Synergic S HP MM TKM

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HP

Control	**Page**	**128**
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- Compact inverter welding machine with one-knob Synergic HP control and integrated wire feed mechanism
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with EN 1090 certified Synergic characteristics for EWM forceArc, rootArc and supePuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Gas-cooled or optionally water-cooled with cool 50 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- HP control can be easily changed for LP control at any time
- Trolly 55-5 trolley and cool50 cooling unit available

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 350 A
Duty cycle 40 °C	350 A / 40 %
	300 A / 60 %
	270 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	625 x 300 x 480
Weight	33 kg

Type	Designation	Item no.
Taurus 355 Synergic S HP MM TKM	Multiprocess MIG/MAG welding machine, compact, portable, Euro torch connector	090-005407-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 355 Basic TKW

- Water-cooled, compact MIG/MAG welding machine with basic control and integrated wire feed mechanism
- Manual twin-knob operation (welding voltage and wire feeding)
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- Suitable for MMA welding and gouging at no extra charge
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 6-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Connection capability for remote control and function torch
- Trolly 55-5 trolley optionally available

Basic

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Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 350 A
Duty cycle 40 °C	350 A / 40 %
	300 A / 60 %
	270 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	625 x 300 x 810
Weight	49 kg
Trolley dimensions L x W x H in mm	1015 x 505 x 1105
Trolley weight	35 kg

Type	Designation	Item no.
Taurus 355 Basic TKW	Multiprocess MIG/MAG welding machine, compact with eFeed drive, water-cooled, Euro torch connector	090-005442-00502
MT301W M7 3m	MIG/MAG welding torch, water-cooled	094-500058-00000
MT301W M7 4m		094-500058-00004
MT301W M7 5m		094-500058-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 355 Synergic S LP MM TKW

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- Equipped at no extra charge with Synergic characteristics for EWM forceArc and rootArc
- Water-cooled, compact MIG/MAG welding machine with one-knob Synergic LP control and integrated wire feed mechanism
- Excellent Multimatrix welding characteristics
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 6-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- LP control can be easily changed for HP control at any time
- Trolly 55-5 trolley optionally available

LP

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Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 350 A
Duty cycle 40 °C	350 A / 40 %
	300 A / 60 %
	270 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	625 x 300 x 810
Weight	49 kg
Trolley dimensions L x W x H in mm	1015 x 505 x 1105
Trolley weight	35 kg

Type	Designation	Item no.
Taurus 355 Synergic S LP MM TKW	Multi-process MIG/MAG welding machine with MULTIMATRIX technology, compact design with eFeed drive, water-cooled, Euro torch connector	090-005443-00502
MT301W M7 3m	MIG/MAG welding torch, water-cooled	094-500058-00000
MT301W M7 4m		094-500058-00004
MT301W M7 5m		094-500058-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 355 Synergic S HP MM TKW

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HP

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- Water-cooled, compact MIG/MAG welding machine with one-knob Synergic HP control and integrated wire feed mechanism
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with EN 1090 certified Synergic characteristics for EWM forceArc, rootArc and supePuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 6-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- HP control can be easily changed for LP control at any time
- Trolly 55-5 trolley optionally available

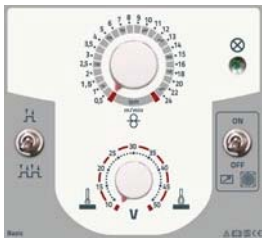
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 350 A
Duty cycle 40 °C	350 A / 40 %
	300 A / 60 %
	270 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	625 x 300 x 810
Weight	49 kg
Trolley dimensions L x W x H in mm	1015 x 505 x 1105
Trolley weight	35 kg

Type	Designation	Item no.
Taurus 355 Synergic S HP MM TKW	Multiprocess MIG/MAG welding machine, compact with eFeed drive, water-cooled, Euro torch connector	090-005444-00502
MT301W M7 3m	MIG/MAG welding torch, water-cooled	094-500058-00000
MT301W M7 4m		094-500058-00004
MT301W M7 5m		094-500058-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 355 ● 405 ● 505 Basic TDM G

Basic

drive_Basic



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- Gas-cooled welding machine with separate drive 4 Basic wire feeder and Basic control
- Manual twin-knob operation (welding voltage and wire feeding)
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- Suitable for MMA welding and gouging at no extra charge
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Gas-cooled or optionally water-cooled with cool 50 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Trolly 55-5 trolley and cool50 cooling unit available

Taurus	355	405	505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	80 V		
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C	350 A / 60 %	–	500 A / 60 %
	300 A / 100 %	400 A / 100 %	430 A / 100 %
cos φ	0.99		
Efficiency	90 %		
Dimensions LxWxH in mm	625 x 300 x 535		
Weight	41 kg		45 kg
Wire feeder, LxWxH in mm	660 x 280 x 380		
Weight, wire feeder	12 kg		

Type	Designation	Item no.
Taurus 355 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	090-005286-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG G 19POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m		094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		094-011063-00004
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 405 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	090-005241-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG G 19POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m		094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		094-011063-00004
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 505 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	090-005221-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG G 19POL 95qmm 550A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011091-00000
MIG G 19POL 95qmm 550A/60% 5m		094-011091-00001
MIG G 19POL 95qmm 550A/60% 10m		094-011091-00002
MIG G 19POL 95qmm 550A/60% 15m		094-011091-00005
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 355 ● 405 ● 505 Synergic S HP/LP MM TDM G

MULTIMATRIX

/forceArc®
/rootArc®
/superPuls

drive HP

drive LP

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- Gas-cooled welding machine with separate drive 4X HP wire feeder with one-knob Synergic HP control
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with EN 1090 certified Synergic characteristics for EWM forceArc, rootArc and supePuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Gas-cooled or optionally water-cooled with cool 50 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 5-litre water tank (cool50 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- HP control in wire feeder can be easily exchanged for LP control at any time
- Trolly 55-5 trolley and cool50 cooling unit available

Taurus	355	405	505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	80 V		
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C	350 A / 60 %	–	500 A / 60 %
	300 A / 100 %	400 A / 100 %	430 A / 100 %
cos φ	0.99		
Efficiency	90 %		
Dimensions LxWxH in mm	625 x 300 x 535		
Weight	41 kg		45 kg
Wire feeder, LxWxH in mm	660 x 280 x 380		
Weight, wire feeder	13 kg		

Type	Designation	Item no.
Taurus 355 Synergic S MM TDM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, portable, modular	090-005336-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG G 7POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m		094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		094-000580-00005
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Taurus 405 Synergic S MM TDM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, portable, modular	090-005337-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG G 7POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m		094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		094-000580-00005
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Taurus 505 Synergic S MM TDM	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, portable, modular	090-005338-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG G 7POL 95qmm 550A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	094-007726-00000
MIG G 7POL 95qmm 550A/60% 5m		094-007726-00001
MIG G 7POL 95qmm 550A/60% 10m		094-007726-00002
MIG G 7POL 95qmm 550A/60% 15m		094-007726-00003
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 355 ● 405 ● 505 Basic TDW

- Water-cooled welding machine with separate drive 4 Basic wire feeder and Basic control
- Manual twin-knob operation (welding voltage and wire feeding)
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- Suitable for MMA welding and gouging at no extra charge
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 6-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Trolly 55-5 trolley optionally available

Basic

drive_Basic

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Taurus	355	405	505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	80 V		
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C	350 A / 60 %	–	500 A / 60 %
	300 A / 100 %	400 A / 100 %	430 A / 100 %
cos φ	0.99		
Efficiency	90 %		
Dimensions LxWxH in mm	625 x 300 x 865		
Weight	57 kg		61 kg
Wire feeder, LxWxH in mm	660 x 280 x 380		
Weight, wire feeder	12 kg		
Trolley dimensions L x W x H in mm	1015 x 505 x 1105		
Trolley weight	35 kg		

Type	Designation	Item no.
Taurus 355 Basic TDW	Multiprocess MIG/MAG welding machine, decompact, water-cooled	090-005436-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG W 19POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 19-pole	094-009082-00000
MIG W 19POL 70qmm 450A/60% 5m		094-009082-00001
MIG W 19POL 70qmm 450A/60% 10m		094-009082-00002
MIG W 19POL 70qmm 450A/60% 15m		094-009082-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 405 Basic TDW	Multiprocess MIG/MAG welding machine, decompact, water-cooled	090-005438-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG W 19POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 19-pole	094-009082-00000
MIG W 19POL 70qmm 450A/60% 5m		094-009082-00001
MIG W 19POL 70qmm 450A/60% 10m		094-009082-00002
MIG W 19POL 70qmm 450A/60% 15m		094-009082-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 505 Basic TDW	Multiprocess MIG/MAG welding machine, decompact, water-cooled	090-005440-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG W 19POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 19-pole	094-009083-00000
MIG W 19POL 95qmm 550A/60% 5m		094-009083-00001
MIG W 19POL 95qmm 550A/60% 10m		094-009083-00002
MIG W 19POL 95qmm 550A/60% 15m		094-009083-00005
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 355 ● 405 ● 505 Synergic S HP/LP MM TDW

MULTIMATRIX

/forceArc®
/rootArc®
/superPuls

- Water-cooled welding machine with separate drive 4X HP wire feeder with one-knob Synergic HP control
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Equipped at no extra charge with EN 1090 certified Synergic characteristics for EWM forceArc, rootArc and supePuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 6-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- HP control in wire feeder can be easily exchanged for LP control at any time
- Trolly 55-5 trolley optionally available

drive HP

drive LP

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Taurus	355	405	505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	80 V		
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C	350 A / 60 %	–	500 A / 60 %
	300 A / 100 %	400 A / 100 %	430 A / 100 %
cos φ	0.99		
Efficiency	90 %		
Dimensions LxWxH in mm	625 x 300 x 865		
Weight	57 kg		61 kg
Wire feeder, LxWxH in mm	660 x 280 x 380		
Weight, wire feeder	13 kg		
Trolley dimensions L x W x H in mm	1015 x 505 x 1105		
Trolley weight	35 kg		

Type	Designation	Item no.
Taurus 355 Synergic S MM TDW	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, water-cooled	090-005437-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Taurus 405 Synergic S MM TDW	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, water-cooled	090-005439-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 505 Synergic S MM TDW	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, decompact, water-cooled	090-005441-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008632-00000
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Set Taurus 505 Basic Duo Gouging

- Special set for gouging consisting of two Taurus 505 Basic
- Gouging with up to 13 mm carbon electrode (1000 A)
- Suitable for MMA welding at no extra charge
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- GMAW welding with separate drive 4 Basic wire feeder and Basic control possible
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- Trolly 39-1 trolley available for delivery
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 32 A
Setting range for welding current	5 A - 1000 A
Duty cycle 40 °C	1000 A / 60 %
	860 A / 100 %
cos φ	0.99
Efficiency	90 %
Dimensions LxWxH in mm	624 x 300 x 1536
Weight	ca.126 kg

Basic

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Type	Designation	Item no.
Set Taurus 505 Basic Duo Gouging	Set consisting of 2 Taurus 505 Basic, remote control, gouging torch, work-piece lead, transport cart	092-008313-00000

Taurus 505 Basic for gouging

- Inverter welding machine, DC
- Gouging with up to 8 mm carbon electrodes
- Suitable for MMA welding at no extra charge
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- GMAW welding with separate drive 4 Basic wire feeder and Basic control possible
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- Trolly 39-1 and Trolly 55-5 trolleys available
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch

Basic

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Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 32 A
Open circuit voltage	80 V
Setting range for welding current	5 A - 500 A
Duty cycle 40 °C	500 A / 60 % 430 A / 100 %
cos φ	0.99
Efficiency	90 %
Dimensions LxWxH in mm	625 x 300 x 535
Weight	45 kg

Type	Designation	Item no.
Taurus 505 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	090-005221-00502
GT 600 SKK95	Gouging torch	094-016099-00000
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
EH 95qmm 4m	Electrode holder with cable	092-000010-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 351 ● 401 Basic FKG

- Gas-cooled, compact welding machine with integrated wire feeder and Basic control
- Manual twin-knob operation (welding voltage and wire feeding)
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- Suitable for MMA welding and gouging at no extra charge
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch

Taurus	351	401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A
Open circuit voltage	80 V	
Setting range for welding current	5 A - 350 A	5 A - 400 A
Duty cycle 40 °C	350 A / 100 %	400 A / 100 %
cos φ	0.99	
Efficiency	90 %	
Dimensions LxWxH in mm	1100 x 455 x 1000	
Weight	107 kg	

Basic

Control	**Page**	**128**
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Type	Designation	Item no.
Taurus 351 Basic FKG	Multiprocess MIG/MAG welding machine, compact with eFeed drive, mobile, gas-cooled	090-005425-00502
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Taurus 401 Basic FKG	Multiprocess MIG/MAG welding machine, compact with eFeed drive, mobile, gas-cooled	090-005426-00502
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 351 ● 401 Synergic S LP MM FKG

MULTIMATRIX

/forceArc®
/rootArc®
/superPuls

- Equipped at no extra charge with Synergic characteristics for EWM forceArc and rootArc
- Gas-cooled, compact welding machine with single-knob Synergic LP control and integrated wire feeder
- Excellent Multimatrix welding characteristics
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- LP control can be easily changed for HP control at any time

LP

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Taurus	351	401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A
Open circuit voltage	80 V	
Setting range for welding current	5 A - 350 A	5 A - 400 A
Duty cycle 40 °C	350 A / 100 %	400 A / 100 %
cos φ	0.99	
Efficiency	90 %	
Dimensions LxWxH in mm	1100 x 455 x 1000	
Weight	107 kg	

Type	Designation	Item no.
Taurus 351 Synergic S LP MM FKG	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, gas-cooled	090-005428-00502
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 401 Synergic S LP MM FKG	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, gas-cooled	090-005429-00502
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 351 ● 401 Synergic S HP MM FKG

MULTIMATRIX

/forceArc®
/rootArc®
/superPuls

- Gas-cooled compact welding machine with one-knob Synergic HP control and integrated wire feed mechanism
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with EN 1090 certified Synergic characteristics for EWM forceArc, rootArc and supePuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- HP control can be easily changed for LP control at any time

HP

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Taurus	351	401
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A
Open circuit voltage	80 V	
Setting range for welding current	5 A - 350 A	5 A - 400 A
Duty cycle 40 °C	350 A / 100 %	400 A / 100 %
cos φ	0.99	
Efficiency	90 %	
Dimensions LxWxH in mm	1100 x 455 x 1000	
Weight	107 kg	

Type	Designation	Item no.
Taurus 351 Synergic S HP MM FKG	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, gas-cooled	090-005431-00502
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 401 Synergic S HP MM FKG	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, gas-cooled	090-005432-00502
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 351 ● 401 ● 501 Basic FKW

- Water-cooled, compact MIG/MAG welding machine with basic control and integrated wire feed mechanism
- Manual twin-knob operation (welding voltage and wire feeding)
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- Suitable for MMA welding and gouging at no extra charge
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch

Basic

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Taurus	351	401	501
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	80 V		
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C		–	500 A / 60 %
	350 A / 100 %	400 A / 100 %	430 A / 100 %
cos φ	0.99		
Efficiency	90 %		
Dimensions LxWxH in mm	1100 x 455 x 1000		
Weight	107 kg	118 kg	

Type	**Designation**	**Item no.**
Taurus 351 Basic FKW	Multiprocess MIG/MAG welding machine, compact with eFeed drive, mobile, water-cooled	090-005419-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 401 Basic FKW	Multiprocess MIG/MAG welding machine, compact with eFeed drive, mobile, water-cooled	090-005408-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 501 Basic FKW	Multiprocess MIG/MAG welding machine, compact with eFeed drive, mobile, water-cooled	090-005410-00502
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 351 ● 401 ● 501 Synergic S LP MM FKW

MULTIMATRIX

/forceArc®
/rootArc®
/superPuls

- Equipped at no extra charge with Synergic characteristics for EWM forceArc and rootArc
- Water-cooled, compact MIG/MAG welding machine with one-knob Synergic LP control and integrated wire feed mechanism
- Excellent Multimatrix welding characteristics
- Synergic or manual welding operation
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- LP control can be easily changed for HP control at any time

LP

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Taurus	351	401	501
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	80 V		
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C		–	500 A / 60 %
	350 A / 100 %	400 A / 100 %	430 A / 100 %
cos φ	0.99		
Efficiency	90 %		
Dimensions LxWxH in mm	1100 x 455 x 1000		
Weight	107 kg	118 kg	

Type	Designation	Item no.
Taurus 351 Synergic S LP MM FKW	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, water-cooled	090-005422-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 401 Synergic S LP MM FKW	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, water-cooled	090-005423-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 501 Synergic S LP MM FKW	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, water-cooled	090-005424-00502
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 351 ● 401 ● 501 Synergic S HP MM FKW

MULTIMATRIX

/forceArc®
/rootArc®
/superPuls

HP

Control	**Page**	**128**
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- Water-cooled, compact MIG/MAG welding machine with one-knob Synergic HP control and integrated wire feed mechanism
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with EN 1090 certified Synergic characteristics for EWM forceArc, rootArc and supePuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- HP control can be easily changed for LP control at any time

Taurus	351	401	501
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	80 V		
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C		–	500 A / 60 %
	350 A / 100 %	400 A / 100 %	430 A / 100 %
cos φ	0.99		
Efficiency	90 %		
Dimensions LxWxH in mm	1100 x 455 x 1000		
Weight	107 kg	118 kg	

Type	Designation	Item no.
Taurus 351 Synergic S HP MM FKW	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, water-cooled	090-005420-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 401 Synergic S HP MM FKW	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, water-cooled	090-005409-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 501 Synergic S HP MM FKW	Multiprocess MIG/MAG welding machine with MULTIMATRIX technology, compact with eFeed drive, mobile, water-cooled	090-005411-00502
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 351 ● 401 ● 451 ● 551 Basic FDG

- Gas-cooled welding machine with separate drive 4 Basic wire feeder and Basic control
- Manual twin-knob operation (welding voltage and wire feeding)
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- Suitable for MMA welding and gouging at no extra charge
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch

Taurus	351	401	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
Open circuit voltage	80 V			
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–		450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	
cos φ	0.99			
Efficiency	90 %			
Dimensions LxWxH in mm	1100 x 455 x 1000			
Weight	107 kg		118 kg	
Wire feeder, LxWxH in mm	660 x 280 x 380			
Weight, wire feeder	12 kg			

Basic

drive_Basic

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Wire feed rolls	Page	296
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Type	Designation	Item no.
Taurus 351 Basic FDG	MIG/MAG multiprocess welding machine, decompact, mobile, gas-cooled	090-005389-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG G 19POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m		094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		094-011063-00004
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Taurus 401 Basic FDG	MIG/MAG multiprocess welding machine, decompact, mobile, gas-cooled	090-005249-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG G 19POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m		094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		094-011063-00004
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Taurus 451 Basic FDG	MIG/MAG multiprocess welding machine, decompact, mobile, gas-cooled	090-005176-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG G 19POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m		094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		094-011063-00004
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 551 Basic FDG	MIG/MAG multiprocess welding machine, decompact, mobile, gas-cooled	090-005178-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG G 19POL 95qmm 550A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	094-011091-00000
MIG G 19POL 95qmm 550A/60% 5m		094-011091-00001
MIG G 19POL 95qmm 550A/60% 10m		094-011091-00002
MIG G 19POL 95qmm 550A/60% 15m		094-011091-00005
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 351 ● 401 ● 451 ● 551 Synergic S HP/LP MM FDG

MULTIMATRIX

/forceArc®
/rootArc®
/superPuls

- Gas-cooled welding machine with separate drive 4X HP wire feeder with one-knob Synergic HP control
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with EN 1090 certified Synergic characteristics for EWM forceArc, rootArc and supePuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- HP control in wire feeder can be easily exchanged for LP control at any time

drive HP

drive LP

Control	**Page**	**128**
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Taurus	351	401	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
Open circuit voltage	80 V			
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–		450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	
cos φ	0.99			
Efficiency	90 %			
Dimensions LxWxH in mm	1100 x 455 x 1000			
Weight	107 kg		118 kg	
Wire feeder, LxWxH in mm	660 x 280 x 380			
Weight, wire feeder	13 kg			

Type	Designation	Item no.
Taurus 351 Synergic S MM FDG	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, gas-cooled	090-005341-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG G 7POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m		094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		094-000580-00005
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Taurus 401 Synergic S MM FDG	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, gas-cooled	090-005342-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG G 7POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m		094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		094-000580-00005
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 451 Synergic S MM FDG	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, gas-cooled	090-005343-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG G 7POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m		094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		094-000580-00005
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 551 Synergic S MM FDG	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, gas-cooled	090-005344-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG G 7POL 95qmm 550A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	094-007726-00000
MIG G 7POL 95qmm 550A/60% 5m		094-007726-00001
MIG G 7POL 95qmm 550A/60% 10m		094-007726-00002
MIG G 7POL 95qmm 550A/60% 15m		094-007726-00003
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

- Water-cooled welding machine with separate drive 4 Basic wire feeder and Basic control
- Manual twin-knob operation (welding voltage and wire feeding)
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- Suitable for MMA welding and gouging at no extra charge
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch

Basic

drive_Basic

Control	**Page**	**128**
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Taurus	351	401	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
Open circuit voltage	80 V			
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–		450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	
cos φ	0.99			
Efficiency	90 %			
Dimensions LxWxH in mm	1100 x 455 x 1000			
Weight	118 kg		129 kg	
Wire feeder, LxWxH in mm	660 x 280 x 380			
Weight, wire feeder	12 kg			

Type	Designation	Item no.
Taurus 351 Basic FDW	MIG/MAG multiprocess welding machine, decompact, mobile, water-cooled	090-005390-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG W 19POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 19-pole	094-009082-00000
MIG W 19POL 70qmm 450A/60% 5m		094-009082-00001
MIG W 19POL 70qmm 450A/60% 10m		094-009082-00002
MIG W 19POL 70qmm 450A/60% 15m		094-009082-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Taurus 401 Basic FDW	MIG/MAG multiprocess welding machine, decompact, mobile, water-cooled	090-005250-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG W 19POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 19-pole	094-009082-00000
MIG W 19POL 70qmm 450A/60% 5m		094-009082-00001
MIG W 19POL 70qmm 450A/60% 10m		094-009082-00002
MIG W 19POL 70qmm 450A/60% 15m		094-009082-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 451 Basic FDW	MIG/MAG multiprocess welding machine, decompact, mobile, water-cooled	090-005150-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG W 19POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 19-pole	094-009082-00000
MIG W 19POL 70qmm 450A/60% 5m		094-009082-00001
MIG W 19POL 70qmm 450A/60% 10m		094-009082-00002
MIG W 19POL 70qmm 450A/60% 15m		094-009082-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 551 Basic FDW	MIG/MAG multiprocess welding machine, decompact, mobile, water-cooled	090-005151-00502
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
MIG W 19POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 19-pole	094-009083-00000
MIG W 19POL 95qmm 550A/60% 5m		094-009083-00001
MIG W 19POL 95qmm 550A/60% 10m		094-009083-00002
MIG W 19POL 95qmm 550A/60% 15m		094-009083-00005
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 351 ● 401 ● 451 ● 551 Synergic S HP/LP MM FDW

MULTIMATRIX

/forceArc®
/rootArc®
/superPuls

- Water-cooled welding machine with separate drive 4X HP wire feeder with one-knob Synergic HP control
- Excellent Multimatrix welding characteristics
- Adjustable start and end-crater functions
- Program operation with 16 programs per JOB
- Synergic or manual welding operation
- Equipped at no extra charge with EN 1090 certified Synergic characteristics for EWM forceArc, rootArc and supePuls
- Equipped at no extra charge with Synergic characteristics for GMAW welding of steel/CrNi/aluminium
- Suitable for MMA welding, TIG welding and gouging at no extra charge
- Free WPQR package for certification up to and including EXC2 in accordance with EN 1090 and for welding of unalloyed steels up to and including S355
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- High-precision, powerful EWM eFeed 4-roll wire feed mechanism for secure feeding of all solid and flux cored wires
- Equipped for 1.2 mm steel wire
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- High mains voltage tolerances and therefore fully generator-compatible
- Ideally suited for use with long hose packages
- Connection capability for remote control and function torch
- Option to network via LAN or WiFi thanks to Multimatrix technology, Xnet-compatible
- HP control in wire feeder can be easily exchanged for LP control at any time

drive HP

drive LP

Control	**Page**	**128**
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Taurus	351	401	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
Open circuit voltage	80 V			
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–		450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	
cos φ	0.99			
Efficiency	90 %			
Dimensions LxWxH in mm	1100 x 455 x 1000			
Weight	118 kg		129 kg	
Wire feeder, LxWxH in mm	660 x 280 x 380			
Weight, wire feeder	13 kg			

Type	Designation	Item no.
Taurus 351 Synergic S MM FDW	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005345-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Taurus 401 Synergic S MM FDW	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005346-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Taurus 451 Synergic S MM FDW	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005347-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

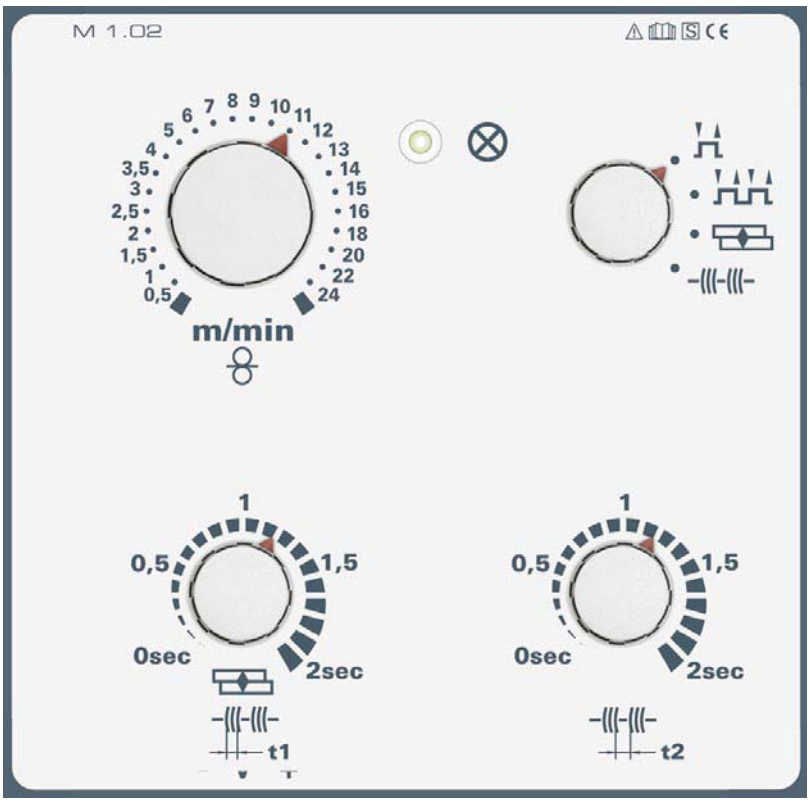
Taurus 551 Synergic S MM FDW	MIG/MAG multiprocess welding machine with MULTIMATRIX technology, decompact, mobile, water-cooled	090-005348-00502
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X LP		090-005412-00502
drive 4X EX		090-005511-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
ON HS XX1	Mount for hose packages and remote control	092-002910-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Overview

MIG/MAG standard welding machines, step switch controlled, Mobile

Design	Max. welding current	Product name	Cooling	Page
	A		Water-cooled	
Compact	150 - 300	Mira 151 ● 221 ● 251 ● 301 M1.02 FKG		180
	300	Mira 301 M2.20 ● M2.40 FKG		182
	300 - 350	Saturn 301 ● 351 M1.02 FKG		183
		Saturn 301 ● 351 M2.20 ● M2.40 FKG		184
	400	Wega 401 M1.02 FKG		188
		Wega 401 M2.20 ● M2.40 FKG		189
		Wega 401 M1.02 FKW	•	190
		Wega 401 M2.20 ● M2.40 FKW	•	191
Decompact	350	Saturn 351 M1.02 ● M2.20 ● M2.40 FDG		186
	400	Wega 401 M1.02 FDG		192
		Wega 401 M2.20 ● M2.40 FDG		193
	400 - 600	Wega 401 ● 501 ● 601 M1.02 FDW	•	194
		Wega 401 ● 501 ● 601 M2.20 ● M2.40 FDW	•	196

M 1.02



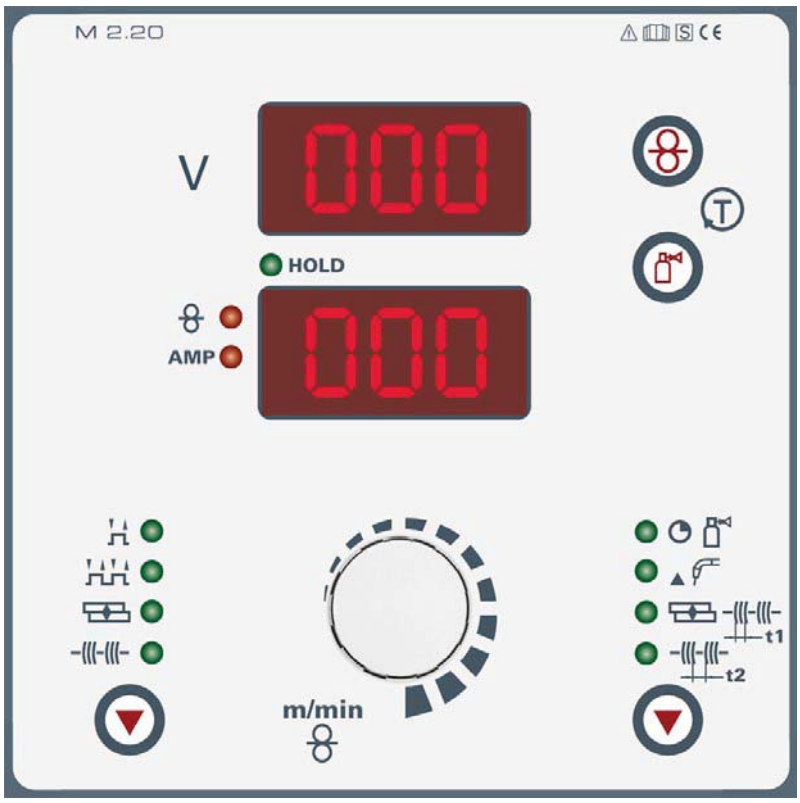
Twin-knob operation

/ Direct access to all welding parameters
/ Operating point adjustment using wire feed speed and welding voltage
/ MIG/MAG welding with solid and flux cored wire

Adjustable welding parameters and functions

/ Operating modes: non-latched, latched, spot, interval
/ Currentless wire inching
/ Wire feed speed
/ Adjustable spot, interval and pause times

M 2.20



Twin-knob operation

/ Direct access to all welding parameters
/ Operating point adjustment using wire feed speed and welding voltage
/ MIG/MAG welding with solid and flux cored wire

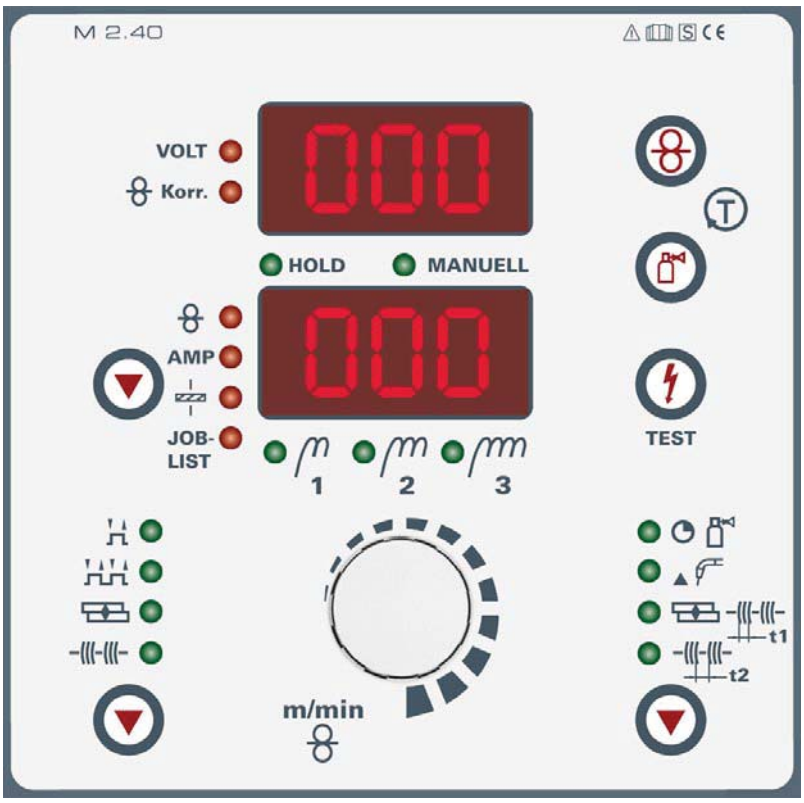
Adjustable welding parameters and functions

/ Operating modes: non-latched, latched, spot, interval
/ Currentless gas test, purge hose package
/ Wire inching
/ Wire feed speed
/ Adjustable spot, interval, pause, gas post-flow and burn-back times

Digital welding data display with hold function

/ Welding current
/ Welding voltage
/ Wire feed speed

M 2.40



Synergic one-knob operation

/ Synergic operating point adjustment with just a single knob
/ Simple JOB selection (material, gas, wire Ø)
/ Selection of the welding task from the JOB list
/ MIG/MAG welding with solid and flux cored wire

Adjustable welding parameters and functions

/ Operating modes: non-latched, latched, interval, spot welding
/ Currentless gas test, purge hose package
/ Wire inching
/ Wire feed speed
/ Wire feed speed correction
/ Adjustable spot, interval, pause, gas post-flow and burn-back times
/ Selection of optimum operating point, test button

Digital welding data display with hold function

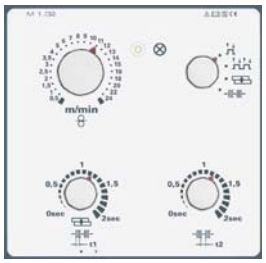
/ Welding current
/ Welding voltage
/ Wire feed speed
/ Plate thickness

Mira 151 ● 221 ● 251 ● 301 M1.02 FKG

- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- Mira 151/Mira 221 MV: 2-roller wire feed. Equipped for 0.8 mm + 1.0 mm steel wires
- Mira 251/Mira 301: 4-roll drive. Equipped for 0.8 mm + 1.0 mm steel wires
- Mira 221 MV: Multivolt – switchable from 230 V to 400 V
- Mobile, compact, sturdy construction with small housing dimensions
- M1.02: Twin-knob operation – setting of the welding voltage and wire-feed speed
- 5 m mains supply lead with CEE 16 A plug
- Mira 151: 3.5 m mains supply lead with 16 A shock-proof plug

Mira	151	221 MV	251	301
Mains voltage (tolerances)	1 x 230 V (-15 % - +15 %)	2 x 400 V (-15 % - +15 %)	3 x 400 V (-15 % - +15 %)	
Mains fuses (slow-blow)	1 x 16 A	2 x 16 A	3 x 16 A	
Open circuit voltage	35 V	40 V	35 V	40 V
Setting range for welding current	30 A - 150 A	30 A - 220 A	30 A - 250 A	30 A - 300 A
Duty cycle 25 °C (40 °C)	150 A / 25 % (150 A / 15 %)	220 A / 25 % (220 A / 15 %)	250 A / 35 % (250 A / 20 %)	300 A / 35 % (300 A / 20 %)
	70 A / 100 % (55 A / 100 %)	105 A / 100 % (85 A / 100 %)	150 A / 100 % (125 A / 100 %)	170 A / 100 % (150 A / 100 %)
Switching steps	6		8	12
cos φ	0.98		0.97	
Dimensions LxWxH in mm	880 x 385 x 610			
Weight	47 kg	56 kg	60 kg	72 kg
Wire speed	1.5 m/min - 15 m/min	1.5 m/min - 20 m/min		

M1.02



Control	Page	177
Wire feed rolls	Page	300
Options/accessories	Page	280

Type	Designation	Item no.
Mira 151 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 2-roll drive	-
MIG 15G 3m	MIG/MAG welding torch, gas-cooled	094-001175-00000
MIG 15G 4m		094-001175-00004
MIG 15G 5m		094-001175-00005
WK25mm² 230A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000016-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Mira 221 MV FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 2-roll drive	-
MIG 25G 3m	MIG/MAG welding torch, gas-cooled	094-001102-00000
MIG 25G 4m		094-001102-00004
MIG 25G 5m		094-001102-00005
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
Mira 251 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	-
MIG 25G 3m	MIG/MAG welding torch, gas-cooled	094-001102-00000
MIG 25G 4m		094-001102-00004
MIG 25G 5m		094-001102-00005
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030

Mira 301 M1.02 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	-
MIG 36G 3m	MIG/MAG welding torch, gas-cooled	094-013388-00000
MIG 36G 4m		094-000536-00004
MIG 36G 5m		094-000536-00005
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030

▶ Only available in packs of 2!

Mira packing units		
2x Mira 151 FKG	Packing unit: 2 x Mira 151 FKG	092-015238-00502

Mira packing units		
2x Mira 221 MV FKG	Packing unit: 2 x Mira 221 MV FKG	092-015239-00502

Mira packing units		
2x Mira 251 FKG	Packing unit: 2 x Mira 251 FKG	092-015240-00502

Mira packing units		
2x Mira 301 M1.02 FKG	Packing unit: 2 x Mira 301 M1.02 FKG	092-015236-00502

Mira 301 M2.20 • M2.40 FKG

- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- 4-roll drive. Equipped for 0.8 mm + 1.0 mm steel wires
- Mobile, compact, sturdy construction with small housing dimensions
- M2.20: Twin-knob operation – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: One-knob operation (Synergic) – easy setting of the operating point thanks to pre-programmed JOBs (welding tasks), display of welding parameters
- 5 m mains supply lead with CEE 16 A plug

Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	40 V
Setting range for welding current	30 A - 300 A
Duty cycle 25 °C (40 °C)	300 A / 35 % (300 A / 20 %) 170 A / 100 % (150 A / 100 %)
Switching steps	12
cos φ	0.97
Dimensions LxWxH in mm	880 x 385 x 610
Weight	72 kg
Wire speed	1.5 m/min - 20 m/min

M2.40

M2.20

Control	**Page**	**177**
Wire feed rolls	**Page**	**300**
Options/accessories	**Page**	**280**

Type	Designation	Item no.
Mira 301 M2.20 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	-
Mira 301 M2.40 FKG		-
MIG 36G 3m	MIG/MAG welding torch, gas-cooled	094-013388-00000
MIG 36G 4m		094-000536-00004
MIG 36G 5m		094-000536-00005
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030

▶ Only available in packs of 2!

Mira packing units		
2x Mira 301 M2.20 FKG	Packing unit: 2 x Mira 301 M2.20 FKG	092-015263-00502

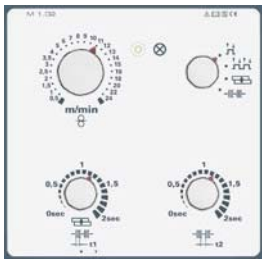
Mira packing units		
2x Mira 301 M2.40 FKG	Packing unit: 2 x Mira 301 M2.40 FKG	092-015237-00502

Saturn 301 • 351 M1.02 FKG

- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- 4-roll drive. Equipped for 0.8 mm + 1.0 mm steel wires
- Compact, mobile, can be lifted by crane and moved by fork lift
- M1.02: Twin-knob operation – setting of the welding voltage and wire-feed speed
- Protective earth monitoring (PE)
- Perfect ignition and welding by means of optimised choke with 2 tappings
- 5 m mains supply lead

Saturn	301	351
Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)	
Mains fuses (slow-blow)	3 x 16 A	3 x 25 A
Open circuit voltage	38,2 V	41 V
Setting range for welding current	30 A - 300 A	30 A - 350 A
Duty cycle 25 °C (40 °C)	300 A / 45 % (300 A / 40 %)	350 A / 45 % (350 A / 40 %)
	250 A / 60 % (190 A / 60 %)	300 A / 60 % (250 A / 60 %)
	190 A / 100 % (160 A / 100 %)	250 A / 100 % (220 A / 100 %)
Switching steps	12	16
cos φ	0.97	
Dimensions LxWxH in mm	930 x 460 x 730	
Weight	100 kg	112 kg
Wire speed	0.5 m/min - 25 m/min	

M1.02



Control	Page	177
Wire feed rolls	Page	300
Options/accessories	Page	280

Type	Designation	Item no.
Saturn 301 M1.02 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	090-004977-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Saturn 351 M1.02 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	090-004983-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Saturn 301 ● 351 M2.20 ● M2.40 FKG

- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- 4-roll drive. Equipped for 0.8 mm + 1.0 mm steel wires
- Compact, mobile, can be lifted by crane and moved by fork lift
- M2.20: Twin-knob operation – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: One-knob operation (Synergic) – easy setting of the operating point thanks to pre-programmed JOBs (welding tasks), display of welding parameters
- Protective earth monitoring (PE)
- Perfect ignition and welding by means of optimised choke with 2 tappings
- 5 m mains supply lead

Saturn	301	351
Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)	
Mains fuses (slow-blow)	3 x 16 A	3 x 25 A
Open circuit voltage	38,2 V	41 V
Setting range for welding current	30 A - 300 A	30 A - 350 A
Duty cycle 25 °C (40 °C)	300 A / 45 % (300 A / 40 %)	350 A / 45 % (350 A / 40 %)
	250 A / 60 % (190 A / 60 %)	300 A / 60 % (250 A / 60 %)
	190 A / 100 % (160 A / 100 %)	250 A / 100 % (220 A / 100 %)
Switching steps	12	16
cos φ	0.97	
Dimensions LxWxH in mm	930 x 460 x 730	
Weight	100 kg	112 kg
Wire speed	0.5 m/min - 25 m/min	

M2.20

M2.40

Control	Page	177
Wire feed rolls	Page	300
Options/accessories	Page	280

Type	Designation	Item no.
Saturn 301 M2.20 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	090-004978-00502
Saturn 301 M2.40 FKG		090-004979-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

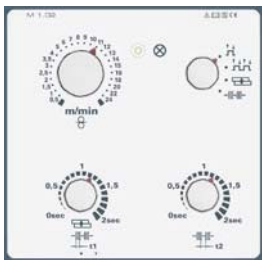
Saturn 351 M2.20 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	090-004984-00502
Saturn 351 M2.40 FKG		090-004985-00502
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Saturn 351 M1.02 ● M2.20 ● M2.40 FDG

- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- Decompact, mobile, can be lifted by crane and moved by fork lift
- 4-roll drive. Equipped for 0.8 mm + 1.0 mm steel wires
- M1.02: Twin-knob operation – setting of the welding voltage and wire-feed speed
- M2.20: Twin-knob operation – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: One-knob operation (Synergic) – easy setting of the operating point thanks to pre-programmed JOBs (welding tasks), display of welding parameters
- Perfect ignition and welding by means of optimised choke with 2 tappings
- 5 m mains supply lead

Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)
Mains fuses (slow-blow)	3 x 25 A
Open circuit voltage	40 V
Setting range for welding current	30 A - 350 A
Duty cycle 25 °C (40 °C)	350 A / 45 % (350 A / 40 %)
	300 A / 60 % (250 A / 60 %)
	250 A / 100 % (220 A / 100 %)
Switching steps	16
cos φ	0.97
Dimensions LxWxH in mm	930 x 460 x 730
Weight	100 kg
Wire speed	Wire speed m/min , 0.5 m/min - 25 m/min
Wire feeder, LxWxH in mm	690 x 300 x 410
Weight, wire feeder	15.5 kg

M1.02



M2.20

M2.40

Control	**Page**	**177**
Wire feed rolls	**Page**	**300**
Options/accessories	**Page**	**280**

Type	Designation	Item no.
Saturn 351 FDG	Step switch controlled MIG/MAG welding machine, decompact, gas-cooled	090-004991-00502
Saturn M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	090-004995-00502
MIG G 7POL 50qmm 350A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	094-000579-00000
MIG G 7POL 50qmm 350A/60% 5m		094-000579-00001
MIG G 7POL 50qmm 350A/60% 10m		094-000579-00002
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

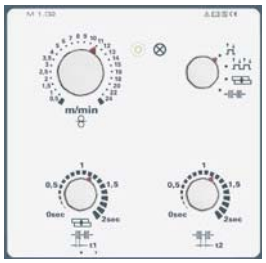
Saturn 351 FDG	Step switch controlled MIG/MAG welding machine, decompact, gas-cooled	090-004991-00502
Saturn M2.20 drive 41L	Wire feeder, water-cooled, Euro torch connector	090-004996-00502
Saturn M2.40 drive 41L		090-004997-00502
MIG G 7POL 50qmm 350A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	094-000579-00000
MIG G 7POL 50qmm 350A/60% 5m		094-000579-00001
MIG G 7POL 50qmm 350A/60% 10m		094-000579-00002
MT301G M9 3m	MIG/MAG welding torch, gas-cooled	094-500055-00000
MT301G M9 4m		094-500055-00004
MT301G M9 5m		094-500055-00005
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Wega 401 M1.02 FKG

- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- Compact, mobile, can be lifted by crane and moved by fork lift
- M1.02: Twin-knob operation – setting of the welding voltage and wire-feed speed
- Protective earth monitoring (PE)
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Perfect ignition and welding by means of optimised choke with 3 tappings
- 5 m mains supply lead

Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)
Mains fuses (slow-blow)	3 x 25 A
Open circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 25 °C (40 °C)	400 A / 70 % (400 A / 60 %)
	300 A / 100 % (300 A / 100 %)
Switching steps	24 (2 x 12)
cos φ	0.97
Dimensions LxWxH in mm	1100 x 550 x 1000
Weight	145 kg

M1.02



Control	**Page**	**177**
Wire feed rolls	**Page**	**300**
Options/accessories	**Page**	**280**

Type	Designation	Item no.
Wega 401 M1.02 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	090-005224-00502
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Wega 401 M2.20 • M2.40 FKG

- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- Compact, mobile, can be lifted by crane and moved by fork lift
- M2.20: Twin-knob operation – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: One-knob operation (Synergic) – easy setting of the operating point thanks to pre-programmed JOBs (welding tasks), display of welding parameters
- Protective earth monitoring (PE)
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Perfect ignition and welding by means of optimised choke with 3 tappings
- 5 m mains supply lead

Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)
Mains fuses (slow-blow)	3 x 25 A
Open circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 25 °C (40 °C)	400 A / 70 % (400 A / 60 %) 300 A / 100 % (300 A / 100 %)
Switching steps	24 (2 x 12)
cos φ	0.97
Dimensions LxWxH in mm	1100 x 550 x 1000
Weight	145 kg

M2.20

M2.40

Control	**Page**	**177**
Wire feed rolls	**Page**	**300**
Options/accessories	**Page**	**280**

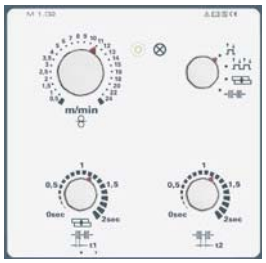
Type	Designation	Item no.
Wega 401 M2.20 FKG	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 4-roll drive	090-005225-00502
Wega 401 M2.40 FKG		090-005226-00502
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
MT401G M9 4m		094-500057-00004
MT401G M9 5m		094-500057-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Wega 401 M1.02 FKW

- MIG/MAG standard welding machine, step switch controlled, water-cooled
- Compact, mobile, can be lifted by crane and moved by fork lift
- M1.02: Twin-knob operation – setting of the welding voltage and wire-feed speed
- Protective earth monitoring (PE)
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Perfect ignition and welding by means of optimised choke with 3 tappings
- Powerful cooling system with centrifugal pump, pressure switch and 7 l tank. Temperature-controlled pump and fan
- 5 m mains supply lead

Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)
Mains fuses (slow-blow)	3 x 25 A
Open circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 25 °C (40 °C)	400 A / 70 % (400 A / 60 %)
	300 A / 100 % (300 A / 100 %)
Switching steps	24 (2 x 12)
cos φ	0.97
Dimensions LxWxH in mm	1100 x 550 x 1000
Weight	165 kg

M1.02



Control	**Page**	**177**
Wire feed rolls	**Page**	**300**
Options/accessories	**Page**	**280**

Type	Designation	Item no.
Wega 401 M1.02 FKW	Step switch controlled MIG/MAG welding machine, compact, water-cooled, Euro torch connector, 4-roll drive	090-005227-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Wega 401 M2.20 • M2.40 FKW

- MIG/MAG standard welding machine, step switch controlled, water-cooled
- Compact, mobile, can be lifted by crane and moved by fork lift
- M2.20: Twin-knob operation – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: One-knob operation (Synergic) – easy setting of the operating point thanks to pre-programmed JOBs (welding tasks), display of welding parameters
- Protective earth monitoring (PE)
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Perfect ignition and welding by means of optimised choke with 3 tappings
- Powerful cooling system with centrifugal pump, pressure switch and 7 l tank. Temperature-controlled pump and fan
- 5 m mains supply lead

Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)
Mains fuses (slow-blow)	3 x 25 A
Open circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 25 °C (40 °C)	400 A / 70 % (400 A / 60 %)
	300 A / 100 % (300 A / 100 %)
Switching steps	24 (2 x 12)
cos φ	0.97
Dimensions LxWxH in mm	1100 x 550 x 1000
Weight	165 kg

M2.20

M2.40

Control	**Page**	**177**
Wire feed rolls	**Page**	**300**
Options/accessories	**Page**	**280**

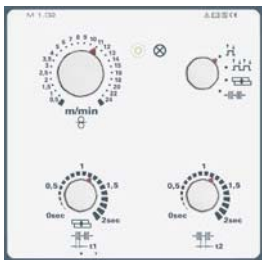
Type	Designation	Item no.
Wega 401 M2.20 FKW	Step switch controlled MIG/MAG welding machine, compact, water-cooled, Euro torch connector, 4-roll drive	090-005228-00502
Wega 401 M2.40 FKW		090-005229-00502
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Wega 401 M1.02 FDG

- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- Decompact, mobile, can be lifted by crane and moved by fork lift
- M1.02: Twin-knob operation – setting of the welding voltage and wire-feed speed
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Perfect ignition and welding by means of optimised choke with 3 tappings
- 5 m mains supply lead

Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)
Mains fuses (slow-blow)	3 x 25 A
Open circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 25 °C (40 °C)	400 A / 70 % (400 A / 60 %) 300 A / 100 % (300 A / 100 %)
Switching steps	24 (2 x 12)
cos φ	0.97
Dimensions LxWxH in mm	1100 x 560 x 1000
Weight	159 kg
Wire feeder, LxWxH in mm	690 x 300 x 410
Weight, wire feeder	18.2 kg

M1.02



Control	**Page**	**177**
Wire feed rolls	**Page**	**300**
Options/accessories	**Page**	**280**

Type	Designation	Item no.
Wega 401 FDG	Step switch controlled MIG/MAG welding machine, decompact, gas-cooled	090-004948-00502
Wega M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	090-004965-00502
MIG G 7POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	094-000580-00000
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Wega 401 M2.20 • M2.40 FDG

- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- Decompact, mobile, can be lifted by crane and moved by fork lift
- M2.20: Twin-knob operation – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: Synergic one-knob operation – easy setting of the operating point thanks to pre-programmed JOBs (welding tasks), display of welding parameters
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Perfect ignition and welding by means of optimised choke with 3 tappings
- 5 m mains supply lead

Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)
Mains fuses (slow-blow)	3 x 25 A
Open circuit voltage	45 V
Setting range for welding current	30 A - 400 A
Duty cycle 25 °C (40 °C)	400 A / 70 % (400 A / 60 %)
	300 A / 100 % (300 A / 100 %)
Switching steps	24 (2 x 12)
cos φ	0.97
Dimensions LxWxH in mm	1100 x 560 x 1000
Weight	159 kg
Wire feeder, LxWxH in mm	690 x 300 x 410
Weight, wire feeder	18.2 kg

M2.20

M2.40

Control	**Page**	**177**
Wire feed rolls	**Page**	**300**
Options/accessories	**Page**	**280**

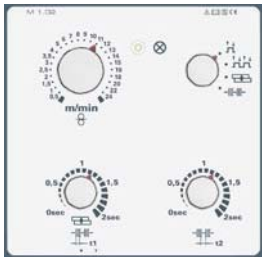
Type	Designation	Item no.
Wega 401 FDG	Step switch controlled MIG/MAG welding machine, decompact, gas-cooled	090-004948-00502
Wega M2.20 drive 41L	Wire feeder, water-cooled, Euro torch connector	090-004966-00502
Wega M2.40 drive 41L		090-004967-00502
MIG G 7POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	094-000580-00000
MT401G M9 3m	MIG/MAG welding torch, gas-cooled	094-500057-00000
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Wega 401 • 501 • 601 M1.02 FDW

- MIG/MAG standard welding machine, step switch controlled, water-cooled
- M1.02: Twin-knob operation – setting of the welding voltage and wire-feed speed
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Perfect ignition and welding by means of optimised choke with 3 tappings
- Powerful cooling system with centrifugal pump, pressure switch and 7 l tank. Temperature-controlled pump and fan
- 5 m mains supply lead

Wega	401	501	601
Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	45 V	50 V	60 V
Setting range for welding current	30 A - 400 A	50 A - 500 A	50 A - 600 A
Duty cycle 25 °C (40 °C)	400 A / 70 % (400 A / 60 %)	500 A / 70 % (500 A / 60 %)	600 A / 60 % (600 A / 45 %)
	300 A / 100 % (300 A / 100 %)	400 A / 100 % (400 A / 100 %)	450 A / 100 % (450 A / 100 %)
Switching steps	24 (2 x 12)	36 (3 x 12)	
cos φ	0.97		
Dimensions LxWxH in mm	1100 x 560 x 1000	960 x 560 x 1010	
Weight	185 kg	200 kg	228 kg
Wire feeder, LxWxH in mm	690 x 300 x 410		
Weight, wire feeder	18.2 kg		

M1.02



M2.40

Control	Page	177
Wire feed rolls	Page	300
Options/accessories	Page	280

Type	Designation	Item no.
Wega 401 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	090-004949-00502
Wega M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	090-004965-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001

Wega 501 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	090-005088-00502
Wega M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	090-004965-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001

Wega 601 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	090-005089-00502
Wega M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	090-004965-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001

Wega 401 ● 501 ● 601 M2.20 ● M2.40 FDW

- MIG/MAG standard welding machine, step switch controlled, water-cooled
- Decompact, mobile, can be lifted by crane and moved by fork lift
- M2.20: Twin-knob operation – setting of welding voltage and wire feed speed, display of welding parameters
- M2.40: One-knob operation (Synergic) – easy setting of the operating point thanks to pre-programmed JOBs (welding tasks), display of welding parameters
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Perfect ignition and welding by means of optimised choke with 3 tappings
- Powerful cooling system with centrifugal pump, pressure switch and 7 l tank. Temperature-controlled pump and fan
- 5 m mains supply lead

M2.20

M2.40

Control	**Page**	**177**
Wire feed rolls	**Page**	**300**
Options/accessories	**Page**	**280**

Wega	401	501	601
Mains voltage (tolerances)	3 x 400 V (-15 % - +15 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	45 V	50 V	60 V
Setting range for welding current	30 A - 400 A	50 A - 500 A	50 A - 600 A
Duty cycle 25 °C (40 °C)	400 A / 70 % (400 A / 60 %)	500 A / 70 % (500 A / 60 %)	600 A / 60 % (600 A / 45 %)
	300 A / 100 % (300 A / 100 %)	400 A / 100 % (400 A / 100 %)	450 A / 100 % (450 A / 100 %)
Switching steps	24 (2 x 12)	36 (3 x 12)	
cos φ	0.97		
Dimensions LxWxH in mm	1100 x 560 x 1000	960 x 560 x 1010	
Weight	185 kg	200 kg	228 kg
Wire feeder, LxWxH in mm	690 x 300 x 410		
Weight, wire feeder	18.2 kg		

Type	Designation	Item no.
Wega 401 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	090-004949-00502
Wega M2.20 drive 41L	Wire feeder, water-cooled, Euro torch connector	090-004966-00502
Wega M2.40 drive 41L		090-004967-00502
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		094-000406-00004
MT451W M9 3m	MIG/MAG welding torch, water-cooled	094-500059-00000
MT451W M9 4m		094-500059-00004
MT451W M9 5m		094-500059-00005
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001

Wega 501 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	090-005088-00502
Wega M2.20 drive 41L	Wire feeder, water-cooled, Euro torch connector	090-004966-00502
Wega M2.40 drive 41L		090-004967-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001

Wega 601 FDW	Step switch controlled MIG/MAG welding machine, decompact, water-cooled	090-005089-00502
Wega M2.20 drive 41L	Wire feeder, water-cooled, Euro torch connector	090-004966-00502
Wega M2.40 drive 41L		090-004967-00502
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		094-000407-00006
MT551W M9 3m	MIG/MAG welding torch, water-cooled	094-500060-00000
MT551W M9 4m		094-500060-00004
MT551W M9 5m		094-500060-00005
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001

▶ Wire feed unit available with either M2.20 or M2.40 control

Overview

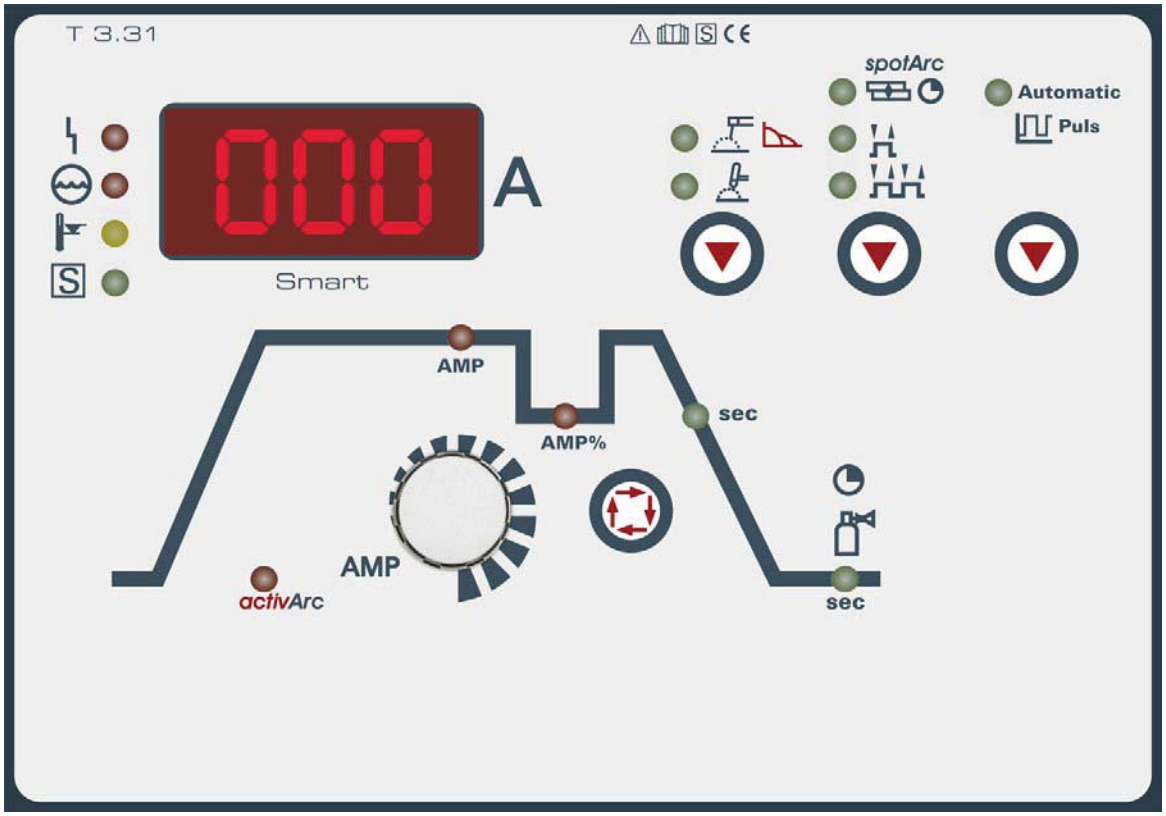
DC TIG welding machines, Portable

Design	Max. welding current	Product name	Cooling		Page
	A		optional cooling unit	Water-cooled	
Modular	200	Picotig 200 ● 200 MV puls TG			204
		Tetrix 200 Smart ● Comfort puls TG			206
	230	Tetrix 230 Comfort 2.0 puls TM	•	•	208
	300	Tetrix 300 Smart ● Classic ● Comfort TM	•		210
		Tetrix 300 Comfort 2.0 puls TM	•	•	212

DC TIG welding machines, Mobile

Design	Max. welding current	Product name	Cooling		Page
	A		optional cooling unit	Water-cooled	
Demodular	350 - 550	Tetrix 351 ● 401 ● 451 ● 551 Smart ● Classic ● Comfort ● Synergic FW		•	214

Smart



One-knob operation
/ Welding current adjustment with just a single knob
/ Features characteristics for EWM activArc and spotArc at no extra charge
/ Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
/ TIG welding, TIG lift arc welding, HF ignition, MMA welding, root welding and gouging

Adjustable welding parameters and functions
/ TIG automated pulsing with automatic specification of required pulse parameters
/ Operating modes: non-latched, latched
/ Spot welding/tack function
/ Spotmatic – halves time required for tacking
/ Up-slope/down-slope

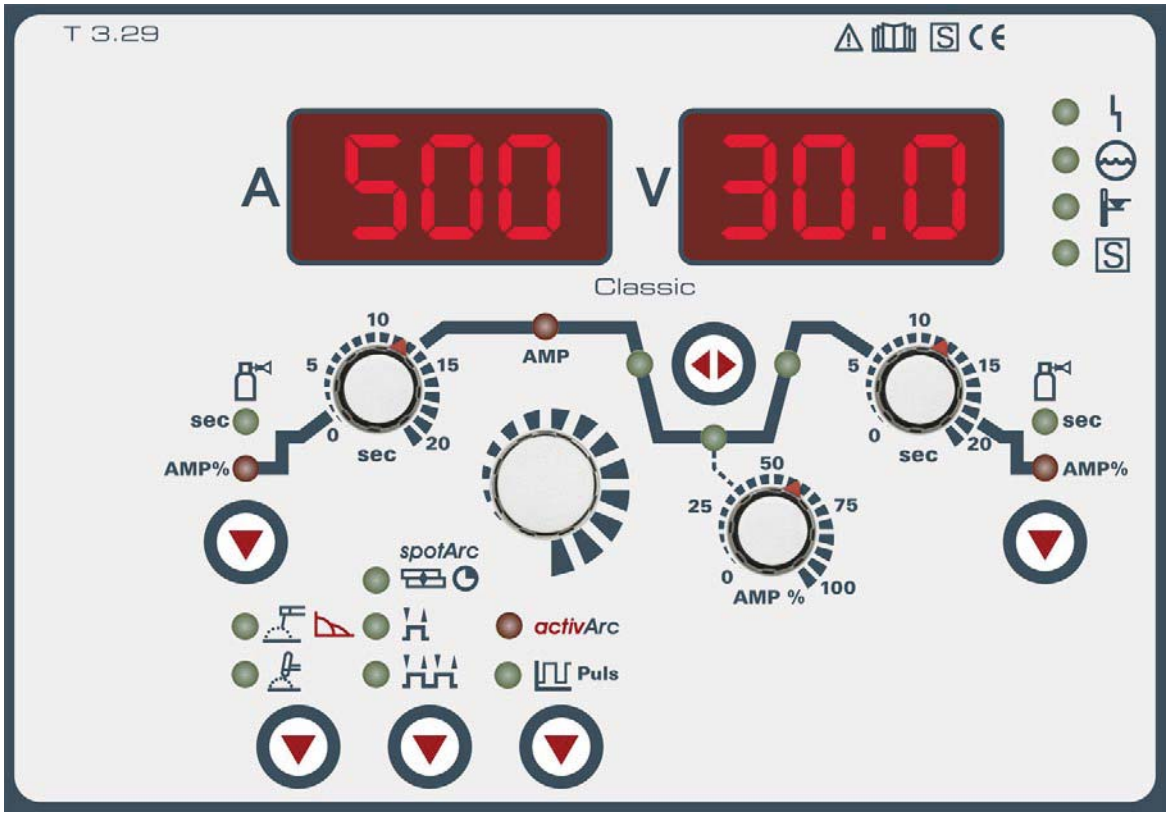
MMA welding
/ MMA/gouge automated pulsing
/ Antistick function
/ Hot start current and hot start time
/ Adjustable Arcforce (except Tetrix 230)

Welding procedure parameters set with LED user guidance
/ Main current
/ Secondary current
/ Down-slope time
/ Gas post-flow time

Digital welding data display with hold function
/ Welding current
/ Welding parameters

Can be optionally networked with LAN or WiFi and EWM Xnet software (except Tetrix 230)

Classic



Classic operation

/ Key functions can be adjusted conventionally using a rotary transducer
/ Features characteristics for EWM activArc and spotArc at no extra charge
/ Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
/ TIG welding, TIG lift arc welding, HF ignition, MMA welding, root welding and gouging

Adjustable welding parameters and functions

/ TIG pulse function
/ Operating modes: non-latched, latched
/ Spot welding/tack function
/ Spotmatic – halves time required for tacking
/ Up-slope/down-slope

MMA welding

/ MMA/gouge automated pulsing
/ Antistick function
/ Hot start current and hot start time
/ Adjustable Arcforce (except Tetrix 230)

Welding procedure parameters set with LED user guidance

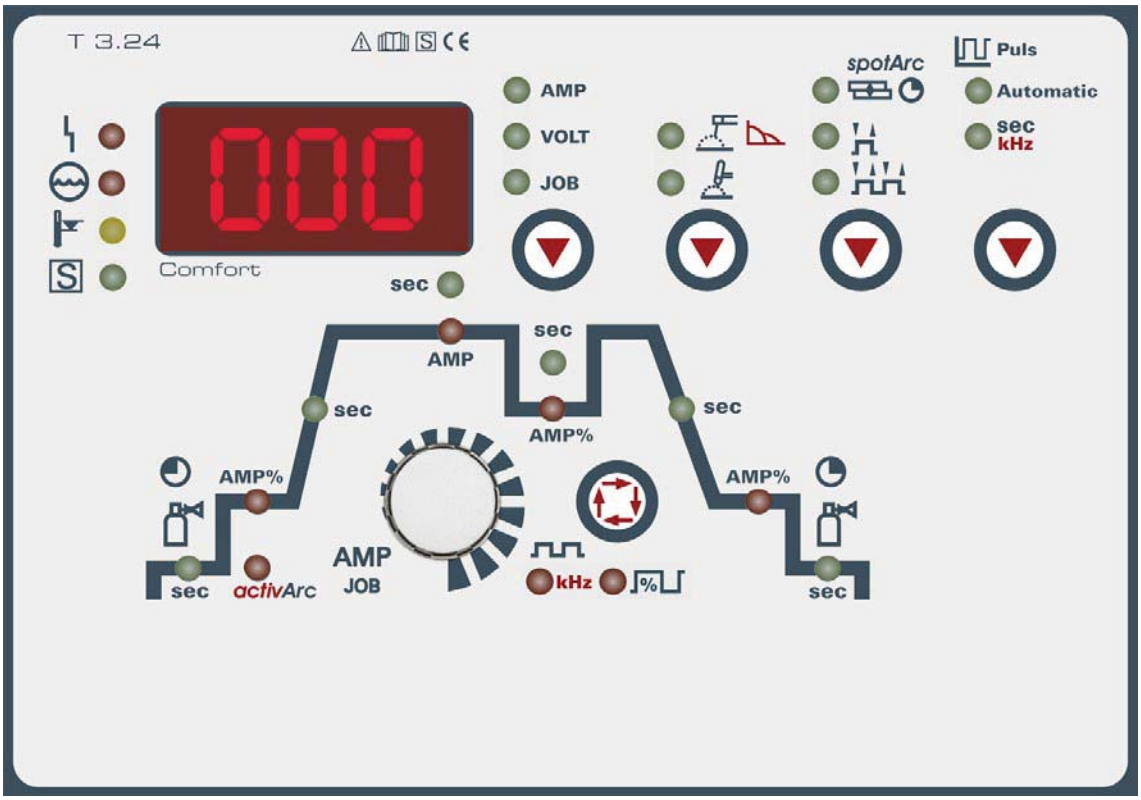
/ Start, welding, secondary and end current
/ Pulse and break currents
/ Up-slope/down-slope time
/ Gas pre- and post-flow time

Digital welding data display with hold function

/ Welding current
/ Welding parameters
/ Welding voltage

Can be optionally networked with LAN or WiFi and EWM Xnet software

Comfort



One-knob operation

/ Welding current adjustment with just a single knob
/ Features characteristics for EWM activArc and spotArc at no extra charge
/ Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
/ TIG welding, TIG lift arc welding, HF ignition, MMA welding, root welding and gouging

Adjustable welding parameters and functions

/ Pulsed TIG welding in Hz and kHz range up to 15 kHz
/ TIG automated pulsing with automatic specification of required pulse parameters
/ 8 programmed JOBs (welding tasks)
/ Operating modes: non-latched, latched
/ Spot welding/tack function
/ Spotmatic – halves time required for tacking
/ Up-slope/down-slope

MMA welding

/ MMA/gouge automated pulsing
/ Antistick function
/ Hot start current and hot start time
/ Adjustable Arcforce (except Tetrix 230)

Welding procedure parameters set with LED user guidance

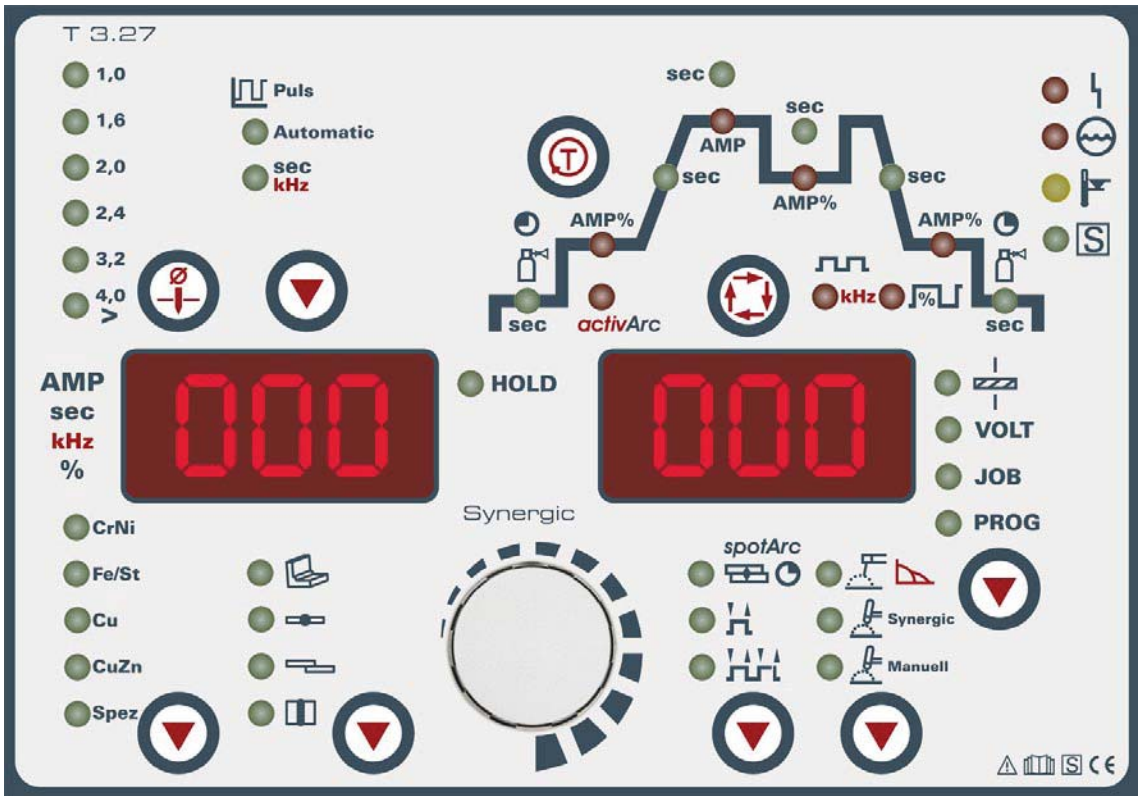
/ Start, welding, secondary and end current
/ Pulse time and pulse pause time with corresponding slope times (slope times not for Tetrix 230)
/ Up-slope/down-slope time
/ kHz pulses: balance, frequency
/ Gas pre- and post-flow time

Digital welding data display with hold function

/ Welding current
/ Welding voltage
/ Welding parameters
/ JOB number

Can be optionally networked with LAN or WiFi and EWM Xnet software (except Tetrix 230)

Synergic



Synergic one-knob operation

/ Welding current adjustment with just a single knob
/ Features user database for Synergic operation at no extra charge
/ Simple, menu-guided selection of welding tasks from user database
/ Features characteristics for EWM activArc and spotArc at no extra charge
/ TIG welding, TIG lift arc welding, HF ignition, MMA welding, root welding and gouging

Adjustable welding parameters and functions

/ Pulsed TIG welding in Hz and kHz range up to 15 kHz
/ TIG automated pulsing with automatic specification of required pulse parameters
/ 256 pre-programmed JOBs/characteristics in the user database
/ Manual or Synergic operation possible
/ Operating modes: non-latched, latched
/ Spot welding/tack function
/ Spotmatic – halves time required for tacking
/ Up-slope/down-slope
/ Currentless gas test, purge hose package

MMA welding

/ MMA/gouge automated pulsing
/ Antistick function
/ Hot start current and hot start time
/ Adjustable Arcforce (except Tetrix 230)

Welding procedure parameters set with LED user guidance

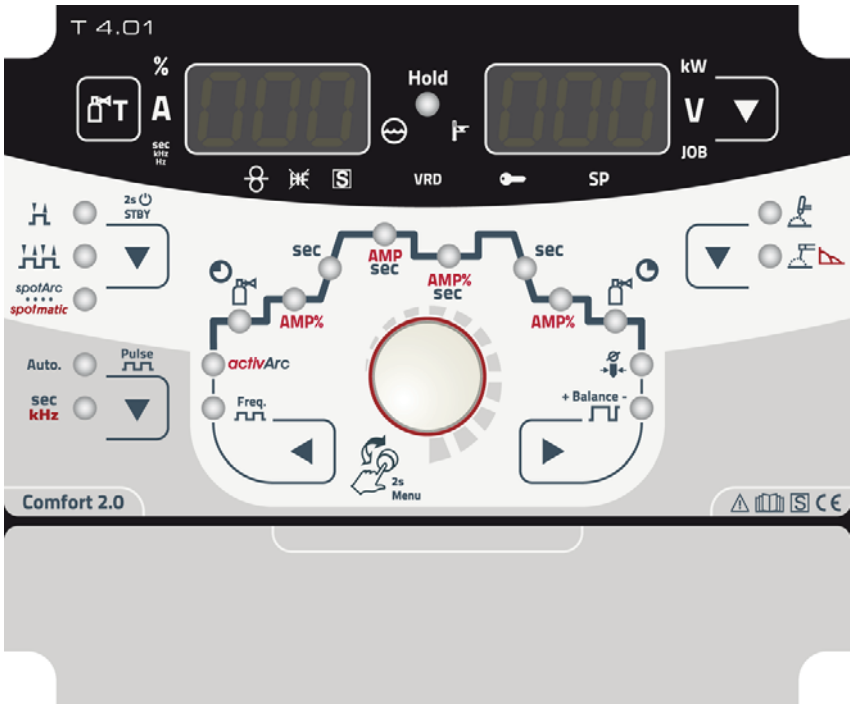
/ Start, welding, secondary and end current
/ Pulse time and pulse pause time with corresponding slope times
/ Up-slope/down-slope time
/ kHz pulses: balance, frequency
/ Gas pre- and post-flow time

Digital welding data display with hold function

/ Welding current
/ Welding voltage
/ Welding parameters
/ JOB number
/ Plate thickness
/ Program number

Can be optionally networked with LAN or WiFi and EWM Xnet software

Comfort 2.0



One-knob operation

/ Welding sequence selection and parameter adjustment via click wheel or with the classic method via sequence buttons (forward/back)
/ Features characteristics for EWM activArc and spotArc at no extra charge
/ Expert menu for advanced welding parameter adjustments
/ TIG-welding, TIG pulses, TIG lift arc welding, HF ignition, MMA welding, MMA pulse welding

Adjustable welding parameters and functions

TIG welding

/ Pulsed TIG welding in Hz and kHz range up to 15 kHz
/ TIG automated pulsing with automatic specification of required pulse parameters
/ Balance, Puls balance
/ Pulse frequency
/ Metallurgical average value pulses (DC)
/ 8 programmed JOBs (welding tasks)
/ Operating modes: non-latched, latched
/ Spot welding/tack function (spotArc / Spotmatic)
/ Spotmatic and spotArc with direct access
/ Up-slope/down-slope
/ Gas test, purge

MMA welding

/ Automated MMA pulsing
/ AC electrode welding
/ Pulsed frequency welding
/ Antistick function
/ Hot start current and hot start time
/ Adjustable Arcforce (except Tetrix 230)
/ Welding polarity switchover
/ 8 programmed JOBs (welding tasks)

Welding procedure parameters set with LED user guidance

/ Start, welding, secondary and end current
/ Pulse time and pulse pause time with corresponding slope times
/ Up-slope/down-slope time
/ kHz pulses: balance, frequency
/ Gas pre- and post-flow time
/ Electrode diameter

Digital welding data display with hold function

/ Welding current
/ Welding voltage
/ Welding parameters
/ Welding power
/ JOB number

Can be optionally networked with LAN or WiFi and EWM Xnet software (except Tetrix 230)

Picotig 200 • 200 MV puls TG

T1.80

Options/accessories Page 280

- Gas-cooled DC TIG inverter welding machine
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- TIG and MMA pulse function
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Up-slope/down-slope adjustable
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- Antistick function
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Energy-saving thanks to high efficiency and standby function
- Portable, including shoulder strap
- Mains connection 230 V/16 A
- High mains voltage tolerance +15%/-40% and therefore fully generator-compatible
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)	1 x 115 V (-15 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A	1 x 25 A
Open circuit voltage	90 V	
Setting range for welding current	5 A - 200 A	5 A - 150 A
Duty cycle 40 °C	200 A / 25 %	–
	–	150 A / 35 %
	150 A / 60 %	120 A / 60 %
	120 A / 100 %	100 A / 100 %
cos φ	0.99	
Efficiency	86 %	
Dimensions LxWxH in mm	428 x 181 x 294	
Weight	9.8 kg	

Type	Designation	Item no.
Set Picotig 200 puls 5P D	Set: TIG torch, workpiece lead, 2 m gas hose, pressure regulator in a case	091-002058-00502
Set Picotig 200 puls 5P RU	Set: TIG torch, workpiece lead, 2 m gas hose, pressure regulator in a case	091-002058-00508
Set Picotig 200 puls 5P DK/FI/NL/NO/SE	Set: TIG torch, workpiece lead, 2 m gas hose, pressure regulator in a case	091-002058-00540
Set Picotig 200 puls 5P GB	Set: TIG torch, workpiece lead, 2 m gas hose, pressure regulator in a case	091-002058-00537
Set Picotig 200 puls 5P	Set: TIG torch, workpiece lead, 2 m gas hose in a case	091-002058-00539
Picotig 200 puls TG	TIG DC welding machine, portable, gas, decentral	090-002058-00502
TIG 150 GD GRIP 5P 4m	TIG welding torch, gas-cooled	394-512291-00600
TIG 150 GD GRIP 5P 8m		394-512291-00608
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
CBP Picotig	Transport case, empty	094-012322-00500
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Picotig 200 MV puls TG	TIG multivolt inverter welding machine	090-002059-00502
TIG 150 GD GRIP 5P 4m	TIG welding torch, gas-cooled	394-512291-00600
TIG 150 GD GRIP 5P 8m		394-512291-00608
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 200 Smart ● Comfort puls TG

/activArc®

Smart

Comfort

Control	**Page**	**199**
Options/accessories	**Page**	**280**

- Gas-cooled DC TIG inverter welding machine
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- MMA automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Antistick function
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Safe ignition also for long hose packages
- Energy-saving thanks to high efficiency and standby function
- Portable, including shoulder strap
- Connection capability for remote control and function torch
- Mains connection 230 V/16 A
- High mains voltage tolerance +15%/-40% and therefore fully generator-compatible
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Mains voltage (tolerances)	1 x 115 V (-15 % - +15 %)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 25 A	1 x 16 A
Open circuit voltage	90 V	
Setting range for welding current	5 A - 150 A	5 A - 200 A
Duty cycle 40 °C	–	200 A / 25 %
	150 A / 35 %	–
	120 A / 60 %	150 A / 60 %
	100 A / 100 %	120 A / 100 %
cos φ	0.99	
Efficiency	86 %	
Dimensions LxWxH in mm	475 x 180 x 295	
Weight	11.5 kg	

Type	Designation	Item no.
Tetrix 200 Smart puls 5P TG	TIG DC welding machine, portable, gas-cooled, decentralised, 5-pole connection socket	090-000227-00502
Tetrix 200 Comfort puls 5P TG		090-000228-00502
Tetrix 200 Smart puls 8P TG	TIG DC welding machine, portable, gas-cooled, decentralised, 8-pole connection socket	090-000227-00504
Tetrix 200 Comfort puls 8P TG		090-000228-00504
TIG 150 GD GRIP 5P 4m	TIG welding torch, gas-cooled	394-512291-00600
TIG 150 GD GRIP 5P 8m		394-512291-00608
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 200 MV Comfort puls 5P TG	TIG multivolt inverter welding machine	090-000229-00502
TIG 150 GD GRIP 5P 4m	TIG welding torch, gas-cooled	394-512291-00600
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 230 Comfort 2.0 puls TM

/activArc®

Comfort 2.0

Control	**Page**	**199**
Options/accessories	**Page**	**280**

- Modular DC TIG inverter welding machine, gas- or water-cooled
- Comfort 2.0 control, simple operation with click wheel
- **TIG welding**
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- TIG automated pulsing with automatic specification of required pulse parameters
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- 8 programmed JOBs (welding tasks)
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- MMA automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Antistick function
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- **Highlights**
- Safe ignition also for long hose packages
- Gas-cooled or optionally water-cooled with cool 40 U31 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 4-litre water tank (cool 41U31 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Connection capability for remote control and function torch
- Trolly 35.2-2 trolley available for delivery
- Mains connection 230 V/16 A
- High mains voltage tolerance +15%/-40% and therefore fully generator-compatible
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Open circuit voltage	90 V
Setting range for welding current	3 A - 230 A
Duty cycle 40 °C	230 A / 40 %
	200 A / 60 %
	170 A / 100 %
cos φ	1
Efficiency	88 %
Dimensions LxWxH in mm	539 x 210 x 415
Weight	17.5 kg
Dimensions cooling unit in mm	600 x 210 x 340
Weight, cooling unit	14 kg
Trolley dimensions L x W x H in mm	600 x 580 x 1200
Trolley weight	33 kg

Type	Designation	Item no.
Tetrix 230 Comfort 2.0 puls 5P TM	TIG DC welding machine, portable, modular, decentral, 5-pole connection socket	090-000240-00502
Tetrix 230 Comfort 2.0 puls 8P TM	TIG DC welding machine, portable, modular, decentral, 8-pole connection socket	090-000240-00504
TIG 200 GRIP GD 5P 4m	TIG welding torch, gas-cooled	394-510981-00600
TIG 200 GRIP GD 5P 8m		394-510981-00608
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 230 Comfort 2.0 puls 5P TM	TIG DC welding machine, portable, modular, decentral, 5-pole connection socket	090-000240-00502
Tetrix 230 Comfort 2.0 puls 8P TM	TIG DC welding machine, portable, modular, decentral, 8-pole connection socket	090-000240-00504
cool40 U31	Cooling unit with centrifugal pump	090-008593-00502
TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	394-510990-00600
TIG 260 GRIP WD 5P 8m		394-510990-00608
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
Trolly 35.2-2	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	090-008296-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

▶ Welding machines optionally available with different controls

Packing unit		
6x Tetrix 230 Comfort 2.0 puls 5P TM	Packing unit: 6x Tetrix 230 Comfort 2.0 puls, 5-pole connection socket	092-015317-00502

Packing unit		
6x Tetrix 230 Comfort 2.0 puls 8P TM	Packing unit: 6x Tetrix 230 Comfort 2.0 puls, 8-pole connection socket	092-015317-00504

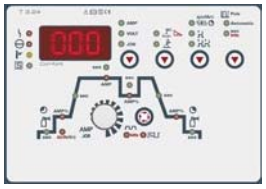
Tetrix 300 Smart ● Classic ● Comfort TM

/activArc®

Smart

Classic

Comfort



Control	**Page**	**199**
Options/accessories	**Page**	**280**

- Modular DC TIG inverter welding machine, gas- or water-cooled
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- TIG automated pulsing with automatic specification of required pulse parameters
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- MMA automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Antistick function
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Safe ignition also for long hose packages
- Gas-cooled or optionally water-cooled with cool 35 U31 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 4.5-litre water tank (cool 35 U31 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Trolly 35.2-2 trolley available for delivery
- Mains connection 3 x 400 V/16 A
- **You will find other functions of the individual controls in the control overview**

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	98 V
Setting range for welding current	5 A - 300 A
Duty cycle 40 °C	300 A / 60 %
	250 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	590 x 230 x 380
Weight	29 kg
Dimensions cooling unit in mm	650 x 270 x 225
Weight, cooling unit	15 kg
Trolley dimensions L x W x H in mm	600 x 580 x 1200
Trolley weight	34 kg

Type	Designation	Item no.
Tetrix 300 Smart TM	TIG DC welding machine, portable, modular, decentral	090-000125-00502
Tetrix 300 Classic TM	TIG DC welding machine, portable, gas, decentral	090-000098-00502
Tetrix 300 Comfort TM	TIG DC welding machine, portable, modular, decentral	090-000099-00502
TIG 200 GRIP GD 5P 4m	TIG welding torch, gas-cooled	394-510981-00600
TIG 200 GRIP GD 5P 8m		394-510981-00608
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 300 Smart TM	TIG DC welding machine, portable, modular, decentral	090-000125-00502
Tetrix 300 Classic TM	TIG DC welding machine, portable, gas, decentral	090-000098-00502
Tetrix 300 Comfort TM	TIG DC welding machine, portable, modular, decentral	090-000099-00502
cool35 U31	Cooling unit with centrifugal pump	090-008235-00502
TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	394-510990-00600
TIG 260 GRIP WD 5P 8m		394-510990-00608
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
Trolly 35.2-2	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	090-008296-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 300 Comfort 2.0 puls TM

/activArc®

Comfort 2.0

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- Modular DC TIG inverter welding machine, gas- or water-cooled
- Comfort 2.0 control, simple operation with click wheel
- **TIG welding**
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- TIG automated pulsing with automatic specification of required pulse parameters
- Metallurgical average value pulses (DC)
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- 8 programmed JOBs (welding tasks)
- Non-latched/latched operation
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- spotmatic and spotArc with direct access
- Up-slope/down-slope adjustable
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- MMA automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Antistick function
- 8 programmed JOBs (welding tasks)
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- **Highlights**
- Safe ignition also for long hose packages
- Gas-cooled or optionally water-cooled with cool 41 U31 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 4-litre water tank (cool 41U31 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Trolly 35.2-2 trolley available for delivery
- Can be optionally connected to LAN or WiFi. Xnet-compatible
- PC interface for PC300.Net software

Tetrix	2.0
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	63 V
Setting range for welding current	5 A - 300 A
Duty cycle 40 °C	300 A / 35 %
	260 A / 60 %
	210 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	539 x 210 x 415
Weight	20 kg
Dimensions cooling unit in mm	600 x 210 x 340
Weight, cooling unit	18.4 kg
Trolley dimensions L x W x H in mm	600 x 580 x 1200
Trolley weight	33 kg

Type	Designation	Item no.
Tetrix 300 Comfort 2.0 puls 5P TM	TIG DC welding machine, portable, modular, decentral, 5-pole connection socket	090-000238-00502
Tetrix 300 Comfort 2.0 puls 8P TM	TIG DC welding machine, portable, modular, decentral, 8-pole connection socket	090-000238-00504
TIG 200 GRIP GD 5P 4m	TIG welding torch, gas-cooled	394-510981-00600
TIG 200 GRIP GD 5P 8m		394-510981-00608
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 300 Comfort 2.0 puls 5P TM	TIG DC welding machine, portable, modular, decentral, 5-pole connection socket	090-000238-00502
Tetrix 300 Comfort 2.0 puls 8P TM	TIG DC welding machine, portable, modular, decentral, 8-pole connection socket	090-000238-00504
cool41 U31	Cooling unit with centrifugal pump	090-008600-00502
TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	394-510990-00600
TIG 260 GRIP WD 5P 8m		394-510990-00608
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
Trolly 35.2-2	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	090-008296-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Packing unit		
6x Tetrix 300 Comfort 2.0 puls 5P TM	Packing unit: 6x Tetrix 300 Comfort 2.0 puls, 5-pole connection socket	092-015315-00502

Packing unit		
6x Tetrix 300 Comfort 2.0 puls 8P TM	Packing unit: 6x Tetrix 300 Comfort 2.0 puls, 8-pole connection socket	092-015315-00504

Tetrix 351 ● 401 ● 451 ● 551 Smart ● Classic ● Comfort ● Synergic FW

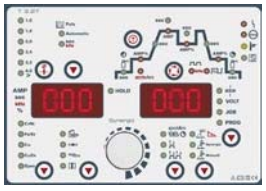
- Water-cooled DC TIG inverter welding machine
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- TIG automated pulsing with automatic specification of required pulse parameters
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA-Welding/gouging**
- MMA/gouging, automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Antistick function
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- Adjustable Arcforce
- Safe ignition also for long hose packages
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Mains connection: 3 x 400 V; other mains voltages and multivolt as an option
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Crane-liftable casing
- Can be optionally networked with LAN or WiFi and EWM Xnet software
- **You will find other functions of the individual controls in the control overview**

Smart

Classic

Comfort

Synergic



Control	**Page**	**199**
Options/accessories	**Page**	**280**

Tetrix	351	401	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)			
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A		
Open circuit voltage	80 V			
Setting range for welding current	5 A - 350 A	5 A - 400 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–		450 A / 80 %	550 A / 60 %
	350 A / 100 %	400 A / 100 %	420 A / 100 %	
cos φ	0.99			
Efficiency	88 %	90 %		
Dimensions LxWxH in mm	1100 x 455 x 1000			
Weight	126 kg	131 kg		

Type	Designation	Item no.
Tetrix 351 Smart FW	TIG DC welding machine, mobile, water-cooled, decentral	090-000129-00502
Tetrix 351 Classic FW		090-000116-00502
Tetrix 351 Comfort FW		090-000117-00502
Tetrix 351 Synergic FW		090-000118-00502
TIG 450 GRIP WD 5P 4m	TIG welding torch, water-cooled	394-510993-00600
TIG 450 GRIP WD 5P 8m		394-510993-00608
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Tetrix 401 Smart FW	TIG DC welding machine, mobile, water-cooled, decentral	090-000176-00502
Tetrix 401 Classic FW		090-000177-00502
Tetrix 401 Comfort FW		090-000178-00502
Tetrix 401 Synergic FW		090-000179-00502
TIG 450 GRIP WD 5P 4m	TIG welding torch, water-cooled	394-510993-00600
TIG 450 GRIP WD 5P 8m		394-510993-00608
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Tetrix 451 Smart FW	TIG DC welding machine, mobile, water-cooled, decentral	090-000130-00502
Tetrix 451 Classic FW		090-000101-00502
Tetrix 451 Comfort FW		090-000102-00502
Tetrix 451 Synergic FW		090-000103-00502
TIG 450 GRIP WD 5P 4m	TIG welding torch, water-cooled	394-510993-00600
TIG 450 GRIP WD 5P 8m		394-510993-00608
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Tetrix 551 Smart FW	TIG DC welding machine, mobile, water-cooled, decentral	090-000131-00502
Tetrix 551 Classic FW		090-000091-00502
Tetrix 551 Comfort FW		090-000092-00502
Tetrix 551 Synergic FW		090-000093-00502
TIG 450SC GRIP 5P HFL 4m	TIG welding torch, water-cooled	394-511016-10600
TIG 450SC GRIP 5P HFL 8m		394-511016-10608
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Overview

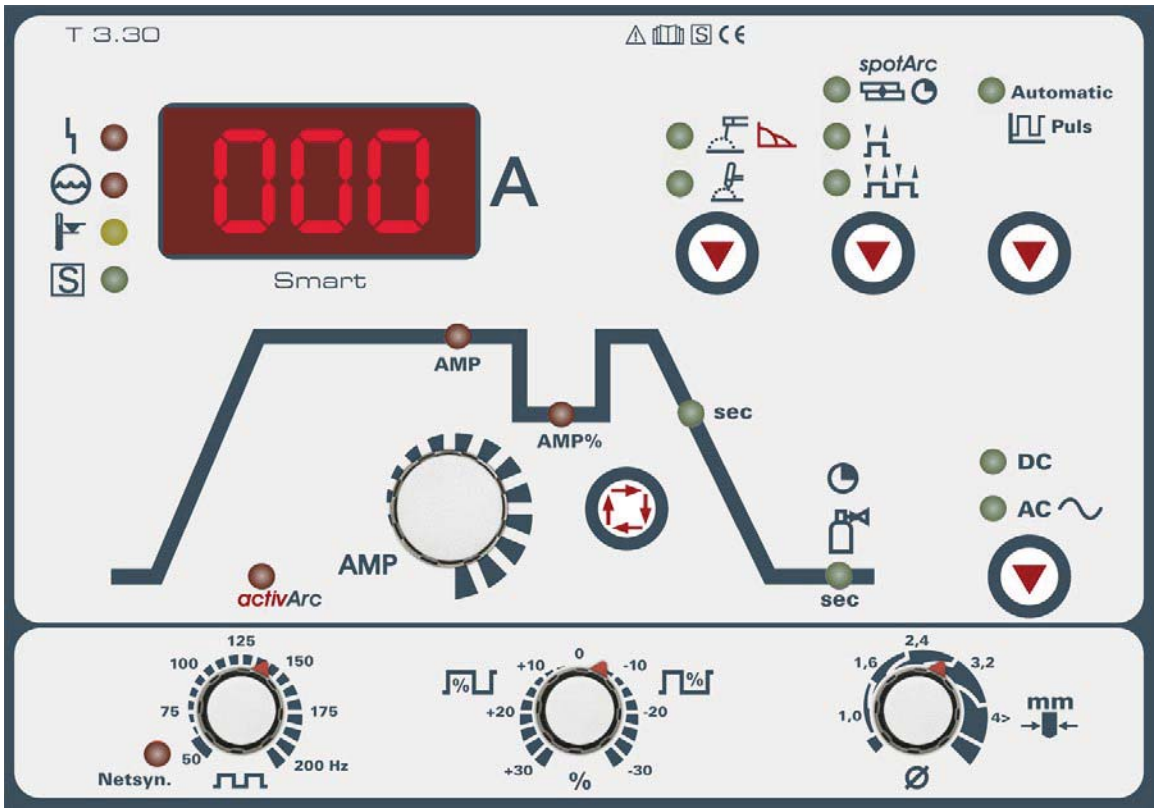
AC/DC TIG welding machines, Portable

Design	Max. welding current	Product name	Cooling		Page
	A		optional cooling unit	Water-cooled	
Modular	200	Picotig 200 AC/DC puls TG			222
	230	Tetrix 230 AC/DC Comfort 2.0 puls TM	•	•	223
	300	Tetrix 300 AC/DC Comfort 2.0 puls TM	•		225

AC/DC TIG welding machines, Mobile

Design	Max. welding current	Product name	Cooling		Page
	A		optional cooling unit	Water-cooled	
Demodular	350 - 550	Tetrix 351 ● 451 ● 551 AC/DC Smart ● Classic ● Comfort ● Synergic FW		•	227

Smart



One-knob operation

/ Welding current adjustment with just a single knob
/ Features characteristics for EWM activArc and spotArc at no extra charge
/ Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
/ TIG welding, TIG lift arc welding, HF ignition, MMA welding, root welding and gouging

Adjustable welding parameters and functions

/ AC waveform, sine, trapezoidal, square current
/ AC frequency between 50 Hz and 200 Hz
/ AC balance
/ TIG automated pulsing with automatic specification of required pulse parameters
/ Operating modes: non-latched, latched
/ Spot welding/tack function
/ Spotmatic – halves time required for tacking
/ Up-slope/down-slope

MMA welding

/ MMA/gouge automated pulsing
/ Antistick function
/ Hot start current and hot start time
/ Adjustable Arcforce (except Tetrix 230)

Welding procedure parameters set with LED user guidance

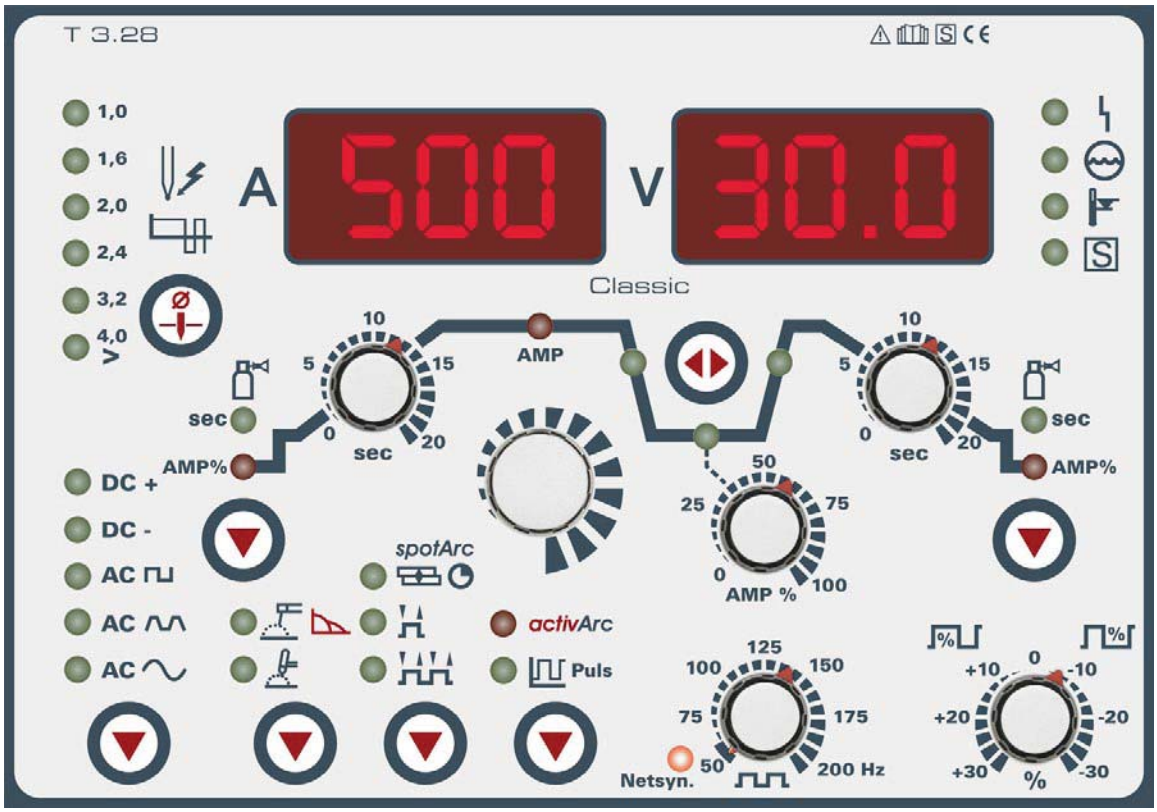
/ Main current
/ Secondary current
/ Down-slope time
/ Gas post-flow time

Digital welding data display with hold function

/ Welding current
/ Welding parameters

Can be optionally networked with LAN or WiFi and EWM Xnet software (except Tetrix 230)

Classic



Classic operation

/ Key functions can be adjusted conventionally using a rotary transducer
/ Features characteristics for EWM activArc and spotArc at no extra charge
/ TIG welding, TIG lift arc welding, HF ignition, MMA welding, root welding and gouging

Adjustable welding parameters and functions

/ Special AC welding procedure to join markedly different aluminium sheets together, e.g. welding 1-mm-sheet to a 10-mm-plate
/ AC waveform, sine, trapezoidal, square current
/ AC frequency between 50 Hz and 200 Hz
/ AC balance
/ TIG pulse function
/ Operating modes: non-latched, latched
/ Spot welding/tack function
/ Spotmatic – halves time required for tacking
/ Up-slope/down-slope

MMA welding

/ MMA/gouge automated pulsing
/ Antistick function
/ Hot start current and hot start time
/ Adjustable Arcforce (except Tetrix 230)

Welding procedure parameters set with LED user guidance

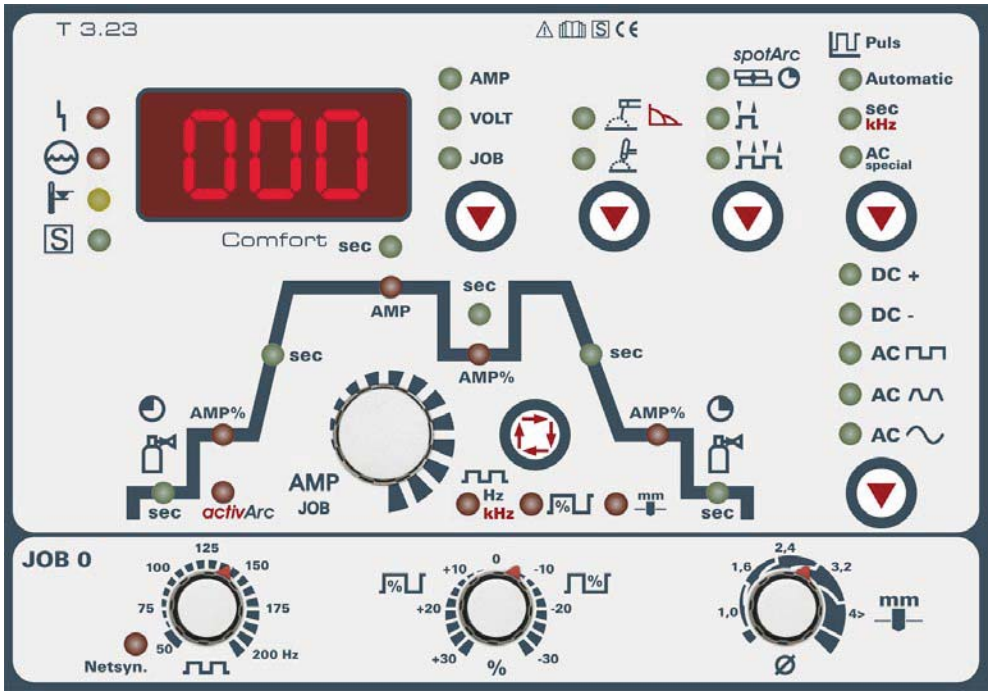
/ Start, welding, secondary and end current
/ Pulse and break currents
/ Up-slope/down-slope time
/ Gas pre- and post-flow time

Digital welding data display with hold function

/ Welding current
/ Welding voltage
/ Welding parameters

Can be optionally networked with LAN or WiFi and EWM Xnet software

Comfort



One-knob operation

/ Welding current adjustment with just a single knob
/ Features characteristics for EWM activArc and spotArc at no extra charge
/ Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
/ TIG welding, TIG lift arc welding, HF ignition, MMA welding, root welding and gouging

Adjustable welding parameters and functions

/ Special AC welding procedure to join markedly different aluminium sheets together, e.g. welding 1-mm-sheet to a 10-mm-plate
/ AC waveform, sine, trapezoidal, square current
/ AC frequency between 50 Hz and 200 Hz
/ AC balance
/ Pulsed TIG welding in Hz and kHz range up to 15 kHz
/ TIG automated pulsing with automatic specification of required pulse parameters
/ 8 programmed JOBs (welding tasks)
/ Operating modes: non-latched, latched
/ Spot welding/tack function
/ Spotmatic – halves time required for tacking
/ Up-slope/down-slope

MMA welding

/ MMA/gouge automated pulsing
/ Antistick function
/ Hot start current and hot start time
/ Adjustable Arcforce (except Tetrix 230)

Welding procedure parameters set with LED user guidance

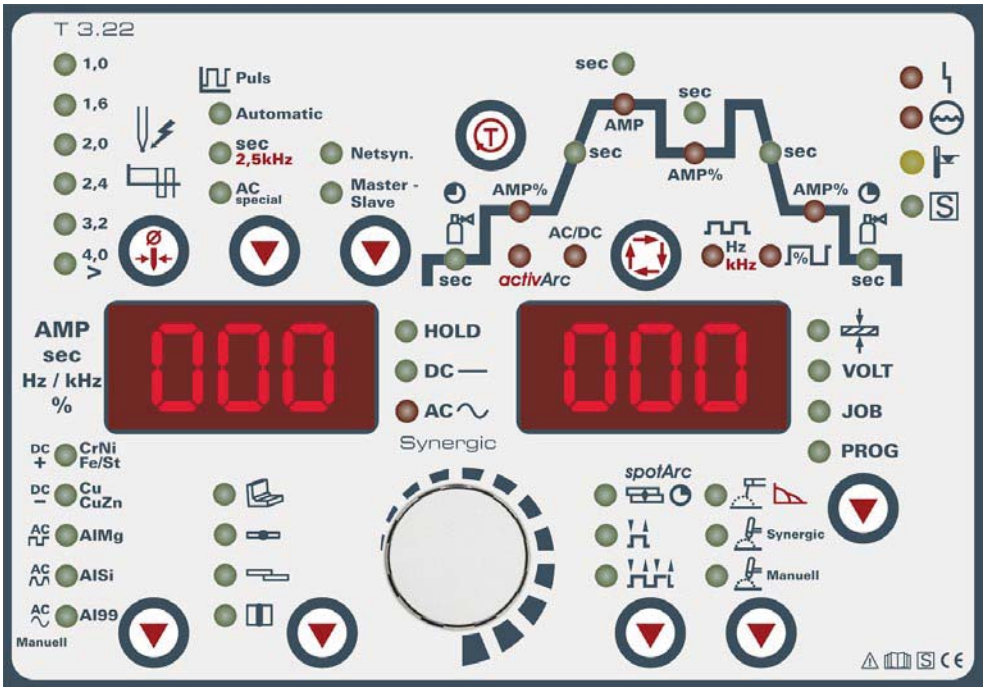
/ Start, welding, secondary and end current
/ Pulse time and pulse pause time with corresponding slope times (slope times not for Tetrix 230)
/ Up-slope/down-slope time
/ kHz pulses: balance, frequency
/ Gas pre- and post-flow time

Digital welding data display with hold function

/ Welding current
/ Welding voltage
/ Welding parameters
/ JOB number

Can be optionally networked with LAN or WiFi and EWM Xnet software (except Tetrix 230)

Synergic



Synergic one-knob operation

/ Welding current adjustment with just a single knob
/ Features user database for Synergic operation at no extra charge
/ Simple, menu-guided selection of welding tasks from user database
/ Features characteristics for EWM activArc and spotArc at no extra charge
/ TIG welding, TIG lift arc welding, HF ignition, MMA welding, root welding and gouging

Adjustable welding parameters and functions

/ Special AC welding procedure to join markedly different aluminium sheets together, e.g. welding 1-mm-sheet to a 10-mm-plate
/ AC waveform, sine, trapezoidal, square current
/ AC frequency between 50 Hz and 200 Hz
/ AC balance
/ Pulsed TIG welding in Hz and kHz range up to 15 kHz
/ TIG automated pulsing with automatic specification of required pulse parameters
/ 256 pre-programmed JOBs/characteristics in the user database
/ Manual or Synergic operation possible
/ Operating modes: non-latched, latched
/ Spot welding/tack function
/ Spotmatic – halves time required for tacking
/ Up-slope/down-slope
/ Currentless gas test, purge hose package

MMA welding

/ MMA/gouge automated pulsing
/ Antistick function
/ Hot start current and hot start time
/ Adjustable Arcforce (except Tetrix 230)

Welding procedure parameters set with LED user guidance

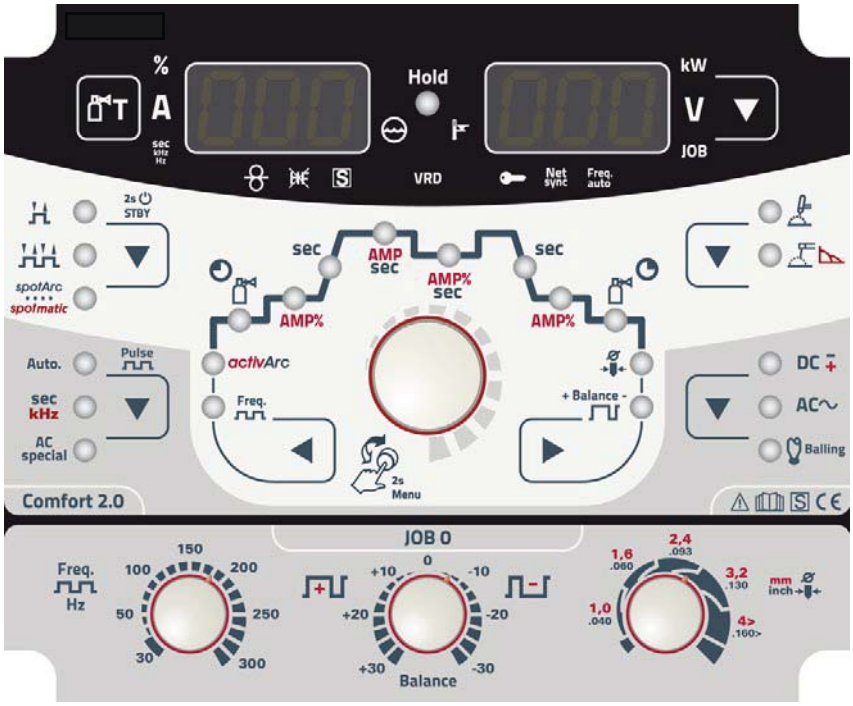
/ Start, welding, secondary and end current
/ Pulse time and pulse pause time with corresponding slope times
/ Up-slope/down-slope time
/ kHz pulses: balance, frequency
/ Gas pre- and post-flow time

Digital welding data display with hold function

/ Welding current
/ Welding voltage
/ Welding parameters
/ JOB number
/ Plate thickness
/ Program number

Can be optionally networked with LAN or WiFi and EWM Xnet software

Comfort 2.0



One-knob operation

- Welding sequence selection and parameter adjustment via click wheel or with the classic method via sequence buttons (forward/back)
- Features characteristics for EWM activArc and spotArc at no extra charge
- Expert menu for advanced welding parameter adjustments
- TIG-DC and AC/DC welding, TIG pulses, TIG lift arc welding, HF ignition, MMA DC and AC/DC welding (except Tetrix 230), MMA pulse welding

Adjustable welding parameters and functions

TIG welding

- Special AC welding procedure to join markedly different aluminium sheets together, e.g. welding 1-mm-sheet to a 10-mm-plate
- AC tungsten balling for the respective diameter
- AC waveform: sine, trapezoidal, square current
- AC frequency: between 30 Hz and 300 Hz (Tetrix 300)
  between 50 Hz and 200 Hz (Tetrix 230)
- Pulsed frequency welding
- AC balance, Pulse balance
- Automatic AC frequency
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- TIG automated pulsing with automatic specification of required pulse parameters
- Metallurgical average value pulses (DC)
- 8 programmed JOBs (welding tasks)
- Operating modes: non-latched, latched
- Spot welding/tack function (spotArc / Spotmatic)
- Spotmatic and spotArc with direct access
- Up-slope/down-slope
- Gas test, purge

MMA welding

- Automated MMA pulsing
- AC electrode welding
- Pulsed frequency welding
- Antistick function
- Hot start current and hot start time
- Adjustable Arcforce (except Tetrix 230)
- Welding polarity switchover
- 8 programmed JOBs (welding tasks)

Welding procedure parameters set with LED user guidance

- Start, welding, secondary and end current
- Pulse time and pulse pause time with corresponding slope times
- Up-slope/down-slope time
- kHz pulses: balance, frequency
- Gas pre- and post-flow time
- Electrode diameter

Digital welding data display with hold function

- Welding current
- Welding voltage
- Welding parameters
- Welding power
- JOB number

Can be optionally networked with LAN or WiFi and EWM Xnet software (except Tetrix 230)

Picotig 200 AC/DC puls TG

Control	**Page**	**217**
Options/accessories	**Page**	**280**

- AC/DC TIG inverter welding machine, gas- or water-cooled
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- Adjustable AC waveform, sine, trapezoidal, square current
- Adjustable AC frequency between 50 Hz and 200 Hz
- Adjustable AC balance
- TIG and MMA pulse function
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Up-slope/down-slope adjustable
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- Antistick function
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Gas-cooled or optionally water-cooled with cool 40 U31 cooling unit
- Energy-saving thanks to high efficiency and standby function
- Portable, including shoulder strap
- Trolly 35.2-2 trolley available for delivery
- Mains connection 230 V/16 A
- High mains voltage tolerance +15%/-40% and therefore fully generator-compatible
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Open circuit voltage	43 V
Setting range for welding current	5 A - 200 A
Duty cycle 40 °C	200 A / 35 %
	150 A / 60 %
	120 A / 100 %
cos φ	0.99
Efficiency	85 %
Dimensions LxWxH in mm	600 x 205 x 415
Weight	16.5 kg

Type	Designation	Item no.
Picotig 200 AC/DC puls 5P TG	AC/DC TIG welding machine, portable, gas, decentral, 5-pole connection socket	090-000188-00502
Picotig 200 AC/DC puls 8P TG	AC/DC TIG welding machine, portable, gas, decentral, 8-pole connection socket	090-000188-00504
TIG 150 GD GRIP 5P 4m	TIG welding torch, gas-cooled	394-512291-00600
TIG 200 GRIP GD 5P 8m		394-510981-00608
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 230 AC/DC Comfort 2.0 puls TM

/activArc®

Comfort 2.0

Control	**Page**	**217**
Options/accessories	**Page**	**280**

- Modular AC/DC TIG inverter welding machine, gas- or water-cooled
- Comfort 2.0 control, simple operation with click wheel
- **TIG welding**
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- Special AC welding procedure to join markedly different aluminium plates together, e.g. welding 1-mm-sheet to a 10-mm-plate
- Adjustable AC waveform, sine, trapezoidal, square current
- Adjustable AC frequency between 50 Hz and 200 Hz
- Adjustable AC balance
- Powersinus: Uniquely high welding current – 230 A from single-phase socket
- TIG automated pulsing with automatic specification of required pulse parameters
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- 8 programmed JOBs (welding tasks)
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- MMA automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Antistick function
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- **Highlights**
- Safe ignition also for long hose packages
- Gas-cooled or optionally water-cooled with cool 40 U31 cooling unit
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 4-litre water tank (cool 41U31 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- Connection capability for remote control and function torch
- Trolly 35.2-2 trolley available for delivery
- Mains connection 230 V/16 A
- High mains voltage tolerance +15%/-40% and therefore fully generator-compatible
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Open circuit voltage	45 V
Setting range for welding current	3 A - 230 A
Duty cycle 40 °C	230 A / 40 %
	200 A / 60 %
	170 A / 100 %
cos φ	1
Efficiency	85 %
Dimensions LxWxH in mm	539 x 210 x 415
Weight	22 kg
Dimensions cooling unit in mm	600 x 210 x 340
Weight, cooling unit	14 kg
Trolley dimensions L x W x H in mm	600 x 580 x 1200
Trolley weight	33 kg

Type	Designation	Item no.
Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	AC/DC TIG welding machine, portable, modular, decentral, 5-pole connection socket	090-000239-00502
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	090-000239-00504
TIG 200 GRIP GD 5P 4m	TIG welding torch, gas-cooled	394-510981-00600
TIG 200 GRIP GD 5P 8m		394-510981-00608
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	AC/DC TIG welding machine, portable, modular, decentral, 5-pole connection socket	090-000239-00502
Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	090-000239-00504
cool40 U31	Cooling unit with centrifugal pump	090-008593-00502
TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	394-510990-00600
TIG 260 GRIP WD 5P 8m		394-510990-00608
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
Trolly 35.2-2	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	090-008296-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

▶ Welding machines optionally available with different controls

Packing unit		
6x Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	Packing unit: 6x Tetrix 230 AC/DC Comfort 2.0 puls, 5-pole connection socket	092-015318-00502

Packing unit		
6x Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	Packing unit: 6x Tetrix 230 AC/DC Comfort 2.0 puls, 8-pole connection socket	092-015318-00504

Tetrix 300 AC/DC Comfort 2.0 puls TM

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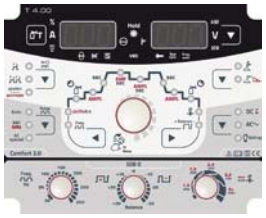
Comfort 2.0



Control	**Page**	**217**
Options/accessories	**Page**	**280**

- Modular AC/DC TIG inverter welding machine, gas- or water-cooled
- Comfort 2.0 control, simple operation with click wheel
- **TIG welding**
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- Special AC welding procedure to join markedly different aluminium plates together, e.g. welding 1-mm-sheet to a 10-mm-plate
- Adjustable AC waveform, sine, trapezoidal, square current
- Adjustable AC frequency between 30 Hz and 300 Hz
- Adjustable AC balance, pulse balance
- Automatic AC frequency
- TIG automated pulsing with automatic specification of required pulse parameters
- Metallurgical average value pulses (DC)
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- 8 programmed JOBs (welding tasks)
- Non-latched/latched operation
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- spotmatic and spotArc with direct access
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- MMA automated pulsing with automatic specification of required pulse parameters
- AC electrode welding
- Ideal for root welding
- Antistick function
- 8 programmed JOBs (welding tasks)
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- **Highlights**
- Safe ignition also for long hose packages
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 4-litre water tank (cool 41U31 cooling unit)
- Energy-saving thanks to high efficiency and standby function
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Trolly 35.2-2 trolley available for delivery
- Can be optionally connected to LAN or WiFi. Xnet-compatible
- PC interface for PC300.Net software

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	63 V
Setting range for welding current	5 A - 300 A
Duty cycle 40 °C	300 A / 35 %
	260 A / 60 %
	210 A / 100 %
cos φ	0.99
Efficiency	84 %
Dimensions LxWxH in mm	539 x 210 x 415
Weight	22 kg
Dimensions cooling unit in mm	600 x 210 x 340
Weight, cooling unit	18.4 kg
Trolley dimensions L x W x H in mm	600 x 580 x 1200
Trolley weight	33 kg

Type	Designation	Item no.
Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	AC/DC TIG welding machine, portable, modular, decentral, 5-pole connection socket	090-000235-00502
Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	AC/DC TIG welding machine, portable, modular, decentral, 8-pole connection socket	090-000235-00504
cool41 U31	Cooling unit with centrifugal pump	090-008600-00502
TIG 260 GRIP WD 5P 4m	TIG welding torch, water-cooled	394-510990-00600
TIG 260 GRIP WD 5P 8m		394-510990-00608
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
Trolly 35.2-2	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	090-008296-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Packing unit		
6x Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	Packing unit: 6x Tetrix 300 AC/DC Comfort 2.0 puls, 5-pole connection socket	092-015316-00502

Packing unit		
6x Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	Packing unit: 6x Tetrix 300 AC/DC Comfort 2.0 puls, 8-pole connection socket	092-015316-00504

Tetrix 351 ● 451 ● 551 AC/DC Smart ● Classic ● Comfort ● Synergic FW

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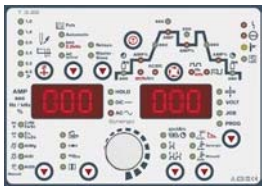
Smart

Classic

Comfort

Synergic



Control	**Page**	**217**
Options/accessories	**Page**	**280**

- Water-cooled AC/DC TIG inverter welding machine
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- Adjustable AC waveform, sine, trapezoidal, square current
- Adjustable AC frequency between 50 Hz and 200 Hz
- Adjustable AC balance
- TIG automated pulsing with automatic specification of required pulse parameters
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA-Welding/gouging**
- MMA/gouging, automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Antistick function
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- Adjustable Arcforce
- Safe ignition also for long hose packages
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Mains connection: 3 x 400 V; other mains voltages and multivolt as an option
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Crane-liftable casing
- Can be optionally networked with LAN or WiFi and EWM Xnet software
- **You will find other functions of the individual controls in the control overview**

Tetrix	351 AC/DC	451 AC/DC	551 AC/DC
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	100 V	80 V	
Setting range for welding current	5 A - 350 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	350 A / 60 %	–	550 A / 60 %
	–	450 A / 80 %	–
	300 A / 100 %	420 A / 100 %	
cos φ	0.99		
Efficiency	85 %		
Dimensions LxWxH in mm	1100 x 455 x 1000	1080 x 690 x 1195	
Weight	132 kg	181.5 kg	

Type	Designation	Item no.
Tetrix 351 AC/DC Smart FW	AC/DC TIG welding machine, mobile, water-cooled, decentral	090-000135-00502
Tetrix 351 AC/DC Classic FW		090-000107-00502
Tetrix 351 AC/DC Comfort FW		090-000108-00502
Tetrix 351 AC/DC Synergic FW		090-000109-00502
TIG 450 GRIP WD 5P 4m	TIG welding torch, water-cooled	394-510993-00600
TIG 450 GRIP WD 5P 8m		394-510993-00608
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Tetrix 451 AC/DC Smart FW	AC/DC TIG welding machine, mobile, water-cooled, decentral	090-000136-00502
Tetrix 451 AC/DC Classic FW		090-000110-00502
Tetrix 451 AC/DC Comfort FW		090-000111-00502
Tetrix 451 AC/DC Synergic FW		090-000112-00502
TIG 450 GRIP WD 5P 4m	TIG welding torch, water-cooled	394-510993-00600
TIG 450 GRIP WD 5P 8m		394-510993-00608
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Tetrix 551 AC/DC Smart FW	AC/DC TIG welding machine, mobile, water-cooled, decentral	090-000137-00502
Tetrix 551 AC/DC Classic FW		090-000113-00502
Tetrix 551 AC/DC Comfort FW		090-000114-00502
Tetrix 551 AC/DC Synergic FW		090-000115-00502
TIG 450SC GRIP 5P HFL 4m	TIG welding torch, water-cooled	394-511016-10600
TIG 450SC GRIP 5P HFL 8m		394-511016-10608
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

▶ Welding machines optionally available with different controls

Overview

TIG cold wire system, Mobile

Design	Max. welding current	Product name	Cooling	Page
	A		Water-cooled	
Demodular	350 - 550	Tetrix 351 • 451 • 551 Synergic AW FW	•	230
		Tetrix 351 • 451 • 551 AC/DC Synergic AW FW	•	234

TIG cold wire system

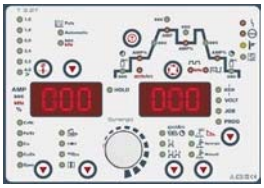
Design	Max. welding current	Product name	Cooling	Page
			Water-cooled	
Demodular		tigSpeed continuous drive 45 coldwire		232
		tigSpeed oscillation drive 45 coldwire		233

Tetrix 351 ● 451 ● 551 Synergic AW FW

/activArc®

Tetrix_drive

Synergic



Control	**Page**	**199**
Options/accessories	**Page**	**280**

- Water-cooled DC TIG cold wire inverter welding machine
- Features user database for Synergic operation at no extra charge
- Simple, menu-guided selection of welding tasks from user database
- 256 pre-programmed JOBs/characteristics in the user database
- Up to 100 % faster welding speeds compared to TIG welding
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- TIG automated pulsing with automatic specification of required pulse parameters
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- Non-latched/latched operation
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA-Welding/gouging**
- MMA/gouging, automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Antistick function
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- Adjustable Arcforce
- Safe ignition also for long hose packages
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- Mains connection: 3 x 400 V; other mains voltages and multivolt as an option
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Crane-liftable casing
- Can be optionally networked with LAN or WiFi and EWM Xnet software

Tetrix	351	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	80 V		
Setting range for welding current	5 A - 350 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–	450 A / 80 %	550 A / 60 %
	350 A / 100 %	420 A / 100 %	
cos φ	0.99		
Efficiency	88 %	90 %	
Dimensions LxWxH in mm	1100 x 680 x 1000		
Weight	134 kg		
Wire feeder, LxWxH in mm	690 x 300 x 410		
Weight, wire feeder	13.7 kg		

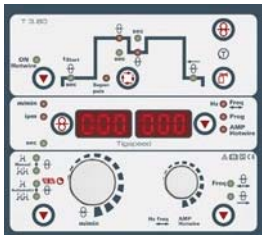
Type	Designation	Item no.
Tetrix 351 AW FW	TIG DC welding machine, mobile, water-cooled, decentral	090-000118-00505
TIG 450 GRIP WD CW U/D HFL 12P 4m flex.	TIG welding torch, cold wire, up/down	094-500094-10200
TIG 450 GRIP WD CW U/D HFL 12P 3m flex.		094-500094-10203
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TIG W 70qmm KD 28POL 2m	Intermediate hose package, water-cooled, cold wire	094-010898-R0001
TIG W 70qmm KD 28POL 5m		094-010898-R0002
TIG W 70qmm KD 28POL 10m		094-010898-R0003
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Tetrix 451 AW FW	TIG DC welding machine, mobile, water-cooled, decentral	090-000103-00505
TIG 450 GRIP WD CW U/D HFL 12P 4m flex.	TIG welding torch, cold wire, up/down	094-500094-10200
TIG 450 GRIP WD CW U/D HFL 12P 3m flex.		094-500094-10203
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TIG W 70qmm KD 28POL 2m	Intermediate hose package, water-cooled, cold wire	094-010898-R0001
TIG W 70qmm KD 28POL 5m		094-010898-R0002
TIG W 70qmm KD 28POL 10m		094-010898-R0003
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Tetrix 551 AW FW	DC TIG welding machine with connection capability for additional wire, mobile, wheel spacers, water-cooled, decentral	090-000093-00505
TIG 450 GRIP WD CW U/D HFL 12P 4m flex.	TIG welding torch, cold wire, up/down	094-500094-10200
TIG 450 GRIP WD CW U/D HFL 12P 3m flex.		094-500094-10203
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TIG W 70qmm KD 28POL 2m	Intermediate hose package, water-cooled, cold wire	094-010898-R0001
TIG W 70qmm KD 28POL 5m		094-010898-R0002
TIG W 70qmm KD 28POL 10m		094-010898-R0003
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4" 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

tigSpeed continuous drive 45 coldwire

- TIG cold wire welding
- High process reliability and reproducible welding results
- Higher welding speed and easy handling
- Perfect weld appearance, no weld spatters
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Can be used with any TIG welding machine

Wire speed m/min	0.5 m/min - 15 m/min
Mains voltage (tolerances)	1 x 230 V (-20 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Wire-feed speed increments	0.1 m/min
Roll diameter	37 mm
Wire feeder, LxWxH in mm	624 x 342 x 480
Weight, wire feeder	25 kg

T3.80



Options/accessories **Page** **280**

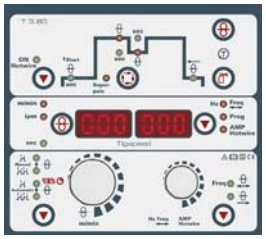
Type	Designation	Item no.
tigSpeed continuous drive 45 coldwire	TIG wire feeder	090-000237-00502
tigSpeed 95QMM W AW 5POL 2m		094-019139-00000
tigSpeed 95QMM W AW 5POL 5m	Intermediate hose package, water-cooled, filler wire, incl. strain relief	094-019139-00005
tigSpeed 95QMM W AW 5POL 10m		094-019139-00010

tigSpeed oscillation drive 45 coldwire

- TIG cold wire welding with dynamic wire feeding system
- Dynamic wire feeding for a controllable weld pool even with positional welding: The wire feeding is superimposed in parallel using a forward and backward movement
- High process reliability and reproducible welding results
- Higher welding speed and easy handling
- Perfect weld appearance, no weld spatters
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Can be used with any TIG welding machine

Wire speed m/min	0.5 m/min - 15 m/min
Mains voltage (tolerances)	1 x 230 V (-20 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Wire-feed speed increments	0.1 m/min
Oscillating frequency	1 Hz - 16 Hz
Roll diameter	37 mm
Wire feeder, LxWxH in mm	624 x 342 x 480
Weight, wire feeder	28 kg

T3.80



Options/accessories **Page** **280**

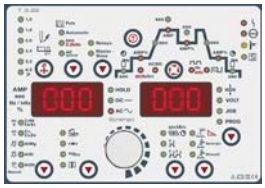
Type	Designation	Item no.
tigSpeed oscillation drive 45 coldwire	TIG wire feeder with adjustable pulse frequency	090-000181-00502
tigSpeed 95QMM W AW 5POL 2m		094-019139-00000
tigSpeed 95QMM W AW 5POL 5m	Intermediate hose package, water-cooled, filler wire, incl. strain relief	094-019139-00005
tigSpeed 95QMM W AW 5POL 10m		094-019139-00010

Tetrix 351 ● 451 ● 551 AC/DC Synergic AW FW

/activArc®

Tetrix_drive

Synergic



Control	Page	
Options/accessories	Page	280

- Water-cooled AC/DC TIG cold wire inverter welding machine
- Features user database for Synergic operation at no extra charge
- Simple, menu-guided selection of welding tasks from user database
- 256 pre-programmed JOBs/characteristics in the user database
- Up to 100 % faster welding speeds compared to TIG welding
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- Special AC welding procedure to join markedly different aluminium plates together, e.g. welding 1-mm-sheet to a 10-mm-plate
- Adjustable AC waveform, sine, trapezoidal, square current
- Adjustable AC frequency between 50 Hz and 200 Hz
- Adjustable AC balance
- TIG automated pulsing with automatic specification of required pulse parameters
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- Non-latched/latched operation
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- MMA/gouging, automated pulsing with automatic specification of required pulse parameters
- Antistick function
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- Adjustable Arcforce
- Safe ignition also for long hose packages
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Crane-liftable casing
- Can be optionally networked with LAN or WiFi and EWM Xnet software

Tetrix	351 AC/DC	451 AC/DC	551 AC/DC
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	100 V	80 V	
Setting range for welding current	5 A - 350 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	350 A / 60 %	–	550 A / 60 %
	–	450 A / 80 %	–
	300 A / 100 %	420 A / 100 %	
cos φ	0.99		
Efficiency	85 %		
Dimensions LxWxH in mm	1100 x 680 x 1000	1080 x 690 x 1195	
Weight	135 kg	184.5 kg	
Wire feeder, LxWxH in mm	690 x 300 x 410		
Weight, wire feeder	13.7 kg		

Type	Designation	Item no.
Tetrix 351 AC/DC AW FW	AC/DC TIG welding machine incl. connection capability for additional wire, mobile, water-cooled, decentral	090-000109-00505
TIG 450 GRIP WD CW U/D HFL 12P 4m flex.	TIG welding torch, cold wire, up/down	094-500094-10200
TIG 450 GRIP WD CW U/D HFL 12P 3m flex.		094-500094-10203
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TIG W 70qmm KD 28POL 2m	Intermediate hose package, water-cooled, cold wire	094-010898-R0001
TIG W 70qmm KD 28POL 5m		094-010898-R0002
TIG W 70qmm KD 28POL 10m		094-010898-R0003
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Tetrix 451 AC/DC AW FW	AC/DC TIG welding machine incl. connection capability for additional wire, mobile, water-cooled, decentral	090-000112-00505
TIG 450 GRIP WD CW U/D HFL 12P 4m flex.	TIG welding torch, cold wire, up/down	094-500094-10200
TIG 450 GRIP WD CW U/D HFL 12P 3m flex.		094-500094-10203
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TIG W 70qmm KD 28POL 2m	Intermediate hose package, water-cooled, cold wire	094-010898-R0001
TIG W 70qmm KD 28POL 5m		094-010898-R0002
TIG W 70qmm KD 28POL 10m		094-010898-R0003
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Tetrix 551 AC/DC AW FW	AC/DC TIG welding machine incl. connection capability for additional wire, mobile, water-cooled, decentral	090-000115-00505
TIG 450 GRIP WD CW U/D HFL 12P 4m flex.	TIG welding torch, cold wire, up/down	094-500094-10200
TIG 450 GRIP WD CW U/D HFL 12P 3m flex.		094-500094-10203
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TIG W 70qmm KD 28POL 2m	Intermediate hose package, water-cooled, cold wire	094-010898-R0001
TIG W 70qmm KD 28POL 5m		094-010898-R0002
TIG W 70qmm KD 28POL 10m		094-010898-R0003
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Overview

TIG hot wire system, Mobile

Design	Max. welding current	Product name	Cooling	Page
	A		Water-cooled	
Demodular	350 - 550	Tetrix 351 • 451 • 551 Synergic AW FW	•	238
		Tetrix 351 • 451 • 551 AC/DC Synergic AW FW	•	241

TIG hot wire system

Design	Max. welding current	Product name	Cooling	Page
			Water-cooled	
		Tetrix 270 Hotwire	•	246
Demodular		tigSpeed continuous drive 45 hotwire		244
		tigSpeed oscillation drive 45 hotwire		245

Tetrix 351 ● 451 ● 551 Synergic AW FW

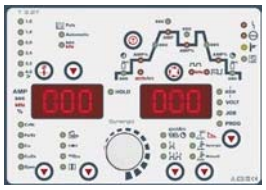
/activArc®

- Water-cooled DC TIG hot wire inverter welding machine
- Features user database for Synergic operation at no extra charge
- Simple, menu-guided selection of welding tasks from user database
- 256 pre-programmed JOBs/characteristics in the user database
- Up to 100 % faster welding speeds compared to TIG welding
- Up to 60% improvement in deposition rate
- Dilution reduced by up to 60%
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- TIG automated pulsing with automatic specification of required pulse parameters
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- Non-latched/latched operation
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA-Welding/gouging**
- MMA/gouging, automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Antistick function
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- Adjustable Arcforce
- Safe ignition also for long hose packages
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Crane-liftable casing
- Can be optionally networked with LAN or WiFi and EWM Xnet software

T3.31

Tetrix_drive

Synergic



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Options/accessories	**Page**	**280**

Tetrix	351	451	551
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	80 V		
Setting range for welding current	5 A - 350 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	–	450 A / 80 %	550 A / 60 %
	350 A / 100 %	420 A / 100 %	
cos φ	0.99		
Efficiency	88 %	90 %	
Dimensions LxWxH in mm	1100 x 680 x 1000		
Weight	134 kg		

Type	Designation	Item no.
Tetrix 351 AW FW	DC TIG welding machine with connection capability for additional wire, mobile, wheel spacers, water-cooled, decentral	090-000118-00505
TIG 450 GRIP WD HW U/D HFL 12P 4m flex.	TIG welding torch, hot wire, up/down	094-500098-10200
TIG 450 GRIP WD HW U/D HFL 12P 3m flex.		094-500098-10203
Tetrix 270 Hotwire	TIG constant-current source to pre-heat the wire, 5-270 A, portable, incl. connection cable	090-000164-00502
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TS drive 4L / HW	Support for transport for Tetrix drive 4L and Tetrix 270 Hotwire	092-000038-00001
TIG W 70qmm HW 70qmm 2m	Intermediate hose package, water-cooled, hot wire	094-015223-00001
TIG W 70qmm HW 70qmm 5m		094-015223-00002
TIG W 70qmm HW 70qmm 10m		094-015223-00003
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 451 AW FW	DC TIG welding machine with connection capability for additional wire, mobile, wheel spacers, water-cooled, decentral	090-000103-00505
TIG 450 GRIP WD HW U/D HFL 12P 4m flex.	TIG welding torch, hot wire, up/down	094-500098-10200
TIG 450 GRIP WD HW U/D HFL 12P 3m flex.		094-500098-10203
Tetrix 270 Hotwire	TIG constant-current source to pre-heat the wire, 5-270 A, portable, incl. connection cable	090-000164-00502
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TS drive 4L / HW	Support for transport for Tetrix drive 4L and Tetrix 270 Hotwire	092-000038-00001
TIG W 70qmm HW 70qmm 2m	Intermediate hose package, water-cooled, hot wire	094-015223-00001
TIG W 70qmm HW 70qmm 5m		094-015223-00002
TIG W 70qmm HW 70qmm 10m		094-015223-00003
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 551 AW FW	DC TIG welding machine with connection capability for additional wire, mobile, wheel spacers, water-cooled, decentral	090-000093-00505
TIG 450 GRIP WD HW U/D HFL 12P 4m flex.	TIG welding torch, hot wire, up/down	094-500098-10200
TIG 450 GRIP WD HW U/D HFL 12P 3m flex.		094-500098-10203
Tetrix 270 Hotwire	TIG constant-current source to pre-heat the wire, 5-270 A, portable, incl. connection cable	090-000164-00502
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TS drive 4L / HW	Support for transport for Tetrix drive 4L and Tetrix 270 Hotwire	092-000038-00001
TIG W 70qmm HW 70qmm 2m	Intermediate hose package, water-cooled, hot wire	094-015223-00001
TIG W 70qmm HW 70qmm 5m		094-015223-00002
TIG W 70qmm HW 70qmm 10m		094-015223-00003
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 351 • 451 • 551 AC/DC Synergic AW FW

/activArc®

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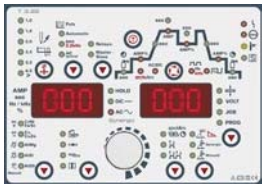
Tetrix_drive

Synergic



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- Water-cooled AC/DC TIG hot wire inverter welding machine
- Features user database for Synergic operation at no extra charge
- Simple, menu-guided selection of welding tasks from user database
- 256 pre-programmed JOBs/characteristics in the user database
- Up to 100 % faster welding speeds compared to TIG welding
- Up to 60% improvement in deposition rate
- Dilution reduced by up to 60%
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- Special AC welding procedure to join markedly different aluminium plates together, e.g. welding 1-mm-sheet to a 10-mm-plate
- Adjustable AC waveform, sine, trapezoidal, square current
- Adjustable AC frequency between 50 Hz and 200 Hz
- Adjustable AC balance
- TIG automated pulsing with automatic specification of required pulse parameters
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- Non-latched/latched operation
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- MMA/gouging, automated pulsing with automatic specification of required pulse parameters
- Antistick function
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- Adjustable Arcforce
- Safe ignition also for long hose packages
- Excellent torch cooling, resulting in cost savings on consumables due to high-performance centrifugal pump and 12-litre water tank
- Energy-saving thanks to high efficiency and standby function
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control and function torch
- Crane-liftable casing
- Can be optionally networked with LAN or WiFi and EWM Xnet software
- Easy positional welding

Tetrix	351 AC/DC	451 AC/DC	551 AC/DC
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)		
Mains fuses (slow-blow)	3 x 25 A	3 x 32 A	
Open circuit voltage	100 V	80 V	
Setting range for welding current	5 A - 350 A	5 A - 450 A	5 A - 550 A
Duty cycle 40 °C	350 A / 60 %	–	550 A / 60 %
	–	450 A / 80 %	–
	300 A / 100 %	420 A / 100 %	
cos φ	0.99		
Efficiency	85 %		
Dimensions LxWxH in mm	1100 x 680 x 1000	1080 x 690 x 1195	
Weight	135 kg	184.5 kg	

Type	Designation	Item no.
Tetrix 351 AC/DC AW FW	AC/DC TIG welding machine incl. connection capability for additional wire, mobile, water-cooled, decentral	090-000109-00505
TIG 450 GRIP WD HW U/D HFL 12P 4m flex.	TIG welding torch, hot wire, up/down	094-500098-10200
TIG 450 GRIP WD HW U/D HFL 12P 3m flex.		094-500098-10203
Tetrix 270 Hotwire	TIG constant-current source to pre-heat the wire, 5-270 A, portable, incl. connection cable	090-000164-00502
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TS drive 4L / HW	Support for transport for Tetrix drive 4L and Tetrix 270 Hotwire	092-000038-00001
TIG W 70qmm HW 70qmm 2m	Intermediate hose package, water-cooled, hot wire	094-015223-00001
TIG W 70qmm HW 70qmm 5m		094-015223-00002
TIG W 70qmm HW 70qmm 10m		094-015223-00003
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 451 AC/DC AW FW	AC/DC TIG welding machine incl. connection capability for additional wire, mobile, water-cooled, decentral	090-000112-00505
TIG 450 GRIP WD HW U/D HFL 12P 4m flex.	TIG welding torch, hot wire, up/down	094-500098-10200
TIG 450 GRIP WD HW U/D HFL 12P 3m flex.		094-500098-10203
Tetrix 270 Hotwire	TIG constant-current source to pre-heat the wire, 5-270 A, portable, incl. connection cable	090-000164-00502
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TS drive 4L / HW	Support for transport for Tetrix drive 4L and Tetrix 270 Hotwire	092-000038-00001
TIG W 70qmm HW 70qmm 2m	Intermediate hose package, water-cooled, hot wire	094-015223-00001
TIG W 70qmm HW 70qmm 5m		094-015223-00002
TIG W 70qmm HW 70qmm 10m		094-015223-00003
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Tetrix 551 AC/DC AW FW	AC/DC TIG welding machine incl. connection capability for additional wire, mobile, water-cooled, decentral	090-000115-00505
TIG 450 GRIP WD HW U/D HFL 12P 4m flex.	TIG welding torch, hot wire, up/down	094-500098-10200
TIG 450 GRIP WD HW U/D HFL 12P 3m flex.		094-500098-10203
Tetrix 270 Hotwire	TIG constant-current source to pre-heat the wire, 5-270 A, portable, incl. connection cable	090-000164-00502
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502
TS drive 4L / HW	Support for transport for Tetrix drive 4L and Tetrix 270 Hotwire	092-000038-00001
TIG W 70qmm HW 70qmm 2m	Intermediate hose package, water-cooled, hot wire	094-015223-00001
TIG W 70qmm HW 70qmm 5m		094-015223-00002
TIG W 70qmm HW 70qmm 10m		094-015223-00003
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
DM 842 Ar/CO2 230bar 30l D	Pressure regulator with manometer	394-002910-00030
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

tigSpeed continuous drive 45 hotwire

- TIG cold wire and hot wire welding
- Up to 100 % faster welding speeds compared to TIG welding
- Up to 60% improvement in deposition rate
- Dilution reduced by up to 60%
- High process reliability and reproducible welding results
- Higher welding speed and easy handling
- Heat supply to the wire for improved deposition rate and an even lower risk of weld errors
- Easy positional welding
- Perfect weld appearance, no weld spatters
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Can be used with any TIG welding machine

Wire speed m/min	0.5 m/min - 15 m/min
Mains voltage (tolerances)	1 x 230 V (-20 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Wire-feed speed increments	0.1 m/min
Hot wire current	40 A - 180 A
Roll diameter	37 mm
Wire feeder, LxWxH in mm	624 x 342 x 480
Weight, wire feeder	31.5 kg

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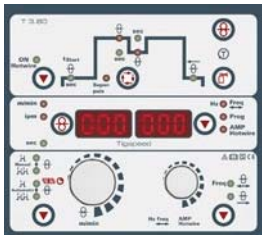

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Type	Designation	Item no.
tigSpeed continuous drive 45 hotwire	TIG wire feeder with wire preheating	090-000236-00502
tigSpeed 95QMM W AW 5POL 2m		094-019139-00000
tigSpeed 95QMM W AW 5POL 5m	Intermediate hose package, water-cooled, filler wire, incl. strain relief	094-019139-00005
tigSpeed 95QMM W AW 5POL 10m		094-019139-00010

tigSpeed oscillation drive 45 hotwire

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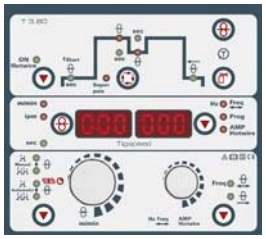

Options/accessories **Page** **280**

- TIG cold wire and hot wire welding with dynamic wire feed system
- Dynamic wire feeding for a controllable weld pool even with positional welding: The wire feeding is superimposed in parallel using a forward and backward movement
- Up to 100 % faster welding speeds compared to TIG welding
- Up to 60% improvement in deposition rate
- Dilution reduced by up to 60%
- High process reliability and reproducible welding results
- Higher welding speed and easy handling
- Heat supply to the wire for improved deposition rate and an even lower risk of weld errors
- Easy positional welding
- Perfect weld appearance, no weld spatters
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Can be used with any TIG welding machine

Wire speed m/min	0.5 m/min - 15 m/min
Mains voltage (tolerances)	1 x 230 V (-20 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Wire-feed speed increments	0.1 m/min
Hot wire current	40 A - 180 A
Duty cycle 40 °C	180 A / 35 % 150 A / 60 % 130 A / 100 %
Oscillating frequency	1 Hz - 16 Hz
Roll diameter	37 mm
Wire feeder, LxWxH in mm	624 x 342 x 480
Weight, wire feeder	34 kg

Type	Designation	Item no.
tigSpeed oscillation drive 45 hotwire	TIG wire feeder with adjustable pulse frequency and wire pre-heating	090-000180-00502
tigSpeed 95QMM W AW 5POL 2m	Intermediate hose package, water-cooled, filler wire, incl. strain relief	094-019139-00000
tigSpeed 95QMM W AW 5POL 5m		094-019139-00005
tigSpeed 95QMM W AW 5POL 10m		094-019139-00010

Tetrix 270 Hotwire

- TIG constant current source for wire preheating

Hot wire current	5 A - 270 A
Dimensions	550 x 205 x 415
Weight	20 kg

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Options/accessories **Page** **280**

Type	Designation	Item no.
Tetrix 270 Hotwire	TIG constant-current source to pre-heat the wire, 5-270 A, portable, incl. connection cable	090-000164-00502

▶ Suitable for the Textrix AW series only!

Overview

Plasma DC welding machines, Portable

Max. welding current	Product name	Cooling optional cooling unit		Page
A		Water-cooled	optional cooling unit	
20 - 120	microplasma 20 • 50 • 120	•	•	248
150	Tetrix 150 Classic • Comfort • Synergic Plasma	•	•	250

microplasma 20 ● 50 ● 120

Control Page
Options/accessories Page 280

- Inverter welding machine, DC, water-cooled
- Microplasma welding
- Portable, external water cooling (cooling unit required!)
- Flow meter
- Pilot arc current
- 5 m mains supply lead with 16 A shock-proof plug

microplasma	20	50	120
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)		
Mains fuses (slow-blow)	1 x 16 A		
Open circuit voltage	95 V		
Setting range for welding current	0.1 A - 20 A	0.1 A - 50 A	0.5 A - 120 A
Duty cycle 40 °C	–		120 A / 35 %
	20 A / 100 %	50 A / 100 %	70 A / 100 %
cos φ	0.99		
Efficiency	86 %		
Dimensions LxWxH in mm	520 x 550 x 480		
Weight	50 kg		

Type	Designation	Item no.
microplasma 20	Microplasma welding machine	090-007010-00501
FR21 14POL 5 M	Foot-operated remote control, current	094-000051-00000
UK 500	Cooling unit	090-008026-00504
PWH 100 3 M	Plasma manual welding torches	094-008232-00000
WK25mm² 230A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000016-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
2M-G1/4“+G3/8“/DIN EN 559		092-000525-00001
Maxex AR/MIX 200bar 30m³ G1/4“	Pressure regulator	096-000000-00000
Maxex Hydrogen 200bar 30m³ G3/8“L		096-000001-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
UKV4SET 4M	Hose connection set to connect a cooling unit	092-000587-00000
ADAP3 G1/4-G1/4 LKS	Threaded adapter	094-001652-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
microplasma 50	Microplasma welding machine	090-007012-00501
FR21 14POL 5 M	Foot-operated remote control, current	094-000051-00000
UK 500	Cooling unit	090-008026-00504
PWH 100 3 M	Plasma manual welding torches	094-008232-00000
WK25mm² 230A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000016-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
2M-G1/4“+G3/8“/DIN EN 559		092-000525-00001
Maxex AR/MIX 200bar 30m³ G1/4“	Pressure regulator	096-000000-00000
Maxex Hydrogen 200bar 30m³ G3/8“L		096-000001-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
UKV4SET 4M	Hose connection set to connect a cooling unit	092-000587-00000
ADAP3 G1/4-G1/4 LKS	Threaded adapter	094-001652-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

microplasma 120	Microplasma welding machine	090-007015-00502
FR21 14POL 5 M	Foot-operated remote control, current	094-000051-00000
UK 500	Cooling unit	090-008026-00504
PWH 150 4 M	Plasma manual welding torches	094-008783-00000
WK25mm² 230A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000016-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
2M-G1/4“+G3/8“/DIN EN 559		092-000525-00001
Maxex AR/MIX 200bar 30m³ G1/4“	Pressure regulator	096-000000-00000
Maxex Hydrogen 200bar 30m³ G3/8“L		096-000001-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
UKV4SET 4M	Hose connection set to connect a cooling unit	092-000587-00000
ADAP3 G1/4-G1/4 LKS	Threaded adapter	094-001652-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

▶You will find more plasma welding machines with gas control in our automated welding price list.

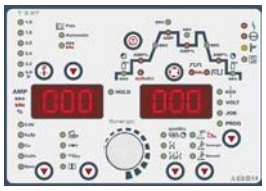
Tetrix 150 Classic ● Comfort ● Synergic Plasma

- Modular TIG DC plasma welding machine
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- TIG automated pulsing with automatic specification of required pulse parameters
- Non-latched/latched operation
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- MMA welding
- MMA automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Antistick function
- Adjustable hot start current and hot start time
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- Adjustable Arcforce
- Safe ignition also for long hose packages
- Excellent torch cooling and therefore cost saving on consumables due to high-performance centrifugal pump and 7 litre water tank (cool71 U43 cooling unit)
- Operation requires a GDE2, GDE2.1 or GDE3 gas metering unit
- High mains voltage tolerances and therefore fully generator-compatible
- Connection capability for remote control
- Trolly 70-3 DF and cool71 U43 cooling unit available
- Mains connection 3 x 400 V/16 A
- **You will find other functions of the individual controls in the control overview**

Classic

Comfort

Synergic



Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	98 V
Setting range for welding current	5 A - 150 A
Duty cycle 40 °C	150 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	1050 x 500 x 1325
Weight	158 kg

Control	**Page**	**199**
Options/accessories	**Page**	**280**

Type	Designation	Item no.
Tetrix 150 Classic Plasma	DC plasma welding machine	090-008720-00502
Tetrix 150 Comfort Plasma		090-008721-00502
Tetrix 150 Synergic Plasma		090-007024-00502
cool71 U43	Cooling unit with centrifugal pump	090-008220-00502
PWH 150 4 M	Plasma manual welding torches	094-008783-00000
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
GH 2x1/4“ 2m	Gas hose	094-000010-00001
2M-G1/4“+G3/8“/DIN EN 559		092-000525-00001
Maxex AR/MIX 200bar 30m³ G1/4“	Pressure regulator	096-000000-00000
Maxex Hydrogen 200bar 30m³ G3/8“L		096-000001-00000
Trolly 70-3 DF	Trolley for power source, 2 modules, two 33 l–50 l shielding gas cylinders	090-008159-00000
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
ADAP3 G1/4-G1/4 LKS	Threaded adapter	094-001652-00000
GDE2	Gas metering unit with 2 gas quantity meters	090-008077-00000
GDE2.1	Gas metering unit with 2 gas quantity meters	090-S08077-01033
GDE3	Gas metering unit with 3 gas quantity meters	090-008081-00000
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

▶You will find more plasma welding machines with gas control in our automated welding price list.
▶ Use the EWM plasma checklist!
These plasma systems are suitable only for manual applications up to 150 A!
Machines and accessories for automation can be found in our Automation price list.
If using a different torch, you may need other cooling units and additional thread adapters!

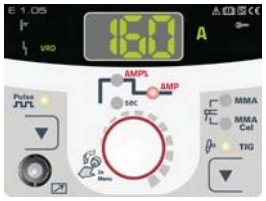
Overview

MMA DC welding machines, Portable

Design	Max. welding current	Product name	Cooling	Page
	A		optional cooling unit	
	160	Pico 160 cel puls		254
	160	Pico 162 ● Pico 162 MV		255
	180	Pico 180 puls		256
	220	Pico 220 cel puls		257
	300	Pico 300 cel ● Pico 300 cel pws		258
	350	Pico 350 cel puls ● Pico 350 cel puls pws		259
		Pico 350 cel puls pws dgs		261
Decompact	400 - 500	Taurus 405 ● 505 Basic TDM	•	262

Pico 160 cel puls

E1.05



Options/accessories Page 280

- Inverter welding machine, DC
- Very light-weight, only 4,7 kg – housing made of aluminium and impact-resistant plastic
- Portable, shoulder strap
- MMA and TIG lift arc welding
- Cellulose electrodes: 100% safe for vertical-down welding with remote control
- Welding of stick electrodes up to 4 mm
  - **Pulsed MMAwelding**:
  - especially suitable for root welding
  - outstanding gap bridging with no sagging of the root side
  - fine-flaked weld surface with a TIG look for final passes
  - less finishing work thanks to less spatter
  - ideal for difficult electrodes
  - less distortion thanks to controlled heat input
- Pulsed TIG welding with up to 2 kHz
- IP23 spray water protected
- Arcforce, hot start, antistick
- Energy efficient due to standby mode
- 3.5 m mains lead with 16 A earthed plug
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A
Open circuit voltage	94 V
Setting range for welding current	5 A - 150 A 5 A - 160 A (TIG)
Duty cycle 40 °C	150 A / 30 % 120 A / 60 % 110 A / 100 %
cos φ	0.99
Efficiency	83 %
Dimensions LxWxH in mm	370 x 129 x 236
Weight	4.7 kg

Type	Designation	Item no.
Pico 160 cel puls	MMA inverter welding machine	090-002129-00502
EH 16qmm 4m	Electrode holders	094-005800-00000
WK16mm² 170A/60% 4m/K	Welding lead	094-005801-00000
RG13 RS-453	Remote control, current	090-008113-0000
Packing unit		
12x Pico 160 cel puls	Packing unit: 12x Pico 160 cel puls	092-015320-00502

Pico 162 ● Pico 162 MV

Options/accessories Page 280

- Inverter welding machine, DC
- Portable, shoulder strap
- MMA and TIG lift arc welding
- Multivolt (MV): automatic mains voltage adaptation (115 V/230 V)
- Arcforce, hot start, antistick
- 3 m mains lead with 16 A earthed plug (except MV machine)
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**
- Contents set: power source, aluminium- framed hard case, electrode holder, welding lead, welding shield, chipping hammer, steel brush

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)	1 x 115 V (-15 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A	1 x 25 A
Open circuit voltage	105 V	
Setting range for welding current	10 A - 150 A 10 A - 160 A (TIG)	10 A - 110 A 10 A - 120 A (TIG)
Duty cycle 40 °C	150 A / 35 % 120 A / 60 % 100 A / 100 %	110 A / 35 % 90 A / 60 % 80 A / 100 %
cos φ	0.99	
Efficiency	86 %	
Dimensions LxWxH in mm	430 x 115 x 225	
Weight	5.1 kg	

Type	Designation	Item no.
SET Pico 162	MMA set: Pico 162 and welding site equipment in a case	091-002040-00502
Pico 162	MMA inverter welding machine	090-002040-00502
WK16mm² 170A/60% 4m/K	Completely assembled workpiece lead with terminal	094-005314-00000
EH 16qmm 4m	Electrode holder with cable	094-005313-00000
CBP Pico 162	Transport case, empty	094-010324-00500
Pico 162 VRD	MMA inverter welding machine with open circuit voltage reduction to AS 1674.2-2003	090-002050-00502
WK16mm² 170A/60% 4m/K	Completely assembled workpiece lead with terminal	094-005314-00000
EH 16qmm 4m	Electrode holder with cable	094-005313-00000
SET Pico 162 MV	MMA set: Pico 162 MV and welding site equipment in a case	091-002042-00502
Pico 162 MV	Multivolt MMA inverter welding machine	090-002042-00502
WK16mm² 170A/60% 4m/K	Completely assembled workpiece lead with terminal	094-005314-00000
EH 16qmm 4m	Electrode holder with cable	094-005313-00000
CBP Pico 162	Transport case, empty	094-010324-00500
Packing unit		
12x Pico162 Set	Packing unit: 12 x Pico 162 SET	092-002055-00502
Packing unit		
12x Pico162	Packing unit: 12 x Pico 162	092-002047-00502
Packing unit		
12x Pico 162 VRD	12 piece pack Pico 162 VRD	092-015247-00502
Packing unit		
12x Pico162 MV Set	Packing unit: 12 x Pico 162 SET MV	092-002059-00502
Packing unit		
12x Pico162 MV	Packing unit: 12 x Pico 162 MV	092-002058-00502

Pico 180 puls

- Inverter welding machine, DC
- Portable, shoulder strap
- MMA and TIG lift arc welding
  - **Pulsed MMAwelding**:
  - especially suitable for root welding
  - fine-flaked weld surface with a TIG look for final passes
  - less finishing work thanks to less spatter
  - ideal for difficult electrodes
  - outstanding gap bridging with no sagging of the root side
  - less distortion thanks to controlled heat input
- Connection capability for remote control
- Arcforce and hot start can be set
- 3.5 m mains supply lead
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

T1.80.2-A

Options/accessories **Page** 280

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)
Mains fuses (slow-blow)	1 x 20 A
Open circuit voltage	98 V
Setting range for welding current	5 A - 180 A
Duty cycle 40 °C	180 A / 25 % 130 A / 60 % 120 A / 100 %
cos φ	0.99
Efficiency	86 %
Dimensions LxWxH in mm	470 x 135 x 250
Weight	8.9 kg

Type	Designation	Item no.
Pico 180 puls	MMA inverter welding machine	090-002003-00502
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
EH 35qmm 4m	Electrode holder with cable	092-000052-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
Pico 180 puls VRD	MMA inverter welding machine with open circuit voltage reduction to AS 1674.2-2003	090-002051-00502
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
EH 35qmm 4m	Electrode holder with cable	092-000052-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
Packing unit		
8x Pico180	Packing unit: 8 x Pico 180 puls	092-015235-00502
Packing unit		
8x Pico 180 puls VRD	Packing unit: 8 x Pico 180 puls VRD	092-015248-00502

Pico 220 cel puls

- Inverter welding machine, DC
- Portable, shoulder strap
- MMA and TIG lift arc welding
- Cellulose electrodes: 100% safe for vertical-down welding
  - **Pulsed MMAwelding**:
  - especially suitable for root welding
  - fine-flaked weld surface with a TIG look for final passes
  - less finishing work thanks to less spatter
  - ideal for difficult electrodes
  - outstanding gap bridging with no sagging of the root side
  - less distortion thanks to controlled heat input
- Arcforce and hot start can be set
- Antistick
- 5 m mains supply lead

T1.80.3-A

Options/accessories **Page** 280

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	97 V
Setting range for welding current	10 A - 220 A
Duty cycle 40 °C	220 A / 30 %
	160 A / 60 %
	140 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	470 x 135 x 250
Weight	8.9 kg

Type	Designation	Item no.
Pico 220 cel puls	MMA inverter welding machine	090-002057-00502
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000
EH 35qmm 4m	Electrode holder with cable	092-000052-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
Packing unit		
8x Pico 220 cel puls	8 piece pack Pico 220 cel puls	092-015280-00502

Pico 300 cel ● Pico 300 cel pws

T1.22

Options/accessories Page 280

- Inverter welding machine, DC
- Portable, shoulder strap
- MMA and TIG lift arc welding
- Cellulose electrodes: 100% safe for vertical-down welding
- Arcforce and hot start can be set
- Arcforce, hot start, antistick
- Antistick
- Pole reversal on the machine or via remote control
- 5 m mains supply lead

Pico	300 cel	300 cel pws
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 16 A	
Open circuit voltage	107 V	
Setting range for welding current	10 A - 300 A	
Duty cycle 40 °C	300 A / 25 % 220 A / 60 % 170 A / 100 %	
cos φ	0.99	
Efficiency	88 %	
Dimensions LxWxH in mm	515 x 185 x 350	515 x 185 x 445
Weight	16.5 kg	23.5 kg

Type	Designation	Item no.
Pico 300 cel	MMA inverter welding machine	090-002043-00502
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
Pico 300 cel vrd 12V	MMA inverter welding machine with open circuit voltage reduction to AS 1674.2-2003	090-002043-00503
Pico 300 cel svrd 12V	MMA inverter welding machine with open circuit voltage reduction to IEC/EN 60974-1 and ГОСТ 12.2 007.8	090-002043-00504
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
Pico 300 cel pws	MMA inverter welding machine, pole reversing switch	090-002044-00502
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
Pico 300 cel pws vrd 12V	MMA inverter welding machine with open circuit voltage reduction to AS 1674.2-2003	090-002044-00503
Pico 300 cel pws svrd 12V	MMA inverter welding machine with open circuit voltage reduction to IEC/EN 60974-1 and ГОСТ 12.2 007.8	090-002044-00504
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000
Packing unit		
6x Pico 300 CEL	6-item pack, Pico 300 cel	092-002298-00502
Packing unit		
6x Pico 300 cel vrd 12V	6-item pack, Pico 300 cel VRD	092-002298-00503
Packing unit		
6x Pico 300 cel svrd 12V	6-item pack, Pico 300 cel SVRD	092-002298-00504

Pico 350 cel puls • Pico 350 cel puls pws

E1.00

Options/accessories Page 280

- Inverter welding machine, DC
- Portable, shoulder strap
- Inspected protection against splash water (IP-34s)
- Available with open circuit voltage reduction, VRD (to AS 1674.2-2003; IEC/DIN EN 60974-1 and ГОСТ 12.2 007.8)
- MMA and TIG lift arc welding
- MIG/MAG CC/CV welding with Pico drive 4L and Pico drive 200C
- Cellulose electrodes: 100% safe for vertical-down welding
  - **Pulsed MMAwelding**:
  - especially suitable for root welding
  - fine-flaked weld surface with a TIG look for final passes
  - less finishing work thanks to less spatter
  - ideal for difficult electrodes
  - outstanding gap bridging with no sagging of the root side
  - less distortion thanks to controlled heat input
- Perfect vertical-up welding through PF pulse function
- Polarity can be reversed by pressing a button (PRS)
- Arcforce, hot start time and hot start current adjustable
- Antistick
- Energy efficient due to standby mode

Pico	350 cel puls	350 cel puls pws
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A	3 x 16 A
Open circuit voltage	95 V	
Setting range for welding current	10 A - 350 A	10 A - 350 A
Duty cycle 40 °C	350 A / 35 %	350 A / 35 %
	280 A / 60 %	280 A / 60 %
	230 A / 100 %	230 A / 100 %
cos φ	0.99	0.99
Efficiency	88 %	88 %
Dimensions LxWxH in mm	600 x 205 x 415	600 x 205 x 415
Weight	23.5 kg	25 kg

Type	Designation	Item no.
Pico 350 cel puls	MMA inverter welding machine	090-002060-00502
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
Pico 350 cel puls vrd (AUS)	MMA inverter welding machine with open circuit voltage reduction to AS 1674.2-2003	090-002060-28503
Pico 350 cel puls vrd (RU)	MMA inverter welding machine with open circuit voltage reduction as per IEC/EN 60974-1 and ГОСТ 12.2	090-002060-28504
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
Pico 350 cel puls pws	MMA inverter welding machine, pole reversing switch	090-002061-00502
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000

Pico 350 cel puls pws vrd (AUS)	MMA inverter welding machine with pole reversing switch and open circuit voltage reduction to AS 1674.2-2003	090-002061-28503
Pico 350 cel puls pws vrd (RU)	MMA inverter welding machine with pole reversal and open circuit voltage reduction as per IEC/DIN EN	090-002061-28504
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000

Packing unit		
6x Pico 350 cel puls	Packing unit: 6 x Pico 350 cel puls	092-015284-00502
Packing unit		
6x Pico 350 cel puls vrd (RU)	Packing unit: 6 x Pico 350 cel puls VRD (RU)	092-015284-28504
Packing unit		
6x Pico 350 cel puls vrd (AUS)	Packing unit: 6 x Pico 350 cel puls VRD (AUS)	092-015284-28503
Packing unit		
6x Pico 350 cel puls pws	Packing unit: 6 x Pico 350 cel puls pole reversing switch	092-015285-00502
Packing unit		
6x Pico 350 cel puls pws vrd (RU)	Packing unit: 6 x Pico 350 cel puls pole reversing switch VRD (RU)	092-015285-28504
Packing unit		
6x Pico 350 cel puls pws vrd (AUS)	Packing unit: 6 x Pico 350 cel puls pole reversing switch VRD (AUS)	092-015285-28503

Pico 350 cel puls pws dgs

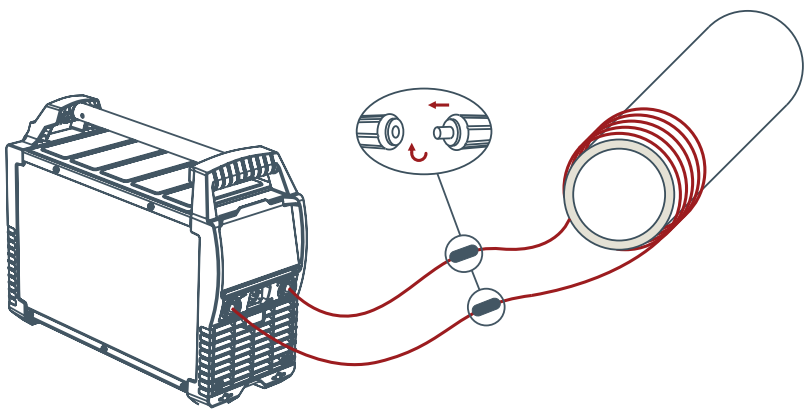
E1.00

Options/accessories **Page** **280**

- MMA inverter welding machine, polarity reversing switch, degaussing
- GMAW welding with Pico drive 4L or Pico drive 200C wire feeder
- Suitable for flux cored wire welding
- CC/CV characteristic
- Degaussing function: Automatic degaussing of pipes and metal sheets
- Stick electrode/MMA for all electrode types
- Stick electrode/MMA cellulose electrodes: 100% safe for vertical-down welding
- MMA/MMA pulse welding:
  - Particularly suitable for root welding
  - Very suitable for difficult electrodes
  - Outstanding gap bridging with no sagging of the root side
  - Less distortion due to controlled heat input
  - Less finishing work due to less spatter
  - Fine-flaked weld surface similar to a TIG look for final passes
- Welding polarity can be reversed by pressing a button (polarity reversing switch)
- Perfect vertical-up welding through PF pulse function
- Portable, shoulder strap
- Antistick function
- TIG lift arc welding
- Adjustable hot start current and hot start time
- Robust design suitable for construction site use
- Impact-resistant casing
- Inspected protection against splash water (IP-34s)
- Adjustable Arcforce
- Energy-saving thanks to high efficiency and standby function
- Mains connection 3 x 400 V/16 A
- 5 m mains supply lead

Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)
Mains fuses (slow-blow)	3 x 16 A
Open circuit voltage	95 V
Setting range for welding current	10 A - 350 A
Duty cycle 40 °C	350 A / 35 %
	280 A / 60 %
	230 A / 100 %
cos φ	0.99
Efficiency	88 %
Dimensions LxWxH in mm	600 x 205 x 415
Weight	25 kg

Type	Designation	Item no.
Pico 350 cel puls pws dgs	MMA inverter welding machine, polarity reversing switch, degaussing	090-002127-00502
Set LC 35 mm²	Set: Two 5-metre load cables (35 mm²) and one 20-metre load cable (35 mm²) for degaussing	092-002921-00000
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000
EH 50qmm 4m	Electrode holder with cable	092-000004-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000



Taurus 405 ● 505 Basic TDM

- Inverter welding machine, DC
- Gouging with up to 8 mm carbon electrodes
- Suitable for MMA welding at no extra charge
- Suitable for GMAW welding of steel/CrNi/aluminium at no extra charge
- MMA welding and gouging possible without wire feeder or remote control
- Infinitely adjustable arc dynamics (choke effect)
- Large power reserves thanks to high duty cycle with all components heating up less as a result, guaranteeing a longer service life for machines when in use
- Trolly 39-1 and Trolly 55-5 trolleys available
- Energy-saving thanks to high efficiency and standby function
- Easy, tool-free change of welding polarity
- Earth fault monitoring (PE protection)
- High mains voltage tolerances and therefore fully generator-compatible
- IP23 spray water protected
- Connection capability for remote control and function torch

Basic

Options/accessories Page 280

Taurus	405	505
Mains voltage (tolerances)	3 x 400 V (-25 % - +20 %)	
Mains fuses (slow-blow)	3 x 32 A	
Open circuit voltage	80 V	
Setting range for welding current	5 A - 400 A	5 A - 500 A
Duty cycle 40 °C	–	500 A / 60 %
	400 A / 100 %	430 A / 100 %
cos φ	0.99	
Efficiency	90 %	
Dimensions LxWxH in mm	625 x 300 x 535	
Weight	41 kg	45 kg

Type	Designation	Item no.
Taurus 405 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	090-005241-00502
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000
EH 70qmm 4m	Electrode holder with cable	092-000011-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000
Taurus 505 Basic TDM	Multiprocess MIG/MAG welding machine, decompact, portable, modular	090-005221-00502
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000
EH 95qmm 4m	Electrode holder with cable	092-000010-00000
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS27	Commissioning: 1 hour	KOS-V00027-00000

Overview

Packing units		Page
Packing units	Picomig	264
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	Picotig/Tetrix DC	266
	Picotig/Tetrix AC/DC	267
	Pico	268
	Cooling units	269
	Transport cart	269

Picomig

Type	Designation	PU Units	Item no.
6x Picomig 180 puls	Packing unit: 6 x Picomig 180 puls	6	092-015321-00502
6x Picomig 180 Synergic	Packing unit: 6 x Picomig 180 Synergic		092-015323-00502
Type	**Designation**	**PU Units**	**Item no.**
6x Picomig 185 puls	Packing unit: 6 x Picomig 185 puls	6	092-015324-00502
6x Picomig 185 Synergic	Packing unit: 6 x Picomig 185 Synergic		092-015325-00502
Type	**Designation**	**PU Units**	**Item no.**
6x Picomig 355 puls TKG	Packing unit: 6 x Picomig 355 puls	6	092-015327-00502
6x Picomig 355 Synergic TKG	Packing unit: 6 x Picomig 355 Synergic		092-015326-00502

Mira

Type	Designation	PU Units	Item no.
2x Mira 151 FKG	Packing unit: 2 x Mira 151 FKG	2	092-015238-00502
2x Mira 221 MV FKG	Packing unit: 2 x Mira 221 MV FKG		092-015239-00502
2x Mira 251 FKG	Packing unit: 2 x Mira 251 FKG		092-015240-00502
2x Mira 301 M1.02 FKG	Packing unit: 2 x Mira 301 M1.02 FKG		092-015236-00502
2x Mira 301 M2.20 FKG	Packing unit: 2 x Mira 301 M2.20 FKG		092-015263-00502
2x Mira 301 M2.40 FKG	Packing unit: 2 x Mira 301 M2.40 FKG		092-015237-00502

Type	Designation	PU Units	Item no.
2x Mira 151 FKG Set D	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 2-roll drive, ready-to-weld with MIG welding torch, workpiece lead, pressure regulator, gas hose, wire spool adapter	2	092-015242-00502
2x Mira 151 FKG Set DK/FI/NL/NO/SE			092-015242-00540
2x Mira 151 FKG Set GB			092-015242-00537
2x Mira 151 FKG Set RU			092-015242-00508

Type	Designation	PU Units	Item no.
2x Mira 221 MV FKG Set D	Step switch controlled MIG/MAG welding machine, compact, gas-cooled, Euro torch connector, 2-roll drive, ready-to-weld with MIG welding torch, workpiece lead, pressure regulator, gas hose, wire spool adapter, CEE to shock-proof plug adapter	2	092-015243-00502
2x Mira 221 MV FKG Set DK/FI/NL/NO/SE			092-015243-00540
2x Mira 221 MV FKG Set GB			092-015243-00537
2x Mira 221 MV FKG Set RU			092-015243-00508

Type	Designation	PU Units	Item no.
2x Mira 251 FKG Set D	Step switch controlled MIG/MAG welding machine, compact, gas cooled, Euro torch connector, 4-roll drive, ready-to-weld with MIG welding torch, workpiece lead, pressure regulator, gas hose, wire spool adapter	2	092-015244-00502
2x Mira 251 FKG Set DK/FI/NL/NO/SE			092-015244-00540
2x Mira 251 FKG Set GB			092-015244-00537
2x Mira 251 FKG Set RU			092-015244-00508

Type	Designation	PU Units	Item no.
2x Mira 301 M1.02 FKG Set D	Step switch controlled MIG/MAG welding machine, compact, gas cooled, Euro torch connector, 4-roll drive, ready-to-weld with MIG welding torch, workpiece lead, pressure regulator, gas hose, wire spool adapter	2	092-015245-00502
2x Mira 301 M1.02 FKG Set DK/FI/NL/NO/SE			092-015245-00540
2x Mira 301 M1.02 FKG Set GB			092-015245-00537
2x Mira 301 M1.02 FKG Set RU			092-015245-00508
2x Mira 301 M2.20 FKG Set D			092-015269-00502
2x Mira 301 M2.20 FKG Set DK/FI/NL/NO/SE			092-015269-00540
2x Mira 301 M2.20 FKG Set GB			092-015269-00537
2x Mira 301 M2.20 FKG Set RU			092-015269-00508
2x Mira 301 M2.40 FKG Set D			092-015246-00502
2x Mira 301 M2.40 FKG Set DK/FI/NL/NO/SE			092-015246-00540
2x Mira 301 M2.40 FKG Set GB			092-015246-00537
2x Mira 301 M2.40 FKG Set RU			092-015246-00508

Picotig/Tetrix DC

Type	Designation	PU Units	Item no.
8x Picotig 200 puls 5P	Packing unit: 8x Picotig 200 puls, without accessories	8	092-015276-00502

Type	Designation	PU Units	Item no.
6x Picotig 200 puls Set D	Packing unit: 6x Picotig 200 puls, TIG welding torch, workpiece lead, 2 m gas hose, pressure regulator	6	092-015277-00502
6x Picotig 200 puls Set DK/FI/NL/NO/SE			092-015277-00540
6x Picotig 200 puls Set RU			092-015277-00508
6x Picotig 200 puls Set GB			092-015277-00537
6x Picotig 200 puls Set	Packing unit: 6x Picotig 200 puls, TIG welding torch, workpiece lead, 2 m gas hose		092-015277-00539

Type	Designation	PU Pack	Item no.
8x Tetrix 200 Smart puls 5P TG	Packing unit: 8 Tetrix 200 Smart puls, 5-pole connection socket	8	092-015302-00502
8x Tetrix 200 Smart puls 8P TG	Packing unit: 8 Tetrix 200 Smart puls, 8-pole connection socket		092-015302-00504

Type	Designation	PU Pack	Item no.
8x Tetrix 200 Comfort puls 5P TG	Packing unit: 8 Tetrix 200 Comfort puls, 5-pole connection socket	8	092-015303-00502
8x Tetrix 200 Comfort puls 8P TG	Packing unit: 8 Tetrix 200 Comfort puls, 8-pole connection socket		092-015303-00504

Type	Designation	PU Units	Item no.
6x Tetrix 230 Comfort 2.0 puls 5P TM	Packing unit: 6x Tetrix 230 Comfort 2.0 puls, 5-pole connection socket	6	092-015317-00502
6x Tetrix 230 Comfort 2.0 puls 8P TM	Packing unit: 6x Tetrix 230 Comfort 2.0 puls, 8-pole connection socket		092-015317-00504

Type	Designation	PU Units	Item no.
6x Tetrix 300 Comfort 2.0 puls 5P TM	Packing unit: 6x Tetrix 300 Comfort 2.0 puls, 5-pole connection socket	6	092-015315-00502
6x Tetrix 300 Comfort 2.0 puls 8P TM	Packing unit: 6x Tetrix 300 Comfort 2.0 puls, 8-pole connection socket		092-015315-00504

Picotig/Tetrix AC/DC

Type	Designation	PU Units	Item no.
6x Picotig 200 AC/DC puls 5P	Packing unit: 6x Picotig 200 AC/DC puls, 5-pole connection socket	6	092-002719-00502
6x Picotig 200 AC/DC puls 8P	Packing unit: 6x Picotig 200 AC/DC puls, 8-pole connection socket		092-002719-00504
Type	**Designation**	**PU Units**	**Item no.**
6x Tetrix 230 AC/DC Comfort 2.0 puls 5P TM	Packing unit: 6x Tetrix 230 AC/DC Comfort 2.0 puls, 5-pole connection socket	6	092-015318-00502
6x Tetrix 230 AC/DC Comfort 2.0 puls 8P TM	Packing unit: 6x Tetrix 230 AC/DC Comfort 2.0 puls, 8-pole connection socket		092-015318-00504
Type	**Designation**	**PU Units**	**Item no.**
6x Tetrix 300 AC/DC Comfort 2.0 puls 5P TM	Packing unit: 6x Tetrix 300 AC/DC Comfort 2.0 puls, 5-pole connection socket	6	092-015316-00502
6x Tetrix 300 AC/DC Comfort 2.0 puls 8P TM	Packing unit: 6x Tetrix 300 AC/DC Comfort 2.0 puls, 8-pole connection socket		092-015316-00504

Pico

Type	Designation	PU Units	Item no.
12x Pico 160 cel puls	Packing unit: 12x Pico 160 cel puls	12	092-015320-00502
Type	**Designation**	**PU Units**	**Item no.**
12x Pico162	Packing unit: 12 x Pico 162	12	092-002047-00502
Type	**Designation**	**PU Units**	**Item no.**
12x Pico162 Set	Packing unit: 12 x Pico 162 SET	12	092-002055-00502
Type	**Designation**	**PU Units**	**Item no.**
12x Pico162 MV	Packing unit: 12 x Pico 162 MV	12	092-002058-00502
Type	**Designation**	**PU Units**	**Item no.**
12x Pico162 MV Set	Packing unit: 12 x Pico 162 SET MV	12	092-002059-00502
Type	**Designation**	**PU Units**	**Item no.**
12x Pico 162 VRD	12 piece pack Pico 162 VRD	12	092-015247-00502
Type	**Designation**	**PU Units**	**Item no.**
8x Pico180	Packing unit: 8 x Pico 180 puls	8	092-015235-00502
Type	**Designation**	**PU Units**	**Item no.**
8x Pico 180 puls VRD	Packing unit: 8 x Pico 180 puls VRD	8	092-015248-00502
Type	**Designation**	**PU Units**	**Item no.**
8x Pico 220 cel puls	8 piece pack Pico 220 cel puls	8	092-015280-00502
Type	**Designation**	**PU Units**	**Item no.**
6x Pico 300 CEL	6-item pack, Pico 300 cel	6	092-002298-00502
6x Pico 300 cel svrd 12V	6-item pack, Pico 300 cel SVRD		092-002298-00504
6x Pico 300 cel vrd 12V	6-item pack, Pico 300 cel VRD		092-002298-00503
Type	**Designation**	**PU Units**	**Item no.**
6x Pico 350 cel puls	Packing unit: 6 x Pico 350 cel puls	6	092-015284-00502
6x Pico 350 cel puls vrd (RU)	Packing unit: 6 x Pico 350 cel puls VRD (RU)		092-015284-28504
6x Pico 350 cel puls vrd (AUS)	Packing unit: 6 x Pico 350 cel puls VRD (AUS)		092-015284-28503
Type	**Designation**	**PU Units**	**Item no.**
6x Pico 350 cel puls pws	Packing unit: 6 x Pico 350 cel puls pole reversing switch	6	092-015285-00502
6x Pico 350 cel puls pws vrd (RU)	Packing unit: 6 x Pico 350 cel puls pole reversing switch VRD (RU)		092-015285-28504
6x Pico 350 cel puls pws vrd (AUS)	Packing unit: 6 x Pico 350 cel puls pole reversing switch VRD (AUS)		092-015285-28503

Cooling units

Type	Designation	PU Units	Item no.
6x cool35 U31	Packing unit: 6 x cool35 U31	6	092-015295-00502
Type	**Designation**	**PU Units**	**Item no.**
6x cool40 U31	Packing unit: 6 x cool40 U31	6	092-015283-00502
Type	**Designation**	**PU Units**	**Item no.**
6x cool41 U31	Packing unit: 6 cool41 U31	6	092-015291-00502

Transport cart

Type	Designation	PU Pack	Item no.
6x Trolly 35.2-2	Packing unit: 6 Trolly 35.2-2	6	092-015282-00000

Overview

Multivolt machines, Mobile

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Multivolt machines, Portable

Design	Max. welding current	Product name	Page
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	150 - 200	Picotig 200 MV 5P TGD	276
		Tetrix 200 MV Comfort puls TG	277

Multivolt machines

Design	Max. welding current	Product name	Page
		voltConverter 230/400	279

Multivolt – options ex works

Many EWM welding machines can be fitted with the following options for operation with different mains voltages.

Machines	Item no.	OW Multivolt 351/401/451/551	OW 440/460/480 Volt
Multiprocess MIG/MAG pulse welding machines			
		230 V 400 V 480 V	440 V 460 V 480 V
alpha Q 351 Progress puls MM FDW	090-005333-00502	•	•
alpha Q 551 Progress puls MM FDW	090-005334-00502	•	•
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	•	•
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	•	•
Phoenix 401 Progress puls MM FKW	090-005323-00502	•	•
Phoenix 501 Progress puls MM FKW	090-005324-00502	•	•
Phoenix 351 Progress puls MM FDW	090-005325-00502	•	•
Phoenix 401 Progress puls MM FDW	090-005326-00502	•	•
Phoenix 451 Progress puls MM FDW	090-005327-00502	•	•
Phoenix 551 Progress puls MM FDW	090-005328-00502	•	•
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	•	•
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	•	•
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	•	•
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	•	•
Multiprocess MIG/MAG standard welding machines			
Taurus 351 Basic FKG	090-005425-00502	•	
Taurus 401 Basic FKG	090-005426-00502	•	
Taurus 351 Basic FKW	090-005419-00502	•	
Taurus 401 Basic FKW	090-005408-00502	•	
Taurus 501 Basic FKW	090-005410-00502	•	
Taurus 401 Synergic S MM FKW	090-005339-00502	•	•
Taurus 501 Synergic S MM FKW	090-005340-00502	•	•
Taurus 351 Basic FDG	090-005389-00502	•	
Taurus 401 Basic FDG	090-005249-00502	•	
Taurus 451 Basic FDG	090-005176-00502	•	
Taurus 551 Basic FDG	090-005178-00502	•	
Taurus 351 Synergic S MM FDG	090-005341-00502	•	•
Taurus 401 Synergic S MM FDG	090-005342-00502	•	•
Taurus 451 Synergic S MM FDG	090-005343-00502	•	•
Taurus 551 Synergic S MM FDG	090-005344-00502	•	•
Taurus 351 Basic FDW	090-005390-00502	•	
Taurus 401 Basic FDW	090-005250-00502	•	
Taurus 451 Basic FDW	090-005150-00502	•	
Taurus 551 Basic FDW	090-005151-00502	•	
Taurus 351 Synergic S MM FDW	090-005345-00502	•	•
Taurus 401 Synergic S MM FDW	090-005346-00502	•	•
Taurus 451 Synergic S MM FDW	090-005347-00502	•	•
Taurus 551 Synergic S MM FDW	090-005348-00502	•	•
DC TIG welding machines			
Tetrix 351 Smart FW	090-000129-00502	•	•
Tetrix 351 Classic FW	090-000116-00502	•	•
Tetrix 351 Comfort FW	090-000117-00502	•	•

Multivolt – options ex works

Machines	Item no.	OW Multivolt 351/401/451/551	OW 440/460/480 Volt
DC TIG welding machines			
		230 V 400 V 480 V	440 V 460 V 480 V
Tetrix 351 Synergic FW	090-000118-00502	•	•
Tetrix 401 Smart FW	090-000176-00502	•	•
Tetrix 401 Classic FW	090-000177-00502	•	•
Tetrix 401 Comfort FW	090-000178-00502	•	•
Tetrix 401 Synergic FW	090-000179-00502	•	•
Tetrix 451 Smart FW	090-000130-00502	•	•
Tetrix 451 Classic FW	090-000101-00502	•	•
Tetrix 451 Comfort FW	090-000102-00502	•	•
Tetrix 451 Synergic FW	090-000103-00502	•	•
Tetrix 551 Smart FW	090-000131-00502	•	•
Tetrix 551 Classic FW	090-000091-00502	•	•
Tetrix 551 Comfort FW	090-000092-00502	•	•
Tetrix 551 Synergic FW	090-000093-00502	•	•
AC/DC TIG welding machines			
Tetrix 351 AC/DC Smart FW	090-000135-00502	•	
Tetrix 351 AC/DC Classic FW	090-000107-00502	•	
Tetrix 351 AC/DC Comfort FW	090-000108-00502	•	
Tetrix 351 AC/DC Synergic FW	090-000109-00502	•	
Tetrix 451 AC/DC Smart FW	090-000136-00502	•	•
Tetrix 451 AC/DC Classic FW	090-000110-00502	•	•
Tetrix 451 AC/DC Comfort FW	090-000111-00502	•	•
Tetrix 451 AC/DC Synergic FW	090-000112-00502	•	•
Tetrix 551 AC/DC Smart FW	090-000137-00502	•	•
Tetrix 551 AC/DC Classic FW	090-000113-00502	•	•
Tetrix 551 AC/DC Comfort FW	090-000114-00502	•	•
Tetrix 551 AC/DC Synergic FW	090-000115-00502	•	•

Description		Item no.
OW Multivolt 351/401/451/551 Multi-voltage (230 V/400 V/480 V) – factory fitting (no retrofitting)	230 V 400 V 480 V	092-002542-00001
OW 440/460/480 Volt Equipment for 355/405/505 and 351/401/451/501/551 machines for 3x 440/460/480 V mains connection (ex works only)	440 V 460 V 480 V	092-002647-00001

Multivolt – options ex works

Many EWM welding machines can be fitted with the following options for operation with different mains voltages.

Machines	Item no.	voltConverter 230/400	OW 440/460/480 Volt
Modular multiprocess MIG/MAG pulse welding machines			
Phoenix 355 Progress puls MM TDM	090-005320-00502	•	•
Phoenix 405 Progress puls MM TDM	090-005321-00502	•	•
Phoenix 505 Progress puls MM TDM	090-005322-00502	•	•
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	•	•
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	•	•
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	•	•
Modular multiprocess MIG/MAG standard welding machines			
Taurus 355 Basic TDM	090-005286-00502	•	•
Taurus 405 Basic TDM	090-005241-00502	•	•
Taurus 505 Basic TDM	090-005221-00502	•	•
Taurus 355 Synergic S MM TDM	090-005336-00502	•	•
Taurus 405 Synergic S MM TDM	090-005337-00502	•	•
Taurus 505 Synergic S MM TDM	090-005338-00502	•	•
Taurus 355 Basic TDW	090-005436-00502		•
Taurus 405 Basic TDW	090-005438-00502		•
Taurus 505 Basic TDW	090-005440-00502		•
Taurus 355 Synergic S MM TDW	090-005437-00502		•
Taurus 405 Synergic S MM TDW	090-005439-00502		•
Taurus 505 Synergic S MM TDW	090-005441-00502		•

Description		Item no.
voltConverter 230/400 Voltage converter ▶ May only be used with gas-cooled machines.		090-008800-00502
OW 440/460/480 Volt Equipment for 355/405/505 and 351/401/451/501/551 machines for 3x 440/460/480 V mains connection (ex works only)		092-002647-00001

Mira 221 MV KGE

Options/accessories Page 280

- MIG/MAG standard welding machines, step switch controlled, gas-cooled
- Mobile, compact, sturdy construction with small housing dimensions
- Multivolt – switchable from 230 V to 400 V
- M1.02: Twin-knob operation – setting of the welding voltage and wire-feed speed
- 2-roll drive, designed for 0.8 mm + 1.0 mm steel wires
- 5 m mains supply lead with CEE 16 A plug and 16 A shock-proof adapter

Mains voltage (tolerances)	1 x 230 V	2 x 400 V (-15 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A	2 x 16 A
Open circuit voltage	40 V	
Setting range for welding current	30 A - 220 A	
Duty cycle 40 °C	220 A / 15 %	
	85 A / 100 %	
Switching steps	6	
Dimensions LxWxH in mm	880 x 385 x 610	
Weight	56 kg	

Type	Designation	PU	Item no.
2x Mira 221 MV FKG	Packing unit: 2 x Mira 221 MV FKG	2	092-015239-00502

▶ Appropriate accessories see chapter MIG/MAG standard welding machines, step switch controlled, in the machine price list.

Picotig 200 MV 5P TGD

Options/accessories Page 280

- Gas-cooled DC TIG inverter welding machine
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- TIG and MMA pulse function
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Up-slope/down-slope adjustable
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- Antistick function
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Energy-saving thanks to high efficiency and standby function
- Portable, including shoulder strap
- Practical reduction of the operating elements down to the most important functions
- Mains connection 230 V/16 A
- Multivolt (MV): automatic mains voltage adaptation (115 V/230 V)
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)	1 x 115 V (-15 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A	1 x 25 A
Open circuit voltage	90 V	
Setting range for welding current	5 A - 200 A	5 A - 150 A
Duty cycle 40 °C	200 A / 25 %	–
	–	150 A / 35 %
	150 A / 60 %	120 A / 60 %
	120 A / 100 %	100 A / 100 %
Dimensions LxWxH in mm	428 x 181 x 294	
Weight	9.8 kg	
	9.8 kg	

Type	Designation	Item no.
Picotig 200 MV puls TG	TIG multivolt inverter welding machine	090-002059-00502

▶ Appropriate accessories see chapter DC TIG welding machines in the machine price list.

Tetrix 200 MV Comfort puls TG

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- Gas-cooled DC TIG inverter welding machine
- Features characteristics for EWM activArc and EWM spotArc at no extra charge
- TIG welding with reproducible, electronic HF start
- TIG lift arc welding without HF
- TIG automated pulsing with automatic specification of required pulse parameters
- Pulsed TIG welding in Hz and kHz range up to 15 kHz
- 8 programmed JOBs (welding tasks)
- Non-latched/latched operation
- Clearly structured operating panel, operating elements streamlined to feature the main TIG functions
- Reduced secondary current accessible using torch trigger
- Spot welding/tack function (spotArc/spotmatic)
- Up-slope/down-slope adjustable
- Spotmatic – halves time required for tacking
- Adjustable gas pre-flows/post-flows
- **MMA welding**
- MMA automated pulsing with automatic specification of required pulse parameters
- Ideal for root welding
- Antistick function
- Safe, reliable vertical-up and vertical-down welding
- Adjustable hot start current and hot start time
- Adjustable Arcforce
- Safe ignition also for long hose packages
- Energy-saving thanks to high efficiency and standby function
- Portable, including shoulder strap
- Connection capability for remote control and function torch
- Mains connection 230 V/16 A
- Multivolt (MV): automatic mains voltage adaptation (115 V/230 V)
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**

Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)	1 x 115 V (-15 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A	1 x 25 A
Open circuit voltage	90 V	
Setting range for welding current	5 A - 200 A	5 A - 150 A
Duty cycle 40 °C	200 A / 25 %	–
	–	150 A / 35 %
	150 A / 60 %	120 A / 60 %
	120 A / 100 %	100 A / 100 %
Dimensions LxWxH in mm	475 x 180 x 295	
Weight	11.5 kg	
	11.5 kg	

Type	Designation	Item no.
Tetrix 200 MV Comfort puls 5P TG	TIG multivolt inverter welding machine	090-000229-00502

▶ Appropriate accessories see chapter DC TIG welding machines in the machine price list.

Pico 162 MV

Options/accessories **Page** **280**

- Inverter welding machine, DC, automatic mains voltage adaptation
- Portable, shoulder strap
- MMA and TIG lift arc welding
- Multivolt (MV): automatic mains voltage adaptation (115 V/230 V)
- Arcforce, hot start, antistick
- **Overvoltage protection: No damage to machine caused if inadvertently connected to 400-V mains voltage**
- Contents set: power source, aluminium- framed hard case, electrode holder, welding lead, welding shield, chipping hammer, steel brush

Pico	162	162 MV
Mains voltage (tolerances)	1 x 230 V (-40 % - +15 %)	1 x 115 V (-15 % - +15 %)
Mains fuses (slow-blow)	1 x 16 A	1 x 25 A
Open circuit voltage	105 V	105 V
Setting range for welding current	10 A - 150 A	10 A - 110 A
Duty cycle 40 °C	150 A / 35 %	110 A / 35 %
	120 A / 60 %	90 A / 60 %
	100 A / 100 %	80 A / 100 %
Dimensions LxWxH in mm	430 x 115 x 225	430 x 115 x 225
Weight	5.1 kg	5.1 kg
	5.1 kg	5.1 kg

Type	Designation	Item no.
Pico 162 MV	Multivolt MMA inverter welding machine	090-002042-00502
SET Pico 162 MV	MMA set: Pico 162 MV and welding site equipment in a case	091-002042-00502

▶ Appropriate accessories see chapter DC MMA welding machines in the machine price list.

voltConverter 230/400

- Voltage converter for modular machines
- Allows operation with 230 V and 400 V mains voltages
- High flexibility thanks to internal switching to the required mains voltage

Mains voltage (tolerances)	3 x 230 V (-25 % - +20 %)
Secondary voltage	400 V
Dimensions LxWxH in mm	610 x 300 x 330

Type	Designation	Item no.
voltConverter 230/400	Voltage converter	090-008800-00502

▶ May only be used with gas-cooled machines.

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			Options for wire feeders	414
			Options for transport carts	419
		General accessories	General accessories	422
	Service accessories	Spare parts set	Starter equipment	428
		Test machine for repetition test	A3-SH SET	429
		Calibration device	KLE	430
	Training and qualification	Welding simulation	Welding Trainer Soldamatic	432
	Software and accessories	Software	PC software	433

Wire feed units ■ drive 4X series

drive 4 Basic

- MIG/MAG wire feeder, suitable for Taurus Basic
- Portable, optional crane attachment, water-cooled, Euro torch connector
- Suitable for 200 mm or 300 mm wire spools
- Easy transport thanks to low weight and compact design
- Standardised accessories, options and replacement parts
- Illumination of internal spaces
- Solidly-designed base of aluminium continuous casting
- Standard sliding rails
- Protected arrangement of connections for intermediate hose packages and control cables
- Non-technical personnel can change hose packages without tools
- Equipped for 1.2 mm steel, stainless steel, flux cored, and brazing wire
- eFeed: Innovative 4-roll drive (4x toothed)
  - Double ball bearings per axle
  - Fully automated wire inching until wire contacts the workpiece
  - Tool-free roller change, permanently secure roller fasteners
  - Adjustable contact pressure for each roller pair
  - Rollers colour-coded for wire diameter and material

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	660 x 280 x 380
Weight, wire feeder	12 kg

Type	Designation	Item no.
drive 4 Basic	Wire feeder, water-cooled, Euro torch connector	090-005401-00502
drive 4 Basic MMA	Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch	090-005401-51502

Suitable for:

Type	Item no.	Page
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 405 Basic TDM	090-005241-00502	141

Type	Item no.	Page
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171

Wire feed units ■ drive 4X series

drive 4X LP

- Equipped at no extra charge with Synergic characteristics for EWM forceArc and rootArc
- MIG/MAG wire feeder, suitable for alpha Q puls, Phoenix puls and Taurus Synergic S with Multimatrix technology
- Very simple operation, direct access to the most important parameters
- Portable, optional crane attachment, water-cooled, Euro torch connector
- Suitable for 200 mm or 300 mm wire spools
- Easy transport thanks to low weight and compact design
- Standardised accessories, options and replacement parts
- Illumination of internal spaces
- Solidly-designed base of aluminium continuous casting
- Standard sliding rails as well as transparent cover cap for protection of the control system
- Rugged electronics in a dust-free enclosure
- Protected arrangement of connections for intermediate hose packages and control cables
- Non-technical personnel can change hose packages without tools
- Equipped for 1.2 mm steel, stainless steel, flux cored, and brazing wire
- eFeed: Innovative 4-roll drive (4x toothed)
  - Double ball bearings per axle
  - Fully automated wire inching until wire contacts the workpiece
  - Tool-free roller change, permanently secure roller fasteners
  - Adjustable contact pressure for each roller pair
  - Rollers colour-coded for wire diameter and material
- Very simple operation for all alpha Q puls, Phoenix puls and Taurus Synergic S machines
  - JOB display: Current welding task (JOB number) visible at all times
  - Kilowatt display for calculating the energy per unit length
  - Standby function

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	660 x 280 x 380
Weight, wire feeder	13 kg

Type	Designation	Item no.
drive 4X LP	Wire feeder, water-cooled, Euro torch connector	090-005412-00502
drive 4X LP MMA	Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch	090-005412-51502

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM FDW	090-005326-00502	107

Type	Item no.	Page
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 551 S MM FDW	090-005348-00502	174

drive 4X HP

- MIG/MAG wire feeder, suitable for alpha Q puls, Phoenix puls and Taurus Synergic S with Multimatrix technology
- All welding parameters directly adjustable on wire feeder
- Portable, optional crane attachment, water-cooled, Euro torch connector
- Suitable for 200 mm or 300 mm wire spools
- Easy transport thanks to low weight and compact design
- Standardised accessories, options and replacement parts
- Illumination of internal spaces
- Solidly-designed base of aluminium continuous casting
- Equipped with key switch for locking the control as standard
- Standard sliding rails
- Rugged electronics in a dust-free enclosure
- Protected arrangement of connections for intermediate hose packages and control cables
- Non-technical personnel can change hose packages without tools
- Equipped for 1.2 mm steel, stainless steel, flux cored, and brazing wire
- eFeed: Innovative 4-roll drive (4x toothed)
  - Double ball bearings per axle
  - Fully automated wire inching until wire contacts the workpiece
  - Tool-free roller change, permanently secure roller fasteners
  - Adjustable contact pressure for each roller pair
  - Rollers colour-coded for wire diameter and material
- Universal control for all alpha Q puls, Phoenix puls and Taurus Synergic S
  - JOB display: Current welding task (JOB number) visible at all times
  - Kilowatt display for calculating the energy per unit length
  - Standby function

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	660 x 280 x 380
Weight, wire feeder	13 kg

Type	Designation	Item no.
drive 4X HP	Wire feeder, water-cooled, Euro torch connector	090-005392-00502
drive 4X HP MMA	Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch	090-005392-51502

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111

Type	Item no.	Page
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

Wire feed units ■ drive 4X series

drive 4X EX

- MIG/MAG wire feeder, suitable for alpha Q puls, Phoenix puls and Taurus Synergic S with Multimatrix technology
- Expert 2.0 control with intuitive user guidance via LCD panel and plain text display of all welding parameters and functions
- Pre-configured languages for control menu: English, German, French, Italian, Dutch, Polish, Danish, Latvian, Russian, Spanish, Czech, Brazilian Portuguese, Swedish, Turkish, Hungarian, Romanian
- USB connection and access authorisation using Xbutton
- All welding parameters directly adjustable on wire feeder
- Portable, optional crane attachment, water-cooled, Euro torch connector
- Suitable for 200 mm or 300 mm wire spools
- Easy transport thanks to low weight and compact design
- Standardised accessories, options and replacement parts
- Illumination of internal spaces
- Solidly-designed base of aluminium continuous casting
- Equipped with key switch for locking the control as standard
- Standard sliding rails
- Rugged electronics in a dust-free enclosure
- Protected arrangement of connections for intermediate hose packages and control cables
- Non-technical personnel can change hose packages without tools
- Equipped for 1.2 mm steel, stainless steel, flux cored, and brazing wire
- eFeed: Innovative 4-roll drive (4x toothed)
  - Double ball bearings per axle
  - Fully automated wire inching until wire contacts the workpiece
  - Tool-free roller change, permanently secure roller fasteners
  - Adjustable contact pressure for each roller pair
  - Rollers colour-coded for wire diameter and material

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	660 x 280 x 380
Weight, wire feeder	13.5 kg

Type	Designation	Item no.
drive 4X EX	Wire feeder, water-cooled, Euro torch connector	090-005511-00502
drive 4X EX MMA	Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch	090-005511-51502
drive 4X EX GFE	Wire feeder, water-cooled, Euro torch connector, electronic gas flow control	090-005511-55502
drive 4X EX MMA GFE	Wire feeder, water-cooled, Euro torch connector, with connection for electrode holder or gouging torch, electronic gas flow control	090-005511-60502

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111

Type	Item no.	Page
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

Wire feed units ■ drive 4X IC series

drive 4 Basic

- MIG/MAG wire feeder, suitable for Taurus Basic
- Steel housing, closed
- Robust, for tough production applications
- Equipped for 1.2 mm steel, stainless steel, flux cored, and brazing wire
- eFeed: Innovative 4-roll drive (4x toothed)
  - Double ball bearings per axle
  - Fully automated wire inching until wire contacts the workpiece
  - Tool-free roller change, permanently secure roller fasteners
  - Adjustable contact pressure for each roller pair
  - Rollers colour-coded for wire diameter and material
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	633 x 496 x 262
Weight, wire feeder	22 kg

Type	Designation	Item no.
drive 4 IC Basic	Wire feeder, water-cooled, Euro torch connector	090-005416-00502

Suitable for:

Type	Item no.	Page
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 405 Basic TDM	090-005241-00502	141

Type	Item no.	Page
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171

Wire feed units ■ drive 4X IC series

drive 4X IC LP

- MIG/MAG wire feeder, suitable for alpha Q puls, Phoenix puls and Taurus Synergic S with Multimatrix technology
- Steel housing, closed
- Robust, for tough production applications
- Very simple operation, direct access to the most important parameters
- Equipped for 1.2 mm steel, stainless steel, flux cored, and brazing wire
- eFeed: Innovative 4-roll drive (4x toothed)
  - Double ball bearings per axle
  - Fully automated wire inching until wire contacts the workpiece
  - Tool-free roller change, permanently secure roller fasteners
  - Adjustable contact pressure for each roller pair
  - Rollers colour-coded for wire diameter and material
- Very simple operation for all alpha Q puls, Phoenix puls and Taurus Synergic S machines
  - JOB display: Current welding task (JOB number) visible at all times
  - Kilowatt display for calculating the energy per unit length
  - Standby function
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	633 x 496 x 262
Weight, wire feeder	22 kg

Type	Designation	Item no.
drive 4X IC LP	Wire feeder, water-cooled, Euro torch connector	090-005415-00502

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100

Type	Item no.	Page
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 551 S MM FDW	090-005348-00502	174

drive 4X IC HP

- MIG/MAG wire feeder, suitable for alpha Q puls, Phoenix puls and Taurus Synergic S with Multimatrix technology
- Steel housing, closed
- Robust, for tough production applications
- All welding parameters directly adjustable on wire feeder
- Equipped for 1.2 mm steel, stainless steel, flux cored, and brazing wire
- eFeed: Innovative 4-roll drive (4x toothed)
  - Double ball bearings per axle
  - Fully automated wire inching until wire contacts the workpiece
  - Tool-free roller change, permanently secure roller fasteners
  - Adjustable contact pressure for each roller pair
  - Rollers colour-coded for wire diameter and material
- Universal control for all alpha Q puls, Phoenix puls and Taurus Synergic S
  - JOB display: Current welding task (JOB number) visible at all times
  - Kilowatt display for calculating the energy per unit length
  - Standby function
- Wire spool diameter up to 300 mm/D300, 200 mm/D200 possible with adapter

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	633 x 496 x 262
Weight, wire feeder	22 kg

Type	Designation	Item no.
drive 4X IC HP	Wire feeder, water-cooled, Euro torch connector	090-005414-00502

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM FDW	090-005327-00502	108

Type	Item no.	Page
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

Wire feed units ■ drive 4L series

Taurus drive 4L Basic

- Aluminium housing
- Suitable for 200 mm or 300 mm wire spools
- Easy transport thanks to low weight and compact design
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Spool diameter up to 300 mm

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	690 x 300 x 410
Weight, wire feeder	13 kg

Type	Designation	Item no.
Taurus drive 4L Basic	Wire feeder	090-005447-00502

Suitable for:

Type	Item no.	Page
Taurus 400 Basic TDG	090-005446-00502	133

Tetrix drive 4L

- Aluminium housing
- Easy transport thanks to low weight and compact design
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Spool diameter up to 300 mm

Wire speed m/min	0.2 m/min - 10 m/min
Roll diameter	37 mm
Wire feeder, LxWxH in mm	690 x 300 x 410
Weight, wire feeder	13.7 kg

Type	Designation	Item no.
Tetrix drive 4L	Wire feeder, water-cooled, Euro torch connector	090-000094-00502

Pico drive 4L

- Aluminium housing
- Suitable for 200 mm or 300 mm wire spools
- Easy transport thanks to low weight and compact design
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	690 x 300 x 410
Weight, wire feeder	13 kg

Type	Designation	Item no.
Pico drive 4L	Wire feeder	090-002121-00502

Suitable for:

Type	Item no.	Page
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132

Type	Item no.	Page
Pico 350 cel puls pws dgs	090-002127-00502	261
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132

Wire feed units ■ drive 41L series

Saturn drive 41L

- Aluminium housing
- Easy transport thanks to low weight and compact design
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Spool diameter up to 300 mm

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	690 x 300 x 410

Type	Designation	Weight, wire feeder kg	Item no.
Saturn M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	13.0	090-004995-00502
Saturn M2.20 drive 41L		15.5	090-004996-00502
Saturn M2.40 drive 41L			090-004997-00502

Suitable for:

Type	Item no.	Page
Saturn 351 FDG	090-004991-00502	187

Wega drive 41L

- Aluminium housing
- Easy transport thanks to low weight and compact design
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Spool diameter up to 300 mm

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	690 x 300 x 410

Type	Designation	Weight, wire feeder kg	Item no.
Wega M1.02 drive 41L	Wire feeder, water-cooled, Euro torch connector	15.6	090-004965-00502
Wega M2.20 drive 41L		18.2	090-004966-00502
Wega M2.40 drive 41L			090-004967-00502

Suitable for:

Type	Item no.	Page
Wega 401 FDW	090-004949-00502	194

Type	Item no.	Page
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

Wire feed units ■ drive 41 series

Saturn drive 41

- Steel housing, closed
- Robust, for tough production applications
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Spool diameter up to 300 mm

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	680 x 460 x 265
Weight, wire feeder	24 kg

Type	Designation	Item no.
Saturn M1.02 drive 41	Wire feeder, water-cooled, Euro torch connector	090-004992-00502
Saturn M2.20 drive 41		090-004993-00502
Saturn M2.40 drive 41		090-004994-00502

Suitable for:

Type	Item no.	Page
Saturn 351 FDG	090-004991-00502	187

Wega drive 41

- Steel housing, closed
- Robust, for tough production applications
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Spool diameter up to 300 mm

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	680 x 460 x 265
Weight, wire feeder	24 kg

Type	Designation	Item no.
Wega M1.02 drive 41	Wire feeder, water-cooled, Euro torch connector	090-004962-00502
Wega M2.20 drive 41		090-004963-00502
Wega M2.40 drive 41		090-004964-00502

Suitable for:

Type	Item no.	Page
Wega 401 FDG	090-004948-00502	192
Wega 401 FDW	090-004949-00502	194

Type	Item no.	Page
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

Wire feed units ■ Pico drive 200C

Pico drive 200C

- Wire feeder housing: Plastic
- Light and robust
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Spool diameter up to 200 mm

Wire speed m/min	0.5 m/min - 25 m/min
Wire speed ipm	19.68 ipm - 944.88 ipm
Roll diameter	37 mm
Wire feeder, LxWxH in mm	690 x 300 x 410
Weight, wire feeder	18 kg

Type	Designation	Item no.
Pico drive 200C	Wire feeder	090-002124-00502

Suitable for:

Type	Item no.	Page
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132

Type	Item no.	Page
Pico 350 cel puls pws dgs	090-002127-00502	261
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132

Wire feed units ■ drive 4D

drive 4X D HP

- Two welding tasks with just one power source for alternating welding of root and final passes, solid and/or flux cored wire, or a variety of materials and wire thicknesses
- The torch trigger is used for changeover between the wire feeders; no special torch or changeover on the machine required!
- Equipped for 1.2 mm steel wire
- 4-roll drive. Equipped for 1.0 mm + 1.2 mm steel wires
- Spool diameter up to 300 mm
- No changing of rollers, no torch conversion required, changeover times are greatly reduced

Wire feeder, LxWxH in mm	680 x 530 x 460
Weight, wire feeder	48 kg

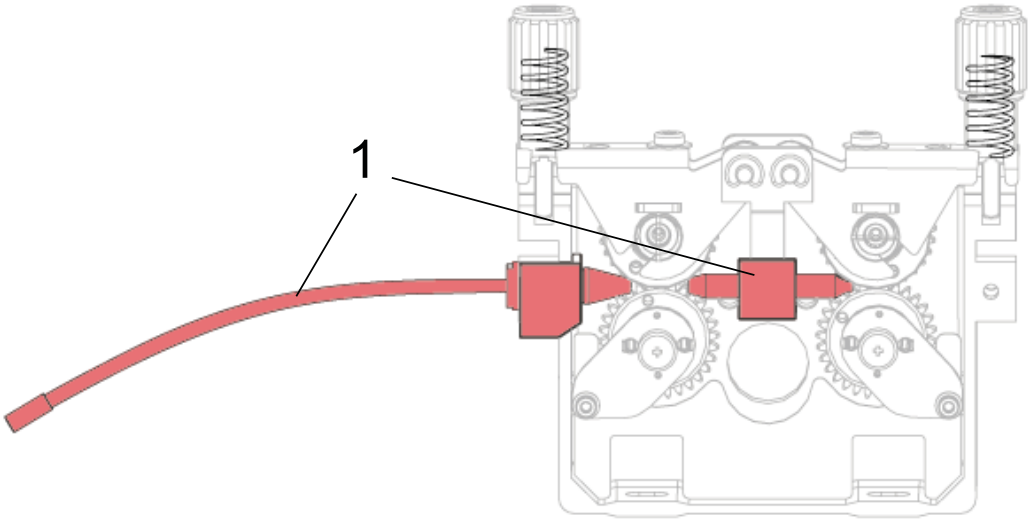
Type	Designation	Item no.
drive 4X D HP	Double wire feeder	090-005459-00502

Suitable for:

Type	Item no.	Page
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113

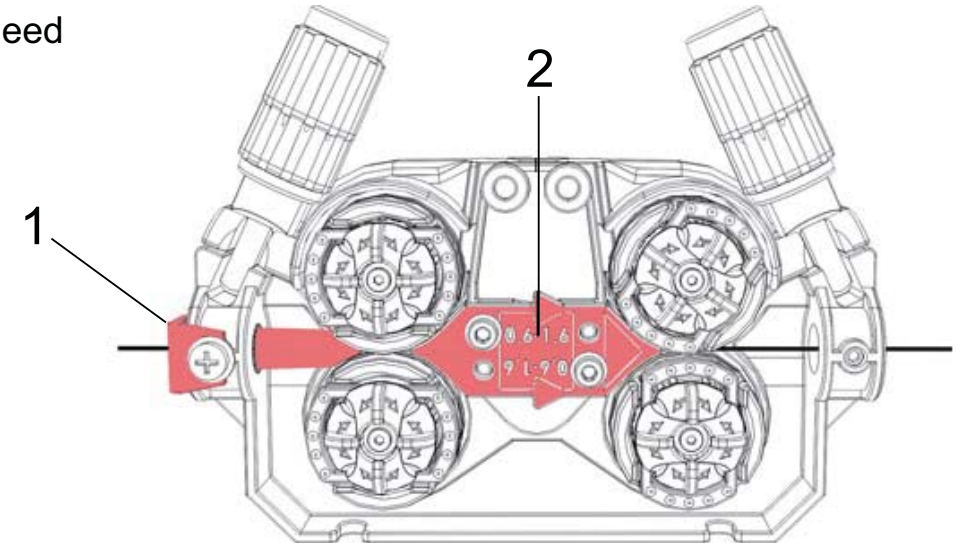
Type	Item no.	Page
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114

Wire feed units



Item	Type	Designation	Item no.
1	ON VWN	Retrofit set: Inlet guide and centre guide for aluminium wire	092-002625-00000

eFeed



Item	Type	Designation	Item no.
1	SET IG 4x4 1.6mm BL	Inlet guide set	092-002780-00000
2	SET WF 1,6mm eFeed	Wire feed set for rolls up to 1.6 mm in diameter	092-002774-00000
2	SET WF 2,0-3,2mm eFeed	Wire feed set for rolls with diameters greater than 1.6 mm	092-019404-00000

Intermediate wire feeders ■ miniDrive

miniDrive

- It is not possible to supply the miniDrive ex works with Phoenix 355 TKM, Taurus 355 TKM/TKW and Picomig 305 machines. We are happy to offer you a special solution. Please contact our Service Department if you are interested in such a solution.
- miniDrive with hose package
- A reinforced coolant pump is required for operation with hose packages featuring an overall length of 20 m or longer.
- 2-roll drive with 37 mm drive rolls. Equipped for 1.0 mm + 1.2 mm steel wires
- Hose packages length up to 25 m possible
- Large action radius for welding in hard-to-reach places
- Robust housing with small dimensions and low weight
- Setting corrections and wire inching can be carried out directly at the machine
- Intermediate hose packages for aluminium welding are only available up to a length of 15 m.

Wire speed m/min	1 m/min - 20 m/min
Welding current	400 A
Roll diameter	37 mm
Wire feeder, LxWxH in mm	302 x 176 x 196
Cross-section	70 mm²
Weight without accessories	7.5 kg

Type	Designation	Length m	Item no.
miniDrive GS 10m 70mm²	miniDrive with hose package for gas-cooled torches	10.0	090-005262-00110
miniDrive GS 15m 70mm²		15.0	090-005262-00115
miniDrive GS 20m 70mm²		20.0	090-005262-00120
miniDrive GS 25m 70mm²		25	090-005262-00125
miniDrive WS 10m 70mm²	miniDrive with hose package for water-cooled torches	10.0	090-005262-01110
miniDrive WS 15m 70mm²		15.0	090-005262-01115
miniDrive WS 20m 70mm²		20.0	090-005262-01120
miniDrive WS 25m 70mm²		25	090-005262-01125

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120

Type	Item no.	Page
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

miniDrive V+A

- miniDrive with hose package for water-cooled torches with volt and ammeter
- A reinforced coolant pump is required for operation with hose packages featuring an overall length of 20 m or longer.
- 2-roll drive with 37 mm drive rolls. Equipped for 1.0 mm + 1.2 mm steel wires
- Hose packages length up to 25 m possible
- Large action radius for welding in hard-to-reach places
- Robust housing with small dimensions and low weight
- Setting corrections and wire inching can be carried out directly at the machine
- Intermediate hose packages for aluminium welding are only available up to a length of 15 m.
- Utilisation of function torch with X technology not possible

Wire speed m/min	1 m/min - 20 m/min
Welding current	400 A
Roll diameter	37 mm
Wire feeder, LxWxH in mm	300 x 180 x 200
Weight without accessories	7.5 kg

Type	Designation	Length m	Item no.
miniDrive WS 10m 70mm² V+A	miniDrive with hose package for water-cooled welding torches with voltmeter and ammeter	10.0	090-005396-01110
miniDrive WS 15m 70mm² V+A		15.0	090-005396-01115
miniDrive WS 20m 70mm² V+A		20.0	090-005396-01120
miniDrive WS 25m 70mm² V+A		25	090-005396-01125

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111

Type	Item no.	Page
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDW	090-005348-00502	174

URUE AL 2R miniDrive

- Kit to convert from steel to aluminium

Wire dia.	1.2 mm

Type	Designation	Item no.
URUE AL 2R 10m miniDrive	Conversion kit for aluminium, consisting of two 37mm rolls, liner and mounting material	092-007906-00010
URUE AL 2R 15m miniDrive	Conversion kit, 37 mm, 2-roll drive	092-007906-00015

Runddrahtspirale CrNi

Type	Designation	Item no.
RDS 2,8x6,3 10m	CrNi round wire liner	092-002872-00010
RDS 2,8x6,3 15m		092-002872-00015
RDS 2,8x6,3 20m		092-002872-00020
RDS 2,8x6,3 25m		092-002872-00025

Wire feed rolls ■ eFeed drive rolls

0.8 mm

- Four roll set

Wire dia.	0.8 mm
Colour code	White

Type	Designation	Colour code	PU Units	groove shape	Item no.
FE 4R 0.8 MM/0.03 INCH WHITE	Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing	White	4	V-groove	092-002770-00008
AL 4R 0.8 MM/0.03 INCH WHITE/ YELLOW	Drive roll set, 37 mm, 4 rollers, U-groove for aluminium	white/yellow		U-groove	092-002771-00008
FUEL 4R 0.8 MM/0.03 INCH WHITE/ORANGE	Drive roll set, 37 mm, 4 rolls, V-groove/ knurled for flux cored wire	White/orange		V-groove/knurl	092-002848-00008

1.0 mm

- Four roll set

Wire dia.	0.9 mm - 1 mm
Colour code	Blue

Type	Designation	Colour code	PU Units	groove shape	Item no.
FE 4R 1,0 MM/0.04 INCH BLUE	Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing	Blue	4	V-groove	092-002770-00010
AL 4R 1.0 MM/0.04 INCH BLUE/ YELLOW	Drive roll set, 37 mm, 4 rollers, U-groove for aluminium	blue/yellow		U-groove	092-002771-00010
FUEL 4R 1.0 MM/0.04 INCH BLUE/ ORANGE	Drive roll set, 37 mm, 4 rolls, V-groove/ knurled for flux cored wire	Blue/orange		V-groove/knurl	092-002848-00010

1.2 mm

- Four roll set

Wire dia.	1.2 mm
Colour code	Red

Type	Designation	Colour code	PU Units	groove shape	Item no.
FE 4R 1.2 MM/0.045 INCH RED	Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing	Red	4	V-groove	092-002770-00012
AL 4R 1.2 MM/0.045 INCH RED/ YELLOW	Drive roll set, 37 mm, 4 rollers, U-groove for aluminium	red/yellow		U-groove	092-002771-00012
FUEL 4R 1.2 MM/0.045 INCH RED/ ORANGE	Drive roll set, 37 mm, 4 rolls, V-groove/ knurled for flux cored wire	Red/orange		V-groove/knurl	092-002848-00012

1.4 mm

- Four roll set

Wire dia.	1.4 mm
Colour code	Green

Type	Designation	Colour code	PU Units	groove shape	Item no.
FE 4R 1.4 MM/0.052 INCH GREEN	Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing	Green	4	V-groove	092-002770-00014
FUEL 4R 1.4 MM/0.052 INCH GREEN/ORANGE	Drive roll set, 37 mm, 4 rolls, V-groove/ knurled for flux cored wire	Green/orange		V-groove/knurl	092-002848-00014

1.6 mm

- Four roll set

Wire dia.	1.6 mm
Colour code	Black

Type	Designation	Colour code	PU Units	groove shape	Item no.
FE 4R 1.6 MM/0.06 INCH BLACK	Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing	Black	4	V-groove	092-002770-00016
AL 4R 1.6 MM/0.06 INCH BLACK/ YELLOW	Drive roll set, 37 mm, 4 rollers, U-groove for aluminium	black/yellow		U-groove	092-002771-00016
FUEL 4R 1.6 MM/0.06 INCH BLACK/ORANGE	Drive roll set, 37 mm, 4 rolls, V-groove/ knurled for flux cored wire	Black/orange		V-groove/knurl	092-002848-00016

2.0 mm

- Four roll set
- You need the SET WF 2,0-3,2 mm eFeed option to use these rolls.

Colour code	Grey

Type	Designation	Colour code	Wire dia. mm	PU Units	groove shape	PE	Item no.
FE 4R 2.0 MM/0.08 INCH GREY	Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing	Grey	0.8	4	V-groove	per PU	092-002770-00020
FUEL 4R 2.0 MM/0.08 INCH GREY/ ORANGE	Drive roll set, 37 mm, 4 rolls, V-groove/knurled for flux cored wire	Grey/ orange	2.0		V-groove/ knurl		092-002848-00020
SET WF 2,0-3,2mm eFeed	Wire feed set for rolls with diameters greater than 1.6 mm	–	–	1	–	per unit	092-019404-00000

Wire feed rolls ■ eFeed drive rolls

2.4 mm

- Four roll set
- You need the SET WF 2,0-3,2 mm eFeed option to use these rolls.

Colour code	Brown

Type	Designation	Colour code	Wire dia.	PU	groove shape	PE	Item no.
			mm	Units			
FE 4R 2.4 MM/0.095 INCH BROWN	Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing	Brown	2.4	4	V-groove	per PU	092-002770-00024
FUEL 4R 2.4 MM/0.095 INCH BROWN/ORANGE	Drive roll set, 37 mm, 4 rolls, V-groove/knurled for flux cored wire	Brown/ orange			V-groove/ knurl		092-002848-00024
SET WF 2,0-3,2mm eFeed	Wire feed set for rolls with diameters greater than 1.6 mm	–	–	1	–	per unit	092-019404-00000

2.8 mm

- Four roll set
- You need the SET WF 2,0-3,2 mm eFeed option to use these rolls.

Colour code	Light green

Type	Designation	Colour code	Wire dia.	PU	groove shape	PE	Item no.
			mm	Units			
FE 4R 2.8 MM/0.11 INCH LIGHT GREEN	Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing	Light green	2.8	4	V-groove	per PU	092-002770-00028
SET WF 2,0-3,2mm eFeed	Wire feed set for rolls with diameters greater than 1.6 mm	–	–	1	–	per unit	092-019404-00000

3.2 mm

- Four roll set
- You need the SET WF 2,0-3,2 mm eFeed option to use these rolls.

Colour code	Violet

Type	Designation	Colour code	Wire dia.	PU	groove shape	PE	Item no.
			mm	Units			
FE 4R 3.2 MM/0.12 INCH VIOLET	Drive roll set, 37 mm, 4 rolls, V-groove for steel, stainless steel and brazing	Violet	3.2	4	V-groove	per PU	092-002770-00032
SET WF 2,0-3,2mm eFeed	Wire feed set for rolls with diameters greater than 1.6 mm	–	–	1	–	per unit	092-019404-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
drive 4 Basic	090-005401-00502	281
drive 4 Basic MMA	090-005401-51502	281
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284
drive 4X EX MMA GFE	090-005511-60502	284
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85

Type	Item no.	Page
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160

Wire feed rolls ■ Drive/spare rolls

FE 2DR4R

- Spare rolls for steel wire (standard steel model)
- Includes two drive rolls

Type	Designation	Wire dia. mm	Roll diameter mm	PU Units	Item no.
FE 2DR4R 0.6+0.8	Drive roll set, 37 mm, for steel	0.6 - 0.8	37	2	092-000839-00000
FE 2DR4R 0.8+1.0		0.8 - 1			092-000840-00000
FE 2DR4R 0.9+1.2		0.9 - 1.2			092-000841-00000
FE 2DR4R 1.0+1.2		1 - 1.2			092-000842-00000
FE 2DR4R 1.2+1.6		1.2 - 1.6			092-000843-00000

▶ Wire feed rollers for Picomig 180, Saturn, Wega, drive 4L/41L, drive 41, drive 200C

Suitable for:

Type	Item no.	Page
Pico drive 200C	090-002124-00502	291
Pico drive 4L	090-002121-00502	288
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Picomig 355 TKG	090-005512-00502	125
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Saturn M1.02 drive 41	090-004992-00502	290
Saturn M1.02 drive 41L	090-004995-00502	289
Saturn M2.20 drive 41	090-004993-00502	290
Saturn M2.20 drive 41L	090-004996-00502	289
Saturn M2.40 drive 41	090-004994-00502	290
Saturn M2.40 drive 41L	090-004997-00502	289

Type	Item no.	Page
Tetrix drive 4L	090-000094-00502	288
tigSpeed continuous drive 45 coldwire	090-000237-00502	232
tigSpeed continuous drive 45 hotwire	090-000236-00502	244
tigSpeed oscillation drive 45 coldwire	090-000181-00502	233
tigSpeed oscillation drive 45 hotwire	090-000180-00502	245
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191
Wega M1.02 drive 41	090-004962-00502	290
Wega M1.02 drive 41L	090-004965-00502	289
Wega M2.20 drive 41	090-004963-00502	290
Wega M2.20 drive 41L	090-004966-00502	289
Wega M2.40 drive 41	090-004964-00502	290
Wega M2.40 drive 41L	090-004967-00502	289

FE 1DR2R

- Spare rolls for steel wire (standard steel model)
- Includes one drive roll

Type	Designation	Wire dia. mm	Roll diameter mm	Item no.
FE 1DR2R 0.6+0.8	Drive roll, 37 mm, for steel	0.6 - 0.8	37	094-003217-00000
FE 1DR2R 0.8+1.0		0.8 - 1		094-003218-00000
FE 1DR2R 1.0+1.2		1 - 1.2		094-003219-00000
FE 1DR2R 0,9+0,9		0.9		092-001107-00000
FE 1DR2R 1,0+1,0		1.0		092-001109-00000
FE 1DR2R 1.2+1.2		1.2		092-001111-00000
FE 1DR2R 1,4+1,4		1.4		094-015328-00000
FE 1DR2R 1,6+1,6		1.6		092-001113-00000

▶ Wire feed rollers for Picomig 180, Saturn, Wega, drive 4L/41L, drive 41, drive 200C

Suitable for:

Type	Item no.	Page
Mira 151 FKG	090-005084-00502	180
Mira 221 MV FKG	090-005085-00502	180

Type	Item no.	Page
Mira 251 FKG	090-005086-00502	180
Mira 301 M1.02 FKG	090-005181-00502	181
Mira 301 M2.20 FKG	090-005207-00502	182

FE/AL 2GR4R

- Spare pressure rolls, steel, standard

Roll diameter	37 mm

Type	Designation	PU Units	Item no.
FE/AL 2GR4R	Pressure rolls, smooth, 37 mm	2	092-000844-00000

▶ Wire feed rollers for Picomig 180, Saturn, Wega, drive 4L/41L, drive 41, drive 200C

Suitable for:

Type	Item no.	Page
Pico drive 200C	090-002124-00502	291
Pico drive 4L	090-002121-00502	288
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Saturn M1.02 drive 41	090-004992-00502	290
Saturn M1.02 drive 41L	090-004995-00502	289
Saturn M2.20 drive 41	090-004993-00502	290
Saturn M2.20 drive 41L	090-004996-00502	289

Type	Item no.	Page
Saturn M2.40 drive 41	090-004994-00502	290
Saturn M2.40 drive 41L	090-004997-00502	289
Tetrix drive 4L	090-000094-00502	288
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191
Wega M1.02 drive 41	090-004962-00502	290
Wega M1.02 drive 41L	090-004965-00502	289
Wega M2.20 drive 41	090-004963-00502	290
Wega M2.20 drive 41L	090-004966-00502	289
Wega M2.40 drive 41	090-004964-00502	290
Wega M2.40 drive 41L	090-004967-00502	289

AL 2ZR4R

- Replacement rolls for aluminium wire
- Includes two drive rolls

Type	Designation	Wire dia. mm	Roll diameter mm	PU Units	Item no.
AL 2ZR4R 0.8+1.0	Drive roll set, 37 mm, for aluminium	0.8 - 1	37	2	092-000873-00000
AL 2ZR4R 1.0+1.2		1 - 1.2			092-000828-00000

▶ Wire feed rollers for Picomig 180, Saturn, Wega, drive 4L/41L, drive 41, drive 200C

Suitable for:

Type	Item no.	Page
Pico drive 200C	090-002124-00502	291
Pico drive 4L	090-002121-00502	288
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Saturn M1.02 drive 41	090-004992-00502	290
Saturn M1.02 drive 41L	090-004995-00502	289
Saturn M2.20 drive 41	090-004993-00502	290
Saturn M2.20 drive 41L	090-004996-00502	289

Type	Item no.	Page
Saturn M2.40 drive 41	090-004994-00502	290
Saturn M2.40 drive 41L	090-004997-00502	289
Tetrix drive 4L	090-000094-00502	288
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191
Wega M1.02 drive 41	090-004962-00502	290
Wega M1.02 drive 41L	090-004965-00502	289
Wega M2.20 drive 41	090-004963-00502	290
Wega M2.20 drive 41L	090-004966-00502	289
Wega M2.40 drive 41	090-004964-00502	290
Wega M2.40 drive 41L	090-004967-00502	289

Wire feed rolls ■ Drive/spare rolls

AL 4ZR4R

- Replacement rolls for aluminium wire
- Includes four drive rolls

Type	Designation	Wire dia. mm	Roll diameter mm	PU Units	PE	Item no.
AL 4ZR4R 0.8+1.0	Drive roll set, 37 mm, for aluminium	0.8 - 1	37	4	per PU	092-000869-00000
AL 4ZR4R 1.0+1.2		1 - 1.2				092-000848-00000
AL 4ZR4R 1.2+1.6		1.2 - 1.6				092-000849-00000
AL 4ZR4R 2.4+3.2		2.4 - 3.2				092-000870-00000
AL-Z-RO 1,0+1,0	Twin wire feed roll, 37 mm, for aluminium	1.0		1	per unit	092-001114-00000
AL-Z-RO 1,2+1,2		1.2				092-001116-00000
AL-Z-RO 1,6+1,6		1.6				092-001118-00000

▶ Wire feed rollers for Picomig 180, Saturn, Wega, drive 4L/41L, drive 41, drive 200C

Suitable for:

Type	Item no.	Page
Pico drive 200C	090-002124-00502	291
Pico drive 4L	090-002121-00502	288
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Saturn M1.02 drive 41	090-004992-00502	290
Saturn M1.02 drive 41L	090-004995-00502	289
Saturn M2.20 drive 41	090-004993-00502	290
Saturn M2.20 drive 41L	090-004996-00502	289

Type	Item no.	Page
Saturn M2.40 drive 41	090-004994-00502	290
Saturn M2.40 drive 41L	090-004997-00502	289
Tetrix drive 4L	090-000094-00502	288
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191
Wega M1.02 drive 41	090-004962-00502	290
Wega M1.02 drive 41L	090-004965-00502	289
Wega M2.20 drive 41	090-004963-00502	290
Wega M2.20 drive 41L	090-004966-00502	289
Wega M2.40 drive 41	090-004964-00502	290
Wega M2.40 drive 41L	090-004967-00502	289

AL-Z-RO

- Replacement rolls for aluminium wire

Wire dia.	0.8 mm - 1 mm
Roll diameter	37 mm

Type	Designation	Item no.
0.8+1.0/U/AL-Z-RO/37mm	Drive roll, 37 mm, for aluminium	094-005428-00000

▶ Wire feed rollers for Picomig 180, Saturn, Wega, drive 4L/41L, drive 41, drive 200C

ROE 2DR4R

- Spare rollers flux cored wire
- Includes two drive rolls

Type	Designation	Wire dia. mm	Roll diameter mm	PU Units	Item no.
ROE 2DR4R 0.8/0.9+0.8/0.9	Drive roll set, 37 mm, for flux cored wire	0.8 - 0.9	37	2	092-000834-00000
ROE 2DR4R 1.0/1.2+1.4/1.6		1 - 1.2			092-000835-00000
ROE 2DR4R 1.4/1.6+2.0/2.4		1.4 - 1.6			092-000836-00000
ROE 2DR4R 2.8+3.2		2.8			092-000837-00000

▶ Wire feed rollers for Picomig 180, Saturn, Wega, drive 4L/41L, drive 41, drive 200C

Suitable for:

Type	Item no.	Page
Pico drive 200C	090-002124-00502	291
Pico drive 4L	090-002121-00502	288
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Saturn M1.02 drive 41	090-004992-00502	290
Saturn M1.02 drive 41L	090-004995-00502	289
Saturn M2.20 drive 41	090-004993-00502	290
Saturn M2.20 drive 41L	090-004996-00502	289

Type	Item no.	Page
Saturn M2.40 drive 41	090-004994-00502	290
Saturn M2.40 drive 41L	090-004997-00502	289
Tetrix drive 4L	090-000094-00502	288
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191
Wega M1.02 drive 41	090-004962-00502	290
Wega M1.02 drive 41L	090-004965-00502	289
Wega M2.20 drive 41	090-004963-00502	290
Wega M2.20 drive 41L	090-004966-00502	289
Wega M2.40 drive 41	090-004964-00502	290
Wega M2.40 drive 41L	090-004967-00502	289

ROE 2GR4R

- Replacement pressure rollers for flux cored wire

Roll diameter	37 mm

Type	Designation	Item no.
ROE 2GR4R	Pressure roll, knurled, 37 mm	092-000838-00000

▶ Wire feed rollers for Picomig 180, Saturn, Wega, drive 4L/41L, drive 41, drive 200C

Suitable for:

Type	Item no.	Page
Pico drive 200C	090-002124-00502	291
Pico drive 4L	090-002121-00502	288
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Saturn M1.02 drive 41	090-004992-00502	290
Saturn M1.02 drive 41L	090-004995-00502	289
Saturn M2.20 drive 41	090-004993-00502	290
Saturn M2.20 drive 41L	090-004996-00502	289

Type	Item no.	Page
Saturn M2.40 drive 41	090-004994-00502	290
Saturn M2.40 drive 41L	090-004997-00502	289
Tetrix drive 4L	090-000094-00502	288
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191
Wega M1.02 drive 41	090-004962-00502	290
Wega M1.02 drive 41L	090-004965-00502	289
Wega M2.20 drive 41	090-004963-00502	290
Wega M2.20 drive 41L	090-004966-00502	289
Wega M2.40 drive 41	090-004964-00502	290
Wega M2.40 drive 41L	090-004967-00502	289

Wire feed rolls ■ Conversion kits

URUE FE/AL 4R

- Conversion to steel standard from optional alu or flux cored wire, without drive rolls
- Includes 2 pressure rollers and 2 spacer rings

Roll diameter	37 mm

Type	Designation	Item no.
URUE VERZ>UNVERZ FE/AL 4R	Conversion kit, 37 mm steel/Alu	092-000845-00000

Suitable for:

Type	Item no.	Page
Pico drive 4L	090-002121-00502	288
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Saturn M1.02 drive 41	090-004992-00502	290
Saturn M1.02 drive 41L	090-004995-00502	289
Saturn M2.20 drive 41	090-004993-00502	290
Saturn M2.20 drive 41L	090-004996-00502	289
Saturn M2.40 drive 41	090-004994-00502	290

Type	Item no.	Page
Saturn M2.40 drive 41L	090-004997-00502	289
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191
Wega M1.02 drive 41	090-004962-00502	290
Wega M1.02 drive 41L	090-004965-00502	289
Wega M2.20 drive 41	090-004963-00502	290
Wega M2.20 drive 41L	090-004966-00502	289
Wega M2.40 drive 41	090-004964-00502	290
Wega M2.40 drive 41L	090-004967-00502	289

URUE AL 4ZR4R

- Sets for conversion from steel standard to optional alu
- Includes 4 drive rolls and 2 gears

Type	Designation	Wire dia. mm	Roll diameter mm	Item no.
URUE AL 4ZR4R 0.8+1.0	Conversion kit, 37 mm, 4-roll drive for aluminium	0.8 - 1	37	092-000867-00000
URUE AL 4ZR4R 1.0+1.2		1 - 1.2		092-000846-00000
URUE AL 4ZR4R 1.2+1.6		1.2 - 1.6		092-000847-00000
URUE AL 4ZR4R 2.4+3.2		2.4 - 3.2		092-000868-00000
URUE AL 4ZR4R 1.0+1.0		1.0		092-001115-00000
URUE AL 4ZR4R 1.2+1.2		1.2		092-001117-00000
URUE AL 4ZR4R 1.6+1.6		1.6		092-001119-00000

Suitable for:

Type	Item no.	Page
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Saturn M1.02 drive 41	090-004992-00502	290
Saturn M1.02 drive 41L	090-004995-00502	289
Saturn M2.20 drive 41	090-004993-00502	290
Saturn M2.20 drive 41L	090-004996-00502	289
Saturn M2.40 drive 41	090-004994-00502	290
Saturn M2.40 drive 41L	090-004997-00502	289

Type	Item no.	Page
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191
Wega M1.02 drive 41	090-004962-00502	290
Wega M1.02 drive 41L	090-004965-00502	289
Wega M2.20 drive 41	090-004963-00502	290
Wega M2.20 drive 41L	090-004966-00502	289
Wega M2.40 drive 41	090-004964-00502	290
Wega M2.40 drive 41L	090-004967-00502	289

URUE ROE 2DR4R

- Sets for conversion from steel standard to optional flux cored wire
- Includes two drive rolls, two pressure rolls and two gears

Type	Designation	Wire dia. mm	Roll diameter mm	Item no.
URUE ROE 2DR4R 0.8/0.9+0.8/0.9	Conversion kit, 37 mm, 4-roll drive for flux cored wire	0.8 - 0.9	37	092-000830-00000
URUE ROE 2DR4R 1.0/1.2+1.4/1.6		1 - 1.2		092-000831-00000
URUE ROE 2DR4R 1.4/1.6+2.0/2.4		1.4 - 1.6		092-000832-00000
URUE ROE 2DR4R 2.8+3.2		2.8		092-000833-00000

Suitable for:

Type	Item no.	Page
Pico drive 4L	090-002121-00502	288
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Saturn M1.02 drive 41	090-004992-00502	290
Saturn M1.02 drive 41L	090-004995-00502	289
Saturn M2.20 drive 41	090-004993-00502	290
Saturn M2.20 drive 41L	090-004996-00502	289
Saturn M2.40 drive 41	090-004994-00502	290

Type	Item no.	Page
Saturn M2.40 drive 41L	090-004997-00502	289
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191
Wega M1.02 drive 41	090-004962-00502	290
Wega M1.02 drive 41L	090-004965-00502	289
Wega M2.20 drive 41	090-004963-00502	290
Wega M2.20 drive 41L	090-004966-00502	289
Wega M2.40 drive 41	090-004964-00502	290
Wega M2.40 drive 41L	090-004967-00502	289

URUE AL 4ZR4R SF

- Sets for conversion from steel standard to optional alu
- Includes 4 twin rollers, 2 gears and 2 spacer rings

Type	Designation	Wire dia. mm	Roll diameter mm	Item no.
URUE AL 4ZR4R 0.8+1.0 SF	Conversion kit, 37 mm, 4-roll drive for aluminium	0.8	37	092-002268-00000
URUE AL 4ZR4R 1.0+1.2 SF		1.0		092-002266-00000
URUE AL 4ZR4R 1.2-1.6 SF		1.2		092-002269-00000
URUE AL 4ZR4R 2.4-3.2 SF		2.4		092-002270-00000

Suitable for:

Type	Item no.	Page
Pico drive 200C	090-002124-00502	291
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Tetrix drive 4L	090-000094-00502	288

Type	Item no.	Page
tigSpeed continuous drive 45 coldwire	090-000237-00502	232
tigSpeed continuous drive 45 hotwire	090-000236-00502	244
tigSpeed oscillation drive 45 coldwire	090-000181-00502	233
tigSpeed oscillation drive 45 hotwire	090-000180-00502	245

Wire feed rolls ■ Conversion kits

URUE ROE 2DR4R SF

- Sets for conversion from steel standard to optional flux cored wire
- Includes 2 twin rolls, 2 gears, 2 pressure rolls and 2 spacer rings

Type	Designation	Wire dia.	Roll diameter	Item no.
		mm	mm	
URUE ROE 2DR4R 0.8/0.9+0.8/0.9 SF	Conversion kit, 37 mm, 4-roll drive for flux cored wire	0.8 - 0.9	37	092-000410-00000
URUE ROE 2DR4R 1.0/1.2+1.4/1.6 SF		1 - 1.2		092-000411-00000
URUE ROE 2DR4R 1.4/1.6+2.0/2.4 SF		1.4 - 1.6		092-000412-00000

Suitable for:

Type	Item no.	Page
Pico drive 200C	090-002124-00502	291
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Tetrix drive 4L	090-000094-00502	288

Type	Item no.	Page
tigSpeed continuous drive 45 coldwire	090-000237-00502	232
tigSpeed continuous drive 45 hotwire	090-000236-00502	244
tigSpeed oscillation drive 45 coldwire	090-000181-00502	233
tigSpeed oscillation drive 45 hotwire	090-000180-00502	245

Overview of use of guide tubes and capillary tubes

On delivery, the machine's Euro torch connector is fitted with a capillary tube for torches with steel liners. Conversion of the torch connector is necessary if a welding torch with plastic liner is used!
Welding torch with plastic liner: use Euro torch connector with guide tube!
Welding torch with steel liner: use Euro torch connector with capillary tube!

	Capillary tubes	Guide tubes
Compact machines (machines with integrated wire feeder)	094-006634-00000 (< 1,6 mm Ø) 094-021470-00000 (> 1,6 mm Ø)	
Phoenix / Taurus xx5	●	094-020064-00000
Phoenix / Taurus xx1	●	094-020064-00000
Mira	094-014186-00000 (< 1,6 mm Ø)	094-019350-00000
Saturn	●	094-006051-00000
Wega	●	094-006051-00000
Picomig 180	094-014667-00000 (< 2,0 mm Ø)	094-018316-00000
Picomig 185/305	●	094-020064-00000

	Capillary tubes	Guide tubes
Wire feeders	094-006634-00000 (< 1,6 mm Ø) 094-021470-00000 (> 1,6 mm Ø)	
drive 4X	●	094-020064-00000
drive 4L / 41L	094-002559-00000 (< 1,6 mm Ø) 094-007515-00000 (> 1,6 mm Ø)	094-001064-00000
drive 4	●	094-020064-00000
drive 41	●	094-006051-00000

Capillary tube

Type	Designation	PU Units	Version	Item no.
CAPTUB L=107 mm; Ø ≤ 1,6 mm	Capillary tube	5	Wire diameter ≤ 1.6 mm	094-006634-00000
CAPTUB L=105 mm; Ø ≤ 2,4 mm			Wire diameter ≤ 2.4 mm	094-021470-00000
CAPTUB L=118 mm; Ø ≤ 1,6 mm			Wire diameter ≤ 1.6 mm	094-002559-00000
CAPTUB L=118 mm; Ø ≤ 2,0 mm			Wire diameter ≤ 2.0 mm	094-007515-00000
CAPTUB L=48 mm Ø ≤ 1,6 mm			Wire diameter ≤ 1.6 mm	094-014186-00000
CAPTUB L=69 mm; Ø ≤ 2,0 mm			Wire diameter ≤ 2.0 mm	094-014667-00000

Guide tube

Type	Designation	Item no.
GuideTube L=45 mm, Ø 4,4 x 5 mm	Guide tube	094-019350-00000
GuideTube L=66 mm, Ø 4,4 x 5 mm		094-018316-00000
GuidTub L=105 mm, Ø 4,4 x 5 mm		094-006051-00000
GuidTub L=115 mm, Ø 4,4 x 5 mm		094-001064-00000

Dimensioning of welding leads for EWM machines

Cable cross-section	Current measured at 100% duty cycle as per EN 60974-9	Current measured at 60% duty cycle
mm²	I/A	I/A
10	100	120
16	135	170
25	180	230
35	225	290
50	285	350
70	355	450
95	430	550
120	500	640
150	580	750
185	665	850

- EWM machines do not present problems when they have long lead lengths thanks to their high power reserves.
  There is thus no need to adapt the cable cross-section for hose package lengths supplied as standard.
- The thermal dimensioning is determined as per EN 60974-9, based on specifications for 100% welding current. The currents for other duty cycles are calculated based on 100%-values with an unvarying root-mean-square value for the current.
- The hose packages recommended in our documentation are based on many years' experience using our machines and represent a weight- and cost-optimised recommendation.
  However, hose packages and earth leads with larger cross-sections can also be used on machines on the customer's request.

Intermediate hose packages ■ Gas-cooled

MIG G 7POL 50qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	50 mm²
Max. welding current	350 A

Type	Designation	Hose package length	Item no.
		m	
MIG G 7POL 50qmm 350A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	1.0	094-000579-00000
MIG G 7POL 50qmm 350A/60% 5m		5.0	094-000579-00001
MIG G 7POL 50qmm 350A/60% 10m		10.0	094-000579-00002

Suitable for:

Type	Item no.	Page
Saturn 351 FDG	090-004991-00502	187

MIG G 19POL 50qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	50 mm²
Max. welding current	350 A

Type	Designation	Hose package length	Item no.
		m	
MIG G 19POL 50qmm 350A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	1.0	094-011451-00000
MIG G 19POL 50qmm 350A/60% 5m		5.0	094-011451-00001
MIG G 19POL 50qmm 350A/60% 10m		10.0	094-011451-00002

MIG G 7POL 70qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	70 mm²
Max. welding current	450 A

Type	Designation	Hose package length m	Item no.
MIG G 7POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	1.0	094-000580-00000
MIG G 7POL 70qmm 450A/60% 5m		5.0	094-000580-00001
MIG G 7POL 70qmm 450A/60% 10m		10.0	094-000580-00002
MIG G 7POL 70qmm 450A/60% 15m		15.0	094-000580-00005
MIG G 7POL 70qmm 450A/60% 20m		20.0	094-000580-00003
MIG G 7POL 70qmm 450A/60% 30m		30	094-000580-00006

Suitable for:

Type	Item no.	Page
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 401 S MM FDG	090-005342-00502	167

Type	Item no.	Page
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Wega 401 FDG	090-004948-00502	192

MIG G 19POL 70qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	70 mm²
Max. welding current	450 A

Type	Designation	Hose package length m	Item no.
MIG G 19POL 70qmm 450A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	1.0	094-011063-00000
MIG G 19POL 70qmm 450A/60% 5m		5.0	094-011063-00001
MIG G 19POL 70qmm 450A/60% 10m		10.0	094-011063-00002
MIG G 19POL 70qmm 450A/60% 15m		15.0	094-011063-00004
MIG G 19POL 70qmm 450A/60% 20m		20.0	094-011063-00003
MIG G 19POL 70qmm 450A/60% 30m		30	094-011063-00006

Suitable for:

Type	Item no.	Page
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws dgs	090-002127-00502	261
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132

Type	Item no.	Page
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 400 Basic TDG	090-005446-00502	133
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 451 Basic FDG	090-005176-00502	164

Intermediate hose packages ■ Gas-cooled

MIG G 7POL 95qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	95 mm²
Max. welding current	550 A

Type	Designation	Hose package length m	Item no.
MIG G 7POL 95qmm 550A/60% 1m	Intermediate hose package, gas-cooled, 7-pole	1.0	094-007726-00000
MIG G 7POL 95qmm 550A/60% 5m		5.0	094-007726-00001
MIG G 7POL 95qmm 550A/60% 10m		10.0	094-007726-00002
MIG G 7POL 95qmm 550A/60% 15m		15.0	094-007726-00003
MIG G 7POL 95qmm 550A/60% 20m		20.0	094-007726-00004
MIG G 7POL 95qmm 550A/60% 30m		30	094-007726-00005
MIG G 7POL 95qmm 550A/60% 40m		40	094-007726-00007

Suitable for:

Type	Item no.	Page
Taurus 505 S MM TDM	090-005338-00502	143

Type	Item no.	Page
Taurus 551 S MM FDG	090-005344-00502	168

MIG G 19POL 95qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	95 mm²
Max. welding current	550 A

Type	Designation	Hose package length m	Item no.
MIG G 19POL 95qmm 550A/60% 1m	Intermediate hose package, gas-cooled, 19-pole	1.0	094-011091-00000
MIG G 19POL 95qmm 550A/60% 5m		5.0	094-011091-00001
MIG G 19POL 95qmm 550A/60% 10m		10.0	094-011091-00002
MIG G 19POL 95qmm 550A/60% 15m		15.0	094-011091-00005
MIG G 19POL 95qmm 550A/60% 20m		20.0	094-011091-00003
MIG G 19POL 95qmm 550A/60% 30m		30	094-011091-00004
MIG G 19POL 95qmm 550A/60% 40m		40	094-011091-00006

Suitable for:

Type	Item no.	Page
Taurus 505 Basic TDM	090-005221-00502	141

Type	Item no.	Page
Taurus 551 Basic FDG	090-005178-00502	165

Intermediate hose packages ■ Water-cooled

MIG W 7POL 50qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Coolant lines marked in colour
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	50 mm²
Max. welding current	350 A

Type	Designation	Hose package length	Item no.
		m	
MIG W 7POL 50qmm 350A/60% 1m	Intermediate hose package, water-cooled, 7-pole	1.0	094-000405-00000
MIG W 7POL 50qmm 350A/60% 5m		5.0	094-000405-00001
MIG W 7POL 50qmm 350A/60% 10m		10.0	094-000405-00002
MIG W 7POL 50qmm 350A/60% 15m		15.0	094-000405-00003

MIG W 19POL 50qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Coolant lines marked in colour
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	50 mm²
Max. welding current	350 A

Type	Designation	Hose package length	Item no.
		m	
MIG W 19POL 50qmm 350A/60% 1m	Intermediate hose package, water-cooled, 19-pole	1.0	094-011450-00000
MIG W 19POL 50qmm 350A/60% 5m		5.0	094-011450-00001
MIG W 19POL 50qmm 350A/60% 10m		10.0	094-011450-00002

Intermediate hose packages ■ Water-cooled

MIG W 7POL 70qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Coolant lines marked in colour
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	70 mm²
Max. welding current	450 A

Type	Designation	Hose package length m	Item no.
MIG W 7POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 7-pole	1.0	094-000406-00000
MIG W 7POL 70qmm 450A/60% 5m		5.0	094-000406-00001
MIG W 7POL 70qmm 450A/60% 10m		10.0	094-000406-00002
MIG W 7POL 70qmm 450A/60% 15m		15.0	094-000406-00004
MIG W 7POL 70qmm 450A/60% 20m		20.0	094-000406-00005
MIG W 7POL 70qmm 450A/60% 30m		30	094-000406-00006

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116

Type	Item no.	Page
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDW	090-005347-00502	174
Wega 401 FDW	090-004949-00502	194

MIG W 19POL 70qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Coolant lines marked in colour
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	70 mm²
Max. welding current	450 A

Type	Designation	Hose package length m	Item no.
MIG W 19POL 70qmm 450A/60% 1m	Intermediate hose package, water-cooled, 19-pole	1.0	094-009082-00000
MIG W 19POL 70qmm 450A/60% 5m		5.0	094-009082-00001
MIG W 19POL 70qmm 450A/60% 10m		10.0	094-009082-00002
MIG W 19POL 70qmm 450A/60% 15m		15.0	094-009082-00004
MIG W 19POL 70qmm 450A/60% 20m		20.0	094-009082-00005
MIG W 19POL 70qmm 450A/60% 30m		30	094-009082-00006

Suitable for:

Type	Item no.	Page
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 355 Basic TDW	090-005436-00502	145

Type	Item no.	Page
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 451 Basic FDW	090-005150-00502	171

TIG W 70qmm KD 28POL

Cross-section	70 mm²
Max. welding current	450 A

Type	Designation	Hose package length m	Item no.
TIG W 70qmm KD 28POL 2m	Intermediate hose package, water-cooled, cold wire	2.0	094-010898-R0001
TIG W 70qmm KD 28POL 5m		5.0	094-010898-R0002
TIG W 70qmm KD 28POL 10m		10.0	094-010898-R0003

Suitable for:

Type	Item no.	Page
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 451 AC/DC AW FW	090-000112-00505	235

Type	Item no.	Page
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AW FW	090-000093-00505	231

Intermediate hose packages ■ Water-cooled

TIG W 70qmm HW 28POL

Cross-section	70 mm²
Max. welding current	450 A

Type	Designation	Hose package length m	Item no.
TIG W 70qmm HW 70qmm 2m	Intermediate hose package, water-cooled, hot wire	2.0	094-015223-00001
TIG W 70qmm HW 70qmm 5m		5.0	094-015223-00002
TIG W 70qmm HW 70qmm 10m		10.0	094-015223-00003

Suitable for:

Type	Item no.	Page
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 451 AC/DC AW FW	090-000112-00505	235

Type	Item no.	Page
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AW FW	090-000093-00505	231

MIG W 7POL 95qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Coolant lines marked in colour
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	95 mm²
Max. welding current	550 A

Type	Designation	Hose package length m	Item no.
MIG W 7POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 7-pole	1.0	094-000407-00000
MIG W 7POL 95qmm 550A/60% 5m		5.0	094-000407-00001
MIG W 7POL 95qmm 550A/60% 10m		10.0	094-000407-00002
MIG W 7POL 95qmm 550A/60% 15m		15.0	094-000407-00006
MIG W 7POL 95qmm 550A/60% 20m		20.0	094-000407-00007
MIG W 7POL 95qmm 550A/60% 30m		30	094-000407-00003
MIG W 7POL 95qmm 550A/60% 40m		40	094-000407-00008

Suitable for:

Type	Item no.	Page
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120

Type	Item no.	Page
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDW	090-005348-00502	174
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

MIG W 19POL 95qmm

- Control cables for high mechanical loads
- Fabric-sheathed, diffusion-free shielding gas hoses
- Coolant lines marked in colour
- Control cable plugs cannot be accidentally swapped
- Torsion-resistant and anti-twist control cables
- Rapid action closures, tool-free assembly
- Fabric- and plastic-sheathed protective hoses are made to be rugged
- Plug connectors in industrial quality
- Large cross-sections prevent voltage drops

Cross-section	95 mm²
Max. welding current	550 A

Type	Designation	Hose package length m	Item no.
MIG W 19POL 95qmm 550A/60% 1m	Intermediate hose package, water-cooled, 19-pole	1.0	094-009083-00000
MIG W 19POL 95qmm 550A/60% 5m		5.0	094-009083-00001
MIG W 19POL 95qmm 550A/60% 10m		10.0	094-009083-00002
MIG W 19POL 95qmm 550A/60% 15m		15.0	094-009083-00005
MIG W 19POL 95qmm 550A/60% 20m		20.0	094-009083-00003
MIG W 19POL 95qmm 550A/60% 30m		30	094-009083-00004
MIG W 19POL 95qmm 550A/60% 40m		40	094-009083-00006

Suitable for:

Type	Item no.	Page
Taurus 505 Basic TDW	090-005440-00502	146

Type	Item no.	Page
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171

tigSpeed W AW 5POL 95qmm

- Intermediate hose package, water-cooled, filler wire, incl. strain relief

Cross-section	95 mm²

Type	Designation	Hose package length m	Item no.
tigSpeed 95QMM W AW 5POL 2m	Intermediate hose package, water-cooled, filler wire, incl. strain relief	2.0	094-019139-00000
tigSpeed 95QMM W AW 5POL 5m		5.0	094-019139-00005
tigSpeed 95QMM W AW 5POL 10m		10.0	094-019139-00010

Suitable for:

Type	Item no.	Page
tigSpeed continuous drive 45 coldwire	090-000237-00502	232
tigSpeed continuous drive 45 hotwire	090-000236-00502	244

Type	Item no.	Page
tigSpeed oscillation drive 45 coldwire	090-000181-00502	233
tigSpeed oscillation drive 45 hotwire	090-000180-00502	245

MIG/MAG welding torches ■ Gas-cooled

MT220G EZA

- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire dia.	0.8 mm - 1.2 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M7
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, gas-cooled	3	094-500050-00000
	4	094-500050-00004
	5	094-500050-00005

Suitable for:

Type	Item no.	Page
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124

MT221G U/D-X

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting the wire feed speed
- Programs can also be optionally selected
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire dia.	0.8 mm - 1.2 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M7
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, up/down, gas cooled, with X Technology	3	094-500116-00200
	4	094-500116-00204
	5	094-500116-00205

MT221G 2 U/D-X

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting wire-feed speed and welding voltage or correcting the voltage
- Programs can also be optionally selected
- For alpha Q, Phoenix, and Taurus
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire dia.	0.8 mm - 1.2 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M7
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, 2 up/down, gas cooled, with X Technology	3	094-500116-00300
	4	094-500116-00304
	5	094-500116-00305

MT221G PC1-X

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Display and setting of wire feed speed
- Programs can also be optionally selected
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire dia.	0.8 mm - 1.2 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M7
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 1, gas cooled, with X Technology	3	094-500116-00400
	4	094-500116-00404
	5	094-500116-00405

MIG/MAG welding torches ■ Gas-cooled

MT221G PC2-X

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Display and setting of wire feed speed and voltage correction
- Optionally also program and JOB selection
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	250 A / 60 %
Duty cycle M21	220 A / 60 %
Duty cycle M21 pulse	150 A / 60 %
Wire dia.	0.8 mm - 1.2 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M7
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 2, gas cooled, with X Technology	3	094-500116-00700
	4	094-500116-00704
	5	094-500116-00705

MT301G EZA

- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire dia.	0.8 mm - 1.6 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, gas-cooled	3	094-500055-00000
	4	094-500055-00004
	5	094-500055-00005

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Mira 301 M2.20 FKG	090-005207-00502	182
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws dgs	090-002127-00502	261
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132
Picomig 355 puls TKG	090-005542-00502	85

Type	Item no.	Page
Picomig 355 TKG	090-005512-00502	125
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 FDG	090-004991-00502	187
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 400 Basic TDG	090-005446-00502	133

MT301G U/D

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting the wire feed speed
- Programs can also be optionally selected
- For alpha Q, Phoenix and Taurus Synergic S
- Torches without X technology are suitable for Picomig 305 machines

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire dia.	0.8 mm - 1.6 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, up/down, gas cooled	3	094-500055-00200
	4	094-500055-00204
	5	094-500055-00205

MT301G 2U/D

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting wire-feed speed and welding voltage or correcting the voltage
- Programs can also be optionally selected
- For alpha Q, Phoenix, and Taurus

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire dia.	0.8 mm - 1.6 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, 2 up/down, gas cooled	3	094-500055-00300
	4	094-500055-00304
	5	094-500055-00305

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90

Type	Item no.	Page
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S LP MM TKM	090-005421-00502	135

MIG/MAG welding torches ■ Gas-cooled

MT301G U/D-X

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting the wire feed speed
- Programs can also be optionally selected
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire dia.	0.8 mm - 1.6 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, up/down, gas cooled, with X Technology	3	094-500117-00200
	4	094-500117-00204
	5	094-500117-00205

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S LP MM TKM	090-005421-00502	135

MT301G 2U/D-X

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting wire-feed speed and welding voltage or correcting the voltage
- Programs can also be optionally selected
- For alpha Q, Phoenix, and Taurus
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire dia.	0.8 mm - 1.6 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, 2 up/down, gas cooled, with X Technology	3	094-500117-00300
	4	094-500117-00304
	5	094-500117-00305

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S LP MM TKM	090-005421-00502	135

MT301G PC1-X

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Display and setting of wire feed speed
- Programs can also be optionally selected
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire dia.	0.8 mm - 1.6 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 1, gas cooled, with X Technology	3	094-500117-00400
	4	094-500117-00404
	5	094-500117-00405

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S LP MM TKM	090-005421-00502	135

MT301G PC2-X

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Display and setting of wire feed speed and voltage correction
- Optionally also program and JOB selection
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	330 A / 60 %
Duty cycle M21	300 A / 60 %
Duty cycle M21 pulse	210 A / 60 %
Wire dia.	0.8 mm - 1.6 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 2, gas cooled, with X Technology	3	094-500117-00700
	4	094-500117-00704
	5	094-500117-00705

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S LP MM TKM	090-005421-00502	135

MIG/MAG welding torches ■ Gas-cooled

MT401G EZA

- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire dia.	0.8 mm - 2 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation		Item no.
	m	
MIG/MAG welding torch, gas-cooled	3	094-500057-00000
	4	094-500057-00004
	5	094-500057-00005

Suitable for:

Type	Item no.	Page
Saturn 351 FDG	090-004991-00502	187
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 S MM FDG	090-005344-00502	168
Wega 401 FDG	090-004948-00502	192
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M2.20 FKG	090-005225-00502	189

MT401G 2U/D

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting wire-feed speed and welding voltage or correcting the voltage
- Programs can also be optionally selected
- For alpha Q, Phoenix, and Taurus

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire dia.	0.8 mm - 2 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation		Item no.
	m	
MIG/MAG welding torch, 2 up/down, gas cooled	3	094-500057-00300
	4	094-500057-00304
	5	094-500057-00305

Suitable for:

Type	Item no.	Page
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 S MM FDG	090-005344-00502	168

MT401G U/D-X

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting the wire feed speed
- Programs can also be optionally selected
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire dia.	0.8 mm - 2 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, up/down, gas cooled, with X Technology	3	094-500118-00200
	4	094-500118-00204
	5	094-500118-00205

Suitable for:

Type	Item no.	Page
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 405 S MM TDM	090-005337-00502	143

Type	Item no.	Page
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 551 S MM FDG	090-005344-00502	168

MT401G 2U/D-X

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting wire-feed speed and welding voltage or correcting the voltage
- Programs can also be optionally selected
- For alpha Q, Phoenix, and Taurus
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire dia.	0.8 mm - 2 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, 2 up/down, gas cooled, with X Technology	3	094-500118-00300
	4	094-500118-00304
	5	094-500118-00305

Suitable for:

Type	Item no.	Page
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 405 S MM TDM	090-005337-00502	143

Type	Item no.	Page
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 551 S MM FDG	090-005344-00502	168

MIG/MAG welding torches ■ Gas-cooled

MT401G PC1-X 3M EZA M8

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- For alpha Q, Phoenix and Taurus Synergic S

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire dia.	0.8 mm - 2 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 1, gas cooled, with X Technology	3	094-500118-00400
	4	094-500118-00404
	5	094-500118-00405

Suitable for:

Type	Item no.	Page
Taurus 355 S MM TDM	090-005336-00502	143

Type	Item no.	Page
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 505 S MM TDM	090-005338-00502	143

MT401G PC1-X 3M EZA M9

- Gas-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- For alpha Q, Phoenix and Taurus Synergic S

Duty cycle CO2	450 A / 35 %
Duty cycle M21	400 A / 35 %
Duty cycle M21 pulse	260 A / 35 %
Wire dia.	0.8 mm - 2 mm
Gas flow	10 l/min - 20 l/min
Thread, contact tip	M9
Bend angle torch neck	45 °

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 2, gas cooled, with X Technology	3	094-500118-00700
	4	094-500118-00704
	5	094-500118-00705

Suitable for:

Type	Item no.	Page
Taurus 355 S MM TDM	090-005336-00502	143

Type	Item no.	Page
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 505 S MM TDM	090-005338-00502	143

MIG15

- Standard welding torch, 180A/60%

Duty cycle CO2	180 A / 60 %
Duty cycle M21	150 A / 60 %
Wire dia.	0.6 mm - 1 mm
Standards	EN 60 974-7
Bend angle torch neck	50 °

Designation	m	Item no.
MIG/MAG welding torch, gas-cooled	3	094-001175-00000
	4	094-001175-00004
	5	094-001175-00005

Suitable for:

Type	Item no.	Page
Mira 151 FKG	090-005084-00502	180

MIG25

- Standard welding torch, 230A/60%

Duty cycle CO2	230 A / 60 %
Duty cycle M21	200 A / 60 %
Wire dia.	0.8 mm - 1.2 mm
Standards	EN 60 974-7
Bend angle torch neck	50 °

Designation	m	Item no.
MIG/MAG welding torch, gas-cooled	3	094-001102-00000
	4	094-001102-00004
	5	094-001102-00005

Suitable for:

Type	Item no.	Page
Mira 221 MV FKG	090-005085-00502	180

Type	Item no.	Page
Mira 251 FKG	090-005086-00502	180

MIG36

- Standard welding torch, 320A/60%

Duty cycle CO2	320 A / 60 %
Duty cycle M21	290 A / 60 %
Standards	EN 60 974-7
Bend angle torch neck	50 °

Designation	m	Item no.
MIG/MAG welding torch, gas-cooled	3	094-013388-00000
	4	094-000536-00004
	5	094-000536-00005

Suitable for:

Type	Item no.	Page
Mira 301 M1.02 FKG	090-005181-00502	181

Type	Item no.	Page
Mira 301 M2.20 FKG	090-005207-00502	182

MIG/MAG welding torches ■ Water-cooled

MT301W EZA

- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire dia.	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation		Item no.
	m	
MIG/MAG welding torch, water-cooled	3	094-500058-00000
	4	094-500058-00004
	5	094-500058-00005

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90

Type	Item no.	Page
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKW	090-005443-00502	138

MT301W 2U/D

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting wire-feed speed and welding voltage or correcting the voltage
- Programs can also be optionally selected
- For alpha Q, Phoenix, and Taurus

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire dia.	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation		Item no.
	m	
MIG/MAG welding torch, 2 up/down, water cooled	3	094-500058-00300
	4	094-500058-00304
	5	094-500058-00305

Suitable for:

Type	Item no.	Page
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Taurus 351 Basic FDW	090-005390-00502	170

Type	Item no.	Page
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKW	090-005443-00502	138

MT301W U/D-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting the wire feed speed
- Programs can also be optionally selected
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire dia.	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Item no.	
	m	
MIG/MAG welding torch, up/down, water cooled, with X Technology	3	094-500119-00200
	4	094-500119-00204
	5	094-500119-00205

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92

Type	Item no.	Page
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKW	090-005443-00502	138

MT301W 2U/D-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting wire-feed speed and welding voltage or correcting the voltage
- Programs can also be optionally selected
- For alpha Q, Phoenix, and Taurus
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire dia.	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	Item no.	
	m	
MIG/MAG welding torch, 2 up/down, water cooled, with X Technology	3	094-500119-00300
	4	094-500119-00304
	5	094-500119-00305

Suitable for:

Type	Item no.	Page
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90

Type	Item no.	Page
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKW	090-005443-00502	138

MIG/MAG welding torches ■ Water-cooled

MT301W PC1-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Display and setting of wire feed speed
- Programs can also be optionally selected
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire dia.	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 1, water cooled, with X technology	3	094-500119-00400
	4	094-500119-00404
	5	094-500119-00405

Suitable for:

Type	Item no.	Page
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90

Type	Item no.	Page
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKW	090-005443-00502	138

MT301W PC2-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Display and setting of wire feed speed and voltage correction
- Optionally also program and JOB selection
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	330 A / 100 %
Duty cycle M21	290 A / 100 %
Duty cycle M21 pulse	250 A / 100 %
Wire dia.	0.8 mm - 1.2 mm
Thread, contact tip	M7

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 2, water cooled, with X technology	3	094-500119-00700
	4	094-500119-00704
	5	094-500119-00705

Suitable for:

Type	Item no.	Page
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90

Type	Item no.	Page
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKW	090-005443-00502	138

MT451W EZA

- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Parallel double-circuit cooling provides optimised heat removal for outstanding welding results.

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire dia.	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	**m**	**Item no.**
MIG/MAG welding torch, water-cooled	3	094-500059-00000
	4	094-500059-00004
	5	094-500059-00005

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97

Type	Item no.	Page
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDW	090-005347-00502	174
Wega 401 FDW	090-004949-00502	194
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKW	090-005228-00502	191

MIG/MAG welding torches ■ Water-cooled

MT451W 2U/D

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting wire-feed speed and welding voltage or correcting the voltage
- Parallel double-circuit cooling provides optimised heat removal for outstanding welding results.
- Programs can also be optionally selected
- For alpha Q, Phoenix, and Taurus

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire dia.	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	m	Item no.
MIG/MAG welding torch, 2 up/down, water cooled	3	094-500059-00300
	4	094-500059-00304
	5	094-500059-00305

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113

Type	Item no.	Page
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDW	090-005347-00502	174

MT451W U/D-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting the wire feed speed
- Parallel double-circuit cooling provides optimised heat removal for outstanding welding results.
- Programs can also be optionally selected
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire dia.	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation		**Item no.**
	m	
MIG/MAG welding torch, up/down, water cooled, with X Technology	3	094-500120-00200
	4	094-500120-00204
	5	094-500120-00205

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116

Type	Item no.	Page
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDW	090-005347-00502	174

MIG/MAG welding torches ■ Water-cooled

MT451W 2U/D-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting wire-feed speed and welding voltage or correcting the voltage
- Parallel double-circuit cooling provides optimised heat removal for outstanding welding results.
- Programs can also be optionally selected
- For alpha Q, Phoenix, and Taurus
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire dia.	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	**m**	**Item no.**
MIG/MAG welding torch, 2 up/down, water cooled, with X Technology	3	094-500120-00300
	4	094-500120-00304
	5	094-500120-00305

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116

Type	Item no.	Page
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDW	090-005347-00502	174

MT451W PC1-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Display and setting of wire feed speed
- Programs can also be optionally selected
- Parallel double-circuit cooling provides optimised heat removal for outstanding welding results.
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire dia.	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 1, water cooled, with X technology	3	094-500120-00400
	4	094-500120-00404
	5	094-500120-00405

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116

Type	Item no.	Page
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDW	090-005347-00502	174

MIG/MAG welding torches ■ Water-cooled

MT451W PC2-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Display and setting of wire feed speed and voltage correction
- Optionally also program and JOB selection
- Parallel double-circuit cooling provides optimised heat removal for outstanding welding results.
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	500 A / 100 %
Duty cycle M21	450 A / 100 %
Duty cycle M21 pulse	350 A / 100 %
Wire dia.	0.8 mm - 1.6 mm
Thread, contact tip	M9

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 2, water cooled, with X technology	3	094-500120-00700
	4	094-500120-00704
	5	094-500120-00705

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116

Type	Item no.	Page
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDW	090-005347-00502	174

MT551W EZA

- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire dia.	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	m	Item no.
MIG/MAG welding torch, water-cooled	3	094-500060-00000
	4	094-500060-00004
	5	094-500060-00005

Suitable for:

Type	Item no.	Page
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117

Type	Item no.	Page
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDW	090-005348-00502	174
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

MT551W 2U/D

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting wire-feed speed and welding voltage or correcting the voltage
- Parallel double-circuit cooling provides optimised heat removal for outstanding welding results.
- Programs can also be optionally selected
- For alpha Q, Phoenix, and Taurus

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire dia.	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	m	Item no.
MIG/MAG welding torch, 2 up/down, water cooled	3	094-500060-00300
	4	094-500060-00304
	5	094-500060-00305

Suitable for:

Type	Item no.	Page
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120

Type	Item no.	Page
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDW	090-005348-00502	174

MIG/MAG welding torches ■ Water-cooled

MT551W U/D-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting the wire feed speed
- Parallel double-circuit cooling provides optimised heat removal for outstanding welding results.
- Programs can also be optionally selected
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire dia.	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	m	Item no.
MIG/MAG welding torch, up/down, water cooled, with X Technology	3	094-500121-00200
	4	094-500121-00204
	5	094-500121-00205

Suitable for:

Type	Item no.	Page
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101

Type	Item no.	Page
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDW	090-005348-00502	174

MT551W 2U/D-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Setting wire-feed speed and welding voltage or correcting the voltage
- Parallel double-circuit cooling provides optimised heat removal for outstanding welding results.
- Programs can also be optionally selected
- For alpha Q, Phoenix, and Taurus
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire dia.	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	m	Item no.
MIG/MAG welding torch, 2 up/down, water cooled, with X Technology	3	094-500121-00300
	4	094-500121-00304
	5	094-500121-00305

Suitable for:

Type	Item no.	Page
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101

Type	Item no.	Page
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDW	090-005348-00502	174

MT551W PC1-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Display and setting of wire feed speed
- Programs can also be optionally selected
- Parallel double-circuit cooling provides optimised heat removal for outstanding welding results.
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire dia.	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 1, water cooled, with X technology	3	094-500121-00400
	4	094-500121-00404
	5	094-500121-00405

Suitable for:

Type	Item no.	Page
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101

Type	Item no.	Page
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDW	090-005348-00502	174

MT551W PC2-X

- Water-cooled MIG/MAG function torch
- Best ignition characteristics even with thin wires
- Ergonomically formed grip to take the strain out of work
- Display and setting of wire feed speed and voltage correction
- Optionally also program and JOB selection
- Parallel double-circuit cooling provides optimised heat removal for outstanding welding results.
- For alpha Q, Phoenix and Taurus Synergic S
- Safe and rugged; without control cable and additional connector plug

Duty cycle CO2	650 A / 100 %
Duty cycle M21	550 A / 100 %
Duty cycle M21 pulse	500 A / 100 %
Wire dia.	0.8 mm - 2 mm
Thread, contact tip	M9

Designation	m	Item no.
MIG/MAG welding torch, Powercontrol 2, water cooled, with X technology	3	094-500121-00700
	4	094-500121-00704
	5	094-500121-00705

Suitable for:

Type	Item no.	Page
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101

Type	Item no.	Page
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDW	090-005348-00502	174

TIG welding torches ■ Gas-cooled

TIG 150 GD

- Gas-cooled TIG welding torch
- Double push-button
- Ergonomic GRIP handle for a secure grip

Duty cycle DC-	150 A / 35 %
Duty cycle AC	105 A / 35 %
Electrode dia.	1 mm - 2.4 mm

Designation	m	Item no.
TIG welding torch, gas-cooled	4	394-512291-00600
	8	394-512291-00608

Suitable for:

Type	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Picotig 200 MV puls TG	090-002059-00502	205
Picotig 200 puls TG	090-002058-00502	204
Tetrix 200 MV puls 5P TG	090-000229-00502	207
Tetrix 200 puls 5P TG	090-000227-00502	206

TIG 200 GD

- Gas-cooled TIG welding torch
- Double push-button
- Ergonomic GRIP handle for a secure grip

Duty cycle DC-	200 A / 35 %
Duty cycle AC	140 A / 35 %
Electrode dia.	1.6 mm - 3.2 mm
Gas flow	10 l/min - 20 l/min

Designation	m	Item no.
TIG welding torch, gas-cooled	4	394-510981-00600
	8	394-510981-00608

Suitable for:

Type	Item no.	Page
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210

TIG welding torches ■ Water-cooled

TIG 260 WD

- Water-cooled TIG welding torch
- Double push-button
- Ergonomic GRIP handle for a secure grip

Duty cycle DC-	260 A / 100 %
Duty cycle AC	185 A / 100 %
Electrode dia.	1 mm - 3.2 mm
Gas flow	10 l/min - 20 l/min

Designation	m	Item no.
TIG welding torch, water-cooled	4	394-510990-00600
	8	394-510990-00608

Suitable for:

Type	Item no.	Page
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209

Type	Item no.	Page
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210

TIG 450 WD

- Water-cooled TIG welding torch
- Double push-button
- Ergonomic GRIP handle for a secure grip

Duty cycle DC-	400 A / 100 %
Duty cycle AC	280 A / 100 %
Electrode dia.	1.6 mm - 4.8 mm

Designation	m	Item no.
TIG welding torch, water-cooled	4	394-510993-00600
	8	394-510993-00608

Suitable for:

Type	Item no.	Page
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215

Type	Item no.	Page
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC FW	090-000137-00502	228

TIG 450SC WD HFL

- Water cooled TIG welding torch with a highly flexible hose package
- SuperCool / high-performance torch version
- Double push-button
- Ergonomic GRIP handle for a secure grip

Duty cycle DC-	450 A / 100 %
Duty cycle AC	320 A / 100 %
Electrode dia.	1.6 mm - 4.8 mm

Designation	m	Item no.
TIG welding torch, water-cooled	4	394-511016-10600
	8	394-511016-10608

Suitable for:

Type	Item no.	Page
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 451 AC/DC FW	090-000136-00502	228

Type	Item no.	Page
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 FW	090-000131-00502	215

TIG welding torches ■ Water-cooled

TIG 450 WD CW 12P 2T UD

- Water cooled TIG welding torch with a separate cold wire feed
- Setting of welding current and programs
- Ergonomic GRIP handle for a secure grip
- Replaceable steel/plastic liner
- Replaceable wire feed rotatable through 270°
- Ceramic-coated wire support
- Three fixed wire feed angles: 30°, 39° and 42°
- Flexible wire feed angles between 15°–42°
- Wire feed integrated in the grip
- Wire feed angle depends on the application.

Duty cycle DC-	400 A / 100 %
Duty cycle AC	280 A / 100 %

Designation	Bend angle torch neck	m	Item no.
TIG welding torch, cold wire, up/down	30 °	3	094-500091-10203
		4	094-500091-10200
	39 °	3	094-500092-10203
		4	094-500092-10200
	42 °	3	094-500093-10203
		4	094-500093-10200
	flex.	3	094-500094-10203
		4	094-500094-10200

Suitable for:

Type	Item no.	Page
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AW FW	090-000103-00505	231

Type	Item no.	Page
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AW FW	090-000093-00505	231
tigSpeed continuous drive 45 coldwire	090-000237-00502	232
tigSpeed oscillation drive 45 coldwire	090-000181-00502	233

TIG 450 WD HW 12P 2T UD

- Water cooled TIG welding torch with a separate cold and hot wire feed
- Setting of welding current and programs
- Replaceable steel/plastic liner
- Replaceable wire feed rotatable through 270°
- Ceramic-coated wire support
- Three fixed wire feed angles: 30°, 39° and 42°
- Flexible wire feed angles between 15°–42°
- Wire feed and hot wire current lead integrated in grip
- Wire feed angle depends on the application.

Duty cycle DC-	400 A / 100 %
Duty cycle AC	280 A / 100 %

Designation	Bend angle torch neck	m	Item no.
TIG welding torch, hot wire, up/down	30 °	3	094-500095-10203
		4	094-500095-10200
	39 °	3	094-500096-10203
		4	094-500096-10200
	42 °	3	094-500097-10203
		4	094-500097-10200
	flex.	3	094-500098-10203
		4	094-500098-10200

Suitable for:

Type	Item no.	Page
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AW FW	090-000103-00505	231

Type	Item no.	Page
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AW FW	090-000093-00505	231
tigSpeed continuous drive 45 hotwire	090-000236-00502	244
tigSpeed oscillation drive 45 hotwire	090-000180-00502	245

TIG welding torches ■ tigSpeed

comfyTig 18-1 CW

- Water cooled TIG welding torch with a separate cold wire feed
- Improved handling through MIG/MAG torch grip casing
- Hardly any changes when switching from MIG/MAG to cold or hot wire welding
- Compatible with SR replacement parts
- Double push-button
- Replaceable steel/plastic liner
- Replaceable wire feed rotatable through 270°
- Ceramic-coated wire support
- Three fixed wire feed angles: 30°, 39° and 42°
- Flexible wire feed angles between 15°–42°
- Wire feed integrated in the grip
- In conjunction with ewm tigSpeed only!

Designation	Bend angle torch neck	m	Item no.
TIG welding torch, cold wire, up/down	30 °	3	094-500142-00603
		4	094-500142-00600
	39 °	3	094-500143-00603
		4	094-500143-00600
	42 °	3	094-500144-00603
		4	094-500144-00600
	flex.	3	094-500145-00603
		4	094-500145-00600

Suitable for:

Type	Item no.	Page
tigSpeed continuous drive 45 coldwire	090-000237-00502	232

Type	Item no.	Page
tigSpeed oscillation drive 45 coldwire	090-000181-00502	233

comfyTig 18-1 HW

- Water cooled TIG welding torch with a separate cold and hot wire feed
- Improved handling through MIG/MAG torch grip casing
- Hardly any changes when switching from MIG/MAG to cold or hot wire welding
- Compatible with SR replacement parts
- Double push-button
- Replaceable steel/plastic liner
- Replaceable wire feed rotatable through 270°
- Ceramic-coated wire support
- Three fixed wire feed angles: 30°, 39° and 42°
- Flexible wire feed angles between 15°–42°
- Wire feed and hot wire current lead integrated in grip
- In conjunction with ewm tigSpeed only!

Designation	Bend angle torch neck	m	Item no.
TIG welding torch, hot wire, up/down	30 °	3	094-500146-00603
		4	094-500146-00600
	39 °	3	094-500147-00603
		4	094-500147-00600
	42 °	3	094-500148-00603
		4	094-500148-00600
	flex.	3	094-500149-00603
		4	094-500149-00600

Suitable for:

Type	Item no.	Page
tigSpeed continuous drive 45 hotwire	090-000236-00502	244

Type	Item no.	Page
tigSpeed oscillation drive 45 hotwire	090-000180-00502	245

Plasma welding torches ■ Water-cooled

PWH 100

- Water-cooled plasma welding torch
- Greater load capacity of the plasma nozzles thanks to optimised cooling system
- Reduced operating costs, long service life of the plasma nozzles thanks to large, threadless retainer cone in the torch body and additional heat dissipation by means of the gas lens on the plasma nozzle
- Compact torch design and small torch head diameter for optimal handling with the best possible performance

Duty cycle DC-	100 A / 100 %
Duty cycle AC	80 A / 100 %
Duty cycle DC+	35 A / 100 %

Designation	m	Item no.
Plasma manual welding torches	3	094-008232-00000

Suitable for:

Type	Item no.	Page
microplasma 20	090-007010-00501	248

Type	Item no.	Page
microplasma 50	090-007012-00501	248
Tetrix 150 Plasma	090-008720-00502	251

PWH 150

- Water-cooled plasma welding torch
- Greater load capacity of the plasma nozzles thanks to optimised cooling system
- Reduced operating costs, long service life of the plasma nozzles thanks to large, threadless retainer cone in the torch body and additional heat dissipation by means of the gas lens on the plasma nozzle
- Compact torch design and small torch head diameter for optimal handling with the best possible performance

Duty cycle DC-	150 A / 60 %
Duty cycle AC	120 A / 60 %
Duty cycle DC+	50 A / 60 %

Designation	m	Item no.
Plasma manual welding torches	4	094-008783-00000

Torch hose package support arm

HASE XX1

- Length of hose package support arm adjustable
- Adjustable angle of inclination allows for different radii of operation
- Integrated torch holder
- Available for all demodular, decompact machines with drive 4/drive 41 and drive 4X/drive 4L/drive 41L wire feeder

Type	Designation	Version	Item no.
OW HASE DV4L/DVX/DV4 XX1	Set: Torch hose package support arm (ex works only)	For alpha Q, Phoenix, Taurus with drive 4X, drive 4L and drive 4	092-007921-00001
ON HASE DV4L XX1 WEGA 401		For Wega 401 with drive 41L	092-007922-00000
ON HASE DV4 XX1 WEGA 401		For Wega 401 with drive 41	092-007925-00000
ON HASE DV4L XX1 WEGA 501/601		For Wega 501, Wega 601 with drive 41L	092-007923-00000
ON HASE DV4 XX1 WEGA 501/601		For Wega 501, Wega 601 with drive 41	092-007926-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 S MM FDG	090-005341-00502	167

Type	Item no.	Page
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Wega 401 FDW	090-004949-00502	194
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

Remote controls ■ MIG/MAG

RG10

- Remote control for Alpha Q, Phoenix, and Taurus, setting of wire feed speed and welding voltage
- Remote control to set the wire speed and welding voltage
- Plastic casing with retaining clip, 19-pole connection socket
- Light, robust and convenient
- Voltage correction from -10 V to +10 V
- Infinitely variable setting of wire-feed speed (0.5–24 m/min)
- With pre-fitted 5-m connection cable
- For alpha Q, Phoenix and Taurus Synergic S machines

Dimensions in mm	260 x 147 x 75
Cable length	5

Type	Designation	Item no.
RG10 19POL	Remote control to set the wire speed and welding voltage	090-008108-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111

Type	Item no.	Page
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

R10

- For alpha Q, Phoenix and Taurus Synergic S
- Robust metal casing with rubber feet, retaining clip and holding magnet, 19-pole connection socket

Dimensions in mm	180 x 100 x 70

Type	Designation	Item no.
R10 19POL	Remote control, wire speed setting, welding voltage correction	090-008087-00502

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108

Type	Item no.	Page
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

Remote controls ■ MIG/MAG

RG11

- Remote control to set the wire speed and welding voltage
- Plastic casing with retaining clip, 19-pole connection socket
- Light, robust and convenient
- Infinite setting of the welding voltage (10–50 V)
- Infinitely variable setting of wire-feed speed (0.5–24 m/min)
- With pre-fitted 5-m connection cable
- For Taurus Basic

Dimensions in mm	260 x 147 x 75
Cable length	5

Type	Designation	Item no.
RG11 19POL 5M	Remote control to set the wire speed and welding voltage	090-008107-00000

Suitable for:

Type	Item no.	Page
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170

Type	Item no.	Page
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171

R11

- Remote control to set the wire speed and welding voltage
- Robust metal casing with rubber feet, retaining clip and holding magnet, 19-pole connection socket
- For Taurus Basic

Dimensions in mm	180 x 100 x 70

Type	Designation	Item no.
R11 19POL	Remote control to set the wire speed and welding voltage	090-008601-00502

Suitable for:

Type	Item no.	Page
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170

Type	Item no.	Page
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171

R20

- Remote control, program switching
- Robust metal casing with rubber feet, retaining clip and holding magnet, 19-pole connection socket
- Changeover and display of up to ten welding programmes
- For alpha Q, Phoenix Progress, Phoenix Expert and Taurus Synergic S

Dimensions in mm	260 x 147 x 75

Type	Designation	Item no.
R20 19POL	Remote control, program switching	090-008263-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98

Type	Item no.	Page
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

Remote controls ■ MIG/MAG

R40

- Switch between MIG standard welding and pulsed arc welding
- Switch super pulse function on or off
- Cannot be used with double or two separate wire feed units!
- Robust metal casing with rubber feet, retaining clip and holding magnet, 7-pole connection socket
- For alpha Q, Phoenix Progress, Phoenix Expert and Taurus Synergic S

Dimensions in mm	260 x 147 x 75

Type	Designation	Item no.
R40 7POL	Remote control, 16 programs	090-008088-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161

Type	Item no.	Page
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

R50

- Remote control R50 7POL enables all Taurus Synergic S, Phoenix and alpha Q machines to be equipped with a second remote control.
- All functions and parameters available on the wire feeder can be adjusted remotely at the workstation using the R50 7POL within a distance of up to 60 m
- Robust metal casing with rubber feet, retaining clip and holding magnet, 7-pole connection socket

Type	Designation	Item no.
R50 7POL	Remote control with complete range of functions	090-008776-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKG	090-005431-00502	155

Type	Item no.	Page
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

RCX Expert 2.0

- Expert 2.0 remote control
- With pre-fitted connection cable

Dimensions in mm	310 x 230 x 110

Type	Designation	Cable length	Item no.
RCX Expert 2.0 2M	Expert 2.0 remote control	2 , 230 , 110	090-008808-00002
RCX Expert 2.0 5M		5 , 230 , 110	090-008808-00005
RCX Expert 2.0 10M		10 , 230 , 110	090-008808-00010
RCX Expert 2.0 15M		15 , 230 , 110	090-008808-00015

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98

Type	Item no.	Page
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

Remote controls ■ TIG/MMA

RT1

- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Operating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- For Tetrix, Picotig 200 AC/DC, Pico 180, Pico 220 cel puls, Pico 300 cel / cel PWS and Pico 350 cel puls / cel puls PWS machine series

Dimensions in mm	180 x 100 x 70
Weight	1.2 kg

Type	Designation	Item no.
RT1 19POL	Remote control, current	090-008097-00000

Suitable for:

Type	Item no.	Page
Pico 180 puls	090-002003-00502	256
Pico 180 puls VRD	090-002051-00502	256
Pico 220 cel puls	090-002057-00502	257
Pico 300 cel	090-002043-00502	258
Pico 300 cel pws	090-002044-00502	258
Pico 300 cel pws vrd 12V	090-002044-00503	258
Pico 300 cel vrd 12V	090-002043-00503	258
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws dgs	090-002127-00502	261
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Picotig 200 MV puls TG	090-002059-00502	205
Picotig 200 puls TG	090-002058-00502	204
Taurus 400 Basic TDG	090-005446-00502	133
Tetrix 150 Plasma	090-008720-00502	251
Tetrix 200 MV puls 5P TG	090-000229-00502	207

Type	Item no.	Page
Tetrix 200 puls 5P TG	090-000227-00502	206
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

RTG1

- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- With pre-fitted 5 or 10 m connection cable
- Operating point setting directly at the site of welding
- For Tetrix, Picotig 200 AC/DC and Stick machine series

Dimensions in mm	180 x 100 x 70

Type	Designation	Cable length m	Item no.
RTG1 19POL 5m	Remote control, current	5.0	090-008106-00000
RTG1 19POL 10m		10.0	090-008106-00010

Suitable for:

Type	Item no.	Page
Pico 220 cel puls	090-002057-00502	257
Pico 350 cel puls	090-002060-00502	131
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Picotig 200 puls TG	090-002058-00502	204
Set Picotig 200 puls 5P	091-002058-00539	204
Set Picotig 200 puls 5P D	091-002058-00502	204
Set Picotig 200 puls 5P DK/FI/NL/NO/SE	091-002058-00540	204
Set Picotig 200 puls 5P GB	091-002058-00537	204
Set Picotig 200 puls 5P RU	091-002058-00508	204
Tetrix 200 MV puls 5P TG	090-000229-00502	207
Tetrix 200 puls 5P TG	090-000227-00502	206
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226

Type	Item no.	Page
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

Remote controls ■ TIG/MMA

RTP1

- Remote control, pulse, spot and pause times are infinitely adjustable.
- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Pulse/spot/normal
- Operating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- For Tetrix and Picotig 200 AC/DC machine series

Dimensions in mm	260 x 147 x 75

Type	Designation	Item no.
RTP1 19POL	Remote control, spot/pulsed welding	090-008098-00000

Suitable for:

Type	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Tetrix 150 Plasma	090-008720-00502	251
Tetrix 200 MV puls 5P TG	090-000229-00502	207
Tetrix 200 puls 5P TG	090-000227-00502	206
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228

Type	Item no.	Page
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

RTP2

- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Pulse/spot/normal
- Frequency and spot times infinitely adjustable.
- Coarse adjustment of the cycle frequency.
- Pulse/pause ratio (balance) adjustable from 10% to 90%.
- Operating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- For Tetrix and Picotig 200 AC/DC machine series

Dimensions in mm	260 x 147 x 75

Type	Designation	Item no.
RTP2 19POL	Remote control, spot/pulsed welding	090-008099-00000

Suitable for:

Type	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Tetrix 150 Plasma	090-008720-00502	251
Tetrix 200 MV puls 5P TG	090-000229-00502	207
Tetrix 200 puls 5P TG	090-000227-00502	206
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228

Type	Item no.	Page
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

RTP3

- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Remote control, pulse / spotArc spot welding / normal
- Frequency and spot times infinitely adjustable.
- Coarse adjustment of the cycle frequency.
- Pulse/pause ratio (balance) adjustable from 10% to 90%.
- Operating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- For Tetrix and Picotig 200 AC/DC machine series

Dimensions in mm	260 x 147 x 75

Type	Designation	Item no.
RTP3 spotArc 19POL	Remote control, spotArc, spot/ pulsed welding	090-008211-00000

Suitable for:

Type	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Tetrix 150 Plasma	090-008720-00502	251
Tetrix 200 MV puls 5P TG	090-000229-00502	207
Tetrix 200 puls 5P TG	090-000227-00502	206
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228

Type	Item no.	Page
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

RTAC1

- AC balance (positive/negative half-wave ratio) can be set from +15% to -15%.
- AC frequency of welding current infinitely adjustable.
- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Operating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet
- For all Textrix AC/DC machines (except Tetrix 230 AC/DC)

Dimensions in mm	260 x 147 x 75

Type	Designation	Dimensions in mm	Item no.
		mm	
RTAC1 19POL	Remote control, current/ balance/ frequency	260 x 147 x 75	090-008197-00000

Suitable for:

Type	Item no.	Page
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228

Type	Item no.	Page
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228

Remote controls ■ TIG/MMA

RT PWS 1

- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Pole reversing switch, suitable for machines with PRS function.
- Operating point setting directly at the site of welding
- For all Textrix AC/DC machines (except Tetrix 230 AC/DC) and Pico 300 cel PWS / Pico 350 cel puls PWS

Dimensions in mm	180 x 100 x 70

Type	Designation	Item no.
RT PWS1 19POL	Remote control, vertical-down weld, current pole reversal	090-008199-00000

Suitable for:

Type	Item no.	Page
Pico 300 cel	090-002043-00502	258
Pico 300 cel pws	090-002044-00502	258
Pico 300 cel pws vrd 12V	090-002044-00503	258
Pico 300 cel vrd 12V	090-002043-00503	258
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws dgs	090-002127-00502	261

Type	Item no.	Page
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228

FR AW1

- Remote control for TIG cold wire and hot wire systems (Tetrix AW)
- Option ASM FR AW1 required!
- Operating point setting directly at the site of welding
- Robust metal casing with rubber feet, retaining clip and holding magnet

Type	Designation	Item no.
FR AW1	Remote controls	090-008765-00000
ON ASM FR AW1	Remote control connection capability for Tetrix drive 4L	092-008765-00000

Suitable for:

Type	Item no.	Page
FR AW1	090-008765-00000	356
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AW FW	090-000118-00505	231

Type	Item no.	Page
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AW FW	090-000093-00505	231

RTG U/D 12POL 5m

- Remote control for tigSpeed system
- All welding parameters directly adjustable at workplace
- Plastic casing with retaining clip, 12-pole connection socket
- With pre-fitted 5-m connection cable

Type	Designation	Item no.
RTG U/D 12POL 5m	Remote controls	094-019921-00000

Suitable for:

Type	Item no.	Page
tigSpeed continuous drive 45 coldwire	090-000237-00502	232
tigSpeed continuous drive 45 hotwire	090-000236-00502	244
tigSpeed oscillation drive 45 coldwire	090-000181-00502	233
tigSpeed oscillation drive 45 hotwire	090-000180-00502	245

RTF1

- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Start/stop welding operation
- Operating point setting directly at the site of welding
- For Tetrix, Picotig 200 AC/DC, Pico 180, Pico 220 cel puls, Pico 300 cel / cel PWS and Pico 350 cel puls / cel puls PWS machine series

Cable length	5

Type	Designation	Item no.
RTF1 19POL 5 M	Foot-operated remote control, current, with connection cable	094-006680-00000

Suitable for:

Type	Item no.	Page
Pico 180 puls	090-002003-00502	256
Pico 180 puls VRD	090-002051-00502	256
Pico 220 cel puls	090-002057-00502	257
Pico 300 cel	090-002043-00502	258
Pico 300 cel pws	090-002044-00502	258
Pico 300 cel pws vrd 12V	090-002044-00503	258
Pico 300 cel vrd 12V	090-002043-00503	258
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws dgs	090-002127-00502	261
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Picotig 200 MV puls TG	090-002059-00502	205
Picotig 200 puls TG	090-002058-00502	204
Tetrix 150 Plasma	090-008720-00502	251
Tetrix 200 MV puls 5P TG	090-000229-00502	207
Tetrix 200 puls 5P TG	090-000227-00502	206
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

FR21

- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Operating point setting directly at the site of welding
- For microplasma machine series

Cable length	5

Type	Designation	Item no.
FR21 14POL 5 M	Foot-operated remote control, current	094-000051-00000

Suitable for:

Type	Item no.	Page
microplasma 120	090-007015-00502	249
microplasma 20	090-007010-00501	248
microplasma 50	090-007012-00501	248

Remote controls ■ TIG/MMA

RT50

- The RT50 7POL remote control allows machines with a 7-pole connection to be equipped with a second remote control
- Robust metal casing with rubber feet, retaining clip and holding magnet, 7-pole connection socket

Dimensions in mm	115 x 235 x 300

Type	Designation	Item no.
RT50 7POL	Remote control with complete range of functions	090-008793-00000

Suitable for:

Type	Item no.	Page
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215

Type	Item no.	Page
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

RG13

- Infinitely adjustable welding current (0% to 100%) depending on the main current preselected at the welding machine.
- Operating point setting directly at the site of welding

Type	Designation	Item no.
RG13 RS-453	Remote control, current	090-008113-00000

Suitable for:

Type	Item no.	Page
Pico 160 cel puls	090-002129-00502	254

Remote controls ■ Plasma

FRP10

- Robust metal casing with rubber feet, retaining clip and holding magnet
- For microplasma machine series

Type	Designation	Cable length m	Item no.
FRP10 14POL 5m	Remote control, spot/pulsed	5.0	090-008002-00000
FRP10 14POL 10m		10.0	090-008002-00010

Suitable for:

Type	Item no.	Page
microplasma 120	090-007015-00502	249

Type	Item no.	Page
microplasma 20	090-007010-00501	248
microplasma 50	090-007012-00501	248

FRP15

- Robust metal casing with rubber feet, retaining clip and holding magnet
- For microplasma machine series

Type	Designation	Cable length m	Item no.
FRP15 14POL 5m	Remote control, pulsed welding	5.0	090-008045-00000
FRP15 14POL 10m		10.0	090-008045-00010

Suitable for:

Type	Item no.	Page
microplasma 120	090-007015-00502	249

Type	Item no.	Page
microplasma 20	090-007010-00501	248
microplasma 50	090-007012-00501	248

Remote controls ■ Connection cables

RA5 19POL

Type	Designation	Item no.
RA5 19POL 5m	Connection cables	092-001470-00005
RA5 19POL 10m		092-001470-00010
RA5 19POL 20m		092-001470-00020

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
R10 19POL	090-008087-00502	347
R11 19POL	090-008601-00502	348
R20 19POL	090-008263-00000	349
RT1 19POL	090-008097-00000	353
RTAC1 19POL	090-008197-00000	355

Type	Item no.	Page
RTP1 19POL	090-008098-00000	354
RTP2 19POL	090-008099-00000	354
RTP3 spotArc 19POL	090-008211-00000	355
RT PWS1 19POL	090-008199-00000	356
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210

RV 19POL

Type	Designation	Item no.
RV 19POL 5m	Extension cable	092-000857-00000
RV 19POL 10m		092-000857-00010
RV 19POL 15m		092-000857-00015
RV 19POL 20m		092-000857-00020

Suitable for:

Type	Item no.	Page
RG10 19POL	090-008108-00000	346
RG11 19POL 5M	090-008107-00000	348
RTF1 19POL 5 M	094-006680-00000	357

Type	Item no.	Page
RTG1 19POL 10m	090-008106-00010	353
RTG1 19POL 5m	090-008106-00000	353
Tetrix 300 TM	090-000125-00502	210

FRV 7POL

Type	Designation	Item no.
FRV 7POL 0.5m	Connection cable extension	092-000201-00004
FRV 7POL 1m		092-000201-00002
FRV 7POL 5m		092-000201-00003
FRV 7POL 10m		092-000201-00000
FRV 7POL 15m		092-000201-00005
FRV 7POL 20m		092-000201-00001
FRV 7POL 25m		092-000201-00007

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
R40 7POL	090-008088-00000	350

Type	Item no.	Page
R50 7POL	090-008776-00000	351
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213

Cooling units ■ Cool-Serie

cool35 U31

- Cooling unit for water-cooled welding torches
- Modular design, tool-free assembly

Cooling output	800 W (1l/min)
Flow rate	5 l/min
Tank capacity	4.5 l
Coolant outlet pressure	3.5 bar
Dimensions cooling unit in mm	650 x 270 x 225
Weight, cooling unit	15 kg

Type	Designation	PU Units	PE	Item no.
cool35 U31	Cooling unit with centrifugal pump	1	per unit	090-008235-00502
6x cool35 U31	Packing unit: 6 x cool35 U31	6	per PU	092-015295-00502

Suitable for:

Type	Item no.	Page
Tetrix 300 TM	090-000125-00502	210

cool40 U31

- Cooling unit for water-cooled welding torches
- Modular design, tool-free assembly

Cooling output	800 W (1l/min)
Flow rate	5 l/min
Tank capacity	4 l
Coolant outlet pressure	3.5 bar
Dimensions cooling unit in mm	600 x 210 x 340
Weight, cooling unit	14 kg

Type	Designation	PU Units	PE	Item no.
cool40 U31	Cooling unit with centrifugal pump	1	per unit	090-008593-00502
6x cool40 U31	Packing unit: 6 x cool40 U31	6	per PU	092-015283-00502

Suitable for:

Type	Item no.	Page
Picotig 200 AC/DC puls TG	090-000188-00502	222
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224

Type	Item no.	Page
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209

cool41 U31

- Cooling unit for water-cooled welding torches
- Modular design, tool-free assembly

Cooling output	800 W (1l/min)
Flow rate	5 l/min
Tank capacity	4 l
Coolant outlet pressure	3.5 bar
Dimensions cooling unit in mm	600 x 210 x 340
Weight, cooling unit	18.4 kg

Type	Designation	PU Units	PE	Item no.
cool41 U31	Cooling unit with centrifugal pump	1	per unit	090-008600-00502
6x cool41 U31	Packing unit: 6 cool41 U31	6	per PU	092-015291-00502

Suitable for:

Type	Item no.	Page
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226

Type	Item no.	Page
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213

Cooling units ■ Cool-Serie

cool50 U40

- Cooling unit for water-cooled welding torches
- For compact machines (TKM).
- We recommend using a cooling unit with a reinforced pump for an overall hose package length of 30 m and above, or for machines with an additional miniDrive of 20 m and above
- Modular design, tool-free assembly

Cooling output	1000 W (1l/min)
Flow rate	5 l/min
Tank capacity	5 l
Coolant outlet pressure	3.5 bar
Dimensions cooling unit in mm	610 x 300 x 330
Weight, cooling unit	16.5 kg

Type	Designation	Item no.
cool50 U40	Cooling unit with centrifugal pump	090-008598-00502

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90

Type	Item no.	Page
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S LP MM TKM	090-005421-00502	135

cool50-2 U40

- Cooling unit for water-cooled welding torches
- For decompact machines (TDM).
- We recommend using a cooling unit with a reinforced pump for an overall hose package length of 30 m and above, or for machines with an additional miniDrive of 20 m and above
- Modular design, tool-free assembly

Cooling output	1000 W (1l/min)
Flow rate	5 l/min
Tank capacity	5 l
Coolant outlet pressure	3.5 bar
Dimensions cooling unit in mm	610 x 300 x 330
Weight, cooling unit	16.5 kg

Type	Designation	Item no.
cool50-2 U40	Cooling unit with centrifugal pump	090-008603-00502

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98

Type	Item no.	Page
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 S MM TDM	090-005338-00502	143

cool50 U42

- Cooling unit with reinforced pump for water cooled welding torches with hose package lengths of 20 m and longer
- Cooling unit for water-cooled welding torches
- For compact machines (TKM).
- Use of overall hose package length up to 60 m for machines with separate wire feeder with/without additional miniDrive and overall hose package length up to 30 m for compact machines with additional miniDrive
- Modular design, tool-free assembly

Cooling output	1000 W
Flow rate	20 l/min
Tank capacity	5 l
Coolant outlet pressure	4.5 bar
Dimensions cooling unit in mm	610 x 300 x 330
Weight, cooling unit	17 kg

Type	Designation	Item no.
cool50 U42	Cooling unit with reinforced pump	090-008797-00502

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90

Type	Item no.	Page
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S LP MM TKM	090-005421-00502	135

cool50-2 U42

- Cooling unit with reinforced pump for water cooled welding torches with hose package lengths of 20 m and longer
- Cooling unit for water-cooled welding torches
- For decompact machines (TDM).
- Use of overall hose package length up to 60 m for machines with separate wire feeder with/without additional miniDrive and overall hose package length up to 30 m for compact machines with additional miniDrive
- Modular design, tool-free assembly

Cooling output	1000 W
Flow rate	20 l/min
Tank capacity	5 l
Coolant outlet pressure	4.5 bar
Dimensions cooling unit in mm	610 x 300 x 330
Weight, cooling unit	17 kg

Type	Designation	Item no.
cool50-2 U42	Cooling unit with reinforced pump	090-008796-00502

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98

Type	Item no.	Page
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 S MM TDM	090-005338-00502	143

Cooling units ■ Cool-Serie

cool71 U42

- Cooling unit for water-cooled welding torches
- For alpha Q 330 and Tetrix 150 Plasma
- Modular design, tool-free assembly

Cooling output	1500 W (2l/min)
Flow rate	20 l/min
Tank capacity	7 l
Coolant outlet pressure	4.5 bar
Dimensions cooling unit in mm	685 x 335 x 255
Weight, cooling unit	34 kg

Type	Designation	Item no.
cool71 U42	Cooling unit with centrifugal pump and enhanced cooling	090-008201-00502

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68

Type	Item no.	Page
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66

cool71 U43

- Cooling unit for water-cooled welding torches
- For alpha Q 330 and Tetrix 150 Plasma
- Modular design, tool-free assembly

Cooling output	1200 W (1l/min)
Flow rate	5 l/min
Tank capacity	7 l
Coolant outlet pressure	3.5 bar
Dimensions cooling unit in mm	685 x 335 x 255
Weight, cooling unit	34 kg

Type	Designation	Item no.
cool71 U43	Cooling unit with centrifugal pump	090-008220-00502

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68

Type	Item no.	Page
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Tetrix 150 Plasma	090-008720-00502	251

UK 500

- Cooling unit for water-cooled welding torches

Cooling output	1200 W
Tank capacity	7 l
Coolant outlet pressure	3.5 bar
Dimensions cooling unit in mm	485 x 390 x 385
Mains voltage	1 x 230 V (-40 % - +15 %)

Type	Designation	Weight, cooling unit kg	Dimensions cooling unit in mm mm	Mains voltage	Item no.
UK 500	Cooling unit	21	485 x 390 x 385	1 x 230 V (-40 % - +15 %)	090-008026-00504
UK 500 S		24	535 x 390 x 385	3 x 400 V (-25 % - +20 %)	090-008026-00506

Suitable for:

Type	Item no.	Page
microplasma 120	090-007015-00502	249

Type	Item no.	Page
microplasma 20	090-007010-00501	248
microplasma 50	090-007012-00501	248

Cooling units ■ Recooling units

RK

- A recooling unit with reinforced pump is necessary when using torches with more than 150 A!
- High-performance recooling unit with fully thermal motor compressor
- Temperature control and LED display
- Connections at rear
- High-performance pump, pressure switch, temperature-controlled pump and fan
- Coolant drain valve and coolant level indicator

Type	Designation	Weight, cooling unit	Dimensions cooling unit in mm	Tank capacity	Cooling output	Mains voltage	Item no.
		kg	mm	l	W	V	
RK 1	Recooling unit	42	565 x 440 x 345	6.0	900	1 x 230	094-002283-00000
RK 2		85	750 x 450 x 500	15.0	2000		094-002284-00000
RK 3					2700	3 x 400	094-002285-00000
RK 2.1	Recooling unit with reinforced pump 8 bar				2000	1 x 230	094-002284-02000
RK 3.1					2700	3 x 400	094-002285-02000

Suitable for:

Type	Item no.	Page
microplasma 120	090-007015-00502	249
microplasma 20	090-007010-00501	248

Type	Item no.	Page
microplasma 50	090-007012-00501	248
Tetrix 150 Plasma	090-008720-00502	251

Frostschutzprüfer

Type	Designation	Item no.
TYP1	Frost protection tester	094-014499-00000

Cooling units ■ Coolant

KF 9,3 l

Type	Designation	Item no.
KF 23E-10, -10	Coolant (-10 °C), 9.3 l	094-000530-00000
KF 37E-10, -20	Coolant (-20 °C), 9.3 l	094-006256-00000

Suitable for:

Type	Item no.	Page
6x cool35 U31	092-015295-00502	269
6x cool40 U31	092-015283-00502	269
6x cool41 U31	092-015291-00502	269
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
cool35 U31	090-008235-00502	361
cool40 U31	090-008593-00502	361
cool41 U31	090-008600-00502	361
cool50-2 U40	090-008603-00502	362
cool50-2 U42	090-008796-00502	363
cool50 U40	090-008598-00502	362
cool50 U42	090-008797-00502	363
cool71 U42	090-008201-00502	364
cool71 U43	090-008220-00502	364
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116

Type	Item no.	Page
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 405 Basic TDW	090-005438-00502	145
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215
Wega 401 FDW	090-004949-00502	194
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKW	090-005228-00502	191
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

DFK10

Type	Designation	Item no.
DKF 23E-10	Deionised coolant, 10 l, no frost protection, for recooling units	094-001504-00000

Suitable for:

Type	Item no.	Page
RK 1	094-002283-00000	365
RK 2	094-002284-00000	365

Type	Item no.	Page
RK 2.1	094-002284-02000	365
RK 3	094-002285-00000	365
RK 3.1	094-002285-02000	365

KF 200 l

Type	Designation	Item no.
KF 23E-200, -10	Coolant (-10 °C), 200 l	094-000530-00001
KF 37E-200, -20	Coolant (-20 °C), 200 l	094-006256-00001

Suitable for:

Type	Item no.	Page
6x cool35 U31	092-015295-00502	269
6x cool40 U31	092-015283-00502	269
6x cool41 U31	092-015291-00502	269
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
cool35 U31	090-008235-00502	361
cool40 U31	090-008593-00502	361
cool41 U31	090-008600-00502	361
cool50-2 U40	090-008603-00502	362
cool50-2 U42	090-008796-00502	363
cool50 U40	090-008598-00502	362
cool50 U42	090-008797-00502	363
cool71 U42	090-008201-00502	364
cool71 U43	090-008220-00502	364
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107

Type	Item no.	Page
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 405 Basic TDW	090-005438-00502	145
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Wega 401 FDW	090-004949-00502	194
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKW	090-005228-00502	191
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

Transport on trolley

In the tables below, you can see which shielding gas cylinders you can carry on our trolleys or welding machines:

Trolly 35-1 | Trolly 35.2-2 | Trolly 38-2 E | Trolly 55-5 | Trolly 75-2 | Trolly 70-3 | Trolly 70-3 DF

Classification

Trolley	Trolly 35-1	Trolly 35.2-2	Trolly 38-2 E	Trolly 55-5	Trolly 75-2	Trolly 70-3	Trolly 70-3 DF
Shielding gas cylinders up to 200 bar							
10 L	●	●	●	●	●	●	-
20 L	●	●	●	●	●	●	●
50 L	-	●	●	●	●	●	● (2x)
Max. shielding gas cylinder height in mm	970 (+/-20)				1640 (+/-20)		
Max. diameter in mm	204 (+/-1%)				229 (+/-1%)		
Shielding gas cylinders up to 300 bar							
10 L	●	●	●	●	●	●	-
20 L	●	●	●	●	●	●	●
33 L	●	●	●	●	●	●	● (2x)
50 L	-	●	●	●	●	●	● (2x)
Max. shielding gas cylinder height in mm	970 (+/-20)				1640 (+/-20)		
Max. diameter in mm	204 (+/-1%)				229 (+/-1%)		

As a basic rule, you must comply with the respective safety regulations when transporting gas cylinders. You will find detailed safety instructions in the operating instructions for the respective welding machines and trolleys.

It is not permitted to lift shielding gas cylinders with a crane or use the cylinders while they are suspended above the ground.

Transport cart ■ Trolly series

Trolly 35-1

- Transport cart
- Solid, stable design
- For Picomig 180, Picotig 200/200 MV, Tetrix 200, Pico 180 and Pico 220
- For transporting a power source and a gas cylinder

Trolley dimensions L x W x H in mm	515 x 585 x 1160
Trolley weight	20 kg

Type	Designation	Item no.
Trolly 35-1	Trolley for power source, 10 l – 33 l shielding gas cylinder	090-008629-00000

Suitable for:

Type	Item no.	Page
Pico 180 puls	090-002003-00502	256
Pico 180 puls VRD	090-002051-00502	256
Pico 220 cel puls	090-002057-00502	257

Type	Item no.	Page
Picomig 180 puls TKG	090-005545-00502	83
Picotig 200 puls TG	090-002058-00502	204
Tetrix 200 MV puls 5P TG	090-000229-00502	207
Tetrix 200 puls 5P TG	090-000227-00502	206

Trolly 35.2-2

- Transport cart
- Solid, stable design
- For transporting a power source, a cooling unit and a gas cylinder
- Can be lifted by crane (option ON CS Trolly 35.2-2 required)

Trolley dimensions L x W x H in mm	600 x 580 x 1200
Trolley weight	33 kg

Type	Designation	PU	PE	Item no.
Trolly 35.2-2	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	1 Units	per unit	090-008296-00000
6x Trolly 35.2-2	Packing unit: 6 Trolly 35.2-2	6 Pack	per PU	092-015282-00000

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85
Picomig 355 TKG	090-005512-00502	125

Type	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Taurus 355 Basic TKM	090-005406-00502	134
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210

Transport cart ■ Trolly series

Trolly 38-2 E

- Transport cart
- For Tetrix 230, 270, 300, 300-2, 400-2 DC as well as Tetrix 230, 300 AC/DC
- Solid, stable design
- For transporting a power source, a cooling unit and a gas cylinder

Trolley dimensions L x W x H in mm	818 x 533 x 1233
Trolley weight	35 kg

Type	Designation	Item no.
Trolly 38-2 E	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder	090-008270-00000

Suitable for:

Type	Item no.	Page
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209

Type	Item no.	Page
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210

Trolly 55-5

- Transport cart
- For Picomig 185 / 305 D3 and Phoenix / Taurus 355 / 405 / 505 as well as Tetrix 230 / 300-2
- Solid, stable design
- For transporting a power source, a cooling unit and a gas cylinder

Trolley dimensions L x W x H in mm	1015 x 505 x 1105
Trolley weight	35 kg

Type	Designation	Version	Item no.
Trolly 55-5	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	assembled	090-008632-00000
Trolly 55-5 DM	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, dismounted	disassembled	090-008632-00001

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85
Set Taurus 505 Basic Duo Gouging	092-008313-00000	150
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137

Type	Item no.	Page
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213

ON TR Trolly 55-5

Type	Designation	Item no.
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000

Suitable for:

Type	Item no.	Page
Trolly 55-5	090-008632-00000	370

Type	Item no.	Page
Trolly 55-5 DM	090-008632-00001	370

ON PS Trolly 55-5 drive 4/4L

- Wire feeder pivots 360° on the welding machine
- For drive 4L / drive 4X / drive 4 Basic on trolly 55-5

Type	Designation	Item no.
ON PS Trolly 55-5 drive 4L/4X	Pivot support	092-002712-00000

Suitable for:

Type	Item no.	Page
Trolly 55-5	090-008632-00000	370

Type	Item no.	Page
Trolly 55-5 DM	090-008632-00001	370

Trolly 75-2

- Transport cart
- For alpha Q 330
- Solid, stable design
- For transporting a power source, a cooling unit and a gas cylinder

Trolley dimensions L x W x H in mm	980 x 505 x 990
Trolley weight	34 kg

Type	Designation	Item no.
Trolly 75-2	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, mounted	090-008176-00001
	Trolley for power source, 1 module, 10 l–50 l shielding gas cylinder, dismounted	090-008176-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68

Type	Item no.	Page
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66

Transport cart ■ Trolly series

TROLLY 70-3 DF

- Transport cart
- For the Tetrix Plasma series of machines
- Solid, stable design
- To transport one power source, two modules and two gas cylinders

Trolley dimensions L x W x H in mm	1050 x 500 x 1325
Trolley weight	50 kg

Type	Designation	Item no.
Trolly 70-3 DF	Trolley for power source, 2 modules, two 33 l–50 l shielding gas cylinders	090-008159-00000

Suitable for:

Type	Item no.	Page
Tetrix 150 Plasma	090-008720-00502	251

ON Trolly Picomig

Type	Designation	Item no.
ON Trolly Picomig	Trolly Picomig 180 with holder for 300 mm wire spool	092-000312-00000

Suitable for:

Type	Item no.	Page
Picomig 180 puls TKG	090-005545-00502	83

Type	Item no.	Page
Picomig 180 TKG	090-005546-00502	123

Gouging ■ GT 600 SKK95

GT 600 SKK95

- Compressed air gouging torch for separating metals
- Suitable for round carbon electrode Ø 3–10 mm, flat carbon electrode (width 10/16 mm; 5 mm thick)
- High-strength, heat-insulated grip
- Rotatable nozzle
- Suitable carbon electrodes can be found in the Accessories section of the price list!

Max. welding current	600 A
Hose package length	3 m

Type	Designation	Pilot arc current	Electrode dia.	Hose package length	PU	Max. welding current	Load capacity	Item no.
		A	mm	m	Units	A	A	
GT 600 SKK95	Gouging torch	–	3 - 10	3.0	1	600	–	094-016099-00000
ABIARC Ø 4 mm, 250 A	Carbon electrodes	250	4.0	–	50	–	250	097-003239-00000
ABIARC Ø 5 mm, 300 A		300	5.0				300	097-003240-00000
ABIARC Ø 6,5 mm, 400 A		400	6.5				400	097-003241-00000
ABIARC Ø 8 mm, 500 A		500	8.0				500	097-003242-00000
ABIARC Ø 9,5 mm, 600 A		600	9.5				600	097-003243-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
GT 600 SKK95	094-016099-00000	373
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114

Type	Item no.	Page
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

WK25mm² 230A/60% 4m/K

Cross-section	25 mm²
Welding current	160 A
Ø plug	9 mm
Characteristics	Original FIX® ground clamp

Type	Designation	Item no.
WK25mm² 230A/60% 4m FIX	Completely assembled workpiece lead with original FIX clamp	398-000593-00000

Suitable for:

Type	Item no.	Page
microplasma 120	090-007015-00502	249
microplasma 20	090-007010-00501	248
microplasma 50	090-007012-00501	248
Mira 151 FKG	090-005084-00502	180
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123

WK35 mm² 290A/60% 4m/K

Cross-section	35 mm²
Welding current	200 A
Ø plug	13 mm
Characteristics	Original FIX® ground clamp

Type	Designation	Item no.
WK35mm² 290A/60% 4m FIX	Completely assembled workpiece lead with original FIX clamp	398-000594-00000

Suitable for:

Type	Item no.	Page
Mira 221 MV FKG	090-005085-00502	180
Mira 251 FKG	090-005086-00502	180
Mira 301 M1.02 FKG	090-005181-00502	181
Mira 301 M2.20 FKG	090-005207-00502	182
Pico 220 cel puls	090-002057-00502	257
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Picotig 200 MV puls TG	090-002059-00502	205
Picotig 200 puls TG	090-002058-00502	204
Tetrix 200 MV puls 5P TG	090-000229-00502	207
Tetrix 200 puls 5P TG	090-000227-00502	206
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209

WK50mm² 350A/60% 4m/K

Cross-section	50 mm²
Welding current	400 A
Ø plug	13 mm
Characteristics	Original FIX® ground clamp

Type	Designation	Item no.
WK50mm² 350A/60% 4m FIX	Completely assembled workpiece lead with original FIX clamp	398-000597-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85
Picomig 355 TKG	090-005512-00502	125
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210

WK70mm² 450A/60% 4m/K

Cross-section	70 mm²
Welding current	400 A
Ø plug	13 mm
Characteristics	Original FIX® ground clamp

Type	Designation	Item no.
WK70mm² 450A/60% 4m FIX	Completely assembled workpiece lead with original FIX clamp	398-000596-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153

Type	Item no.	Page
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 551 AC/DC FW	090-000137-00502	228
Wega 401 FDW	090-004949-00502	194
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191

WK95mm² 550A/60% 4m/K

Cross-section	95 mm²
Welding current	600 A
Ø plug	13 mm
Characteristics	Original FIX® ground clamp

Type	Designation	Item no.
WK95mm² 550A/60% 4m FIX	Completely assembled workpiece lead with original FIX clamp	398-000595-00000

Suitable for:

Type	Item no.	Page
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Set Taurus 505 Basic Duo Gouging	092-008313-00000	150
Taurus 501 Basic FKW	090-005410-00502	158

Type	Item no.	Page
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

WK16mm² 170A/60% 4m/K

Cross-section	16 mm²
Welding current	150 A
Ø plug	9 mm
Characteristics	Clamp

Type	Designation	Item no.
WK16mm² 170A/60% 4m/K	Completely assembled workpiece lead with terminal	094-005314-00000

Suitable for:

Type	Item no.	Page
Pico 162	090-002040-00502	255
Pico 162 MV	090-002042-00502	278

Type	Item no.	Page
Pico 162 VRD	090-002050-00502	255
SET Pico 162	091-002040-00502	255
SET Pico 162 MV	091-002042-00502	278

WK16mm² 170A/60% 4m/K

Cross-section	16 mm²
Welding current	170 A
Ø plug	13 mm

Type	Designation	Item no.
WK16mm² 170A/60% 4m/K	Welding lead	094-005801-00000

Suitable for:

Type	Item no.	Page
Pico 160 cel puls	090-002129-00502	254

WK25mm² 230A/60% 4m/K

Cross-section	25 mm²
Welding current	200 A
Ø plug	9 mm
Characteristics	Clamp

Type	Designation	Item no.
WK25mm² 230A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000016-00000

Suitable for:

Type	Item no.	Page
microplasma 120	090-007015-00502	249
microplasma 20	090-007010-00501	248
microplasma 50	090-007012-00501	248
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123

WK35 mm² 290A/60% 4m/K

Cross-section	35 mm²
Welding current	250 A
Ø plug	13 mm
Characteristics	Clamp

Type	Designation	Item no.
WK35 mm² 290A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000008-00000

Suitable for:

Type	Item no.	Page
Mira 221 MV FKG	090-005085-00502	180
Mira 251 FKG	090-005086-00502	180
Mira 301 M1.02 FKG	090-005181-00502	181
Mira 301 M2.20 FKG	090-005207-00502	182
Pico 180 puls	090-002003-00502	256
Pico 180 puls VRD	090-002051-00502	256
Pico 220 cel puls	090-002057-00502	257
Picotig 200 puls TG	090-002058-00502	204
Tetrix 200 puls 5P TG	090-000227-00502	206
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209

WK50mm² 350A/60% 4m/K

Cross-section	50 mm²
Welding current	300 A
Ø plug	13 mm
Characteristics	Clamp

Type	Designation	Item no.
WK50mm² 350A/60% 4m/K	Completely assembled workpiece lead with terminal	092-000003-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws dgs	090-002127-00502	261
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85
Picomig 355 TKG	090-005512-00502	125
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S MM TDM	090-005336-00502	143
Tetrix 300 TM	090-000125-00502	210

WK70mm² 450A/60% 4m/Z

Cross-section	70 mm²
Welding current	400 A
Ø plug	13 mm
Characteristics	Clamp with wing nut

Type	Designation	Item no.
WK70mm² 450A/60% 4m/Z	Workpiece lead with clamp	092-000013-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM FDW	090-005327-00502	108

Type	Item no.	Page
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 S MM TDM	090-005337-00502	143
Tetrix 401 FW	090-000176-00502	215

WK95mm² 550A/60% 4m/Z

Cross-section	95 mm²
Welding current	500 A
Ø plug	13 mm
Characteristics	Clamp with wing nut

Type	Designation	Item no.
WK95mm² 550A/60% 4m/Z	Completely assembled workpiece lead with clamp	092-000171-00000

Suitable for:

Type	Item no.	Page
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162

Type	Item no.	Page
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

Welding accessories ■ Electrode holders

EH 16qmm 4m

- Fully assembled electrode holder with cable

Material type	H 01 N2 neoprene
Cross-section	16 mm²
Welding current	150 A
Ø plug	9 mm

Type	Designation	Item no.
EH 16qmm 4m	Electrode holder with cable	094-005313-00000

Suitable for:

Type	Item no.	Page
Pico 162	090-002040-00502	255
Pico 162 MV	090-002042-00502	278
Pico 162 VRD	090-002050-00502	255
SET Pico 162	091-002040-00502	255
SET Pico 162 MV	091-002042-00502	278

EH 16qmm 4m

- Fully assembled electrode holder with cable

Cross-section	16 mm²
Ø plug	13 mm

Type	Designation	Item no.
EH 16qmm 4m	Electrode holders	094-005800-00000

Suitable for:

Type	Item no.	Page
Pico 160 cel puls	090-002129-00502	254

EH 25qmm 4m

- Fully assembled electrode holder with cable

Material type	H 01 N2 neoprene
Cross-section	25 mm²
Welding current	200 A
Ø plug	9 mm

Type	Designation	Item no.
EH 25qmm 4m	Electrode holder with cable	092-000017-00000

Suitable for:

Type	Item no.	Page
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123

EH 35qmm 4m

- Fully assembled electrode holder with cable

Material type	H 01 N2 neoprene
Cross-section	35 mm²
Welding current	250 A
Ø plug	13 mm

Type	Designation	Item no.
EH 35qmm 4m	Electrode holder with cable	092-000052-00000

Suitable for:

Type	Item no.	Page
Pico 180 puls	090-002003-00502	256
Pico 180 puls VRD	090-002051-00502	256
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Picotig 200 MV puls TG	090-002059-00502	205
Picotig 200 puls TG	090-002058-00502	204
Taurus 400 Basic TDG	090-005446-00502	133
Tetrix 200 MV puls 5P TG	090-000229-00502	207
Tetrix 200 puls 5P TG	090-000227-00502	206
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213

EH 50qmm 4m

- Fully assembled electrode holder with cable

Material type	H 01 N2 neoprene
Cross-section	50 mm²
Welding current	300 A
Ø plug	13 mm

Type	Designation	Item no.
EH 50qmm 4m	Electrode holder with cable	092-000004-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws dgs	090-002127-00502	261
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85

Type	Item no.	Page
Picomig 355 TKG	090-005512-00502	125
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 400 Basic TDG	090-005446-00502	133
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210

EH 70qmm 4m

- Fully assembled electrode holder with cable

Material type	H 01 N2 neoprene
Cross-section	70 mm²
Welding current	400 A
Ø plug	13 mm

Type	Designation	Item no.
EH 70qmm 4m	Electrode holder with cable	092-000011-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 400 Basic TDG	090-005446-00502	133
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC FW	090-000137-00502	228

EH 95qmm 4m

- Fully assembled electrode holder with cable

Material type	H 01 N2 neoprene
Cross-section	95 mm²
Welding current	500 A
Ø plug	13 mm

Type	Designation	Item no.
EH 95qmm 4m	Electrode holder with cable	092-000010-00000

Suitable for:

Type	Item no.	Page
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 400 Basic TDG	090-005446-00502	133
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 FW	090-000131-00502	215

DM 842 Ar/CO2 230bar

- Pressure regulator with manometer
- Manufactured in accordance with ISO 2503
- Maximum primary pressure of 230 bar
- Single-stage
- Infinite and highly accurate adjustment
- Safety manometer with pressure meter or flow meter (bar/psi or litres per minute)
- With cut-off valve

Coolant outlet pressure	230 bar
Gas type	Argon/CO2/mixed gas

Type	Designation	Item no.
DM 842 Ar/CO2 230bar 15l D	Pressure regulator with manometer	394-002910-00015
DM 842 Ar/CO2 230bar 30l D		394-002910-00030
DM 801 Ar/CO2 230bar 15l UK		394-002911-00015
DM 801 Ar/CO2 230bar 30l UK		394-002911-00030

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Pico 160 cel puls	090-002129-00502	254
Pico 162	090-002040-00502	255
Pico 162 MV	090-002042-00502	278
Pico 162 VRD	090-002050-00502	255
Pico 180 puls	090-002003-00502	256
Pico 180 puls VRD	090-002051-00502	256
Pico 220 cel puls	090-002057-00502	257
Pico 300 cel	090-002043-00502	258
Pico 300 cel pws	090-002044-00502	258
Pico 300 cel pws vrd 12V	090-002044-00503	258
Pico 300 cel vrd 12V	090-002043-00503	258
Pico 350 cel puls	090-002060-00502	131

Type	Item no.	Page
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws dgs	090-002127-00502	261
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
SET Pico 162	091-002040-00502	255
SET Pico 162 MV	091-002042-00502	278
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

DM 200 D F1

- Single stage pressure regulator with float type meter for flow measurement

Coolant outlet pressure	200 bar

Type	Designation	Gas type	Item no.
Tigex Ar/Mix 200 bar 5l/min	Pressure regulator with flow meter	Argon / Mix	094-001812-00001
Tigex N/H2 T 200bar 20l G3/8“L		Argon/H2 (forming gas)	094-001813-00001
Tigex AR/MIX 200bar 20l G1/4“		Argon / Mix	094-001980-00000

Suitable for:

Type	Item no.	Page
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AW FW	090-000118-00505	231

Type	Item no.	Page
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AW FW	090-000093-00505	231

DMHD AR

- Single-stage pressure regulator for measuring pressure
- Controller in front of gas metering units, for example

Coolant outlet pressure	10 bar 200 bar
Gas type	Argon / Mix

Type	Designation	Item no.
Maxex AR/MIX 200bar 30m³ G1/4“	Pressure regulator	096-000000-00000

Suitable for:

Type	Item no.	Page
microplasma 120	090-007015-00502	249

Type	Item no.	Page
microplasma 20	090-007010-00501	248
microplasma 50	090-007012-00501	248

DMHD H2

- Single-stage pressure regulator for measuring pressure
- Controller in front of gas metering units, for example

Coolant outlet pressure	10 bar 200 bar
Gas type	H2

Type	Designation	Item no.
Maxex Hydrogen 200bar 30m³ G3/8“L	Pressure regulator	096-000001-00000

Suitable for:

Type	Item no.	Page
microplasma 120	090-007015-00502	249

Type	Item no.	Page
microplasma 20	090-007010-00501	248
microplasma 50	090-007012-00501	248

Welding accessories ■ Gas metering units for Tetrix plasma machines without digital gas control

GDE2

- Gas metering unit with 2 gas quantity meters
- Shielding gas: 1 - 16,5 l/min
- Pilot arc gas: 0,4 - 5,2 l/min

Type	Designation	Item no.
GDE2	Gas metering unit with 2 gas quantity meters	090-008077-00000

Suitable for:

Type	Item no.	Page
Tetrix 150 Plasma	090-008720-00502	251

GDE2.1

- Gas metering unit with 2 gas quantity meters
- Shielding gas: 1–16.5 l/min
- Pilot arc gas: 0.08–1.08 l/min

Type	Designation	Item no.
GDE2.1	Gas metering unit with 2 gas quantity meters	090-S08077-01033

Suitable for:

Type	Item no.	Page
Tetrix 150 Plasma	090-008720-00502	251

GDE3

- Gas metering unit with 3 gas quantity meters
- Shielding gas: 1–16.5 l/min
- Pilot arc gas: 0.4–5.2 l/min and 0.08–1.08 l/min

Type	Designation	Item no.
GDE3	Gas metering unit with 3 gas quantity meters	090-008081-00000

Suitable for:

Type	Item no.	Page
Tetrix 150 Plasma	090-008720-00502	251

Options/accessories ■ Options for welding machines

EXPERT 2.0 LG

- Networking with built-in Expert 2.0 control for alpha Q Expert 2.0 puls MM and Phoenix Expert 2.0 puls MM series

Type	Designation	Item no.
OW EXPERT 2.0 LG	Expert 2.0 LAN gateway (ex works only)	092-003648-00001

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
ewm Tower Server	092-002813-xxxxx	48
ewm Xnet Starter-Set	091-008788-00001	48
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111

EXPERT 2.0 WLG

- Expert 2.0 WiFi gateway (ex works only)
- Networking with built-in Expert 2.0 control for alpha Q Expert 2.0 puls MM and Phoenix Expert 2.0 puls MM series

Type	Designation	Item no.
OW EXPERT 2.0 WLG	Expert 2.0 WiFi gateway (ex works only)	092-003649-00001

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
ewm Tower Server	092-002813-xxxxx	48
ewm Xnet Starter-Set	091-008788-00001	48
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111

OW LG 1.0

- Networking with built-in LAN gateway for the alpha Q Progress puls MM, Phoenix Progress puls MM and Taurus Synergic S MM machine series

Type	Designation	Item no.
OW LG 1.0	Built-in LAN gateway (ex works only)	092-003645-00001

Suitable for:

Type	Item no.	Page
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
ewm Tower Server	092-002813-xxxxx	48
ewm Xnet Starter-Set	091-008788-00001	48
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161

Type	Item no.	Page
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

Options/accessories ■ Options for welding machines

OW WLG 1.0

- Networking with built-in LAN/WiFi gateway for the alpha Q Progress puls MM, Phoenix Progress puls MM and Taurus Synergic S MM machine series

Type	Designation	Item no.
OW WLG 1.0	Built-in WiFi gateway (ex works only)	092-003646-00001

Suitable for:

Type	Item no.	Page
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
ewm Tower Server	092-002813-xxxxx	48
ewm Xnet Starter-Set	091-008788-00001	48
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161

Type	Item no.	Page
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

ON LG-EX

- Networking via external LAN gateway for machines with 7-pole digital interface

Type	Designation	Item no.
ON LG-EX	LAN gateway in external housing	090-008789-00502

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114

Type	Item no.	Page
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

Options/accessories ■ Options for welding machines

ON WLG-EX

- Networking via external WiFi gateway for machines with 7-pole digital interface

Type	Designation	Item no.
ON WLG-EX	WiFi gateway in external casing	090-008790-00502

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM 2DVX FDW	090-005360-54502	79
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114

Type	Item no.	Page
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

LIZENZ

- Xnet machine licence

Type	Designation	Item no.
ewm Xnet LC1	Xnet machine licence	090-008787-LIZ01
ewm Xnet LC5+1	Xnet machine license 5+1 (6 licenses for the price of 5)	090-008787-LIZ05
ewm Xnet LC10+3	Xnet machine license 10+3 (13 licenses for the price of 10)	090-008787-LIZ10

Suitable for:

Type	Item no.	Page
ewm Tower Server	092-002813-xxxxx	48

Type	Item no.	Page
ewm Xnet Starter-Set	091-008788-00001	48

ON Filter Pico 160

Type	Designation	Item no.
ON Filter Pico 160	Dirt filter for air inlet	092-003206-00000

Suitable for:

Type	Item no.	Page
Pico 160 cel puls	090-002129-00502	254

ON Filter Pico 162

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON Filter Pico 162	Dirt filter for air inlet	092-002072-00000

Suitable for:

Type	Item no.	Page
Pico 162	090-002040-00502	255
Pico 162 MV	090-002042-00502	278

Type	Item no.	Page
Pico 162 VRD	090-002050-00502	255
SET Pico 162	091-002040-00502	255
SET Pico 162 MV	091-002042-00502	278

ON Filter Pico 300

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON Filter Pico 300	Dirt filter for air inlet	092-001856-00000

Suitable for:

Type	Item no.	Page
Pico 300 cel	090-002043-00502	258
Pico 300 cel pws	090-002044-00502	258

Type	Item no.	Page
Pico 300 cel pws vrd 12V	090-002044-00503	258
Pico 300 cel vrd 12V	090-002043-00503	258

ON Filter Pico/Picotig 180/200

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON Filter Pico/Picotig 180/200	Dirt filter for air inlet	092-002546-00000

Suitable for:

Type	Item no.	Page
Pico 180 puls	090-002003-00502	256
Pico 180 puls VRD	090-002051-00502	256
Pico 220 cel puls	090-002057-00502	257
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Picotig 200 MV puls TG	090-002059-00502	205

Type	Item no.	Page
Picotig 200 puls TG	090-002058-00502	204
Set Picotig 200 puls 5P	091-002058-00539	204
Set Picotig 200 puls 5P D	091-002058-00502	204
Set Picotig 200 puls 5P DK/FI/NL/NO/SE	091-002058-00540	204
Set Picotig 200 puls 5P GB	091-002058-00537	204
Set Picotig 200 puls 5P RU	091-002058-00508	204

ON Filter MV/Tetrix 200

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON Filter MV/Tetrix 200	Dirt filter for air inlet	092-002547-00000

Suitable for:

Type	Item no.	Page
Tetrix 200 MV puls 5P TG	090-000229-00502	207

Type	Item no.	Page
Tetrix 200 puls 5P TG	090-000227-00502	206

ON Filter TIG 200/300-2

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON Filter TIG 200/300-2	Dirt filter for air inlet	092-002551-00000

Suitable for:

Type	Item no.	Page
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209

Type	Item no.	Page
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213

ON Filter 2756

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON Filter 2756	Dirt filter for air inlet	092-002756-00000

Suitable for:

Type	Item no.	Page
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws dgs	090-002127-00502	261

Type	Item no.	Page
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132
Set Degauss 600	091-002065-00502	58

ON Filter Picomig

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON Filter Picomig 180	Dirt filter for air inlet	092-002553-00000

Suitable for:

Type	Item no.	Page
Picomig 180 puls TKG	090-005545-00502	83

Type	Item no.	Page
Picomig 180 TKG	090-005546-00502	123

ON Filter 355/405/505/50

- Dirt filter for air inlet
- Reliably protects the machine from dirt under difficult working conditions.
- Suitable for decompact Phoenix xx5, Taurus xx5, cool50 U40 and cool50-2 U40

Type	Designation	Item no.
ON Filter 355/405/505/50	Dirt filter for air inlet	092-002698-00000

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Set Taurus 505 Basic Duo Gouging	092-008313-00000	150
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 355 S HP MM TKM	090-005407-00502	136

Type	Item no.	Page
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149

ON Filter xx5

- Dirt filter for air inlet
- Comprised of two filter units
- For Picomig 185/305 D3 and Phoenix/Taurus 355 compact

Type	Designation	Item no.
ON Filter xx5	Dirt filter for air inlet	092-002662-00000

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85

Type	Item no.	Page
Picomig 355 TKG	090-005512-00502	125
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138

Options/accessories ■ Options for welding machines

ON Filter Tetrix 300 cel / 300 AC/DC

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON Filter Tetrix 300 cel / 300 AC/DC	Dirt filter for air inlet	092-007901-00000

ON Filter T/P

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.
- For all mobile alpha Q/Phoenix/Taurus/Tetrix 351/401/451/551 machines

Type	Designation	Item no.
ON Filter T/P	Dirt filter for air inlet	092-002092-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161

Type	Item no.	Page
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

ON Filter Tetrix XL

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON Filter Tetrix XL	Dirt filter for air inlet	092-004999-00000

Suitable for:

Type	Item no.	Page
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228

Type	Item no.	Page
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228

ON Filter S

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON Filter S	Dirt filter for air inlet	092-002090-00000

Suitable for:

Type	Item no.	Page
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184

Type	Item no.	Page
Saturn 351 FDG	090-004991-00502	187
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185

ON Filter W

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON Filter W	Dirt filter for air inlet	092-002091-00000

Suitable for:

Type	Item no.	Page
Wega 401 FDG	090-004948-00502	192
Wega 401 FDW	090-004949-00502	194

Type	Item no.	Page
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M2.20 FKG	090-005225-00502	189

ON FILTER WEGA 501/601

- Dirt filter for air inlet
- Reliably protects the machine from impurities under tough working conditions.

Type	Designation	Item no.
ON FILTER WEGA 501/601	Dirt filter for air inlet	092-002730-00000

Suitable for:

Type	Item no.	Page
Wega 401 FDW	090-004949-00502	194

Type	Item no.	Page
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

OW Reinforced Pump T/P

- Reinforced coolant pump
- Recommended for long hose packages. Increases the flow rate up to 20 l/min and the pressure to max. 4.5 bar

Type	Designation	Item no.
OW Reinforced Pump T/P	Heavy-duty coolant pump (only ex works)	092-002118-00001

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKW	090-005422-00502	159

Type	Item no.	Page
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

OW Reinforced Pump Wega

- Reinforced coolant pump

Type	Designation	Item no.
OW Reinforced Pump Wega	Heavy-duty coolant pump (only ex works)	092-002119-00001

Suitable for:

Type	Item no.	Page
Wega 401 FDW	090-004949-00502	194

OW Key Switch XX5

- Key switch for locking the welding machine control (ex works only)
- For modular compact machines

Type	Designation	Item no.
OW Key Switch XX5	Key switch for locking the welding machine control (ex works only)	092-002666-00001

Suitable for:

Type	Item no.	Page
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138

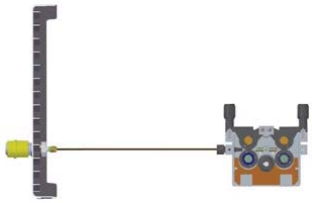
ON Key Switch Tetrix

Type	Designation	Item no.
ON Key Switch Tetrix	Key switch	092-001828-00000

Suitable for:

Type	Item no.	Page
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

ON D XX5 BARREL



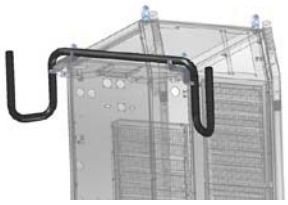
Type	Designation	Item no.
ON D XX5 BARREL	Wire guide Rolliner for drum feed	092-007929-00000

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85
Picomig 355 TKG	090-005512-00502	125
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138

Options/accessories ■ Options for welding machines

ON HS XX1



- Mount for hose packages and remote control
- Keeps the machine tidy: tubes and cables from items such as welding torches or remote controls can be coiled on the machine, so that they are neat and tidy. Also helps to fix remote controls in place
- For all mobile alpha Q/Phoenix/Taurus/Tetrix 351/401/451/551 machines

Type	Designation	Item no.
ON HS XX1	Mount for hose packages and remote control	092-002910-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170

Type	Item no.	Page
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215
Wega 401 FDG	090-004948-00502	192
Wega 401 FDW	090-004949-00502	194
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M2.20 FKG	090-005225-00502	189

ON CS 55

Type	Designation	Item no.
ON CS K	Crane suspension for Picomig 180/185 D3/305 D3; Phoenix and Taurus 355 compact; drive 4	092-002549-00000

Suitable for:

Type	Item no.	Page
drive 4X IC HP	090-005414-00502	287
drive 4X IC LP	090-005415-00502	286
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Picomig 180 puls TKG	090-005545-00502	83
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124

Type	Item no.	Page
Picomig 355 puls TKG	090-005542-00502	85
Picomig 355 TKG	090-005512-00502	125
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138

ON CS D

Type	Designation	Item no.
ON CS D	Crane console, transport/ram protection Phoenix/Taurus 355/405/505	092-007895-00032

Suitable for:

Type	Item no.	Page
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Taurus 355 Basic TDM	090-005286-00502	140

Type	Item no.	Page
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 S MM TDM	090-005338-00502	143

ON Set CS HOR

- Cross arm for horizontal suspension of the machine
- To mount the welding machine, e.g. directly above the workplace.

Type	Designation	Item no.
ON Set CS HOR 330	Cross arm for horizontal suspension of the machine	092-001832-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68

Type	Item no.	Page
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66

ON Set CS HOR/VER alpha Q 330

- Cross arm for horizontal suspension of the machine
- To mount the welding machine, e.g. directly above the workplace.

Type	Designation	Item no.
ON Set CS HOR/VER 330 alpha Q	Cross arm for horizontal or vertical suspension of the machine. With impact protection	092-002393-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68

Type	Item no.	Page
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66

ON PS drive 4L/4X T/P

- Pivot support for wire feeders
- Wire feeder pivots 360° on the welding machine

Type	Designation	Item no.
ON PS drive 4L/4X T/P	Pivot support	092-002112-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170

Type	Item no.	Page
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

ON DK drive 41L Wega

- Pivot support for wire feeders
- Wire feeder pivots 360° on the welding machine
- Only for Wega 401

Type	Designation	Item no.
ON DK drive 41L Wega	Pivot support, horizontal for Drive 41L	092-002113-00000

Suitable for:

Type	Item no.	Page
Wega 401 FDG	090-004948-00502	192

Type	Item no.	Page
Wega 401 FDW	090-004949-00502	194

ON DK drive 41L Wega 501/601

- Pivot support for wire feeders
- Wire feeder pivots 360° on the welding machine
- For Wega 501/601

Type	Designation	Item no.
ON DK drive 41L Wega 501/601	Pivot support, horizontal for Drive 41L	092-002635-00000

Suitable for:

Type	Item no.	Page
Wega 501 FDW	090-005088-00502	195

Type	Item no.	Page
Wega 601 FDW	090-005089-00502	195

ON PS Phoenix drive 4

- Pivot support for wire feeders
- Wire feeder pivots 360° on the welding machine

Type	Designation	Item no.
ON PS Phoenix drive 4	Pivot support for drive 4	092-002280-00000

Suitable for:

Type	Item no.	Page
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170

Type	Item no.	Page
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

ON DK drive 41 Wega 401

- Pivot support for wire feeders
- Only for Wega 401
- Cannot be used with wheel assembly kit 090-008035-00000

Type	Designation	Item no.
ON DK drive 41 Wega 401	Pivot support, horizontal for Drive 41	092-002522-00000

Suitable for:

Type	Item no.	Page
Wega 401 FDG	090-004948-00502	192

Type	Item no.	Page
Wega 401 FDW	090-004949-00502	194

ON DK drive 41 Wega 501/601

- Pivot support for wire feeders
- Cannot be used with wheel assembly kit 090-008035-00000

Type	Designation	Item no.
ON DK drive 41 Wega 501/601	Pivot support, horizontal for Drive 41	092-000680-00000

Suitable for:

Type	Item no.	Page
Wega 501 FDW	090-005088-00502	195

Type	Item no.	Page
Wega 601 FDW	090-005089-00502	195

Options/accessories ■ Options for welding machines

ON PS drive 4 Wheels T/P

- Pivot support for wire feeders
- Wire feeder pivots 360° on the welding machine

Type	Designation	Item no.
ON PS drive 4 Wheels T/P	Set comprising pivot support and wheel kit for Drive 4 type wire feeders	092-002284-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173

Type	Item no.	Page
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174

TS drive 4L / HW

- For Tetrix hot wire power sources only!

Type	Designation	Item no.
TS drive 4L / HW	Support for transport for Tetrix drive 4L and Tetrix 270 Hotwire	092-000038-00001

Suitable for:

Type	Item no.	Page
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 451 AC/DC AW FW	090-000112-00505	235

Type	Item no.	Page
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AW FW	090-000093-00505	231

ON Holder Gas Bottle <50L

- Holding plate for gas cylinders smaller than 50 litres
- Transport even small gas cylinders safely on the machine
- Not suitable for mounting on double cylinder carts!

Type	Designation	Item no.
ON Holder Gas Bottle <50L	Holding plate for gas cylinders smaller than 50 litres	092-002151-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKG	090-005426-00502	152

Type	Item no.	Page
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215
Wega 401 FDG	090-004948-00502	192
Wega 401 FDW	090-004949-00502	194

ON Holder Gas Bottle <50L Tetrix XL

- Holding plate for gas cylinders smaller than 50 litres
- Transport even small gas cylinders safely on the machine
- Not suitable for mounting on double cylinder carts!

Type	Designation	Item no.
ON Holder Gas Bottle <50L TETRIX XL	Holding plate for gas cylinders smaller than 50 litres	092-002345-00000

Suitable for:

Type	Item no.	Page
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228

Type	Item no.	Page
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228

ON Shock Protect

- Ram protection: protects the machine from scratches and dents. Highly recommended if the machine is transported frequently
- Not possible in combination with parking brake, wheel spacers or double cylinder cart!

Type	Designation	Item no.
ON Shock Protect	Ram protection	092-002154-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170

Type	Item no.	Page
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

ON Tool Box

- Toolbox between gas cylinder and rear casing panel
- Tools and torch replaceable parts always to hand.
- Dimensions L x W x H in mm: 240 x 100 x 80

Type	Designation	Item no.
ON Tool Box	Toolbox between gas cylinder and rear casing panel	092-002138-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173

Type	Item no.	Page
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215
Wega 401 FDG	090-004948-00502	192
Wega 401 FDW	090-004949-00502	194
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M2.20 FKG	090-005225-00502	189

ON CASE 55

- Tool box for mounting to trolley Trolly 55-5
- All tools and replacement parts always to hand.
- Only suitable for gas-cooled machines from the XX5 series used with trolley 55,5!

Type	Designation	Item no.
ON TC 55	Tool box for mounting to trolley Trolly 55-5	092-002899-00000

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Picomig 355 puls TKG	090-005542-00502	85
Picomig 355 TKG	090-005512-00502	125

Type	Item no.	Page
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 S MM TDM	090-005338-00502	143

ON WHEELS 330

- Wheel set – facilitates work at frequently changing welding sites

Type	Designation	Item no.
ON WHEELS 330	Wheel assembly kit for series 330 machine	092-002387-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68

Type	Item no.	Page
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66

ON WAK xx5

- Wheel set – facilitates work at frequently changing welding sites
- For Picomig 185 / 305 D3, Phoenix / Taurus 355 TKM and Phoenix / Taurus 355, 405, 505 TDM

Type	Designation	Item no.
ON WAK xx5	Wheel assembly kit	092-001356-00000

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85
Picomig 355 TKG	090-005512-00502	125
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TDW	090-005436-00502	145

Type	Item no.	Page
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149

ON WAK tigSpeed

Type	Designation	Item no.
ON WAK tigSpeed	With wheel assembly kit with strain relief	092-007927-00000

Suitable for:

Type	Item no.	Page
tigSpeed continuous drive 45 coldwire	090-000237-00502	232
tigSpeed continuous drive 45 hotwire	090-000236-00502	244

Type	Item no.	Page
tigSpeed oscillation drive 45 coldwire	090-000181-00502	233
tigSpeed oscillation drive 45 hotwire	090-000180-00502	245

ON LB Wheels 125x38MM

- Front wheels with locking brake allow the machine to be safely parked even on uneven ground.

Type	Designation	Item no.
ON LB Wheels 125x38MM	Locking brake for machine wheels	092-002109-00000

Suitable for:

Type	Item no.	Page
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184

Type	Item no.	Page
Saturn 351 FDG	090-004991-00502	187
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185

ON LB Wheels 160x40MM

- Front wheels with locking brake allow the machine to be safely parked even on uneven ground.
- Locking brake cannot be combined with ram protection!

Type	Designation	Item no.
ON LB Wheels 160x40MM	Locking brake for machine wheels	092-002110-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164

Type	Item no.	Page
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215
Trolly 55-5	090-008632-00000	370
Trolly 55-5 DM	090-008632-00001	370
Wega 401 FDG	090-004948-00502	192
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

ON Safeguard S

- Optimised supplementary protection provided by impact-resistant and insulating enclosure for use under difficult conditions.
- May be retrofitted with just a few steps
- Lightweight and robust
- Washable

Type	Designation	Item no.
ON Safeguard S	Insulating protective cover for Pico 162/Pico 162 MV	092-007879-00000
12x ON Safeguard S	12-item pack, ON Safeguard S	092-015273-00000

Suitable for:

Type	Item no.	Page
Pico 162	090-002040-00502	255
Pico 162 MV	090-002042-00502	278

Type	Item no.	Page
Pico 162 VRD	090-002050-00502	255
SET Pico 162	091-002040-00502	255
SET Pico 162 MV	091-002042-00502	278

ON Safeguard M

- Optimised supplementary protection provided by impact-resistant enclosure for use under difficult conditions.
- May be retrofitted with just a few steps
- Lightweight and robust
- Washable

Type	Designation	Item no.
ON Safeguard M	Protective sleeve for welding machines	092-008767-00000
8x ON Safeguard M	Packing unit 8 pieces ON Safeguard M	092-002806-00000

Suitable for:

Type	Item no.	Page
Pico 180 puls	090-002003-00502	256
Pico 180 puls VRD	090-002051-00502	256
Pico 220 cel puls	090-002057-00502	257
Picotig 200 puls TG	090-002058-00502	204

ON Handle Pico 160

Type	Designation	Item no.
ON Handle Pico 160	Handle	092-003205-00000

Suitable for:

Type	Item no.	Page
Pico 160 cel puls	090-002129-00502	254

ON Drahteinschleich Poti M1.02

Type	Designation	Item no.
ON Drahteinschleich Poti M1.02	Rotary knob for setting the wire creep speed	092-001102-00000

Suitable for:

Type	Item no.	Page
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 FDG	090-004991-00502	187
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Wega 401 FDG	090-004948-00502	192
Wega 401 FDW	090-004949-00502	194
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

Veraltet ON AIF 335

Type	Designation	Item no.
ON AIF K XX5	Interface for automated welding	092-001237-00000

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97

ON AIF MOD 405/505

Type	Designation	Item no.
ON AIF D xx5	Analogue interface for automated welding for modular Phoenix Progress	092-007891-00000

Suitable for:

Type	Item no.	Page
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98

ON A INTERFACE

Type	Designation	Item no.
ON A INTERFACE	Analogue interface for automated welding for Phoenix Progress	092-001779-00000

Suitable for:

Type	Item no.	Page
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM FDW	090-005328-00502	108

ON 7pol

Type	Designation	Item no.
ON 7pol	Connection socket	092-001826-00000

Suitable for:

Type	Item no.	Page
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

ON 8pol Tetrix 200

Type	Designation	Item no.
ON 8pol Tetrix 200	8-pole welding torch connection socket for Tetrix 180 (from serial No. 196718 onwards) and Tetrix 200	092-002465-00000

Suitable for:

Type	Item no.	Page
Tetrix 200 MV puls 5P TG	090-000229-00502	207
Tetrix 200 puls 5P TG	090-000227-00502	206

ON 12pol Retox Tetrix 200/300-2

Type	Designation	Item no.
ON 12pol Retox Tetrix 200/300-2	12-pole welding torch connection socket for connection to Tetrix 200/300-2	092-002466-00000

Suitable for:

Type	Item no.	Page
Tetrix 200 MV puls 5P TG	090-000229-00502	207

Type	Item no.	Page
Tetrix 200 puls 5P TG	090-000228-00502	206
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213

ON 12pol TIG Tetrix 190/230

Type	Designation	Item no.
ON 12pol Retox TIG 190/230	12-pole torch connection socket	092-002519-00000

Suitable for:

Type	Item no.	Page
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222

ON 12pol Retox Tetrix 300/400/401/351/451/551

Type	Designation	Item no.
ON 12pol Retox Tetrix 300/400/401/ 351/4	Connection socket	092-001807-00000

Suitable for:

Type	Item no.	Page
Tetrix 300 TM	090-000125-00502	210
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215

Type	Item no.	Page
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 FW	090-000131-00502	215

ON 19pol Tetrix 300/351

Type	Designation	Item no.
ON 19pol Tetrix 300/351	Connection socket	092-001827-00000

Suitable for:

Type	Item no.	Page
Tetrix 300 TM	090-000125-00502	210
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228

Type	Item no.	Page
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228

Options/accessories ■ Options for welding machines

ON 19pol 351/451/551

Type	Designation	Item no.
ON 19pol 351/451/551	19-pole connection socket for accessory components and/or as analog interface for automated welding	092-001951-00000

Suitable for:

Type	Item no.	Page
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235

Type	Item no.	Page
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215

ON Netsynchron 351/451/551

Type	Designation	Item no.
ON Netsynchron 351/451/551	Phase sequence changeover set for synchronous welding	090-008212-00000

Suitable for:

Type	Item no.	Page
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 451 AC/DC AW FW	090-000112-00505	235

Type	Item no.	Page
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228

OW CEE16A

- Factory fitting (no retrofitting)

Max. welding current	16 A

Type	Designation	Item no.
OW CEE 16A/400V	Factory-fit option, mains plug including fitting	092-008214-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Pico 220 cel puls	090-002057-00502	257
Pico 300 cel	090-002043-00502	258
Pico 300 cel pws	090-002044-00502	258
Pico 300 cel pws vrd 12V	090-002044-00503	258
Pico 300 cel vrd 12V	090-002043-00503	258
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws dgs	090-002127-00502	261
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132

Type	Item no.	Page
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210

OW CEE32A

- Factory fitting (no retrofitting)
- Suitable for all machines with a welding current of 350 A and above

Max. welding current	32 A

Type	Designation	Item no.
OW CEE 32A	Factory-fit option, mains plug including fitting	092-008215-00000

Options/accessories ■ Options for wire feeders

ON TS drive 4X

- Torch holder
- For greater safety while working
- Extends torch service life
- Keeps work area organised

Type	Designation	Item no.
ON TS drive 4X	Torch holder for drive 4X, drive 4 Basic and drive 4X IC	092-002836-00000

Suitable for:

Type	Item no.	Page
drive 4 Basic	090-005401-00502	281
drive 4 Basic MMA	090-005401-51502	281
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284
drive 4X EX MMA GFE	090-005511-60502	284

Type	Item no.	Page
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X IC HP	090-005414-00502	287
drive 4X IC LP	090-005415-00502	286
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282

ON WAK drive 4X

- Wheel set
- Makes drive 4X even more versatile
- Ensures limitless mobility
- Large rollers (Ø 125 mm) for optimal freedom of movement

Type	Designation	Item no.
ON WAK drive 4X	Wheel assembly kit for drive 4X and drive 4 Basic	092-002844-00000

Suitable for:

Type	Item no.	Page
drive 4 Basic	090-005401-00502	281
drive 4 Basic MMA	090-005401-51502	281
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284

Type	Item no.	Page
drive 4X EX MMA GFE	090-005511-60502	284
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282

ON RFAK drive 4X

- Rubber feet to replace sliding rails

Type	Designation	Item no.
ON RFAK drive 4X	Rubber feet for drive 4X and drive 4 Basic	092-002845-00000

Suitable for:

Type	Item no.	Page
drive 4 Basic	090-005401-00502	281
drive 4 Basic MMA	090-005401-51502	281
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284

Type	Item no.	Page
drive 4X EX MMA GFE	090-005511-60502	284
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282

ON GK drive 4X

- Metal runners for drive 4X and drive 4 Basic

Type	Designation	Item no.
ON GK drive 4X	Metal runners for drive 4X and drive 4 Basic	092-003030-00000

Suitable for:

Type	Item no.	Page
drive 4 Basic	090-005401-00502	281
drive 4 Basic MMA	090-005401-51502	281
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284

Type	Item no.	Page
drive 4X EX MMA GFE	090-005511-60502	284
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282

OW GFE

- Electronic shielding gas flow control
- Fully reproducible thanks to digital configuration and saving to the respective JOB (welding task)
- Constant gas flow rate thanks to electronic adjustment
- Nominal and actual value display of gas flow rate in l/min

Type	Designation	Item no.
OW GFE	Electronic gas flow control for drive 4X (ex works)	092-002812-00001

Suitable for:

Type	Item no.	Page
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284
drive 4X EX MMA GFE	090-005511-60502	284

Type	Item no.	Page
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282

ON CMF drive 4X

- Crane suspension for safe and easy transportation
- Maximum mobility even during suspension operations

Type	Designation	Item no.
ON CMF drive 4X	Crane suspension for drive 4X and drive 4 Basic	092-002833-00000

Suitable for:

Type	Item no.	Page
drive 4 Basic	090-005401-00502	281
drive 4 Basic MMA	090-005401-51502	281
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284

Type	Item no.	Page
drive 4X EX MMA GFE	090-005511-60502	284
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282

ON TCC drive 4X

- Heavy-duty set: safety plate and crane suspension
- For optimised protection under tough conditions
- For standing, vertical and suspension operation
- Temperature- and impact-resistant sliding safety plate
- Crane suspension for maximum mobility and easy, safe transport

Type	Designation	Item no.
ON TCC drive 4X	Set comprises crane suspension bracket and protective plate, for use of drive 4X and drive 4 Basic in lateral position	092-002835-00000

Suitable for:

Type	Item no.	Page
drive 4 Basic	090-005401-00502	281
drive 4 Basic MMA	090-005401-51502	281
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284
drive 4X EX MMA GFE	090-005511-60502	284
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282

ON CC drive 4X

- Protective cap made of transparent plastic
- Reliable protection for the entire control
- Good visibility of the protected display

Type	Designation	Item no.
ON CC drive 4X	Transparent cover cap to protect the whole machine control for drive 4X and drive 4 Basic	092-002834-00000

Suitable for:

Type	Item no.	Page
drive 4 Basic	090-005401-00502	281
drive 4 Basic MMA	090-005401-51502	281
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284
drive 4X EX MMA GFE	090-005511-60502	284
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282

ON PDM drive 4X

- Cover lens made of transparent plastic
- Protects control against dirt and damage
- Operation still possible thanks to recesses for the rotary knobs

Type	Designation	Item no.
ON PDM drive 4X	Transparent cover lens for machine control	092-002987-00000

Suitable for:

Type	Item no.	Page
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282

ON CONNECTOR drive 4X

- Connection for drum feed
- Drum-based feed boosts effectiveness
- Less need to change wire spools saves time

Type	Designation	Item no.
ON CONNECTOR drive 4X	Connection for wire feeding from drum for drive 4X, drive 4 Basic and drive 4X IC	092-002842-00000
CONNECTOR BARREL	Connection for large spool/drum	094-011517-00000
WIRE CONDUIT 1,8M	Wire guide	094-011515-00004
WIRE CONDUIT 3M		094-011515-00000
WIRE CONDUIT 4,5M		094-011515-00001
WIRE CONDUIT 8M		094-011515-00002
WIRE CONDUIT 12M		094-011515-00003

Suitable for:

Type	Item no.	Page
drive 4 Basic	090-005401-00502	281
drive 4 Basic MMA	090-005401-51502	281
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284
drive 4X EX MMA GFE	090-005511-60502	284
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282

ON DREHDORN VERLAENGERUNG

- Retrofit set: turning mandrel extension, for supporting the drive 4X / drive 4 Basic with wheel kit ON WAKD 4X
- The 092-002112-00000 pivot support must be used! Not possible with gas-cooled demodular machines and Trolly 55-5!

Type	Designation	Item no.
ON PS EXT drive 4X	Retrofit set: turning mandrel extension, for supporting the drive 4X / drive 4 Basic with wheel kit ON WAKD 4X	092-002871-00000

Suitable for:

Type	Item no.	Page
drive 4 Basic	090-005401-00502	281
drive 4 Basic MMA	090-005401-51502	281
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284
drive 4X EX MMA GFE	090-005511-60502	284
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282

ON WAKD 4L/41L

- Wheel set – facilitates work at frequently changing welding sites
- Extra large wheels for easier movement across uneven ground
- May not be used together with pivot supports 092-002112-00000, 092-002113-00000 or 092-002635-00000.

Type	Designation	Item no.
ON WAKD 4L/41L	Wheel assembly kit for drive 4L/41L	090-008169-00000

Suitable for:

Type	Item no.	Page
Pico drive 4L	090-002121-00502	288
Saturn M1.02 drive 41L	090-004995-00502	289
Saturn M2.20 drive 41L	090-004996-00502	289
Saturn M2.40 drive 41L	090-004997-00502	289
Tetrix drive 4L	090-000094-00502	288
Wega M1.02 drive 41L	090-004965-00502	289
Wega M2.20 drive 41L	090-004966-00502	289
Wega M2.40 drive 41L	090-004967-00502	289

ON WAKD 4/41

- Wheel set – facilitates work at frequently changing welding sites
- May not be used with pivot supports for Wega (092-002522-00000 and 092-000680-00000)!

Type	Designation	Item no.
ON WAKD 4/41	Wheel assembly kit for drive 4/41	090-008035-00000

Suitable for:

Type	Item no.	Page
drive 4 IC Basic	090-005416-00502	285
drive 4X IC HP	090-005414-00502	287
drive 4X IC LP	090-005415-00502	286
Saturn M1.02 drive 41	090-004992-00502	290

Type	Item no.	Page
Saturn M2.20 drive 41	090-004993-00502	290
Saturn M2.40 drive 41	090-004994-00502	290
Wega M1.02 drive 41	090-004962-00502	290
Wega M2.20 drive 41	090-004963-00502	290
Wega M2.40 drive 41	090-004964-00502	290

ON WAKD2 4L/41L

- Wheel set – facilitates work at frequently changing welding sites

Type	Designation	Item no.
ON WAKD2 4L/41L	Wheel assembly kit for drive 4L/41L	090-008151-00000

Suitable for:

Type	Item no.	Page
Pico drive 4L	090-002121-00502	288
Saturn M1.02 drive 41L	090-004995-00502	289
Saturn M2.20 drive 41L	090-004996-00502	289
Saturn M2.40 drive 41L	090-004997-00502	289

Type	Item no.	Page
Tetrix drive 4L	090-000094-00502	288
Wega M1.02 drive 41L	090-004965-00502	289
Wega M2.20 drive 41L	090-004966-00502	289
Wega M2.40 drive 41L	090-004967-00502	289

ON RADMONTAGESATZ DOPPELKOFFER

- Wheel set – facilitates work at frequently changing welding sites

Type	Designation	Item no.
ON WAK drive 4D	Wheel assembly kit for double wire feeder drive 4D	090-008810-00000

Suitable for:

Type	Item no.	Page
drive 4X D HP	090-005459-00502	292

Options/accessories ■ Options for transport carts

ON CS Trolly 35.2-2

- Suspension for instant, easy crane transportation of welding machine and Trolly

Type	Designation	Item no.
ON CS Trolly 35.2-2	Crane suspension for Trolly 35.2-2	092-002931-00000

Suitable for:

Type	Item no.	Page
6x Trolly 35.2-2	092-015282-00000	269

Type	Item no.	Page
Trolly 35.2-2	090-008296-00000	369

ON TC 55

- Tool box for mounting to trolley Trolly 55-5
- All tools and replacement parts always to hand.
- Only suitable for gas-cooled machines from the XX5 series used with trolley 55,5!

Type	Designation	Item no.
ON TC 55	Tool box for mounting to trolley Trolly 55-5	092-002899-00000

Suitable for:

Type	Item no.	Page
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Picomig 355 puls TKG	090-005542-00502	85
Picomig 355 TKG	090-005512-00502	125

Type	Item no.	Page
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 S MM TDM	090-005338-00502	143

Options/accessories ■ Options for transport carts

ON TR Trolly 55-5

Type	Designation	Item no.
ON TR Trolly 55-5	Cross arm and holder for wire feeder	092-002700-00000

Suitable for:

Type	Item no.	Page
Trolly 55-5	090-008632-00000	370

Type	Item no.	Page
Trolly 55-5 DM	090-008632-00001	370

ON PS Trolly 55-5 drive 4L/4X

- Wire feeder pivots 360° on the welding machine
- For drive 4L / drive 4X / drive 4 Basic on trolly 55-5

Type	Designation	Item no.
ON PS Trolly 55-5 drive 4L/4X	Pivot support	092-002712-00000

Suitable for:

Type	Item no.	Page
Trolly 55-5	090-008632-00000	370

Type	Item no.	Page
Trolly 55-5 DM	090-008632-00001	370

General accessories

Set LC 35qmm

Type	Designation	Item no.
Set LC 35 mm²	Set: Two 5-metre load cables (35 mm²) and one 20-metre load cable (35 mm²) for degaussing	092-002921-00000

Suitable for:

Type	Item no.	Page
Pico 350 cel puls pws dgs	090-002127-00502	261

Type	Item no.	Page
Set Degauss 600	091-002065-00502	58

16A 5POLE/CEE

Type	Designation	Item no.
16A 5POLE/CEE	Mains plug	094-000712-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Pico 220 cel puls	090-002057-00502	257
Pico 300 cel	090-002043-00502	258
Pico 300 cel pws	090-002044-00502	258
Pico 300 cel pws vrd 12V	090-002044-00503	258
Pico 300 cel vrd 12V	090-002043-00503	258
Pico 350 cel puls	090-002060-00502	131
Pico 350 cel puls pws	090-002061-00502	132
Pico 350 cel puls pws dgs	090-002127-00502	261
Pico 350 cel puls pws vrd (AUS)	090-002061-28503	132
Pico 350 cel puls vrd (AUS)	090-002060-28503	132

Type	Item no.	Page
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85
Picomig 355 TKG	090-005512-00502	125
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210

General accessories

32A 5POLE/CEE

Type	Designation	Item no.
32A 5POLE/CEE	Mains plug	094-000207-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM FDW	090-005359-00502	73
alpha Q 351 Progress puls MM FDW	090-005333-00502	71
alpha Q 551 Expert 2.0 puls MM FDW	090-005360-00502	73
alpha Q 551 Progress puls MM FDW	090-005334-00502	71
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Saturn 351 FDG	090-004991-00502	187
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Set Degauss 600	091-002065-00502	58
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 355 Basic TDM	090-005286-00502	140
Taurus 355 Basic TDW	090-005436-00502	145
Taurus 355 S MM TDM	090-005336-00502	143
Taurus 355 S MM TDW	090-005437-00502	148
Taurus 401 Basic FDG	090-005249-00502	164

Type	Item no.	Page
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 405 Basic TDM	090-005241-00502	141
Taurus 405 Basic TDW	090-005438-00502	145
Taurus 405 S MM TDM	090-005337-00502	143
Taurus 405 S MM TDW	090-005439-00502	148
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 505 Basic TDM	090-005221-00502	141
Taurus 505 Basic TDW	090-005440-00502	146
Taurus 505 S MM TDM	090-005338-00502	143
Taurus 505 S MM TDW	090-005441-00502	149
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215
Wega 401 FDG	090-004948-00502	192
Wega 401 FDW	090-004949-00502	194
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

SCHUKO/16A

Type	Designation	Item no.
SKGS 16A 250V CEE7/7, DIN 49440/441	Shock-proof plug, solid rubber	094-001756-00000

Suitable for:

Type	Item no.	Page
Pico 180 puls	090-002003-00502	256
Pico 180 puls VRD	090-002051-00502	256
Picotig 200 puls TG	090-002058-00502	204
Tetrix 200 puls 5P TG	090-000227-00502	206

ADAP CEE16/SCHUKO

Type	Designation	Item no.
ADAP CEE16/SCHUKO	Earth contact coupling/CEE16A plug	092-000812-00000

Suitable for:

Type	Item no.	Page
Pico 162	090-002040-00502	255
Pico 162 MV	090-002042-00502	278
Pico 162 VRD	090-002050-00502	255
Pico 180 puls	090-002003-00502	256
Pico 180 puls VRD	090-002051-00502	256
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Picotig 200 MV puls TG	090-002059-00502	205
Picotig 200 puls TG	090-002058-00502	204
SET Pico 162	091-002040-00502	255
SET Pico 162 MV	091-002042-00502	278
Tetrix 200 puls 5P TG	090-000227-00502	206
Tetrix 230 AC/DC 2.0 puls 5P TM	090-000239-00502	224
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209

ADAP 8-5 POL

Type	Designation	Item no.
ADAP 8-5 POL	8-to-5-pole cable adapter	092-000940-00000

ADAP 16/25-35 QMM

Type	Designation	Item no.
ADAP 16/25-35 QMM	Welding current socket adapter, 9/13 mm (16 mm²/35 mm²)	094-001780-00000

Suitable for:

Type	Item no.	Page
Pico 162	090-002040-00502	255
Pico 162 MV	090-002042-00502	278
Pico 162 VRD	090-002050-00502	255
SET Pico 162	091-002040-00502	255
SET Pico 162 MV	091-002042-00502	278

General accessories

ADAP ZSP 5POLIG/500MM

Type	Designation	Item no.
ADAP ZSP 5POLIG/500MM	Adapter for tigSpeed intermediate hose package for connection to equipment from other manufacturers	094-019463-00000

Suitable for:

Type	Item no.	Page
tigSpeed continuous drive 45 coldwire	090-000237-00502	232
tigSpeed continuous drive 45 hotwire	090-000236-00502	244

Type	Item no.	Page
tigSpeed oscillation drive 45 coldwire	090-000181-00502	233
tigSpeed oscillation drive 45 hotwire	090-000180-00502	245

AK300

- Wire spool adapter for use with a wire basket spool (B 300)

Type	Designation	Item no.
AK300	Wire spool adapter B300	094-001803-00001

CA D200

- Centering adapter 5 kg (D200) spools on wire spool support for 15 kg (D300) spools

Type	Designation	Item no.
CA D200	Centering adapter for 5 kg spool	094-011803-00000

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
drive 4 Basic	090-005401-00502	281
drive 4 Basic MMA	090-005401-51502	281
drive 4X EX	090-005511-00502	284
drive 4X EX GFE	090-005511-55502	284
drive 4X EX MMA	090-005511-51502	284
drive 4X EX MMA GFE	090-005511-60502	284
drive 4X HP	090-005392-00502	283
drive 4X HP MMA	090-005392-51502	283
drive 4X IC HP	090-005414-00502	287
drive 4X IC LP	090-005415-00502	286
drive 4X LP	090-005412-00502	282
drive 4X LP MMA	090-005412-51502	282
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103

Type	Item no.	Page
Taurus 351 Basic FKG	090-005425-00502	152
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKG	090-005431-00502	155
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKG	090-005428-00502	153
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 355 Basic TKM	090-005406-00502	134
Taurus 355 Basic TKW	090-005442-00502	137
Taurus 355 S HP MM TKM	090-005407-00502	136
Taurus 355 S HP MM TKW	090-005444-00502	139
Taurus 355 S LP MM TKM	090-005421-00502	135
Taurus 355 S LP MM TKW	090-005443-00502	138
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKG	090-005432-00502	156
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKG	090-005429-00502	154
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160

CBP Pico 162

- Transport case for welding machine and accessories

Type	Designation	Item no.
CBP Pico 162	Transport case, empty	094-010324-00500

Suitable for:

Type	Item no.	Page
Pico 162	090-002040-00502	255
Pico 162 MV	090-002042-00502	278

Type	Item no.	Page
Pico 162 VRD	090-002050-00502	255
SET Pico 162	091-002040-00502	255
SET Pico 162 MV	091-002042-00502	278

CBP Picotig 200

- Transport case for welding machine and accessories

Type	Designation	Item no.
CBP Picotig	Transport case, empty	094-012322-00500

Suitable for:

Type	Item no.	Page
Picotig 200 MV puls TG	090-002059-00502	205

Type	Item no.	Page
Picotig 200 puls TG	090-002058-00502	204

General accessories

GH 2X1/4“

- Shielding gas hose
- Equipped with plastic nuts on both sides for tool-free assembly

Type	Designation	Length	Item no.
		m	
GH 2x1/4“ 2m	Gas hose	2.0	094-000010-00001
GH 2x1/4“ 3m		3.0	094-000010-00003
GH 2X1/4“ 5m		5.0	094-000010-00005

Suitable for:

Type	Item no.	Page
alpha Q 330 Progress puls HP MM TKM	090-005402-00502	68
alpha Q 330 Progress puls LP MM TKM	090-005501-00502	66
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
alpha Q 351 Progress puls MM 2DVX FDW	090-005333-54502	77
alpha Q 351 Progress puls MM D FDW	090-005333-10502	75
alpha Q 551 Progress puls MM 2DVX FDW	090-005334-54502	77
alpha Q 551 Progress puls MM D FDW	090-005334-10502	75
DM 842 Ar/CO2 230bar 15l D	394-002910-00015	382
DM 842 Ar/CO2 230bar 30l D	394-002910-00030	382
microplasma 120	090-007015-00502	249
microplasma 20	090-007010-00501	248
microplasma 50	090-007012-00501	248
Mira 151 FKG	090-005084-00502	180
Mira 221 MV FKG	090-005085-00502	180
Mira 251 FKG	090-005086-00502	180
Mira 301 M1.02 FKG	090-005181-00502	181
Mira 301 M2.20 FKG	090-005207-00502	182
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 355 Expert 2.0 puls MM TDM	090-005352-00502	100
Phoenix 355 Expert 2.0 puls MM TKM	090-005445-00502	94
Phoenix 355 Progress puls HP MM TKM	090-005403-00502	92
Phoenix 355 Progress puls LP MM TKM	090-005502-00502	90
Phoenix 355 Progress puls MM TDM	090-005320-00502	97
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 405 Expert 2.0 puls MM TDM	090-005353-00502	100
Phoenix 405 Progress puls MM TDM	090-005321-00502	97
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 505 Expert 2.0 puls MM TDM	090-005354-00502	101
Phoenix 505 Progress puls MM TDM	090-005322-00502	98
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Picomig 180 puls TKG	090-005545-00502	83
Picomig 180 TKG	090-005546-00502	123
Picomig 185 puls TKG	090-005547-00502	84
Picomig 185 TKG	090-005548-00502	124
Picomig 355 puls TKG	090-005542-00502	85
Picotig 200 AC/DC puls 5P TG	090-000188-00502	222
Saturn 301 M1.02 FKG	090-004977-00502	183
Saturn 301 M2.20 FKG	090-004978-00502	184
Saturn 351 FDG	090-004991-00502	187
Saturn 351 M1.02 FKG	090-004983-00502	183
Saturn 351 M2.20 FKG	090-004984-00502	185
Taurus 351 Basic FDG	090-005389-00502	164
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 Basic FKG	090-005425-00502	152

Type	Item no.	Page
Taurus 351 Basic FKW	090-005419-00502	157
Taurus 351 S HP MM FKW	090-005420-00502	161
Taurus 351 S LP MM FKW	090-005422-00502	159
Taurus 351 S MM FDG	090-005341-00502	167
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDG	090-005249-00502	164
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 Basic FKG	090-005426-00502	152
Taurus 401 Basic FKW	090-005408-00502	158
Taurus 401 S HP MM FKW	090-005409-00502	162
Taurus 401 S LP MM FKW	090-005423-00502	160
Taurus 401 S MM FDG	090-005342-00502	167
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDG	090-005176-00502	164
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDG	090-005343-00502	168
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 501 Basic FKW	090-005410-00502	158
Taurus 501 S HP MM FKW	090-005411-00502	162
Taurus 501 S LP MM FKW	090-005424-00502	160
Taurus 551 Basic FDG	090-005178-00502	165
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDG	090-005344-00502	168
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 150 Plasma	090-008720-00502	251
Tetrix 230 2.0 puls 5P TM	090-000240-00502	209
Tetrix 300 AC/DC 2.0 puls 5P TM	090-000235-00502	226
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 300 TM	090-000125-00502	210
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 AW FW	090-000118-00505	231
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 AW FW	090-000103-00505	231
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 AW FW	090-000093-00505	231
Tetrix 551 FW	090-000131-00502	215
Wega 401 FDW	090-004949-00502	194
Wega 401 M1.02 FKG	090-005224-00502	188
Wega 401 M1.02 FKW	090-005227-00502	190
Wega 401 M2.20 FKG	090-005225-00502	189
Wega 401 M2.20 FKW	090-005228-00502	191
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

HOSE BRIDGE UNIVERSAL

- Hose bridge
- For operating gas-cooled torches on water-cooled welding machines

Type	Designation	Item no.
HOSE BRIDGE UNI	Hose bridge	092-007843-00000

Suitable for:

Type	Item no.	Page
alpha Q 351 Expert 2.0 puls MM 2DVX FDW	090-005359-54502	79
Phoenix 351 Expert 2.0 puls MM 2DVX FDW	090-005329-54502	119
Phoenix 351 Expert 2.0 puls MM FDW	090-005329-00502	110
Phoenix 351 Progress puls MM 2DVX FDW	090-005325-54502	116
Phoenix 351 Progress puls MM D FDW	090-005325-10502	113
Phoenix 351 Progress puls MM FDW	090-005325-00502	107
Phoenix 401 Expert 2.0 puls MM 2DVX FDW	090-005330-54502	119
Phoenix 401 Expert 2.0 puls MM FDW	090-005330-00502	110
Phoenix 401 Progress puls HP MM FKW	090-005404-00502	104
Phoenix 401 Progress puls LP MM FKW	090-005503-00502	102
Phoenix 401 Progress puls MM 2DVX FDW	090-005326-54502	116
Phoenix 401 Progress puls MM D FDW	090-005326-10502	113
Phoenix 401 Progress puls MM FDW	090-005326-00502	107
Phoenix 451 Expert 2.0 puls MM 2DVX FDW	090-005331-54502	120
Phoenix 451 Expert 2.0 puls MM FDW	090-005331-00502	111
Phoenix 451 Progress puls MM 2DVX FDW	090-005327-54502	117
Phoenix 451 Progress puls MM D FDW	090-005327-10502	114
Phoenix 451 Progress puls MM FDW	090-005327-00502	108
Phoenix 501 Progress puls HP MM FKW	090-005405-00502	105
Phoenix 501 Progress puls LP MM FKW	090-005504-00502	103
Phoenix 551 Expert 2.0 puls MM 2DVX FDW	090-005332-54502	120
Phoenix 551 Expert 2.0 puls MM FDW	090-005332-00502	111
Phoenix 551 Progress puls MM 2DVX FDW	090-005328-54502	117

Type	Item no.	Page
Phoenix 551 Progress puls MM D FDW	090-005328-10502	114
Phoenix 551 Progress puls MM FDW	090-005328-00502	108
Taurus 351 Basic FDW	090-005390-00502	170
Taurus 351 S MM FDW	090-005345-00502	173
Taurus 401 Basic FDW	090-005250-00502	170
Taurus 401 S MM FDW	090-005346-00502	173
Taurus 451 Basic FDW	090-005150-00502	171
Taurus 451 S MM FDW	090-005347-00502	174
Taurus 551 Basic FDW	090-005151-00502	171
Taurus 551 S MM FDW	090-005348-00502	174
Tetrix 300 2.0 puls 5P TM	090-000238-00502	213
Tetrix 351 AC/DC AW FW	090-000109-00505	235
Tetrix 351 AC/DC FW	090-000135-00502	228
Tetrix 351 FW	090-000129-00502	215
Tetrix 401 FW	090-000176-00502	215
Tetrix 451 AC/DC AW FW	090-000112-00505	235
Tetrix 451 AC/DC FW	090-000136-00502	228
Tetrix 451 FW	090-000130-00502	215
Tetrix 551 AC/DC AW FW	090-000115-00505	235
Tetrix 551 AC/DC FW	090-000137-00502	228
Tetrix 551 FW	090-000131-00502	215
Wega 401 FDW	090-004949-00502	194
Wega 501 FDW	090-005088-00502	195
Wega 601 FDW	090-005089-00502	195

UKV4SET 4M

Type	Designation	Item no.
UKV4SET 4M	Hose connection set to connect a cooling unit	092-000587-00000

Suitable for:

Type	Item no.	Page
microplasma 120	090-007015-00502	249

Type	Item no.	Page
microplasma 20	090-007010-00501	248
microplasma 50	090-007012-00501	248

ADAP3 G1/4-G1/4 LKS

Type	Designation	Item no.
ADAP3 G1/4-G1/4 LKS	Threaded adapter	094-001652-00000

Suitable for:

Type	Item no.	Page
microplasma 120	090-007015-00502	249

Type	Item no.	Page
microplasma 20	090-007010-00501	248
microplasma 50	090-007012-00501	248

Spare parts set ■ Starter equipment

SERVICE SYSTEM SS02

- Spare parts starter kit for service technicians for maintenance and repairs to EWM machines and EWM torches
- Covers machine, torch and automation
- **Machine spare parts:** Casing screws, spacers, gas valves, ring screws, rotary knobs, tank caps, filter sieves, connecting pieces, couplings, safety fuses, push-buttons, switches, connection sockets, contact pins, protective dust caps, caps for openings in casings, jumpers, plug connectors, protective caps, strain reliefs
- **Torch spare parts:** Microswitches, push-button springs, cable lugs, single-ear clamps, control cable plugs and contacts, connecting nipples, screws, cylindrical pins
- Approx. 2000 items total
- The assortment boxes can be ordered separately and the contents may be ordered in packing units (see spare parts catalogue)

Type	Designation	Item no.
SERVICE SYSTEM SS02	Spare parts starter set, two boxes	092-002469-00001

BOX 1-2

- Spare parts starter kit, separate boxes
- Box 1 contains assortment boxes 1–4
- Box 2 contains assortment boxes 5–8

Type	Designation	Item no.
BOX 1	Spare parts starter kit, box 1	092-007781-00001
SBOX 2	Spare parts starter kit, box 2	092-007786-00001

Service Case 1-8

- Separate assortment boxes
- The contents can be ordered separately or in packing units (see replacement parts catalogue)

Type	Designation	Item no.
SBOX	Assortment box without drawers	094-014770-00000
SERVICE CASE SC01	–	092-007782-00001
SERVICE CASE SC02	Assortment box 2: Rotary dials and covers, gas valves, spacers, lifting eyes	092-007783-00001
SERVICE CASE SC03	–	092-007784-00001
SERVICE CASE SC04		092-007785-00001
SERVICE CASE SC05		092-007787-00001
SERVICE CASE SC06		092-007788-00001
SERVICE CASE SC07		092-007789-00001
SERVICE CASE SC08		092-007790-00001

Test machine for repetition test ■ A3-SH SET

A3-SH SET

- Test machine with CE mark for repetition tests as per IEC/EN 60974-4 and VDE 0701-0702 for arc welding machines as follows: Single phase machines with 230 V connection voltage, three-phase machines between 230 V and 500 V
- All measurements performed according to IEC/EN 60974-4
- Special test routines for EWM machines
- Universal test routines also for testing other manufacturers' machines
- Extensive database functions
- Test logs printed with your customer logo
- **Scope of supply:**
- Test Machine A3-SH
- Measuring leads
- 230 V connecting cable/AC
- Control/testing/logging software
- Test log as per IEC/EN 60974-4 and VDE 0701-0702
- Free software upgrades for changes or modifications to test procedures
- EWM specific software with test programs (EWM machines and machines by other manufacturers)

Type	Designation	Item no.
A3-SH SET	Test machine for repetition test	090-008210-00000

Calibration device ■ KLE

KLE

- Calibration device, portable
- Measurement data recording for mains input current, mains input voltage
- Measurement data display: One ammeter each for the mains currents, one voltmeter with changeover switch for the mains voltages
- Measurement data recording for actual value welding current and welding voltage
- Digital measurement data display for welding current and welding voltage
- Digital instrument for ambient temperature
- Measuring circuit for measuring the open circuit voltage as per IEC 60974
- Included: Two measuring lines for external voltage metering (2 m), four connection cables for calibration (4 m)
- EWM strongly recommend participating in a EWM calibration seminar!

Mains voltage (tolerances)	3 x 400 V
Mains fuses (slow-blow)	3 x 32 A
Dimensions in mm	625 x 300 x 535
Weight	25 kg

Type	Designation	Item no.
KLE 2	Calibration device	090-008297-00502
KOS60	Calibration costs per welding machine	KOS-S00018-00000
–	Calibration certificate	KOS-V00038-00000

Rent KLE

- EWM strongly recommend participating in a EWM calibration seminar!

Type	Designation	Item no.
KLE+LS600A WEEKLY RENTAL	Weekly rental LS600A, incl. calibration unit and TESTO 470	KOS-S00019-00000
KLE+LS600A MONTHLY RENTAL	Monthly rental LS600A, incl. calibration unit and TESTO 470	KOS-S00020-00000

LS 600A

- EWM strongly recommend participating in a EWM calibration seminar!
- Load-simulation equipment up to 600 A, mobile
- The load voltage can be adjusted for MIG/MAG, TIG and MMA

Mains voltage (tolerances)	3 x 400 V
Mains fuses (slow-blow)	3 x 32 A
Dimensions in mm	1110 x 550 x 890
Weight	139.5 kg

Type	Designation	Item no.
LS 600A	Load simulation device	090-008059-00101

TESTO 470

- Measurements of rotation speeds, speeds and lengths
- Saving of average, max. and min. values and the last measurement value
- Measurement spacing up to 600 mm (optical measurement)
- Easy one-hand operation

Type	Designation	Item no.
TESTO 470	Measuring instrument for rotational speeds, velocities and lengths	098-005120-00000

A/V EN1090

- External indication unit for welding current (A) and welding voltage (V)
- For retrofitting all welding machines without digital control
- Fastening by means of hooks at lifting eyes of the welding machine or by means of magnets

Mains voltage (tolerances)	1 x 230 V (-25 % - +20 %)
Mains fuses (slow-blow)	1 x 16 A
Dimensions in mm	390 x 270 x 110
Weight	5 kg

Type	Designation	Item no.
A/V EN1090	Display unit for non digital welding machines within the scope of EN 1090	090-008788-00000

Welding simulation ■ Welding Trainer Soldamatic

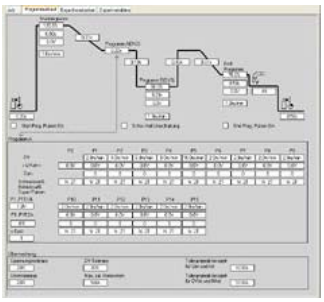
Welding Trainer Soldamatic

- Augmented Reality training system for welder training
- AR simulator with real components and applications
- Universal, realistic welding training
- MIG/MAG, TIG and MMA
- Effective learning in a virtual work environment
- Analysis module shows overview of learning progress
- Realistic representation of workpiece and weld seam
- Conserves resources and protects the environment
- Scope of supply: Power source, e-Soldamatic platform, teacher software, WiFi router, Augmented Reality helmet, welding torch, AR electrode (MMA), AR welding consumable (TIG), welder's gloves, work stand, transport case

Type	Designation	Item no.
Welding Trainer Soldamatic Set	Welding trainer, stand-alone version incl. work stand and transport case	094-022842-00000
	Welding trainer, network version incl. work stand and transport case	094-022843-00000
Welding Trainer Soldamatic	Welding trainer, stand-alone version	094-022850-00000
	Welding trainer, network version	094-022853-00000
AL Soldamatic	Licence for additional software	094-022844-00000
CrNi Soldamatic		094-022845-00000
–	MIG/MAG welding course, German	094-022846-00000
	MIG/MAG welding course, English	094-022846-00001
	TIG welding course, German	094-022847-00000
	TIG welding course, English	094-022847-00001
	MMA welding course, German	094-022848-00000
	MMA welding course, English	094-022848-00001
	Work stand, holder for the workpieces	094-022852-00000
	Transport case	094-022851-00000
	Soldamatic server	094-022849-00000

Software ■ PC software

PC300 SET



- Welding parameter software
- Windows interface makes operation straightforward
- Structured operating menus and levels for changing, setting and programming all welding parameters
- Management of 510 JOBs in a database with easy-to-use search options
- Exchange of JOBs to and from the welding machine
- Online data exchange, i.e. data is visualised in PC300 and mapped directly to the welding process (ideal for training and test welding purposes)
- Integrated password protection to protect against unauthorised changes
- Display of the actual values for the welding voltage and current, wire feed speed, WF motor armature current and welding power using digital screen displays with bar graph and hold function
- Connection to a standard serial COM interface on the welding machine
- Default settings for welding data monitoring
- Always up-to-date due to standard update function for new welding parameters
- Ideal for data backup via easy exchange between power source and PC
- EWM Backup Tool - simple backup function of JOB and system configuration
- EWM PC300 Light Version - simple operation, compressed to the most important functions
- EWM Config Tool - configuration of system components
- System requirements: Windows 7 (32/64-bit), Windows Vista, Windows XP SP3, .NET Framework 2.0 installed (will be installed at the same time where applicable), Intel Pentium (or comparable) CPU with at least 1.7 GHz, 512 MB RAM, min. 300 MB free hard disk space, USB 1.1 or USB 2.0 for installation the software, USB 1.1 or USB 2.0 port for connection to welding machine

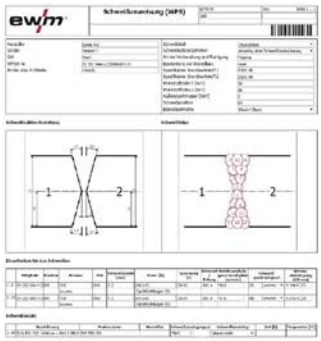
Type	Designation	Item no.		
PC300.Net Set	PC300.Net welding parameter software set incl. CMSTICK, cable and interface SECINT X10 USB	090-008777-00000		

xNet 1.0

- QM softare for analysing of welding processes
- Record, view and analyse welding data
- Fast identification of disruptive factors thanks to realtime monitoring
- Suitable for manual, automated and robot -controlled applications
- Network can be expanded to any number of welding machines and computers
- Customisable user and machine management
- Ethernet networking, Wi-Fi also possible

Type	Designation	Item no.		
ewm Xnet Starter-Set	Set: QM software, a dongle (contains the installation files and software licence)	091-008788-00001		

WPQ Manager



- Most simple and efficient WPS creation and management
- Graphical seam definition (runs/passes)
- Graphics editor for seam preparation
- The software is available as a module for ewm Xnet (WPQ-X-Manager) or as a stand-alone package (WPQ-Manager)
- Advantages of integration into Xnet: Seam/WPS assignment, automatic process control by WPS specifications

Type	Designation	Item no.		
WPQ-Manager	Software for WPS creation and management	090-008813-00000		
WPQ-X-Manager	Xnet software module for WPS creation and management	090-008814-00000		

Replacement printed circuit boards for one-phase EWM welding machines up to 230 A

MIG/MAG welding machines

Welding machine		Replacement board			
	Item no.	Short description	Item no.		
Picomig 180 puls	090-005135-00502	DC183M	040-000803-E0001		
Picomig 180 Basic *	090-005216-00502				

DC TIG welding machines

Welding machine		Replacement board			
	Item no.	Short description	Item no.		
Picotig 180 TGD*	090-002046-00502	DC183T	040-000803-E0002		
Picotig 200 TGD	090-002058-00502				
Picotig 180 TGD MV*	090-002047-00502	DC182A MV	040-000758-E0001		
Picotig 200 TG MV	090-002059-00502				
Tetrix 180 Comfort 5P TGD*	090-000097-00502	DC183T	040-000803-E0002		
Tetrix 180 Comfort 8P TGD*	090-000097-00504				
Tetrix 180 Smart 5P TGD*	090-000124-00502				
Tetrix 180 Smart 8P TGD*	090-000124-00504				
Tetrix 180 Hotwire*	090-000163-00502				
Tetrix 200 Comfort 5P TM	090-000183-00502	DC183T	040-000803-E0002		
Tetrix 200 Comfort 8P TM	090-000183-00504				
Tetrix 200 Smart 5P TM	090-000182-00502				
Tetrix 200 Smart 8P TM	090-000182-00504				
Tetrix 230 Comfort 5P TM	090-000157-00502	DC210	040-000587-00001		
Tetrix 230 Comfort 5P TM	090-000157-00504				
Tetrix 230 Smart 5P TM	090-000156-00502				
Tetrix 230 Smart 5P TM	090-000156-00504				

AC/DC TIG welding machines

Welding machine		Replacement board			
	Item no.	Short description	Item no.		
Picotig 190 AC/DC 5P TG	090-000151-00502	DC180	040-000630-00001		
Picotig 190 AC/DC 8P TG	090-000151-00504				
Picotig 200 AC/DC 5P TG	090-000188-00502	DC180	040-000630-00001		
Picotig 200 AC/DC 8P TG	090-000188-00504				
Tetrix 230 AC/DC Comfort 5P TM	090-000159-00502	DC210	040-000587-00001		
Tetrix 230 AC/DC Comfort 5P TM	090-000159-00504				
Tetrix 230 AC/DC Comfort 5P TM	090-000158-00502				
Tetrix 230 AC/DC Comfort 5P TM	090-000158-00504				

MMA welding machines

Welding machine		Replacement board			
	Item no.	Short description	Item no.		
Pico 162	090-002040-00502	DC162	040-000675-E0000		
Pico 162 MV	090-002042-00502	DC162MV	040-000692-E0001		
Pico 162 VRD	090-002050-00502	DC162 VRD2	040-000891-E0000		
Pico 180	090-002003-00502	DC183T	040-000803-E0002		
Pico 180 MV	090-002051-00502				

*Note: The identified machines are not part of the current product line, but can still be equipped with the new replacement boards.

General information

The global economy is changing continuously. Markets evolve, requirements change, opportunities arise and fade away. Companies that are committed to supporting their customers in this kind of environment must be one thing above all, flexible.

For this reason, the EWM Group is continually expanding its worldwide presence. Our advanced manufacturing, service and training sites in key industrial and growth regions reinforce our dedication to be as close to our customers as absolutely possible. Continuous expansion of our network with EWM sales offices as well as committed sales and service partners ensures global availability and optimum customer service for the customers who use our products.

We believe that acting in our customers' interests means accepting their challenges as our own. That is why we continuously optimise our product and service offerings. Innovative power electronics, the latest information technology and comprehensive expertise in application issues flow into each of our four service areas and combine to create complete solutions for arc welding that offer real added value.

This price list gives you an overview of the wide range of services from EWM so that you can get the best possible results from our products.

Conditions

- Subject to technical modification.
- We deliver products and services on the basis of our "General Terms and Conditions of Sale" which can be found at www.ewm-group.com.

Sales and service partners

Please visit our website at www.ewm-group.com to find the sales and service partner closest to you.

Customised machine configuration

Included in delivery

Order one or more weld-ready systems and configure them precisely to your requirements by adding relevant accessories and options. Of course, we are also happy to advise you beforehand about the optimum configuration for your welding task. We will assemble the system at our factory according to your specifications and test the system before delivery. The following services are included (varies according to machine type and composition):

- Mounting and assembly of trolley, cooling unit, multi-voltage module, pivot support and other accessories.
- Connection of the intermediate hose package to power source and wire feeder.
- Changing of the wire feed rollers and optimisation of the wire feed roller for your preferred wire.
- Configuration of welding torch: Gas and contact tip plus liner on MIG/MAG torches, tungsten electrode, gas nozzle and collet body on TIG torches.
- Filling of coolant container, connection of mains plug (European standard), gas supply, workpiece lead, etc.
- A trained employee will use pre-programmed JOBs (welding tasks) to perform a test weld using the wire/gas combination that you specify.

Costs

Type	Designation	Item no.
KOS25	Customised configuration with assembly for portable and compact systems	092-002686-00001
KOS26	Customised configuration with assembly for decompact systems	092-002685-00001

Commissioning

Included in delivery

- On-site assembly of individual components
- Connection of the hose packages and welding cables
- Connection of the supply lines (e.g. gas, mains, compressed air connection, etc.)
- Insert and inch in the welding filler (MIG/MAG)
- Adjust the wire feed system and the gas quantity
- Explanation of basic functions and test welding
- Tips on servicing and maintaining the machine
- If requested (and following written or verbal agreement), we will be happy to provide additional training after commissioning (see Chapter Instruction/Basic Training).

Costs

▶**The hourly rates given exclude any travel and accommodation costs incurred, as well as expenses!**

Type	Designation	Item no.
KOS3	Manual welding: hourly rate for welding experts, electrical engineers	KOS-A00000-00002
KOS4-I	Automated welding: hourly rate for welding experts, electrical engineers	KOS-A00000-I0003
KOS24	Mileage allowance	KOS-S00010-00000
KOS57	Hourly rate for travel expenses for technicians and engineers	KOS-V00057-00000

Instruction/basic training

Duration: 1 hour

Included in delivery

In combination with the "customised machine configuration", we offer you on-site commissioning. On the agreed date we commission your system at the place of installation, adjust the parameters to your current application and instruct you on the functions of the system.

Costs

▶**The hourly rates given exclude any travel and accommodation costs incurred, as well as expenses!**

Type	Designation	Item no.
KOS27	Commissioning: 1 hour	KOS-V00027-00000
KOS24	Mileage allowance	KOS-S00010-00000
KOS57	Hourly rate for travel expenses for technicians and engineers	KOS-V00057-00000

Duration: 2 hours

Included in delivery

This detailed two-hour instruction/basic training is designed to give you a more in-depth overview of the functionality and performance of our machines. Building upon the one-hour instruction, all functions on the welding machine are explained in detail. We closely examine your configuration and applications in order to jointly optimise the welding process with you.

Costs

▶**The hourly rates given exclude any travel and accommodation costs incurred, as well as expenses!**

Type	Designation	Item no.
KOS29	Instruction/basic training: 2 hours	KOS-V00029-00000
KOS24	Mileage allowance	KOS-S00010-00000
KOS57	Hourly rate for travel expenses for technicians and engineers	KOS-V00057-00000

Machine updates

Included in delivery

- Delivery of the machine to EWM Service in Mündersbach or on-site update
- Check of the existing software/machine version
- Machine updated to the latest software version

Costs

You will be charged for replacement circuit boards and time spent. Freight costs for delivery and return will be charged according to the volume of the goods being sent.

▶The hourly rates given exclude any travel and accommodation costs incurred, as well as expenses!

Notes

Replacement circuit boards and any other necessary parts and software are invoiced according to the currently valid price list or, if available, the valid price quotation.

Type	Designation	Item no.
KOS29	Machine update, hourly rate for welding experts, electrical engineers	KOS-S00015-00000
KOS29-I	Machine update, hourly rate for development staff, technicians/ engineers	KOS-S00015-I0000
KOS24	Mileage allowance	KOS-S00010-00000
KOS57	Hourly rate for travel expenses for technicians and engineers	KOS-V00057-00000

Parameter determination/characteristics/process optimisation

Parameter determination

General remarks

- The welding machine required for the following services plus common gases and welding consumables are provided by EWM.
- If special gases, parent metals and consumables are needed for parameter determination/finding of characteristics, these must be provided in adequate quantities.
- You are required to deliver to your site at no charge your supplied samples, as well as the gases, parent metals and welding consumables. The freight costs for the return delivery are calculated based on the volume of goods dispatched.
- Any parts and software required will also be charged as per the quotation or the current price list.

Included in delivery

- Parameters adjusted to your requirements

Costs

Type	Designation	Item no.
KOS3	Manual welding: hourly rate for welding experts, electrical engineers	KOS-A00000-00002
KOS4-I	Automated welding: hourly rate for welding experts, electrical engineers	KOS-A00000-I0003
KOS3-I	Hourly rate for development staff, technicians/engineers	KOS-A00000-I0002

Preparing a characteristic

Costs

Type	Designation	Item no.
KOS51	Fixed price per characteristic	KOS-A00007-00001

Creating a new characteristic at our site

Included in delivery

- We create for you a new, customised characteristic in accordance with your requirements (welding task, parent metal, welding consumable, gas, etc.)

Costs

Type	Designation	Item no.
KOS3	Manual welding: hourly rate for welding experts, electrical engineers	KOS-A00000-00002
KOS4-I	Automated welding: hourly rate for welding experts, electrical engineers	KOS-A00000-I0003

Process optimisation

Included in delivery

- Process optimisation or new determination according to your requirements.
- Because any process optimisation requires a customised solution, we are unable to give a more precise description here.

Costs

▶**The hourly rates given exclude any travel and accommodation costs incurred, as well as expenses!**

Type	Designation	Item no.
KOS49	Manual welding: hourly rate for welding experts, electrical engineers	KOS-V00013-00000
KOS49-01	Automated welding: hourly rate for welding experts, electrical engineers	KOS-V00013-00001
KOS49-I	Hourly rate for development staff, technicians/engineers	KOS-V00013-I0000
KOS24	Mileage allowance	KOS-S00010-00000
KOS57	Hourly rate for travel expenses for technicians and engineers	KOS-V00057-00000

Calibration

Our calibration service is designed for those with the highest quality expectations.

One of our service technicians uses a calibration device to adjust your welding machine. We are also happy to provide this service on-site.

Included in delivery

- Determining welding parameters under load
- Correction of deviations
- Documentation of measurement values
- Quality assurance for reproducible welding results

Costs

Freight costs for delivery and return will be charged according to the volume of the goods being sent.

▶The hourly rates given exclude any travel and accommodation costs incurred, as well as expenses!

Type	Designation	Item no.
KOS60	Calibration costs per welding machine	KOS-S00018-00000
KOS24	Mileage allowance	KOS-S00010-00000
KOS57	Hourly rate for travel expenses for technicians and engineers	KOS-V00057-00000

Demonstrations/training

Demonstrations/demonstration machines

Included in delivery

- We demonstrate for you the main features and functions as well as the performance capabilities of the machines.
- Welding on sample panels to demonstrate the various functions is included, highlighting the advantages to the user.
- Please bear in mind that a demonstration does not represent any form of training and cannot replace a training course.
- We can provide you with a machine for a long-term test. To do this, we conclude a contract with you for limited-time use of the machine in return for a fee.

Costs

▶The hourly rates given exclude any travel and accommodation costs incurred, as well as expenses!

Type	Designation	Item no.
KOS3	Manual welding: hourly rate for welding experts, electrical engineers	KOS-A00000-00002
KOS4-I	Automated welding: hourly rate for welding experts, electrical engineers	KOS-A00000-I0003
KOS3-I	Hourly rate for development staff, technicians/engineers	KOS-A00000-I0002
KOS24	Mileage allowance	KOS-S00010-00000
KOS57	Hourly rate for travel expenses for technicians and engineers	KOS-V00057-00000

Training courses/advanced training courses/presentations

Included in delivery

We offer our customers and sales partners training courses on our products, we present all new developments in our training news, we conduct welding training with different materials and help you develop excellence when it comes to service.

An updated training calendar with detailed information about individual training events is available at www.ewm-group.com in the Download area under the Service heading.

Costs

Free of charge in Mündersbach for sales partners

On-site: Free of charge for sales partners, plus any travel costs, accommodation and expenses incurred, purchase of workpieces, welding consumables, gases, etc.

On-site: Plus any costs for travel and accommodation as well as expenses incurred, purchase of workpieces, welding consumables, gases, etc.

▶Please note that for cancellations received less than 7 days before the start of the training course, the full course fee is payable, and for complimentary courses, €50.00 is payable for each participant.

Type	Designation	Item no.
TRAINING 1	Standard training courses (according to training calendar)	KOS-V00017-00000
TRAINING 2	Special training courses (topics at customer's request not already covered in training calendar)	KOS-V00017-00001
TRAINING 3	Expert training courses (highly specialised, by development staff)	KOS-V00017-00002
KOS24	Mileage allowance	KOS-S00010-00000
KOS57	Hourly rate for travel expenses for technicians and engineers	KOS-V00057-00000

Service: Servicing and repair (incl. repetition test)

Included in delivery

- Repair or servicing, including repetition test, on-site or at EWM.

Costs

Freight costs for delivery and return will be charged according to the volume of the goods being sent.

The cost for this service is calculated from the work expense plus any applicable material costs. Spare parts required for repairs will be calculated upon the basis of the currently valid price list or a valid price quotation, to the extent not covered by our warranty terms (see Chapter Warranty Declaration).

▶The hourly rates given exclude any travel and accommodation costs incurred, as well as expenses!

Notes

- If requested, we will be happy to provide a cost estimate for the service. Cost estimates are invoiced at a flat rate of €50.00 (KOS-S00011-00000).
- These costs are not applied if the repair work is carried out.

Type	Designation	Item no.
KOS15	Hourly rate for electrical engineers	KOS-S00001-00000
KOS2	Hourly rate for test	KOS-S00002-00000
KOS24	Mileage allowance	KOS-S00010-00000
KOS57	Hourly rate for travel expenses for technicians and engineers	KOS-V00057-00000

Metallurgic testing

At the EWM site

Included in delivery

- Non-destructive and destructive test of your welding samples
- Metallurgic testing of your welded sample
- Extensive report with results of the test

Costs

Freight costs for delivery and return will be charged according to the volume of the goods being sent.

▶The hourly rates given exclude any travel and accommodation costs incurred, as well as expenses!

Type	Designation	Item no.
KOS54	Hourly rate for metallurgic testing	KOS-A00009-00000
KOS3	Manual welding: hourly rate for welding experts, electrical engineers	KOS-A00000-00002
KOS4-I	Automated welding: hourly rate for welding experts, electrical engineers	KOS-A00000-I0003
KOS3-I	Hourly rate for development staff, technicians/engineers	KOS-A00000-I0002

Welding tests/sample welds

At EWM's site

Included in delivery

- Welding of samples with our machines
- Welding report with results
- The welding machine required and the standard gases and welding consumables are provided by EWM.
- If we will need special gases, parent metals and consumables for your sample welds, these must be provided in adequate quantities.

Costs

Freight costs for delivery and return will be charged according to the volume of the goods being sent.

Type	Designation	Item no.
KOS3	Manual welding: hourly rate for welding experts, electrical engineers	KOS-A00000-00002
KOS4-I	Automated welding: hourly rate for welding experts, electrical engineers	KOS-A00000-I0003

On-site

Included in delivery

- Welding of samples with our machines
- Welding report with results

Costs

Freight costs for delivery and return will be charged according to the volume of the goods being sent.

▶The hourly rates given exclude any travel and accommodation costs incurred, as well as expenses!

Type	Designation	Item no.
KOS3	Manual welding: hourly rate for welding experts, electrical engineers	KOS-A00000-00002
KOS4-I	Automated welding: hourly rate for welding experts, electrical engineers	KOS-A00000-I0003
KOS24	Mileage allowance	KOS-S00010-00000
KOS57	Hourly rate for travel expenses for technicians and engineers	KOS-V00057-00000

Rent/leasing/financing

Welding machines are capital investments. For this reason, the decision to purchase such a product is influenced not only by good welding characteristics, but also to a large extent by a good return on investment. However, at first glance returns often appear insufficient.

For example, short-term, seasonal peaks in orders, special orders or other special occasions (training, welder tests, etc.) may cause capacity bottlenecks in your production, but the temporary nature of these events does not justify the procurement costs of a new machine, causing the investment to appear not worthwhile.

In other cases, you may have an urgent need to expand long-term capacity, but find it impossible to finance the purchase at the current time. Or perhaps you simply want to experience the quality of our machines over a longer period of time before making a purchase decision.

In order to react flexibly to all of these scenarios, we offer you the option of renting or leasing one or several welding machines as an alternative to a direct purchase.

- **Renting EWM welding machines**
- Cover short-term production bottlenecks with the latest EWM technology.
- Durations and rent are agreed individually.
- At the end of the contract duration, return the machine without surcharges or choose to purchase the machine with full accounting of previous rental payments.
- Tax advantages: Rental payments may be deducted as operational expenses.
- **Leasing EWM welding machines**
- Transparent, uniform rates facilitate reliable planning
- Individualised determination of leasing rates, durations and closing charges
- Pay-as-you-earn: The leasing rates are incurred parallel to the use of the machine and can therefore be financed from the profits.
- This allows you to make a large investment without committing a large amount of capital.
- Tax advantages: Leasing charges may be deducted as operational expenses.

Are you interested in a welding machine and would like to receive a price quotation? We are available to help at any time and will be happy to work with you to create a rental or leasing contract adapted to your requirements.

General assembly and service conditions

The setup, commissioning or repair of systems supplied, and the instruction of operating staff on those systems, are undertaken on acceptance of the following conditions. The Assembly and Service Terms and Conditions are based on our General Terms and Conditions of business. These terms supplement and specify the general terms for the areas of assembly and service.

1. The ordering party shall ensure that all preparations required for on-site completion of assembly work are carried out to ensure that the work can be started immediately on arrival. The connections for operating power and water must be provided up to the supply point, among other things. If the setup and commissioning of systems is delayed or prevented due to circumstances not under our control, the ordering party shall bear the costs for sending the personnel (travel costs, hourly rates, daily allowance, etc.) Not included in our services are electrical cabling at the installation site from the switching cabinet to the individual power consumers including installation material, prop supports, building, plastering and painting work, pneumatic and water installations, roofing and other building and additional work required. Any crane and scaffolding work required shall be carried out by the customer.
2. The assembly and service rates, unless otherwise agreed, are calculated on the basis of time (incl. travel and waiting time) and costs. The following are also subject to charges: Allowances, accommodation, travel expenses and preparation costs required for assembly. For assembly work abroad, the additional costs, e.g. for obtaining visas, for any medical examination costs and immunisations, will be billed at cost. If additional safety tests are required for the work, e.g. radiation passport, these formalities must be completed in advance by the ordering party. The use of materials will be charged at cost + sales tax at the relevant prices valid at the time. The calculation will be carried out based on the work documentation from our engineers. The engineers are required to present their work documentation on completion of work (for extended assignments on a weekly basis) to our customers for signature. This shall also apply for flat-rate assembly work. For extended assemblies, monthly partial invoices will be generated. Time and materials required for assembly and service are acknowledged by signature, making them binding for both sides. If the ordering party refuses to sign, it shall submit a written declaration immediately to that respect. If our staff are not able to obtain the signature for any other reason, the details given on the customer service invoice shall be assumed to be agreed upon. Our engineers are not authorised to submit legally binding declarations on our behalf. All agreements not covered by the assembly and service conditions shall require written confirmation.
3. Cost proposals are produced to the best of our knowledge, but are not binding. Should the price given in advance increase significantly during the maintenance work, consultation will be sought. Generation of a cost estimate is subject to a flat charge (€50.00 per estimate) but will be reimbursed when the associated contract is signed. The prices given in the cost estimates are valid for one month. Maintenance jobs with a low value are also carried out without providing a cost estimate in advance.
4. Wage costs: Per working hour (worktime, waiting time, travel time and preparation time for staff on-site and office staff), based on 40 hours per week of 5 working days. Overtime and surcharges are not charged by EWM!
5. Expenses are charged in accordance with the relevant regional regulations on travel costs.
6. Travel and freight costs: We calculate the actual outlay incurred for transporting staff, their tools and their luggage, if incurred via public transport. When using motor vehicles (cars and service vehicles) we calculate €0.60/km. When using the train, we calculate 2nd class for travel in both directions. Flight costs will be charged at Business Class. Freight costs, for travel in both directions, for machines sent in for maintenance will be billed to the customer.
7. Overnight stays will be charged at cost. Daily allowances and overnight stays are also charged for Sundays and holidays when the engineer is not working and does not travel home for cost reasons.
8. The payment conditions in our general terms and conditions of business and delivery shall apply over and above any other agreements made where applicable. Unless written authorisation is provided, our engineers are not authorised to receive payments on our behalf. The payment due date for all services shall be 14 days net.
9. Our services are provided in the German or English language. Should other languages be required, an interpreter should be procured by the customer!
10. These general assembly and service terms and conditions shall apply from January 1, 2012. All previous assembly and service conditions are hereby invalidated.

Disposal of old equipment

In accordance with Germany's Used Electrical Equipment Law (Elektro-Altgeräte-Gesetz), this machine does not belong in domestic waste.

In Germany, waste equipment from private households can be disposed of free of charge at local community collection points. Your local administration point can provide information on the options available.

EWM participates in an approved waste disposal and recycling system and is registered in the Used Electrical Equipment Register (EAR) under number WEEE DE 57686922.

Manufacturer's declaration to end user

- According to European provisions (guideline 2002/96/EG of the European Parliament and the Council of January 27, 2003), used electric and electronic equipment may no longer be placed in unsorted municipal waste. It must be collected separately. The symbol depicting a waste container on wheels indicates that the equipment must be collected separately. Please contribute to environmental protection and ensure that this machine is placed in the appropriate collection category when you no longer intend to use the machine.
- According to German law (law governing the distribution, taking back and environmentally correct disposal of electric and electronic equipment (ElektroG) from March 16, 2005), you are required to place used machines in a collection system separate from unsorted municipal waste. The public waste management utilities (communities) have created collection points at which used equipment from private households can be disposed of free of charge. It is possible that legally authorised disposal authorities will also collect used equipment from private households.
- Please refer to your local waste collection calendar or inquire with your state or municipal government about options available in your area for returning or collecting used equipment.

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Sales / Consultancy / Service

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