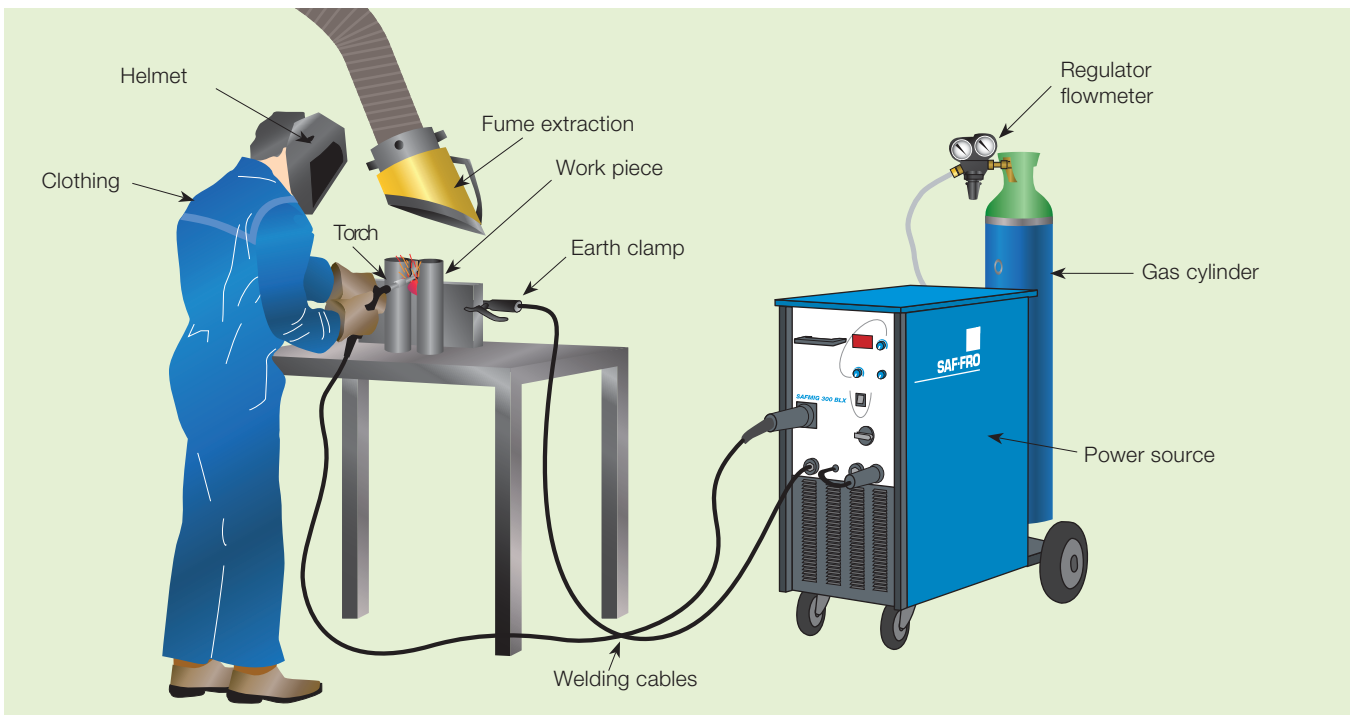


Section 3 - MIG/MAG welding

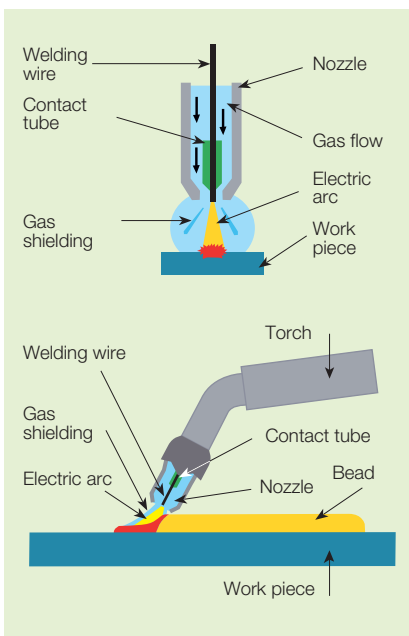
General information and choice criteria



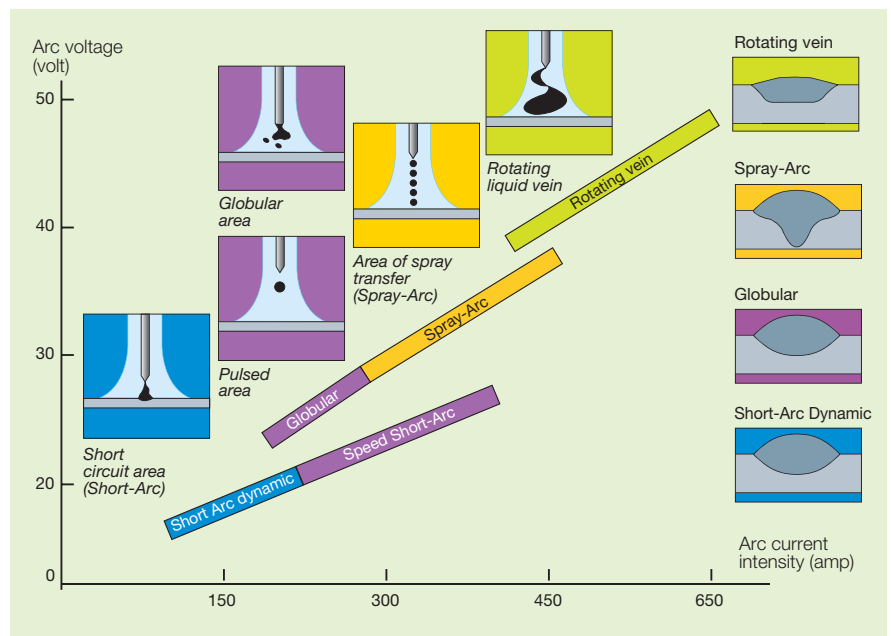
Scheme of a manual installation for MIG/MAG welding

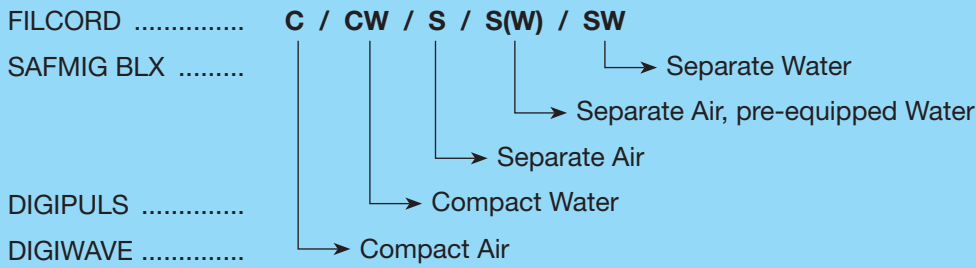


MIG/MAG welding



Transfer modes





Arc transfer modes

• Short-Arc transfer:

The Short Arc has a low spatter rate with good wetting and is suited to welding thin steel plate, working in position and penetration passes. This mode is characterized by alternating short circuits and light arc.

• Speed Short-Arc™ transfer: (Air Liquide Welding exclusivity)

The Speed Short Arc allows a high travel speed due to a rigid arc and a cold regime. It is very effective for welding thin steel plates, working in position and in closed angle and filling bevels. The SSA™ is used for short circuit welding though the normal globular regime travel speed domain.

SSA™ advantages

- Increase in travel speed
- Reduced distortion (thin steel sheets)
- Suited to welding in position
- Tolerance and usability.

• Globular transfer:

Metal is transferred in the arc as large drops with hardly mastered trajectories. It's a transfer mode giving low quality results.

• Spray-Arc transfer:

Metal is transferred in the arc as small droplets. The mode is very regular but requires high welding parameters and therefore is usable only for thickness above 5 mm.

• Pulsed transfer:

This pulsed current called "standard", is a very efficient arc regime; it enables welding of fine sheet metal from 1 mm thickness. It is used on all metals (steel, stainless steel, aluminum) with solid wires as with certain flux-cored wires. Almost total elimination of spatter, and thus of finishing.

Advantages:

- Excellent weld bead appearance
- Reduction of fume emissions
- All positional.

• Spray Modal™ transfer

(Air Liquide Welding exclusivity)

Spray-MODAL™ is a process that greatly reduces micro porosity and increases penetration.

It can be used in all positions and is particularly effective on aluminium sheets greater than 3 mm. Spray-MODAL™ uses a low-frequency modulated current which has the effect of removing most hydrogen bubbles from the weld pool before solidification.

Spray-MODAL™ advantages

- Reduces porosity
- Increases penetration
- All-position welding
- Higher travel speed.

Special
for Light
Alloys

Criteria choice for MIG/MAG equipment

Name	Main power supply	Technology	Welding current range	Wire diameter	Wire feeder		Rollers
					Enclosed	Separate	
FILCORD 171C	Single phase	Step control	30 – 170 A	0.6 – 1.0 mm	✓	-	2
FILCORD 203C	Three phase	Step control	27 – 200 A	0.6 – 1.0 mm	✓	-	4
FILCORD 253C	Three phase	Step control	35 – 250 A	0.6 – 1.0 mm	✓	-	4
FILCORD 303C / S	Three phase	Step control	35 – 300 A	0.6 – 1.2 mm	✓	✓	4
FILCORD 353C / S	Three phase	Step control	35 – 350 A	0.6 – 1.2 mm	✓	✓	4
FILCORD 453S (W)	Three phase	Step control	50 – 450 A	0.6 – 1.6 mm	-	✓	4
SAFMIG 300 BLX C / S	Three phase	Step control	30 – 280 A	0.6 – 1.2 mm	✓	✓	4
SAFMIG 400 BLX C / CW / S / SW	Three phase	Step control	30 – 380 A	0.8 – 1.6 mm	✓	✓	4
SAFMIG 500 BLX S / SW	Three phase	Step control	16 – 480 A	0.8 – 2.4 mm	-	✓	4
DIGISTEEL 420	Three phase	Inverter	20 - 420 A	0.8 - 1.6 mm	-	✓	4
DIGIPULS II 320 S(W)	Three phase	Inverter	20 – 320 A	0.6 – 1.2 mm	-	✓	4
DIGIPULS II 420 S(W)	Three phase	Inverter	20 – 420 A	0.8 – 1.6 mm	-	✓	4
DIGIPULS 520 SW	Three phase	Inverter	20 – 500 A	0.8 – 2.4 mm	-	✓	4
DIGIWAVE 280	Three phase	Inverter	20 – 280 A	0.6 – 1.2 mm	✓	-	4
DIGIWAVE 400 SW	Three phase	Inverter	20 – 400 A	0.8 – 1.6 mm	-	✓	4
DIGIWAVE 500 SW	Three phase	Inverter	20 – 500 A	0.8 – 2.4 mm	-	✓	4

3 - MIG/MAG welding

Professional compact machines (enclosed wire feeder)

The **FILCORD** machine range is manufactured using quality electrical components to provide fast and positive wire feed response via a 4-roll drive (FILCORD 171C - 2 roll) system. Each machine offers smooth trouble free welding operation.

FILCORD 171 C

6 decisive advantages:

- Specialized in thin sheet,
- User-friendly front panel,
- 2T and spot modes,
- EURO torch connector,
- 2 roll wire feed,
- 6 voltage steps.

To order - Cat. No. W000263762

Standard equipment:

- 1 power source with wheels,
- 1 cylinder holder,
- 3 m primary cable,
- Earth cable and clamp,
- 2 m fitted gas hose,
- 1 accessories kit for solid wire 0.6-0.8 mm.

2007-068



FILCORD 203 C

6 decisive advantages:

- User-friendly front panel,
- 2T/4T and spot modes,
- 4 roll wire feed,
- Reverse polarity (gasless),
- 7 voltage steps,
- 2 inductance settings.

To order - Cat. No. W000263765

Standard equipment:

- 1 power source with wheels,
- 1 cylinder holder,
- 3 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- 2 m fitted gas hose,
- 1 accessories kit for solid wire 0.8-1.0 mm.

2007-073



FILCORD 253 C

6 decisive advantages:

- User-friendly front panel,
- 2T/4T and spot modes,
- 4 roll wire feed,
- Reverse polarity (gasless),
- 10 voltage steps,
- 2 inductance settings.

To order - Cat. No. W000263766

Standard equipment:

- 1 power source with wheels,
- 1 ergonomic lower cylinder holder,
- 1 upper cylinder support with torch rest,
- 3 m primary cable
- 5 m earth cable and clamp with DINSE connector
- 2 m fitted gas hose,
- 1 kit accessories for solid wires 0.8-1.0 mm.

2007-073



	FILCORD 171 C	FILCORD 203 C	FILCORD 253 C	FILCORD 303 C	FILCORD 353 C	
Power supply	230 V single phase	230 V / 400 V three phase (+/- 10%) - 50 Hz				
Primary effective consumption	7.5 A	10.4 A / 6 A	14.8 A / 8.5 A	19.5 A / 11.3 A	25 A / 14.2 A	
Primary consumption at I max.	24 A	19 A / 11 A	27 A / 15.6 A	33 A / 19 A	41 A / 24 A	
No-load voltage	18 - 32 V	18 - 35 V	18 - 40 V	18 - 45 V	18 - 45 V	
Welding current	30 to 170 A	27 to 200 A	35 to 250 A	35 to 300 A	35 to 350 A	
Duty cycle 10 min. cycle (at 40 °C)	35%	140 A (at 18%)	200 A (at 30%)	250 A	300 A	350 A
	60%	-	140 A	170 A	230 A	270 A
	100%	-	110 A	140 A	180 A	210 A
Adjustment voltage steps	6	7	12	14	21	
Inductance settings	1	1	2	2	3	
Number of rollers	2	4	4	4	4	
Reverse polarity	Yes	Yes	Yes	Yes	Yes	
Digital display	No	Option	Option	Yes	Yes	
Dimensions (L x W x H) mm	340 x 800 x 540	800 x 510 x 690	800 x 510 x 690	890 x 610 x 1 030	890 x 610 x 1 030	
Weight	38.5 kg	71 kg	77 kg	96 kg	100 kg	
Protection index	IP 21	IP 23				
Protection class	H					
Standard	EN 60974-1					

To order			FILCORD 171 C	FILCORD 203 C	FILCORD 253 C	FILCORD 303 C	FILCORD 353 C
Power source			W000263762	W000263765	W000263766	W000263767	W000263768
Add ons							
PROMIG NG 141T torch	3 m	W000275406	●	-	-	-	-
	4 m	W000275407	●	-	-	-	-
WELDLINE WMT2 15A torch	3 m	W000277445	●	-	-	-	-
	4 m	W000277447	●	-	-	-	-
PROMIG NG 181T torch	3 m	W000275408	-	●	-	-	-
	4 m	W000275419	-	●	-	-	-
WELDLINE WMT2 25A torch	3 m	W000277473	-	●	●	-	-
	4 m	W000277474	-	●	●	-	-
PROMIG NG 241 torch	3 m	W000345060	-	-	●	●	-
	4 m	W000345061	-	-	●	●	-
WELDLINE WMT2 36A torch	3 m	W000277482	-	-	-	●	●
	4 m	W000277483	-	-	-	●	●
PROMIG NG 341 torch	3 m	W000345066	-	-	-	-	●
	4 m	W000345067	-	-	-	-	●
EUROSAF manoflowmeter 40 l/min		W000290248	●	●	●	●	●
Options							
Digital display kit *		W000352093	-	●	●	-	-
Torch arm rest for compact installation		W000261845	-	●	●	●	●

* Digital display included for FILCORD 303C & 353C

FILCORD 303 C

Features:

- User-friendly front panel,
- 2T/4T and spot modes,
- 4 roll wire feed,
- Reverse polarity (gasless),
- 2 x 7 voltage steps,
- 2 inductance positions,
- Digital display included.

To order - Cat. No. **W000263767**

Standard package:

- 1 power source with wheels,
- 1 ergonomic lower cylinder holder,
- 1 upper cylinder support with torch rest,
- 3 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- 2 m fitted gas hose,
- 1 accessories kit for solid wire 0.8-1.0 mm.



2007-073



FILCORD 353 C

Features:

- User-friendly front panel,
- 2T/4T and spot modes,
- 4 roll wire feed,
- Reverse polarity (gasless),
- 3 x 7 voltage steps,
- 3 inductance positions,
- Digital display included.

To order - Cat. No. **W000263768**

Standard package:

- 1 power source with wheels,
- 1 ergonomic lower cylinder holder,
- 1 upper cylinder support with torch rest,
- 3 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- 2 m fitted gas hose,
- 1 accessories kit for solid wire 1.0 -1.2 mm.



2007-076



3 - MIG/MAG welding

Professional separate machines (external wire feeder)

FILCORD 303 S

Features:

- Power source with self, protected safety switches,
- Separate wire feeder with digital display
- 1 accessory kit for solid wires 1.0-1.2 mm,
- User-friendly front panel,
- 2T/4T and spot modes,
- 4 roll wire feed,
- 2 x 7 voltage steps,
- 2 inductance settings.

To order - Cat. No. W000263769

Standard package:

- 1 power source with handle and wheels,
- 1 ergonomic lower cylinder holder,
- 1 upper cylinder support with torch rest,
- 3 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- 2 m fitted gas hose.



2007-211

FILCORD 353 S / 353 SW

Features:

- Power source with self protected safety switches,
- Separate wire feeder with digital display,
- 1 accessory kit for solid wires 1.0-1.2 mm,
- User-friendly front panel,
- 2T/4T and spot modes,
- 4 roll wire feed,
- 3 x 7 voltage steps,
- 3 inductance settings.

To order -

353 S: Cat. No. W000263770

353 SW: Cat. No. W000305242

Standard package:

- 1 power source with handle and wheels,
- 1 ergonomic lower cylinder holder,
- 1 upper cylinder support with torch rest,
- 3 m primary cable
- 5 m earth cable and clamp with DINSE connector
- 2 m fitted gas hose.



2007-646

	FILCORD 303 S	FILCORD 353 S	FILCORD 353 SW	FILCORD 453 S	FILCORD 453 SW
Power supply	230 V / 400 V three phase (+/- 10%)				
Primary effective consumption	19.5 A / 11.3 A	25 A / 14.2 A		35.5 A / 20.5 A	
Primary consumption at I max.	33 A / 19 A	41 A / 24 A		60 A / 34.5 A	
No-load voltage	18 - 45 V	18 - 45 V		19 - 54 V	
Welding current	35 to 300 A	35 to 350 A		51 to 450 A	
Duty cycle	35%	300 A	350 A	450 A	
10 min. cycle	60%	230 A	270 A	345 A	
(at 40 °C)	100%	180 A	210 A	270 A	
Adjustment voltage steps	14	21	30		
Inductance settings	2	3	3		
Number of rollers	4	4	4		
Reverse polarity (gasless)	No	No	No		
Digital display	Yes	Yes	Yes		
Dimensions (L x W x H) mm	890 x 610 x 1 030	890 x 610 x 1 030	890 x 610 x 1 030		
Weight	120 kg	125 kg	135 kg		
Protection index	IP 23				
Protection class	H				
Standard	EN 60974-1				

To order			FILCORD 303 S	FILCORD 353 S	FILCORD 353 SW	FILCORD 453 S	FILCORD 453 SW
Power source			W000263769	W000263770	W000305242	W000263771	W000263771
Add ons							
Separate air cooled wire feeder	DV 405F harness – 5 m	W000263774	●	●	-	●	-
	DV 410F harness – 10 m	W000263775	●	●	-	●	-
Separate water cooled wire feeder	DV 400FW	W000262181	-	-	●	-	●
	DV 400FW – 42V	W000271009	-	-	●	-	●
Harness DV 400 FW water	5 m	W000262342	-	-	●	-	●
	10 m	W000262343	-	-	●	-	●
Harness DV 400 FW-42V water	5 m	W000254614	-	-	●	-	●
	10 m	W000254715	-	-	●	-	●
Cooling Unit FC		W000273686	-	-	●	-	●
Antifreeze cooling liquid FREEZCOOL		W000010167	-	-	●	-	●
PROMIG NG 241 torch	3 m	W000345060	●	-	●	-	-
	4 m	W000345061	●	-	●	-	-
WELDLINE WMT2 36A torch	3 m	W000277482	●	●	-	-	-
	4 m	W000277483	●	●	-	-	-
PROMIG NG 341 torch	3 m	W000345066	-	●	-	-	-
	4 m	W000345067	-	●	-	-	-
PROMIG NG 341W torch	3 m	W000345069	-	-	●	-	-
	4 m	W000345070	-	-	●	-	-
PROMIG NG 441 torch	3 m	W000345072	-	-	-	●	-
	4 m	W000345073	-	-	-	●	-
PROMIG NG 441W torch	3 m	W000345075	-	-	-	-	●
	4 m	W000345076	-	-	-	-	●
WELDLINE WMT2 500W torch	3 m	W000277492	-	-	-	-	●
	4 m	W000277493	-	-	-	-	●
EUROSAF manoflowmeter 40 l/min		W000290248	●	●	●	●	●
Options							
Boom arm for separate installation		W000261846	●	●	●	●	●

FILCORD 453 S / 453 SW

Features:

- Power source with self protected safety switches,
- Separate wire feeder with digital display,
- 1 accessory kit for solid wires 1.0-1.2 mm,
- User-friendly front panel,
- 2T/4T and spot modes,
- 4 roll wire feed,
- 3 x 7 voltage steps,
- 3 inductance settings.

To order -

453 S(W): Cat. No. W000263771

Standard package:

- 1 power source with handle and wheels,
- 1 ergonomic lower cylinder holder,
- 1 upper cylinder support with torch rest,
- 3 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- 2 m fitted gas hose.



2007-223

3 - MIG/MAG welding Industrial installations

- SAFMIG versions
- BLX = compact air
 - BLX W = compact water
 - BLX S = separate air
 - BLX SW = separate water

The **SAFMIG BLX** range are conventional switched MIG-MAG welding installations with ESP help system setting. These units are equipped with digital wire speed regulation, maintaining a constant value in wire feed supply regardless of variations in resistance. This characteristic produces a perfectly stable arc for high quality defect free welds and excellent surface appearance.

SAFMIG 300 BLX / BLX S

Features:

- User-friendly front panel,
- Pre-gas, post-gas and burn-back times adjustment,
- ESP mode to adjust easily the welding parameters,
- Digital display,
- 2T/4T, spot and intermittent modes,
- 4 roll wire feed,
- Reverse polarity(gasless),
- 12 voltage steps,
- 2 inductance settings,
- Fan on demand,
- Digital wire speed regulation,
- Saturable inductance,
- Spatter reduction system.

To order -

BLX: Cat. No. **W000260977**

BLX S: Cat. No. **W000260978**

Standard package:

- 1 power source with wheels, cylinder support and handle,
- 5 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- 2 m fitted gas hose,
- 1 accessory kit for solid wires 1.0 -1.2 mm.



2006-362

SAFMIG 400 BLX / BLX S / BLX W / BLX SW

Features:

- User-friendly front panel,
- Pre-gas, post-gas and burn-back times adjustment,
- ESP mode to adjust easily the welding parameters,
- Digital display,
- 2T/4T, spot and intermittent modes,
- 4 roll wire feed,
- Reverse polarity(gasless),
- 3 x 10 voltage steps,
- 2 inductance settings,
- Fan on demand,
- Digital wire speed regulation,
- Saturable inductance,
- Spatter reduction system.

To order -

BLX: Cat. No. **W000260979**

BLX S: Cat. No. **W000260981**

BLX W: Cat. No. **W000260980**

BLX SW: Cat. No. **W000260982**

Standard package:

- 1 power source with wheels, cylinder support and handle,
- 5 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- 2 m fitted gas hose,
- 1 accessory kit for solid wires 1.0 -1.2 mm.



2006-293

	SAFMIG 300 BLX	SAFMIG 400 BLX	SAFMIG 500 BLX
Power supply	230 V / 400 V three phase (+/- 10%) 50/60 Hz		
Primary effective consumption	20.5 A / 12 A	30.4 A / 17.6 A	44.9 A / 25.9 A
Primary consumption at I max.	27.7 A / 16 A	47 A / 27 A	63 A / 36 A
No-load voltage	16.5 - 35.8 V	16.6 - 45.8 V	15.8 - 50.4 V
Welding current	30 to 280 A	28 to 380 A	16 to 480 A
Duty cycle	45%	270 A	380 A (at 40%)
10 min. cycle	60%	240 A	320 A
(at 40 °C)	100%	200 A	280 A
Adjustment voltage steps	12	30	30
Inductance settings	1	2	2
Number of rollers	4	4	4
Reverse polarity (gasless)	Yes	Yes	Yes
Digital display	Yes	Yes	Yes
Dimensions (L x W x H)	390 x 780 x 825 mm	925 x 580 x 1 060 mm	925 x 580 x 1 060 mm
Weight	101 kg	161 kg	201 kg
Protection index		IP 23	
Protection class		H	
Standard		EN 60974-1	

SAFMIG 500 BLX S / BLX SW

Features:

- User-friendly front panel,
- Pre-gas, post-gas and burn-back times adjustment,
- ESP mode to adjust easily the welding parameters,
- Digital display,
- 2T/4T, spot and intermittent modes,
- 4 roll wire feed,
- Reverse polarity (gasless),
- 3 x 10 Voltage steps,
- 2 inductance settings,
- Fan standby,
- Digital wire feed regulation,
- Inductance,
- Spatter reduction system.

To order -

BLX S: Cat. No. **W000260983**

BLX SW: Cat. No. **W000260984**

Standard package:

- 1 power source with wheels, cylinder support and handle,
- 5 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- 2 m fitted gas hose,
- Accessory kit for 1.0-1.2 mm solid wire,
- Enclosed cooling unit (for the SW version).



2006-293R

To order			SAFMIG 300 BLX	SAFMIG 300 BLX S	SAFMIG 400 BLX	SAFMIG 400 BLX W	SAFMIG 400 BLX S	SAFMIG 400 BLX SW	SAFMIG 500 BLX S	SAFMIG 500 BLX SW	
Power source			W000260977	W000260978	W000260979	W000260980	W000260981	W000260982	W000260983	W000260984	
Add ons											
Air cooled wire feeder DV 44X mobile on trolley	Harness 5 m	W000260986	-	●	-	-	-	●	-	●	-
	Harness 10 m	W000260987	-	●	-	-	-	●	-	●	-
Water cooled wire feeder DV 44X mobile on trolley	Harness 5 m	W000260988	-	-	-	-	-	-	●	-	●
	Harness 10 m	W000260989	-	-	-	-	-	-	●	-	●
	Harness 15 m	W000268547	-	-	-	-	-	-	●	-	●
	Harness 20 m	W000268548	-	-	-	-	-	-	●	-	●
Antifreeze cooling liquid FREEZCOOL		W000010167	-	-	-	●	-	-	●	-	●
PROMIG NG 241	Torch 3 m	W000345060	●	●	-	-	-	-	-	-	-
	Torch 4 m	W000345061	●	●	-	-	-	-	-	-	-
WELDLINE WMT2 36A	Torch 3 m	W000277482	●	●	●	-	-	●	-	-	-
	Torch 4 m	W000277483	●	●	●	-	-	●	-	-	-
PROMIG NG 341	Torch 3 m	W000345066	-	-	●	-	-	●	-	-	-
	Torch 4 m	W000345067	-	-	●	-	-	●	-	-	-
PROMIG NG 341W	Torch 3 m	W000345069	-	-	-	●	-	-	●	-	-
	Torch 4 m	W000345070	-	-	-	●	-	-	●	-	-
PROMIG NG 441	Torch 3 m	W000345072	-	-	-	-	-	-	-	●	-
	Torch 4 m	W000345073	-	-	-	-	-	-	-	●	-
PROMIG NG 441W	Torch 3 m	W000345075	-	-	-	●	-	-	●	-	●
	Torch 4 m	W000345076	-	-	-	●	-	-	●	-	●
WELDLINE WMT2 500W	Torch 3 m	W000277492	-	-	-	●	-	-	●	-	●
	Torch 4 m	W000277493	-	-	-	●	-	-	●	-	●
EUROSAF manoflowmeter 40 l/min		W000290248	●	●	●	●	●	●	●	●	●
Options											
Boom arm for compact installation		W000261845	●	-	●	●	-	-	-	-	-
Boom arm for separate installation		W000261846	-	●	-	-	●	●	●	●	●
Wire feeder swivel mount		W000055048	-	-	-	-	●	●	●	●	●
Suspension support		W000305061	-	-	-	-	●	●	●	●	●

3 - MIG/MAG welding Industrial installations

DIGISTEEL 420 is the new product on the MIG/MAG welding market offering superior quality welding and advanced welding processes with a simple interface at a competitive price. Moreover DIGISTEEL 420 is designed in a modular system to fit with all user's requirements.

DIGISTEEL 420

Features:

- Fully digital controlled inverter,
- More than 80 synergies are available in flat current,
- Front panels are easy to understand and use,
- Small machine for easier access,
- Light installation (37 kg for the power source),
- Compatible with motor generator,
- Full range of processes:
 - Standard MIG/MAG
 - Speed Short Arc
 - Mig brazing
 - Gouging (up to 6.3 mm diameter electrode)
 - MMA coated electrode,
- Powerful installation up to 420 A at 60%,
- Storage of 100 welding programs,
- Parameters locking with a digit code,
- The parameters will be limited from 0 to +/- 20% range,
- Harnesses (up to 50 m).

To order -

Cat. No. W000371513

Standard package:

- 1 power source with handle,
- 1 connected primary cable 5 m long,
- 1 ground cable L = 5 m with clamp and DINSE connector.



2011-303

Power source

DIGISTEEL 420

PRIMARY	
Power supply - 3 phases - 50/60 Hz	400 V (+ 15% / - 20%)
Maximum primary consumption (100%)	29 A
Temporised fuses	32 A
SECONDARY	
Open circuit voltage	86 V
Welding range	15 A - 420 A
Duty cycle	60% : 420 A - 100% : 350 A
APPLICATION	
Processes	MIG-MAG / Speed Short Arc™ / MIG Brazing / MMA / Gouging
Additional feature	Synergic machine
Programs	100 (with expert wire feeder or RC JOB)
GENERAL	
Standard	EN 60974-1 - EN 60974-10
Protection index	IP 23S
Dimensions (L x W x H) - Weight	738 x 273 x 521 mm - 37 kg

Wire feeder

DVU P400

DVU P500 expert

YARD PC D200

Rollers		4 drive rollers	
Wire speed		1 to 25 m/min	
Wire Ø - Stainless steel		0.6 - 1.6 mm	
Wire Ø - Cored wires		1.0 - 1.6 mm	
Wire Ø - Aluminium		1.0 - 1.6 mm	
Regulation	2 potentiometers	2 encoders	2 encoders
Additional feature	-	Program management	Program management
Display	-	3 LCD displays	3 LCD displays + flowmeter
GENERAL			
Protection / Insulation	IP 23S - H	IP 23S - H	In progress
Standards		EN 60974-5 - EN 60974-10	
Dimensions (L x W x H) - Weight	265 x 590 x 383 mm - 17.5 kg	265 x 590 x 383 mm - 17.5 kg	230 x 650 x 400 mm - 11 kg

Cooling unit

COOLER II

Cooling power	1.3 kW
Maximum pressure	4.5 bar
Dimensions (L x W x H) - Weight	720 x 280 x 270 mm - 16 kg

To order

Wire feeder	Simple DVU P 400	W000275266
	Expert DVU P 500	W000275267
	DV YARD PC D 200	W000372373
DIGISTEEL Harnesses Air version	2 m	W000275894
	5 m	W000275895
	10 m	W000275896
	15 m	W000275897
	25 m	W000276901
	30 m	W000371246
	40 m	W000371245
DIGISTEEL Harness Water version	50 m	W000371244
	2 m	W000275898
	5 m	W000275899
	10 m	W000275900
COOLER II cooling unit	15 m	W000275901
	25 m	W000276902
Antifreeze cooling liquid FREEZCOOL 9,6 L		W000273516
Air cooled torch PROMIG NG 441		W000010167
	3 m	W000345072
	4 m	W000345073
DIGITORCH P 341 with potentiometer	5 m	W000345074
	4 m	W000345014
Water cooling torch PROMIG NG 441W	3 m	W000345075
	4 m	W000345076
	5 m	W000345077
DIGITORCH P 341 W with potentiometer	4 m	W000345016
DIGITORCH P 441 W with potentiometer	4 m	W000345018
EUROSAF manoflowmeter 40l /min		W000290248
Options		
Trolley II		W000279927
Arms Trolley II		W000279930
Swivel Trolley II		W000279932
Trolley On site for power source		W000372274
Adaptator for exhaust fume arm		W000371976
Trolley Wire Feeder DVU P400 - P500		W000275908
Remote control	RC Simple	W000275904
	RC JOB	W000273134
Additional flowmeter	DVU P400 & P500	W000275905
Alukit BOX DVU P400 & P500	Wire 1.0 / 1.2	W000277622
	Wire 1.2 / 1.6	W000277623
Anti dust filter		W000370925
POWER BOX Auto-transformer 230V - 400 V		W000305106

DIGISTEEL 420 - DIGIPULS II: Add ons and option

Wire feeders

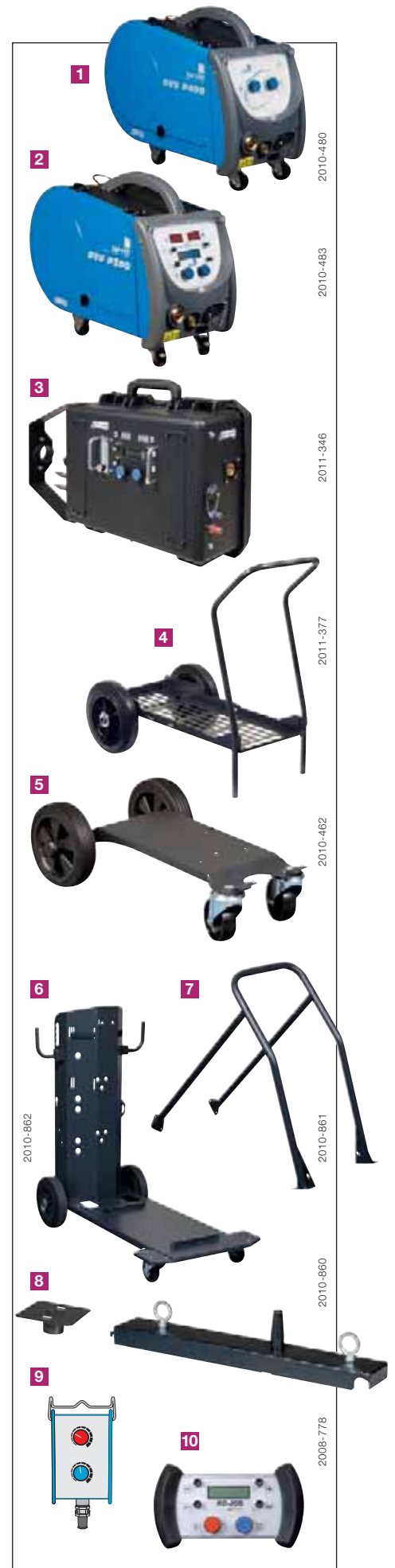
- 1** Standard DVU P400
W000275266
- 2** Expert DVU P500
- 100 programs
- possibility to lock welding parameters
- LCD display
W000275267
- 3** YARD PC D200
W000372373

Trolley

- 4** On site trolley for power source
W000372274
 - 5** Trolley for wire feeder DVU
W000275908
- Trolley for complete equipment (power source + Cooling unit + Wire feeder)
- 6** Trolley II
W000279927
 - 7** Arms for trolley II
W000279930
 - 8** Swivel for wire feeder DVU
W000279932

Remote control

- 9** Simple remote control 10 m long
W000275904
- 10** Expert remote control 10 m long RC JOB
W000273134



3 - MIG/MAG welding

Industrial High Tech installations (Inverter technology)

DIGIPULS II is the very latest innovative MIG/MAG advanced welding machines offering the welding market superior quality welding. DIGIPULS II has been designed in a modular form for easy workshop mobility to suit all welding applications (manual or automatic). These machines offer easy to understand process options and parameter selection via the machine control panel or the wire feed unit.

DIGIPULS II 320 S / SW

Features:

- A modular concept to meet all user requirements,
- User friendly control panels,
- Small machine for easier access,
- Light installation (37 kg for the power source),
- Generator compatible,
- Full range of processes: Standard MIG/MAG / Pulse / Spray Modal / Speed Short Arc / MIG brazing / MMA coated electrodes,
- In synergic mode, more than 100 synergies available,
- Storage of 100 welding programmes,
- Parameter locking with a digit code the parameters will be limited from 0 to +/- 20% range,
- Full A1 automatic interface included,
- Harnesses (up to 50 m).

DIGIPULS II 320
Cat. No. W000275263

is delivered with:


- 1 power source with handle,
- 5 m primary cable,
- 5 m earth cable and clamp with DINSE connector.

NEW RANGE

2 YEARS WARRANTY

MODULAR

COMPATIBLE WITH MOTOR GENERATOR



2010-873

DIGIPULS II 420 S / SW

Features:

- A modular concept to meet all user requirements,
- User friendly control panels,
- Small machine for easier access,
- Light installation (37 kg for the power source),
- Generator compatible,
- Full range of processes: Standard MIG/MAG / Pulse / Spray Modal / Speed Short Arc / MIG brazing / MMA coated electrodes,
- In synergic mode, more than 100 synergies available,
- Storage of 100 welding programmes,
- Parameter locking with a digit code the parameters will be limited from 0 to +/- 20% range,
- Full A1 automatic interface included,
- Harnesses (up to 50 m).

DIGIPULS II 420
Cat. No. W000274838

is delivered with:

- 1 power source with handle,
- 5 m primary cable,
- 5 m earth cable and clamp with DINSE connector.

2 YEARS WARRANTY

MODULAR

COMPATIBLE WITH MOTOR GENERATOR



2010-900

DIGIPULS 520 SW

Features:

- The front panel is simplified to give direct access to the welding parameters,
- Full range of processes: Standard MIG/MAG / Pulse / Speed Short arc / MIG brazing / MMA coated electrodes,
- In synergic mode, more than 100 synergies are available,
- Complete welding cycle, pre-gas - hot start - down slope - post gas time adjustments,
- Storage of 9 welding programmes with additional option RC JOB or DV WKS,
- Full A1 automatic interface in option allows direct connection to an automatic welding machine as standard,
- Up to 500 A @ 60%,
- Manual push-pull option card to use with the push-pull torches.

To order - Cat. No. W000270954

Standard equipment:

- 1 power source,
- 5 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- Enclosed cooling unit.

2 YEARS WARRANTY



2008-655

	DIGIPULS II 320	DIGIPULS II 420	DIGIPULS 520
Power supply – Three phase - 50/60 Hz	400 V (+ 15% / - 20%)		400 V (+/- 10%)
Primary consumption at I max.	21.2 A	29 A	51.8 A
Fuse rating	32 A	32 A	-
No-load voltage	86 V	86 V	113 V
Welding current	15 A - 320 A	15 A - 420 A	20 A - 500 A
Duty cycle 10 min. cycle (at 40 °C)	60%	320 A	500 A
	100%	270 A	450 A
Number of rollers	4 drive rollers		
Dimensions (L x W x H)	Power source	738 x 273 x 521 mm	845 x 380 x 855 mm
	Wire feeder	738 x 273 x 521 mm	
	Cooling unit	720 x 280 x 270 mm	
Weight	Power source	37 kg	91 kg
	Wire feeder	17.5 kg	
	Cooling unit	16 kg	
Protection index	IP 23S		
Standard	EN 60974-1 - EN 60974-10		

To order			DIGIPULS II 320 S	DIGIPULS II 320 SW	DIGIPULS II 420 S	DIGIPULS II 420 SW	DIGIPULS 520 SW
Power source			W000275263		W000274838		W000270954
Add ons							
Wire feeder	Simple - DVU P 400	W000275266	●	●	●	●	-
	Expert - DVU P 500	W000275267	●	●	●	●	-
	DV 400 CDR	W000055082	-	-	-	-	●
	DV YARD PC D200	W000372373	●	-	●	-	-
	DV 400 WKS	W000267593	-	-	-	-	●
DIGIPULS II harness air version *	2 m	W000275894	●	-	●	-	-
	5 m	W000275895	●	-	●	-	-
	10 m	W000275896	●	-	●	-	-
	15 m	W000275897	●	-	●	-	-
	25 m	W000276901	●	-	●	-	-
	30 m	W000371246	●	-	●	-	-
	40 m	W000371245	●	-	●	-	-
DIGIPULS II harness water version *	50 m	W000371244	●	-	●	-	-
	2 m	W000275898	-	●	-	●	-
	5 m	W000275899	-	●	-	●	-
	10 m	W000275900	-	●	-	●	-
	15 m	W000275901	-	●	-	●	-
DIGIPULS I standard harness *	25 m	W000276902	-	●	-	●	-
	2 m	W000055091	-	-	-	-	●
	5 m	W000055092	-	-	-	-	●
	10 m	W000055093	-	-	-	-	●
	15 m	W000055094	-	-	-	-	●
COOLER II cooling unit for DIGIPULS II		W000273516	-	●	-	●	-
Antifreeze cooling liquid FREEZCOOL		W000010167	-	●	-	●	●
PROMIG NG 341 torch	3 m	W000345066	●	-	-	-	-
	4 m	W000345067	●	-	-	-	-
PROMIG NG 341W torch	3 m	W000345066	-	●	-	-	-
	4 m	W000345070	-	●	-	-	-
PROMIG NG 441 torch	3 m	W000345066	-	-	●	-	-
	4 m	W000345073	-	-	●	-	-
PROMIG NG 441W torch	3 m	W000345066	-	-	-	●	●
	4 m	W000345076	-	-	-	●	●
DIGITORCH P 341	4 m	W000345014	●	-	●	-	-
DIGITORCH P 341W	4 m	W000345016	-	●	-	-	-
DIGITORCH P 441W	4 m	W000345018	-	-	-	●	●
EUROSAF manoflowmeter 40 l/min		W000290248	●	●	●	●	●
Options							
Trolley	DIGIPULS II	W000279927	●	●	●	●	-
	DIGIPULS 520	W000055046	-	-	-	-	●
Swivel trolley II		W000279932	●	●	●	●	-
Pivot stand DIGIPULS 520 (requires wire feeder trolley)		W000055048	-	-	-	-	●
Boom arm trolley II		W000279930	●	●	●	●	-
Boom arm support		W000371976	●	●	●	●	-
Trolley wire feeder	DVU P400 & P500	W000275908	●	●	●	●	-
	DV 400 CDR	W000055050	-	-	-	-	●
	DV 400 WKS	W000267595	-	-	-	-	●
Wire feeder suspension cradle for DV 400 CDR		W000055101	-	-	-	-	●
Remote control	Simple for DVU P 400	W000275904	●	●	●	●	-
	RC JOB	W000273134	●	●	●	●	●
Push -pull board	DIGIPULS II	W000275907	●	●	●	●	-
	DIGIPULS 520	W000055061	-	-	-	-	●
Additional socket DIGIPULS 520 (CAD - Plug)		W000055040	-	-	-	-	●
Anti dust filter DIGIPULS 520		W000272382	-	-	-	-	●
Anti dust filter DIGIPULS II		W000370925	●	●	●	●	-
Push-Pull ALUTORCH	DG 342 torch 10 m	W000264913	●	-	●	-	-
	DG 352 torch 8 m	W000267606	●	-	●	-	-
	DG 441W torch 10 m	W000265067	-	●	-	●	●
Push-Pull DIGITORCH PP 451W	Straight torch 8 m	W000271006	-	●	-	●	●
	Curved 45° torch 8 m	W000267607	-	●	-	●	●
Additional flowmeter	DVU P 400 & P 500	W000275905	●	●	●	●	-
	DV 400 WKS	W000267596	-	-	-	-	●
ALUKIT box DIGIPULS II	Wire 1.0 / 1.2 mm	W000277622	●	●	●	●	-
	Wire 1.2 / 1.6 mm	W000277623	●	●	●	●	-
ALUKIT box DIGIPULS 520	wire 1.0 / 1.2 mm	W000255648	-	-	-	-	●
	wire 1.2 / 1.6 mm	W000255649	-	-	-	-	●
	wire 1.6 / 2.4 mm	W000255650	-	-	-	-	●
Power box		W000305106	●	●	●	●	●

*Also exist in aluminium version: consult us.

3 - MIG/MAG welding

Industrial High Tech equipment (Inverter technology)

DIGIWAVE - A user-friendly high level performance DIGIWAVE makes the ideal partner for all manual, automatic and robotic welding applications. The wide graphic screen allows the operator to navigate easily around the menu bar for parameter adjusting.

DIGIWAVE range the decisive advantages:

- **Control of aluminium welding:** special equipments, adapted processes (SM: Spray Modal™), essential options for demanding applications (reduction of micro porosity and increased penetration).
- **Regulation and numerical controls:** total control of wave form alignment for process improvement and for exact parameter reproduction.
- **Increased power (Voltage/Current):** increase the arc rigidity with pulsed mode, which improves penetration and allow a good fusion with usually "hard-to-weld" wires.
- **More processes:** Soft current, Pulsed, SSA, SSP, SM, CDP, MIG brazing, MMA, and PR Spray.
- **More memory:** 115 welding synergies on DIGIWAVE 280 and 153 on DIGIWAVE 400/450W are available for all welding applications. These machines also include 100 programme memory selected via the wire feeder, remote control or DIGITORCH E range.
- **More controls:** parameters monitoring, indication of the defects, parameters blocking on several levels, printing, 99 programs, calibration...
- **More cycles:** 2T/ 4T/ Spot weld/Cold Double Pulse current (CDP).
- **More options:** wide range for improved welding operations and applications.
- **Advanced torch "DIGITAL".**

DIGIWAVE 280
(with enclosed wire feeder)

DIGIWAVE 280
Cat. No. **W000055011** is delivered with:

- 1 power source,
- With enclosed wire feeder,
- 5 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- 2 m fitted gas hose,
- Accessory kit for solid wires 1.0 – 1.2 mm.



2006-094

2 YEARS WARRANTY

DIGIWAVE 400 SW

DIGIWAVE 400 SW
Cat. No. **W000055015** is delivered with:

- 1 power source,
- 5 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- Enclosed water cooling unit.



2006-005

2 YEARS WARRANTY

	DIGIWAVE 280	DIGIWAVE 400	DIGIWAVE 500
Power supply (+/- 10%)	400 V - Three phase - 50/60 Hz		
Primary effective consumption	21.4 A	29.8 A	38.9 A
Primary consumption at I max.	31.4 A	34.5 A	45.2 A
No-load voltage	113 V	113 V	113 V
Welding current	20 A - 280 A	20 - 400 A	20 - 500 A
Duty cycle	45%	400 A	-
10 min. cycle	60%	-	500 A
(at 40 °C)	100%	280 A	440 A
Inductance	Electronic	Electronic	Electronic
Number of rollers	4	4	4
Reverse polarity (gasless)	Yes	Yes	Yes
Digital display	Yes	Yes	Yes
Dimensions (L x W x H)	845 x 380 x 855 mm	845 x 380 x 855 mm	845 x 380 x 855 mm
Weight	76 kg	91 kg	91 kg
Protection index	IP 23 S		
Protection class	H		
Standard	EN 60974-1 / EN 60 974-10		

DIGIWAVE 500 SW

DIGIWAVE 500 SW

Cat. No. **W000055020**

is delivered with:

- 1 power source,
- 5 m primary cable,
- 5 m earth cable and clamp with DINSE connector,
- Enclosed water cooling unit.



2006-004

To order			DIGIWAVE 280	DIGIWAVE 400 SW	DIGIWAVE 500 SW
Power source			W000055011	W000055015	W000055020
Add ons					
DV 500 CDR wire feeder			W000055083	-	●
Harness for steel & stainless steel	2 m	W000055091	-	●	●
	5 m	W000055092	-	●	●
	10 m	W000055093	-	●	●
	15 m	W000055094	-	●	●
Harness for aluminium	2 m	W000055095	-	●	●
	10 m	W000055096	-	●	●
	15 m	W000055097	-	●	●
	25 m	W000055098	-	●	●
Antifreeze cooling liquid FREEZCOOL			W000010167	-	●
PROMIG NG 241 torch	3 m	W000345060	●	-	-
	4 m	W000345061	●	-	-
PROMIG NG 341 torch	3 m	W000345066	●	-	-
	4 m	W000345067	●	-	-
PROMIG NG 341W torch	3 m	W000345069	-	●	-
	4 m	W000345070	-	●	-
PROMIG NG 441W torch	3 m	W000345075	-	-	●
	4 m	W000345076	-	-	●
DIGITORCH	E 241 - 4 m	W000345006	●	-	-
	E 341 - 4 m	W000345011	●	-	-
	E 341W - 4 m	W000345008	-	●	-
	E 441W - 4 m	W000345012	-	-	●
EUROSAF manoflowmeter 40 l/min			W000290248	●	●
Options					
Trolley DIGIWAVE			W000055046	●	●
Pivot stand (requires wire feeder trolley)			W000055048	-	●
Trolley DV 500 CDR wire feeder			W000055050	-	●
Wire feeder suspension support			W000055101	-	●
Remote control RC JOB			W000273134	●	●
Push -pull board			W000055061	-	●
Additional socket DIGIWAVE			W000055040	-	●
Panels filter DIGIWAVE			W000272382	●	●
Push-Pull ALUTORCH DG 441W torch 10 m			W000265067	-	●
Push-Pull DIGITORCH PP 451W	Straight torch 8 m	W000271006	-	●	●
	Curved 45° torch 8 m	W000267607	-	●	●
ALUKIT box D37	1.0 / 1.2 mm	W000255648	●	●	●
	1.2 / 1.6 mm	W000255649	●	●	●
	1.6 / 2.4 mm	W000255650	-	●	●
PC tool - Welding data downloading via USB/Ethernet			W000272383	●	●

3 - MIG/MAG welding

Wear parts for 4 roll wire feeders

Wire feeder: DVU P400 - DVU P500

DIGIPULS II : DVU P400 - DVU P500

Ø mm	Entry wire guide	Roll diam. 37	Middle wire guide	Exit wire guide	ALUKIT		
Steel / Stainless steel	0.6	W000277333	W000305125	W000277334	W000277335		
	0.8		W000267598				
	1.0		W000267599				
	1.2						
	1.6		W000305126				W000277336
Aluminium	1.0	Included in ALUKIT	Included in ALUKIT	Included in ALUKIT	Included in ALUKIT	W000277622	
	1.2					W000277623	
	1.6						
Flux cored wire	1.0	W000277333	W000277010	W000277334	W000277335		
	1.2		W000266330				
	1.6		W000277011				W000277336
	2.4						

Wire feeder: DV 400 CDR - DV 400 WKS - DV 500 CDR - DV 500

DIGIPULS: DV 400 CDR - DV 400 WKS

DIGIWAVE: DV 500 CDR

DIGIMAG: DV 500

Ø mm	Entry wire guide	Roll diam. 37	Middle wire guide	Exit wire guide	ALUKIT		
Steel / Stainless	0.6	W000305150	W000305125	W000162834	W000255654		
	0.8		W000267598				
	1.0		W000267599				W000241685
	1.2						
	1.6		W000305126				W000241682
Aluminium	1.0	Included in ALUKIT	W000260185	W000305135	Included in ALUKIT	W000255648	
	1.2		W000260186			W000255649	
	1.6		W000260187				
	2.4						
FCW	1.0	W000305150	W000266330	W000162834	W000255655	W000241682	
	1.2						
	1.6	W000257395	W000266331	W000257397	W000257396		
	2.0						
	2.4						

Wire feeders: DV 44X - DV 44i D37

SAFMIG BLX: DV 44X

OPTIMAG: DV 44i D37

Ø mm	Entry wire guide	Roll diam. 37	Middle wire guide	Exit wire guide	ALUKIT		
Steel / Stainless	0.6	W000305150	W000305125	W000162834	W000271819		
	0.8		W000267598				
	1.0		W000267599				W000271820
	1.2						
	1.6		W000305126				W000271821
Aluminium	1.0	Included in ALUKIT	W000260185	W000305135	Included in ALUKIT	W000255648	
	1.2		W000260186			W000255649	
	1.6		W000260187				
	2.4						
FCW	1.0	W000305150	W000266330	W000162834	W000271820	W000271821	
	1.2						
	1.6	W000257395	W000266331	W000257397			
	2.0						
	2.4						

3 - MIG/MAG welding

Wear parts for 4 roll wire feeders

Wire feeders: DV 44i - DV 44 - DVi - DVA (diam 30 rolls)

MAJOR, MAJOR BL 4 rolers, OPTIMAG: DV 44
 OPTIPULS 280i, 350i and 350: DV 44i / DVA
 OPTITECH, SAFMIG BLX SAF: DV 44i
 SAFMIG TRi: DVi

Ø mm	Entry wire guide	Roll diam. 30	Middle wire guide	Exit wire guide	ALUKIT
Steel / Stainless	W000305150	W000305146	W000305138	W000305141	
		W000305147		W000305142	
		W000305148		W000305143	
		W000305149		W000305144	
Aluminium	W000305162	W000305160	W000305171	W000305174	W000305157
	W000305163	W000305173	W000305172	W000305175	W000305158
	W000305170		W000305173	W000305176	W000305159
FCW	W000305150	W000305151	W000305138	W000305143	
				W000305144	
			W000305139	W000305140	
		W000305152			

Wire feeders: DV 34i - DV 34 - DV 24 - DV 21 (diam 30 rollers)

SAFMIG BLS, BHM: DV 21
 SAFMIG TRS, SAFYARD: DV 24

Ø mm	Entry wire guide	Roll diam. 30	Middle wire guide	Exit wire guide	ALUKIT
Steel / Stainless	W000305150	W000305146	W000305153	W000305195	
		W000305147		W000305192	
		W000305148		W000305193	
		W000305149			
Aluminium	Included in ALUKIT	Included in ALUKIT	Included in ALUKIT	Included in ALUKIT	W000305155
					W000305156
FCW	W000305150	W000305151	W000305153	W000305192	
				W000305193	
			W000305154	W000305193	
		W000305152			

Wire feeders: D3CC - D2H

Ø mm	Entry wire guide	Rolls	Middle wire guide	Exit wire guide
Steel / Stainless	W000305231	W000305229	W000305188	W000305231
		W000305223		W000305193
		W000305224		
		W000305225		
Aluminium	W000305232	W000305218	W000305187	W000305240
		W000305220		W000305190
		W000305222		
		W000305221		
FCW	W000305231	W000305214	W000305188	W000305193
		W000305227		
	W000305233	W000305215	W000305189	W000305194
		W000305216		
		W000305217		
	W000305228			

3 - MIG/MAG welding

Wear parts for 2 roll wire feeders

Wire feeders: DV 32 / DV 10

SAFMIG 280 BL - 400 BL - 280 DBL - 400 BL - 321 C
 JUNIOR 201 - 323 - 323 S - 403 - 403 S
 MAJOR 251 - 251 S - MAJOR BL

Ø mm	Entry wire guide	Rolls		Exit wire guide		
Steel	0.6	W000305150	W000305146	W000305192		
	0.8					
	1.0		W000305148	W000305147		
	1.2			W000305149		W000305193
	1.6			W000305149		
Aluminium	1.0	W000305145	W000305160	W000305240		
	1.2			W000305161		
	1.6				W000305241	
FCW	1.0	W000305150	W000305151		W000305192	
	1.2				W000305193	
	1.6					

Wire feeder

JUNIOR 203 and 283

Ø mm	Entry wire guide	Rolls		Exit wire guide	
Steel / Stainless	0.6	W000305145	W000305204	W000305302	
	0.8				
	1.0		W000305206	W000305205	
	1.2				
Aluminium	1.0	W000305207			
	1.2				

Wire feeder: DEVISAF D1E

SAFMIG 250 and 380 BL - SAFOR MR 200 - MAJOR 200 ZN

Ø mm	Entry wire guide	Rolls		Exit wire guide		
Steel / Stainless	0.6	W000305210	W000305234	W000305198		
	0.8					
	1.0		W000305236	W000305235		
	1.2			W000305237		W000305201
	1.6					
Aluminium	0.8	W000305209	W000305239		W000305199	
	1.0					
	1.2				W000305200	
	1.6					
FCW	1.2	W000305210	W000305238*		W000305201	
	1.6					

* A special strap is necessary **W000100143**

3 - MIG/MAG welding

Wear parts for wire feeders

Wear parts for wire feeder – SAXOMIG – PRESTOMIG – FILCORD

			SAXOMIG 171 C	PRESTOMIG 201 C	FILCORD 171 C	FILCORD 203C – 253C – 303C/S - 353S – 453S
Wire guide	Entry		W000231810	W000227907	W000231810	W000352069
	Exit		W000269661			
	Middle		W000252183			
Roller	Steel / Stainless steel	0.6 mm	W000232110	W000352037	W000232110	W000050096
		0.8 mm				W000050097
		1.0 mm	W000352055	W000352036	W000352055	W000050098
		1.2 mm				W000050099
		1.6 mm				W000218767
	Aluminium	0.8 mm	-	-	-	W000050100
		1.0 mm	-	W000270323	-	W000050101
		1.2 mm	-		-	W000050102
	Flux cored wire	1.0 - 1.2 mm	-	W000227891	-	W000229621
		1.4 - 1.6 mm	-	-	-	W000233882

Add ons for MIG/MAG power sources

Power box

Autotransformer 230-400 V three phase.

Allows electric feeding of inverter technology power sources with duty cycle up to 350 A @ 60%.

Can be used with

PRESTO 220, BUFFALO 350 i, PRESTOTIG 310, 410 and 350 AC/DC, ADMIRAL 350 DC, PRESTOJET 2, DIGIPULS 320, DIGIWAVE 280 and DIGIPULS II 320 - 420.



1806-054

Input voltage	230 V
Output voltage	400 V
Maximal output intensity	28 A
Power	20 kVa
Protection index	IP 21
Weight	44 kg
Dimensions (L x w x h)	550 x 255 x 255 mm
Cat. n°	W000305106

Autonomous cooling unit

For every MIG/MAG or TIG power source with water cooled torch.

W000305084

Built in flowrate security.

Delivered with a 5 litre drum of cooling liquid FREEZCOOL. Cooling capacity: 1.5 kW.

Flowrate: 3 l/min. (4.2 bars).

Dimensions (L x w x H): 680 x 220 x 340 mm.

Weight: 18 + 5 kg.

Do not mix with other cooling liquid.

FREEZCOOL

Red (9.6 litres) **W000010167**

Red (20 litres) **W000010168**



1124-19

2004-216

Ergonomic boom arm

1 Boom arm for compact power source (integrated wire feeder)

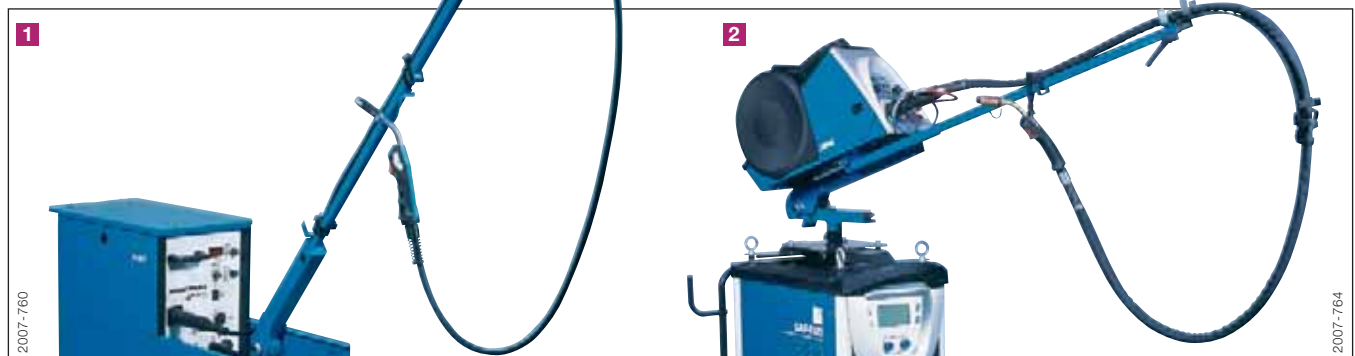
- Can be fixed on the side or on the front of the power source.
- Arm can be set with a maximum length: 2.5 m.

W000261845 SAFMIG BLX.

2 Boom arm for power source with separate wire feeder

- Must be fixed on the top of the power source or on swivel (when available).
- Arm can be set with a maximum length: 2.5 m.

W000261846 FILCORD, SAFMIG BLX, DIGIPULS and DIGIWAVE, for DIGIPULS II add the adaptation piece (W000371976).



2007-760

2007-764

3 - MIG/MAG welding

PROMIG NG torches

A complete range of MIG/MAG torches

- Extra flexible coaxial cable with ultra-resistant elastomer outer,
- Ergonomic handle with ball joint for perfect handling,
- Long lasting active part with few parts (monobloc nozzle).

Air cooled

SAXOMIG NG 141

- Duty cycle at 60%
140 A (CO₂) - 130 A (Ar+CO₂)
- Original equipment:
- steel 0.8 mm
- nozzle Ø 11 mm
- Wire diameters:
0.6 to 0.8 mm
(1.0 mm possible).

To order:

3 m W000275403



2010-020

PROMIG NG 241

- Duty cycle at 60%
270 A (CO₂) - 250 A (Ar+CO₂)
- Original equipment:
- steel 1.0 mm
- nozzle Ø 14 mm
- Wire diameters:
0.8 to 1.0 mm
(1.2 mm possible).

To order:

3 m W000345060

4 m W000345061

5 m W000345062



2006-226

PROMIG NG 141 T

- Duty cycle at 60%
160 A (CO₂) - 150 A (Ar+CO₂)
- Original equipment:
- steel 0.8 mm
- nozzle Ø 11 mm
- Wire diameters:
0.6 to 0.8 mm
(1.0 mm possible).

To order:

3 m W000275406

4 m W000275407



2010-022

PROMIG NG 341

- Duty cycle at 60%
350 A (CO₂) - 320 A (Ar+CO₂)
- Original equipment:
- steel 1.2 mm
- nozzle Ø 16 mm
- Wire diameters:
1.0 to 1.2 mm
(1.6 mm possible).

To order:

3 m W000345066

4 m W000345067

5 m W000345068



2006-951

PROMIG NG 181 T

- Duty cycle at 60%
200 A (CO₂) - 180 A (Ar+CO₂)
- Original equipment:
- steel 0.8 mm
- nozzle Ø 12 mm
- Wire diameters:
0.8 to 1.0 mm.

To order:

3 m W000275408

4 m W000275419

5 m W000275420



2009-464

PROMIG NG 441

- Duty cycle at 60%
420 A (CO₂) - 380 A (Ar+CO₂)
- Original equipment:
- steel 1.2 mm
- nozzle Ø 16 mm
- Wire diameters:
1.0 to 1.6 mm.

To order:

3 m W000345072

4 m W000345073

5 m W000345074



2006-952

3 - MIG/MAG welding PROMIG NG torches

Water cooled

PROMIG NG 241 W

- Duty cycle at 100%
270 A (CO₂) - 250 A (Ar+CO₂)
- Original equipment:
- steel 1.0 mm
- nozzle Ø 14 mm
- Wire diameters:
0.8 to 1.0 mm
(1.2 mm possible).

To order:

- 3 m **W000345063**
- 4 m **W000345064**
- 5 m **W000345065**



2006-953

PROMIG NG 450 W

- Duty cycle at 100%
450 A (Ar+CO₂) - 500 A (CO₂)
- Original equipment:
- steel 1.2 mm
- nozzle Ø 16 mm
- Wire diameters:
1.0 to 1.6 mm.

To order:

- 3 m **W000274865**
- 4 m **W000274866**
- 5 m **W000274867**



2009-776

PROMIG NG 341 W

- Duty cycle at 100%
350 A (CO₂) - 320 A (Ar+CO₂)
- Original equipment:
- steel 1.2 mm
- nozzle Ø 16 mm
- Wire diameters:
1.0 to 1.2 mm
(1.6 mm possible).

To order:

- 3 m **W000345069**
- 4 m **W000345070**
- 5 m **W000345071**



2006-954

PROMIG NG 501 W

- Duty cycle at 100%
500 A (Ar+CO₂) - 550 A (CO₂)
- Original equipment:
- steel 1,6 mm
- nozzle Ø 18 mm
- Wire diameters:
1.2 to 3.2 mm
- Length 4 m.

To order:

- 4 m **W000274871**



2006-277

PROMIG NG 441 W

- Duty cycle at 100%
420 A (CO₂) - 380 A (Ar+CO₂)
- Original equipment:
- steel 1.2 mm
- nozzle Ø 16 mm
- Wire diameters:
1.0 to 1.6 mm.

To order:

- 3 m **W000345075**
- 4 m **W000345076**
- 5 m **W000345077**



2006-955

PISTOLET P 14

- Duty cycle at 100%
500 A (Ar+CO₂)
- Original equipment:
- steel 1.2 mm
- nozzle Ø 16 mm
- Wire diameters:
1.0 to 2.4 mm
- Length 3 m.

To order:

- 3 m **S91590330**



0951-079

3 - MIG/MAG welding DIGITORCH range

With DIGITORCH the operator can set the parameters from the handle.

DIGITORCH E for DIGIWAVE power sources

- A** Digital display of parameters
- B** +/- setting buttons
- C** Mode selection button (programme, synergy, arc length).



DIGITORCH P for DIGIPULS and DIGIPULS II power sources

- Double potmeter for setting:**
- Energy and arc length in synergic mode
 - Welding current and voltage in manual mode.



Air cooled

DIGITORCH E 241

- Duty cycle at 60%
270 A (CO₂) - 250 A (Ar+CO₂)
- Wire diameters:
0.8 to 1.0 mm*
- Original equipment wire
Steel 1.0 mm
nozzle Ø 14
- Length 4 m.

To order: **W000345006**



DIGITORCH E 341

- Duty cycle at 60%
350 A (CO₂) - 320 A (Ar+CO₂)
- Wire diameters:
1.0 to 1.2 mm**
- Original equipment wire
Steel 1.2 mm
nozzle Ø 16
- Length 4 m.

To order: **W000345011**



DIGITORCH P 341

- Duty cycle at 60%
350 A (CO₂) - 320 A (Ar+CO₂)
- Wire diameters:
1.0 to 1.2 mm**
- Original equipment wire
Steel 1.0 mm
nozzle Ø 14
- Length 4 m.

To order: **W000345014**



Water cooled

DIGITORCH E 341 W

- Duty cycle at 100%
350 A (CO₂) - 320 A (Ar+CO₂)
- Wire diameters:
1.0 to 1.2 mm**
- Original equipment wire
Steel 1.2 mm
nozzle Ø 16
- Length 4 m.

To order: **W000345008**



DIGITORCH P 341 W

- Duty cycle at 100%
350 A (CO₂) - 320 A (Ar+CO₂)
- Wire diameters:
1.0 to 1.2 mm**
- Original equipment wire
Steel 1.2 mm
nozzle Ø 16
- Length 4 m.

To order: **W000345016**



DIGITORCH E 441 W

- Duty cycle at 100%
420 A (CO₂) - 380 A (Ar+CO₂)
- Wire diameters:
1.0 to 1.6 mm
- Original equipment wire
Steel 1.2 mm
nozzle Ø 16
- Length 4 m.

To order: **W000345012**



DIGITORCH P 441 W

- Duty cycle at 100%
420 A (CO₂) - 380 A (Ar+CO₂)
- Wire diameters:
1.0 to 1.6 mm
- Original equipment wire
Steel 1.2 mm
nozzle Ø 16
- Length 4 m.

To order: **W000345018**



3 - MIG/MAG welding

Push-Pull torches and guns for DIGIPULS



Push-pull torches and guns

Several push-pull systems are available for use with DIGIPULS II.

The **ALUTORCH (torches)** and **DIGITORCH PP (guns)** ranges have excellent operation due to the miniaturization of the wire drive system in line with the push-pull wire feeding axis.

These torches and guns offer constant trouble free wire feeding resulting in excellent weld quality.

Particularly suited for aluminium applications and use with smaller diameter wires.

They can be easily adapted with a push-pull kit.

Air cooled

ALUTORCH DG 342

- Duty cycle at 40% 300 A (Ar+CO₂)
- Wire diameters: 1.0 to 1.2 mm
- Original equipment wire alu 1.2 mm nozzle Ø 16
- Length 10 m.

To order: **W000264913***



Water cooled

ALUTORCH DG 441 W

- Duty cycle at 60% 450 A (CO₂) - 400 A (Ar+CO₂)
- Wire diameters: 1.0 to 1.2 mm
- Original equipment wire alu 1.2 mm nozzle Ø 16
- Length 10 m.

To order: **W000265067 ***



DIGITORCH PP 352

- Duty cycle at 60% 270 A (Ar+CO₂)
- Wire diameters: 0.8 to 1.2 mm
- Original equipment wire alu 1.0 mm nozzle Ø 15
- Length 8 m.

To order: **W000267606**



DIGITORCH PP 451 W

- Duty cycle at 60% 450 A (Ar+CO₂)
- Wire diameters: 1.0 to 1.6 mm
- Original equipment wire alu 1.2 mm nozzle Ø 15
- Length 8 m.

To order:
Swan neck 45° **W000267607**
Swan neck 0° **W000271006**



* Delivered with 19 pins plug (+5 pins plug)

3 - MIG/MAG welding

MIG-MAG WMT2 torches



A complete range of MIG-MAG torches.

Product advantages:

- wear parts compatible with the most common standard in Europe,
- easy pivoting handle,
- complete range.



WMT2 15A

- Duty cycle at 60%
180 A (CO₂) - 150 A (Ar+CO₂)
- Original equipment:
- steel 0.8 mm
- nozzle Ø 12.5 mm
- Air cooled
- Wire diameters:
0.6 to 1.0 mm
- For car bodywork and welding in difficult to access places due to its small overall size.

To order:
3 m **W000277445**
4 m **W000277447**

2010-105

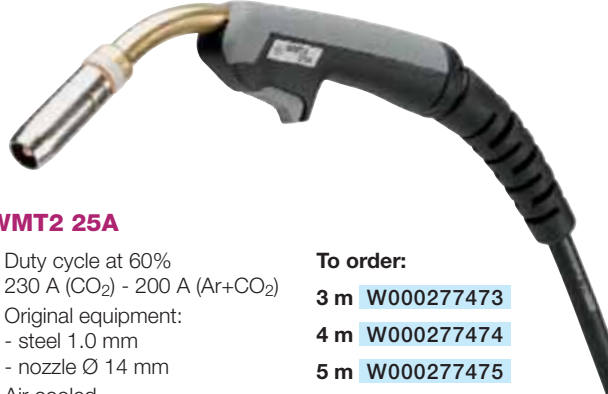


WMT2 36A

- Duty cycle at 60%
340 A (CO₂) - 330 A (Ar+CO₂)
- Original equipment:
- steel 1.2 mm
- nozzle Ø 16 mm
- Air cooled
- Wire diameters:
0.8 to 1.6 mm
- For boiler making metal works, mechanical welding and metal frames.

To order:
3 m **W000277482**
4 m **W000277483**
5 m **W000277484**

2010-109



WMT2 25A

- Duty cycle at 60%
230 A (CO₂) - 200 A (Ar+CO₂)
- Original equipment:
- steel 1.0 mm
- nozzle Ø 14 mm
- Air cooled
- Wire diameters:
0.8 to 1.2 mm
- For locksmiths, thin sheet metal and maintenance works.

To order:
3 m **W000277473**
4 m **W000277474**
5 m **W000277475**

2010-107



WMT2 500W

- Duty cycle at 100%
500 A (CO₂) - 450 A (Ar+CO₂)
- Original equipment:
- steel 1.2 mm
- nozzle Ø 16.5 mm
- Water cooled
- Wire diameters:
1.0 to 1.6 mm
- For heavy duty work requiring water cooling of the torch. The swan neck is available in two lengths.

To order:
3 m **W000277492**
4 m **W000277493**
5 m **W000277494**

**Long swan neck
WMT2 - 500 LW**
3 m **W000277533**
4 m **W000277534**
5 m **W000277535**

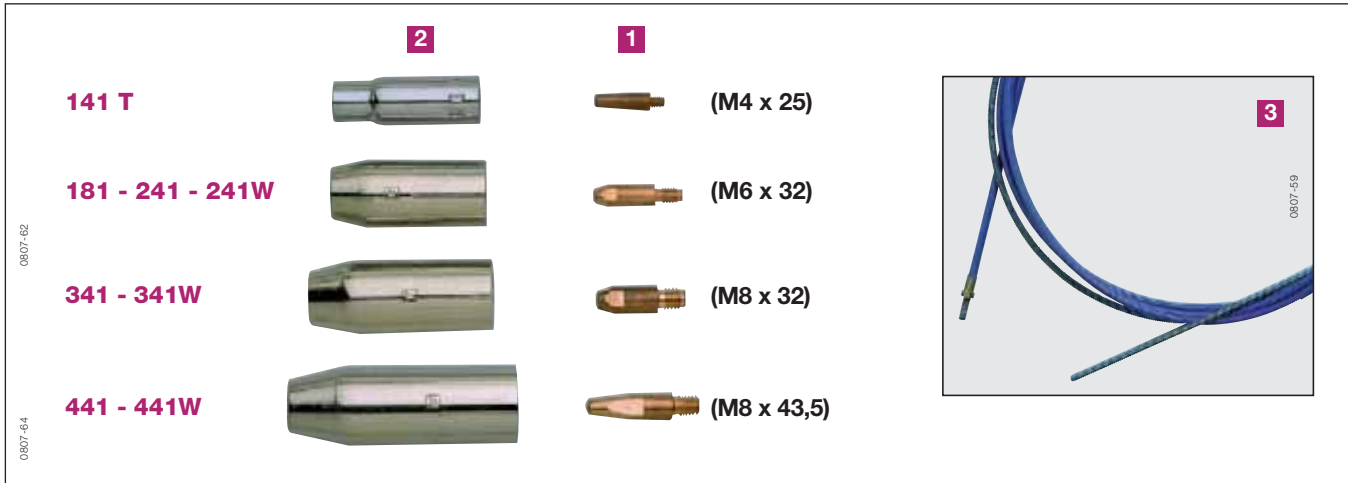
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2570-028

3 - MIG/MAG welding

Wear parts for PROMIG NG and DIGITORCH



PROMIG NG	Ø mm	1 Contact tip	Diffuser	2 Nozzle	3 Internal liner				
					3 m	3 m Graphite brass	4 m	4 m Graphite brass	5 m
141 T	Steel	0.6	W000345571	W000345405 (D14PT*) or W000345403 (D11) or W000345404 (D14)	W000010730	W000010733	W000010731	W000010734	
		0.8			W000010730		W000010731		
		1.0			W000010733		W000010734		
181 T	Steel	0.8	W000345574	W000345335 W000345408 (D12) or W000345409 (D14)	W000010730	W000010733	W000010731	W000010734	W000010732
		1.0			W000010733		W000010734		W000010735
		1.2			W000010733		W000010734		W000010735
241 - 241W	Steel	0.8	W000345574	W000345335 W000345410 (D12) or W000345411 (D14)	W000010730	W000010733	W000010731	W000010734	W000010732
		1.0			W000010733		W000010734		W000010735
		1.2			W000010733		W000010734		W000010735
	Aluminium	1.0			W000010736	W000271824	W000010737	W000271825	W000010738
		1.2			W000010736		W000010737		W000010738
341 - 341 W	Steel	1.0	W000345580	W000345341 W000345420 (D12) or W000345421 (D14) or W000345422 (D16)	W000010733	W000010736	W000010734	W000010737	W000010735
		1.2			W000010733		W000010734		W000010735
		1.4			W000010867		W000010868		W000010869
		1.6			W000010867		W000010868		W000010869
	Aluminium	1.0			W000010736	W000271824	W000010737	W000271825	W000010738
		1.2			W000010736		W000010737		W000010738
		1.6			W000010736		W000010737		W000010738
441 - 441W	Steel	1.0	W000345587	W000345347 W000345427 (D16) or W000345428 (D19)	W000010733	W000010736	W000010734	W000010737	W000010735
		1.2			W000010733		W000010734		W000010735
		1.4			W000010867		W000010868		W000010869
		1.6			W000010867		W000010868		W000010869
	Aluminium	1.0			W000010736	W000271824	W000010737	W000271825	W000010738
		1.2			W000010736		W000010737		W000010738
		1.6			W000010745		W000010746		W000010747

*for point welding

Original equipment parts

3 - MIG/MAG welding

PROMIG NG torches wear parts



	Ø mm	1 Contact tip	Contact tip support	2 Diffuser	3 Nozzle	4 Internal liner				
						3 m	4 m	5 m		
P 14	Steel	D 6 x 217	1.0		W000345202	W000345322	W000345240			
			1.2				W000345240			
			1.6				W000345383			
	Aluminium		1.2				W000345280			
			1.6							
			2.4							
PROMIG 501 W NG	Steel	M 8 x 43.5	1.0		W000345429 (D16) or W000345436 (D18)		W000010733	W000010734	W000010735	
			1.2				W000010867	W000010868	W000010869	
			1.4							
			1.6							
			2.4							
	Aluminium		1.2							W000010742
			1.6				W000010736	W000010737	W000010738	
			1.6				W000010745	W000010746	W000010747	
			PROMIG 450 W NG				Steel	M 8 x 43.5	1.0	W000345347
1.2	W000010867	W000010868		W000010869						
1.4										
1.6										
Aluminium					1.0	W000010736	W000010737		W000010738	
	1.2	W000010745		W000010746	W000010747					
	1.6									

3 - MIG/MAG welding

Wear parts for push-pull torches and guns

	Ø mm	Contact tip	Nozzle isolator	Nozzle holder	Nozzle	Rolls	Internal liner					
							10 m long	Swan neck	8.5 m long			
ALUTORCH 342	Steel	0.8		W000345357	W000345438	W000345423 (D16)	W000345380	W000345396				
		1.0	W000345642									
		1.2	W000345643									
		1.6	W000345644									
	Aluminium	1.0	W000345588				W000345400	W000345397				
		1.2	W000345590									
		1.6										
ALUTORCH 441W	Steel	0.8				W000345427 (D16) or W000345428 (D19)	W000345380	W000345396				
		1.0	W000345642									
		1.2	W000345643									
		1.6	W000345644									
	Aluminium	1.0	W000345588				W000345400	W000345397				
		1.2	W000345590									
		1.6	W000345593									
DIGITORCH PP 352	Steel	0.8	W000346014			W000346002 (D13) or W000346006 (D15) or W000346010 (D18)	W000346059	W000346049	W000273445			
		1.0	W000346022							W000346060		
		1.2	W000346024							W000346061	W000346050	W000273446
		1.6									W000346051	W000346052
	Aluminium	0.8	W000346014				W000346058	W000273444				
		1.0	W000346016						W000270326			
		1.2	W000346018						W000346063	W000346056	W000346057	
		1.6										
DIGITORCH PP 451W	Steel	1.0	W000346022			W000346004 (D13) or W000346008 (D15) or W000346012 (D18)	W000346060	W000346049	W000273445			
		1.2	W000346024							W000346061	W000346050	W000273446
		1.6	W000346026							W000346062	W000346051	W000346052
	Aluminium	1.0	W000346016				W000346058	W000273444				
		1.2	W000346018						W000270326	W000346056	W000346057	
		1.2	W000346018						W000346063			
		1.6	W000346020						W000346064			

3 - MIG/MAG welding

Wear parts for WMT2 torches



	Ø mm	1 Contact tip		2 Contact tip support	3 Nozzle	Nozzle spring	Internal liner			4 Isolator																					
							3 m	4 m	5 m	Standard	High temperature	Ceramic																			
WMT2 15A	Steel	0.6	M 6 x 25	W000010820	W000277903	W000010787 (D10) W000010786 (D12.5) W000010788 (D16)	W000277448	W000010730	W000010731	W000010732																					
				W000010821																											
				W000010822																											
WMT2 25A	Steel	0.8	M 6 x 28	W000010826	W000010720	W000010791 (D12) W000010790 (D14) W000010792 (D17)	W000277477	W000010730	W000010731	W000010732																					
				W000010827																											
				W000010828																											
	Aluminium	1.0	M 6 x 28	W000010850	W000010720	W000010791 (D12) W000010790 (D14) W000010792 (D17)	W000277477	W000010730	W000010731	W000010732																					
				W000010851																											
WMT2 36A	Steel	0.8	M6 M8	M6 x 28 x 30	W000010721 (M6) W000010722 (M8)	W000010795 (D14) W000010794 (D16) W000010796 (D20)		W000010867	W000010868	W000010869	W000010780	W000010781	W000010782																		
				M8 x 30 x 30																											
		1.0	M6 M8	M6 x 28 x 30										W000010721 (M6) W000010722 (M8)	W000010795 (D14) W000010794 (D16) W000010796 (D20)		W000010867	W000010868	W000010869	W000010780	W000010781	W000010782									
				M8 x 30 x 30																											
		1.2	M6 M8	M6 x 28 x 30										W000010721 (M6) W000010722 (M8)	W000010795 (D14) W000010794 (D16) W000010796 (D20)		W000010867	W000010868	W000010869	W000010780	W000010781	W000010782									
				M8 x 30 x 30																											
	1.6	M6 M8	M6 x 28 x 30	W000010721 (M6) W000010722 (M8)	W000010795 (D14) W000010794 (D16) W000010796 (D20)		W000010867	W000010868	W000010869	W000010780	W000010781	W000010782																			
			M8 x 30 x 30																												
	Aluminium	1.0	M6 M8	M6 x 28 x 30	W000010721 (M6) W000010722 (M8)	W000010795 (D14) W000010794 (D16) W000010796 (D20)		W000010736	W000010737	W000010738	W000010780	W000010781	W000010782																		
				M8 x 30 x 30																											
				1.2										M6 M8	M6 x 28 x 30	W000010721 (M6) W000010722 (M8)	W000010795 (D14) W000010794 (D16) W000010796 (D20)		W000010736	W000010737	W000010738	W000010780	W000010781	W000010782							
		M8 x 30 x 30																													
		1.6	M6 M8	M6 x 28 x 30										W000010721 (M6) W000010722 (M8)	W000010795 (D14) W000010794 (D16) W000010796 (D20)											W000010736	W000010737	W000010738	W000010780	W000010781	W000010782
M8 x 30 x 30																															
WMT2 500W		Steel	0.8	M 8 x 30																											
	W000010835																														
	W000010836																														
	W000010837																														
Aluminium	1.0	M 8 x 30	W000010853	W000010724 (M8)	W000010798 (D14.5) W000010797 (D16.5) W000010799 (D20)		W000010736	W000010737	W000010738	W000010783	W000010784	W000010785																			
			W000010854																												
			1.2										M 8 x 30	W000010854	W000010724 (M8)	W000010798 (D14.5) W000010797 (D16.5) W000010799 (D20)		W000010736	W000010737	W000010738	W000010783	W000010784	W000010785								
			W000010855																												
1.6	M 8 x 30	W000010852	W000010724 (M8)	W000010798 (D14.5) W000010797 (D16.5) W000010799 (D20)		W000010736	W000010737	W000010738	W000010783	W000010784	W000010785																				
		W000010855																													

3 - MIG/MAG welding Accessories

Name	Features	To order
1 SPRAYMIG H ₂ O 	Silicon-free water-based anti-spatter. Prevents spatter adhering to nozzles, tips, and work pieces. Net volume 400 ml.	W000010001
2 SPRAYMIG SVB 	Anti-spatter silicone free spray for welding applications (nozzles; tips and work pieces). Compatible with paint. Net volume 400 ml.	W000011092
3 SPRAYMIG SVD 	Anti-spatter silicone free spray for welding applications (nozzles; tips and work pieces). Compatible with paint. Net volume 300 ml.	W000271574
4 SPRAYMIG SIB	Anti-spatter spray with silicone for welding applications (nozzles; tips and work pieces). Not suitable for parts that are to be painted. Net volume 400 ml.	W000011093
5 CERASKIN  	High Tech anti-spatter spray with ceramic coating. Highly recommended for heavy duty automatic and robotic applications. CERASKIN - on application lasts for a complete working shift (8 hours). Compatible with paint. Net volume 400 ml.	W000277679
6 NETMIG POT	Anti spatter in paste. Protects nozzles and contact tips from spatter by immersion. Silicone and solvent free. Net volume 220 ml.	W000011071
7 GALVASPRAY	High resistance to oxidation and corrosion. GALVASPRAY sprays a zinc protective finish. Quick drying. Permits welded parts to be lacquered. Net volume 400 ml.	W000011094
8 MIG Plier D12-15	Useful to: - Cut wire - Clean nozzles - Unscrew tips - Unscrew nozzles.	W000010453
8 MIG plier D15-18		W000010454
9 Magnetic MIG torch stand	Simple stand with magnetic base to keep the work place clean.	W000010802
10 FLOW WELD	Designed to measure gas flow at the MIG/MAG torch nozzle. Maximum flowrate: 20 l/min (Ar, CO ₂ or mixed gas). Accuracy +- 10%. Unbreakable.	W000335159



CAUTION:
before use, carefully read and understand the safety datasheet available on www.weldline-alw.com

